

SFT65

1965-76 Ford Truck 2WD

Stainless Steel Crossmember-back System

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 disassembly.



BILL OF MATERIALS

1PR	X-pipe Extension Pipes
1	X-pipe w/ Kick Up Rear Legs
1PR	Mufflers (If Ordered)
1	Tailpipes (4 Pieces)
14	Clamps
1PR	Muffler Hangers
1PR	Tailpipe Hangers

1. After you have inventoried the parts begin by placing your truck on a lift or 4 jack stands so you can work safely under your vehicle.
2. Remove the exiting system at this time along with the hangers. New ones are supplied in the kit. Next using a 13mm socket loosen the ball socket clamp at the end of the factory down pipe and remove the factory mid-pipe. Save all the rubber hanger bushing they will be reused. (Removal of the skid plate is recommended for this step.)
3. Begin the installation of your new system with the tailpipes followed by the mufflers (if ordered). Only the violator is directional and marked on the case. Clamp these components loosely to just hold them in place.
4. Next, install the X-pipe. Make sure the arrow on the X portion points toward the front and is positioned 8 to 10" behind the tail shaft of the transmission. You may need to trim the back of the x-pipe legs or front of the tailpipes (depending on the bed length of your truck) to get the X-pipe into position.
5. Now that you have the major components loosely installed you can begin to make your connection to either headers or manifold downpipes. The front legs of the X-pipe are adjustable by trimming where they slip into the X (narrow is the front) or by pulling out slightly (to widen) but not enough to uncover the slots. The two 12" straight extension pipes also aid in this step but in some cases (mainly header) custom collector reducers will have to be fabricated.
NOTE: Pypes offers a wide assortment of collector reducers and hardware to aid in this step.
6. Finish up your system by installing the hangers and doing your final adjustments to get the mufflers level and tailpipe even. Once you are satisfied with the alignment tighten all clamps. U clamps are supplied with the kit but if you prefer to weld the system you can. 409ss can be welded with a standard MIG welder with carbon wire but we rust where welded with out treatment.

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