

## INSTALLATION INSTRUCTIONS

### JBA exhaust systems P/N 50-2651 67-68 side exhaust installation instructions

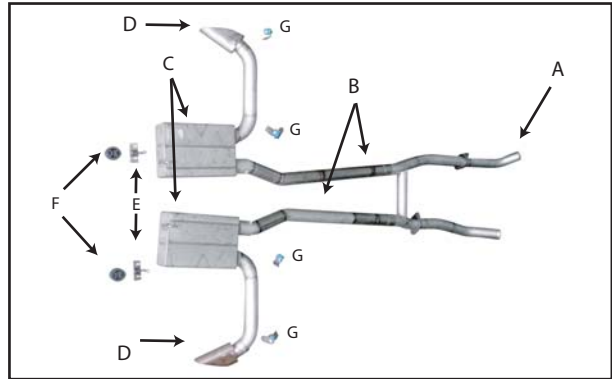
#### RECOMMENDED TOOLS:

Tape Measure  
Saws all  
3" hole saw  
Hammer  
Center Punch  
5/16" Drill bit  
Drill  
XX" socket  
Ratchet  
1/2" wrench

#### PARTS LIST:

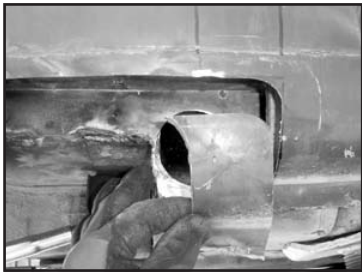
A. H-Pipe (Sold Separately)	1
B. Intermediate pipes	2
C. Muffler assemblies	2
D. Exhaust tips	2
E. Rear muffler hanger	2
F. Rear muffler hanger isolators	2
G. Side pipe exhaust hangers	4

\* Side Skirts not supplied by JBA



#### TO START:

1. Remove and inventory JBA exhaust.
2. Disconnect negative battery cable and allow vehicle exhaust to cool.

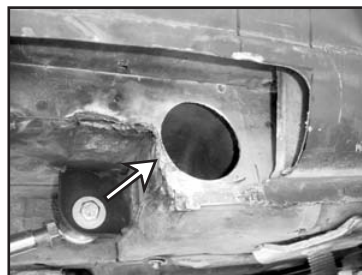


3. Trim the rocker panel at the front of the side skirt hole approximately 2" more. Total length of side skirt hole should measure 11" across.

**Note:** Passenger side shown.



4. Starting with the passenger side, place template 1A against the frame rail. **Note:** make sure to place it as far to the rear of the vehicle and into the top of the open area as possible. Once the template is in the proper position, use the hammer and center punch to make a mark at the point indicated on the template.



5. Using the 3" hole saw, drill at point marked in step 4. **Note:** We found that the body panels were different from side to side. The 3" Hole is made very close to the junction of the body panels (arrow).

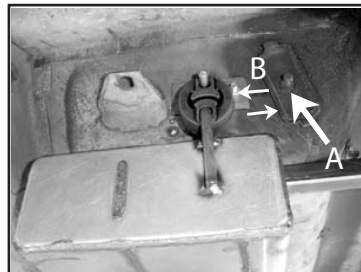


6. Continuing on the passenger side, place template 2A against inside frame rail. **Note:** make sure to place template as far forward and to the top of the floor pan as possible. Once the template is in the proper position, use the hammer and center punch to make a mark at the point indicated on the template.



7. Using the 3" hole saw, cut at the point marked in step 6.

8. Repeat steps 4, 5, and 6 for the left side of the vehicle using templates 1B and 2B.



9. Place muffler hanger (E) (arrow A) in line with bolts for rear seat belts, 1 3/4" from top of bracket on driver side (arrow B) and bottom of pass. side bracket to the bolt hole. Mark holes and drill with 5/16" drill bit



10. Working inside the interior of the vehicle, separate the pieces of muffler hanger (E). Find the plate containing the studs, insert studs through holes drilled in step 8.



11. Place the other side of hanger (E) (hook side) over the studs inserted through the interior in step 10. Install lock washers and nuts.

12. Install muffler assemblies (C) by feeding the side pipes through the 3" holes made in step 7. Attach the muffler assembly (C) to the muffler hanger (E) using the rubber isolators (F) (arrow). The side pipe from the muffler is tac-welded and must be fully welded for final assembly.

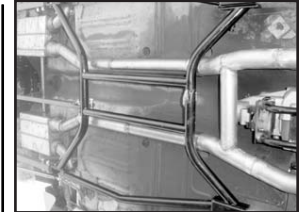
**Attention:** Hang entire assembly to check alignment and fitment. The exhaust pipe from the muffler is tac-welded to allow for vehicle variation. If fitment must be adjusted, cut tac-weld, align properly and re-tac in car for final fitment making sure that the pipe is centered in the hole. Once proper fitment has been achieved fully weld the side pipe.



- 13 A & B. After muffler assemblies are in place, attach hangers (G) to the side pipe on the outside of the frame rail (photo A) and inside of the frame rail (photo B).

