

## SGA30/ SGA31/ SGA29

409 Stainless Steel header/cross-member back exhaust system for  
1964-1972 GM A-bodies  
(Traditional dual exhaust, no crossover section)

**SGA30:** 2-1/2" w/o x-pipe

**SGA29:** 2-1/2" w/o x-pipe 70-71 GTO only

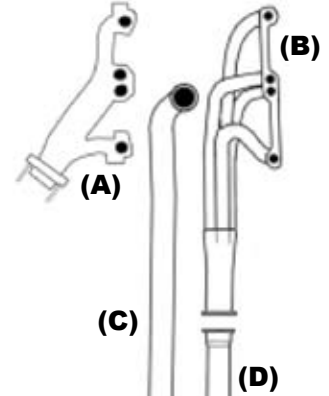
**SGA31:** 3" w/o x-pipe



**Pypes Performance Exhaust**  
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800-421-3890 (voice) 215-712-9968 (fax)  
[www.pypesexhaust.com](http://www.pypesexhaust.com)

Thanks again for purchasing your new 409 stainless steel Pypes Performance Exhaust header/cross-member back system. Please be sure to confirm all the components in the kit were received in your shipment before beginning installation. These kits will include (2) down-pipe extensions, (2) Mufflers (if purchased), (2) tailpipes, (2) extensions pipes, (2) muffler hangers, (2) tailpipe hangers, (8) clamps, and (1) bonus pack. If you purchased a kit including mufflers you will see the following notation after the system number: (S) Street Pro, (R) Race Pro, and (V) Violator. If you find any component missing, please contact our office at 800-421-3890 for replacement. Installation of this kit will require some simple hand tools; box wrenches, deep sockets w/ ratchet, extension, a saws-all and some penetrating lubricant. For a quicker and tighter installation, air tools are recommended. Fully welding the system is always recommended when possible. Technical assistance is available both online at [www.pypesexhaust.com](http://www.pypesexhaust.com) or 800-421-3890.

- (A) Manifold (optional)
- (B) Header (optional)
- (C) Downpipe (optional)
- (D) Collector Reducer (optional)
- (E) Extension Pipes
- (F) Downpipe Extension
- (G) Mufflers
- (H) Tailpipes
- (I) Tips or Turndowns (optional)



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. 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 installing, the new tailpipe hangers. These holes are located approx 12-16" forward from the rear bumper, on the outside of the frame rails. Next, the muffler hangers install just forward of the rear end housing to the cross-member which is perpendicular to the frame rails. Your new hangers have two rubber straps with three holes each. They install as follows: the vertical strap gets bolted through the middle hole to the cross-member parallel to the floor towards the outside of the car. The horizontal strap gets bolted through the top of the cross member by wrapping the rubber strap into a "C" shape. The bolt will need to go through the top hole in the strap. Next, install a complete clamp on each hanger.

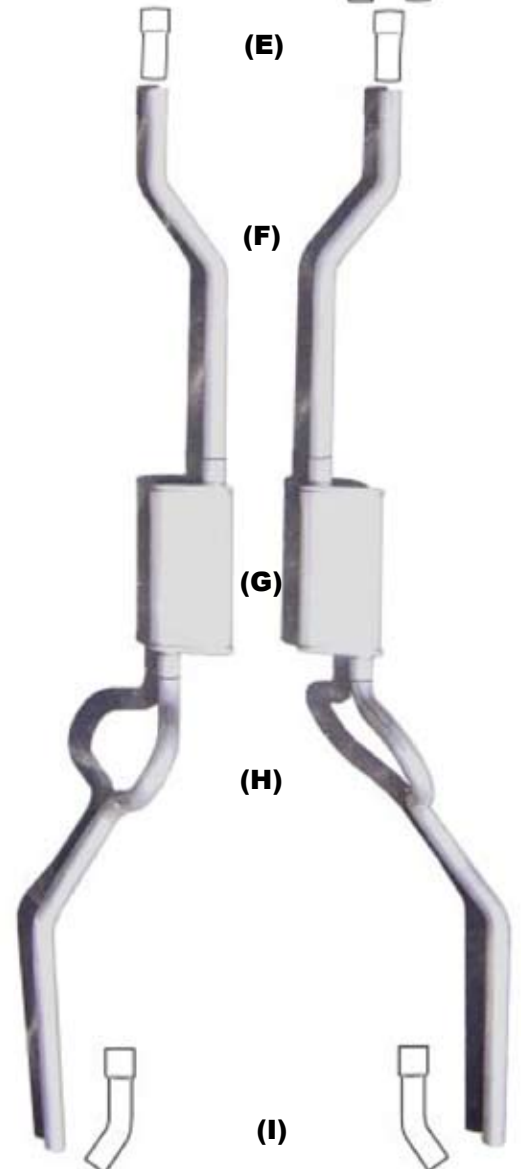
4. Install the two tailpipes on to the clamps you just installed on the hangers. Snug the nuts to hold the tailpipes in place. Your new tailpipes will not require trimming unless installing tips.

5. Now, install the mufflers. The inlet should be closest to the drive shaft and the outlet should be towards the rockers of the car. The clamp attached to the hanger at the backside of the muffler will be the only connection clamp used.

6. Next, install the down-pipe extensions. This is where trimming of the tubing may be required for the optimum length. Slide the extensions into mufflers. The expanded portion of the extensions should land close to the humps in your transmission cross-member.

7. Finish the system by connecting the down-pipe extensions to the headers (collector reducers) utilizing the two 1ft extension pipes. Trimming the length may be required. If down pipes (see down-pipe instructions) are used, make sure the tubing ends close to the rear side of the transmission cross member. If they are too long they must be trimmed. Some header applications require custom collectors due to the header not ending square and parallel in the car. For proper system fit, you collectors must run parallel with your rocker panels.

8. Finish the system by making all your final adjustments to position the x-pipe, mufflers and tailpipes. Now tighten all the clamps (Warning: tightened clamps will leave marks in the tubing, making removal or adjustments extremely difficult) or for the best fit weld all the slip joints. The 409 stainless can be welded with your standard mig welder, and is highly recommended when possible



**Now it's time to fire up that muscle car and enjoy your  
new Pypes Performance Exhaust.**