



409S® Stainless Steel

Installation Instructions

815936

**16-PIECE UNIVERSAL DUAL
EXHAUST TUBING
2.5"**

Notes:

Rev. 6/19/2025

Due to the universal nature of this kit, trimming of the individual pipes is required for installation. When trimming material off of the various pipes, we recommend that you leave the pipes slightly long when initially assembling the system. After the system is into its rough position go back and carefully measure and trim the pipes for the final fit. Also, when assembling the pipes, keep in mind that each slip-fit connection can be rotated to allow for a wide variety of paths for the exhaust system. If this is the first time that you have installed one of these systems, it is very helpful to assemble the pipes on the floor and experiment with its possibilities before you begin on the vehicle.

Typical Installation:

- 1) Place the muffler in the desired location under the vehicle.
- 2) Select the best assembly of pipes to build the head pipes from the engine to the mufflers. Cut and trim front pipes until you have assembled a head pipe assembly. Tack weld these pipes in place and hang the mufflers properly.
- 3) Select the best pipes to fabricate your tailpipe assembly. Work on one side at a time and build the pipe to your preferred outlet location. Again, only tack weld the pipe in place until fabrication is final.
- 4) Repeat the assembly on the opposite side of the vehicle and tack in place. Finish pipe to match the outlet location of prior side.
- 5) Install H-pipe fittings as close to the engine as possible. This is usually right behind the trans crossmember. When fabricating, make sure that you have adequate clearance from the driveshaft. Using the H-pipe fittings supplied, hole saw or torch the appropriate size holes in the head pipe assembly and fit the H-pipe. Tack weld in place at this time.
- 6) This system should be well supported with good quality rubber hangers in at least two positions. Try to avoid supporting the system too rigidly, as this can lead to excessive interior noise and unnecessary stress on exhaust components such as gaskets and head pipes.
- 7) At this time, go back and check for proper clearance around driveline, floor pan, fuel and brake lines, etc. Fully weld all connections of the exhaust system for a trouble free/leak free installation.

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