**Attention:** You can not remove the side pipe after hangers are welded. Do not weld hangers until pipe is centered.

14. Repeat step 13 to complete the muffler installation for the remaining side of the vehicle.



15. Insert intermediate pipes (B) through the front of the sub frame connector assembly.



16. Install H-pipe (A) to the intermediate pipes (B) and the headers.

17. Tighten all fasteners and clamps.



18. Install side skirts. (Not supplied by JBA)



19. Install exhaust tips.

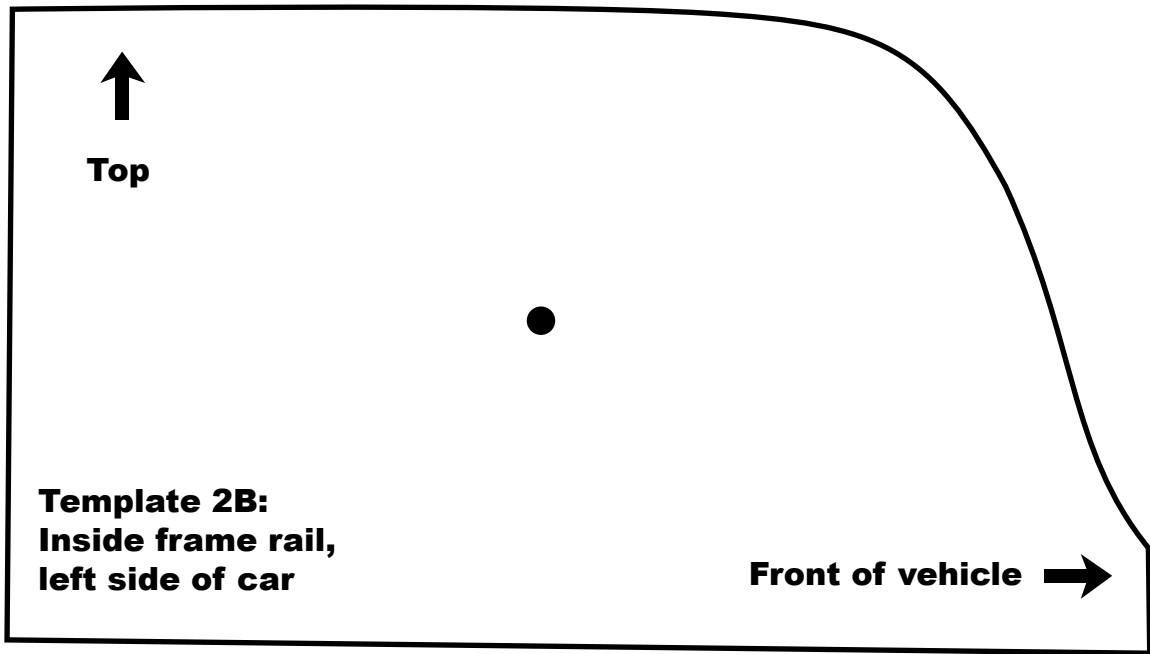
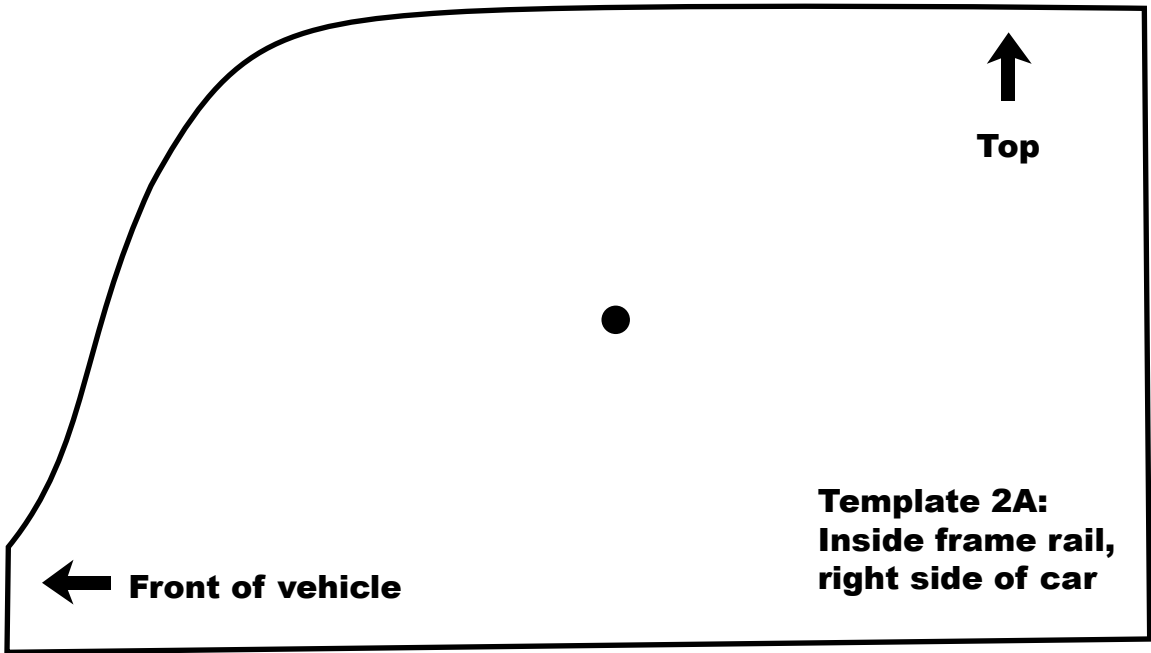
20. After installation, it is recommended that all clamps be retightened.

21. Tack weld all slip connections in three spots.

22. Lower the vehicle and reattach the negative battery cable.

#### NOTES:

- 1) All exhaust systems will expand about 1" rearward when exhaust temperatures start to rise
- 2) Use Anti-seize on threads of clamps.





**Top**



**Rear of vehicle**



**Template 1B:  
Outside frame rail,  
left side of vehicle.**



**Top**



**Rear of vehicle**

**Template 1A:  
Outside frame rail,  
right side of vehicle.**

