

# SGT78

1967-74 GM Trucks

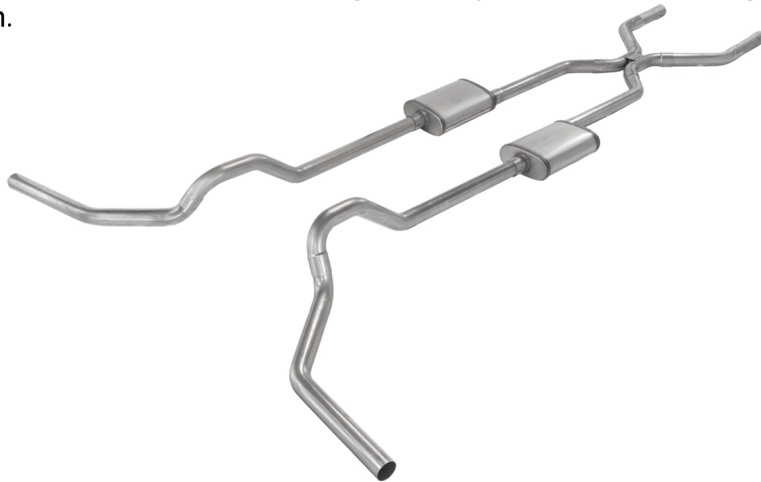
SGT78: 2.5" w/ H-pipe

Stainless Steel Header/Crossmember-back System



**Pypes Performance Exhaust**  
2705 Clemens Rd B103 Hatfield, PA 19440  
www.pypesexhaust.com 800-421-3890

Thanks again for purchasing your new stainless steel Pypes Performance Exhaust. Please take the time now to review these installation instructions and confirm that all the components in the kit were received in your shipment before you begin dis-assembly. If you find a component missing or have questions about the installation please contact our technical department at [tech@pypesexhaust.com](mailto:tech@pypesexhaust.com) or through our live chat room found on the home page of the Pypes website at [www.pypesexhaust.com](http://www.pypesexhaust.com).



## BILL OF MATERIALS

A	Manifold
B	Header
C	Downpipes
D	Collector Reducer
E	Collector Extensions
F	H pipe Assembly
G	Muffler
H	Tailpipes

**1.** Begin by placing the vehicle on a lift or four jack stands at maximum height to aid in an easier installation. To help ease the installation, pre-fit all the components into a complete system on your garage floor, using the diagram provided.

**2.** First, remove the existing exhaust system from the headers or exhaust manifolds back. You can also remove any hanger mounted to the frame as your new kit includes factory reproduction hangers.

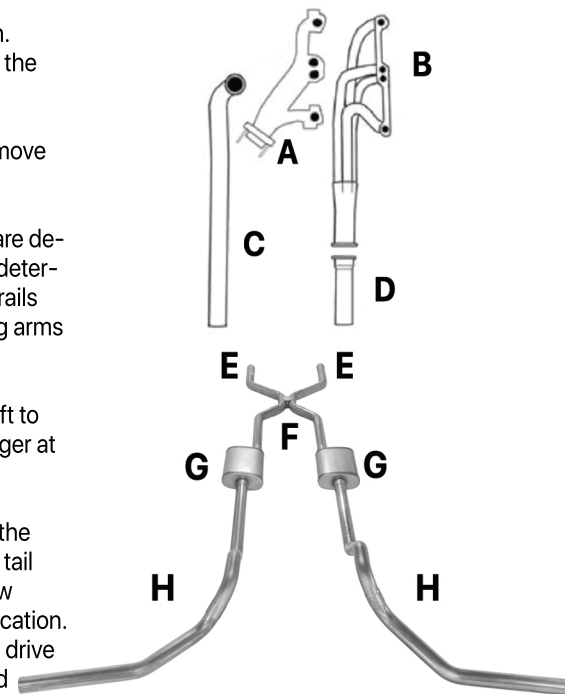
**3.** Now, install your new components. Begin by test installing your new side exit tailpipes. These tailpipes are designed to run inside the rear trailing arms. Since this system uses universal style hangers, you will need to determine the approximate location to mount them. The tailpipe hangers will mount to the outside of the frame rails just behind the rear tires. The muffler hangers will get mounted to the mid cross-member where the trailing arms are attached. If you so choose, custom hangers may be fabricated, let your creativity shine.

**4.** Now, install the mufflers. The mufflers in the kit are designed to mount vertically with the logos facing left to right. The center outlet will get connected to the beginning of the tailpipes. The clamp attached to the hanger at the front side of the muffler will be the only connection clamp used.

**5.** Next, install the h-pipe. This is where trimming of the tubing may be required for the optimum fit. Install the rear legs into the mufflers first. You are aiming to have the center "H" and approx. 12-16 inches behind the tail shaft of your transmission and centered under the driveshaft. Also, the center plate on the "H" has an arrow stamp which must point forward. Trim the rear legs as needed to put your "H" and mufflers in the proper location. Quick tip: If the rear suspension is unloaded, you can push the center "H" up until it just about touches the drive shaft as it will never hit once the suspension is loaded. Slide the front legs into the h-pipe. They should end somewhere close to the humps in your transmission cross-member. On some applications, the front "H" legs may not be centered in the humps but line up to your headers or downpipes. This is fine as the system will not hang too low. Be extra careful when measuring and cutting. A helpful tip: Line up the front legs under the center "H" to mark your cut lines making sure to line them up with you headers or downpipes.

**6.** Continue by connecting the front legs of the h-pipe to the headers (collector/reducers) utilizing the two 1ft collector extension pipes. Trimming the length will be required. Do not connect the h-pipe directly your headers. If downpipes (see downpipe instructions) are used, make sure the pipe ends close to the rear side of the transmission crossmember. If they are too long they must be trimmed. Some header applications require custom collectors due to the header not ending square and parallel to the car. For proper system fit, you collectors must run parallel with your rocker panels.

**7.** Finish the system by making all your final adjustments to position the mufflers and piping. Now tighten all the clamps or for the best fit weld all the slip joints. The stainless steel can be welded with your standard mig welder.



**FIRE IT UP!**