

## **SGF15/ SGF15R/ TGF15**

**1970-81 Camaro/ Firebird**

**Cross Member Back system for Detroit Speed  
Quadra-link Suspension**

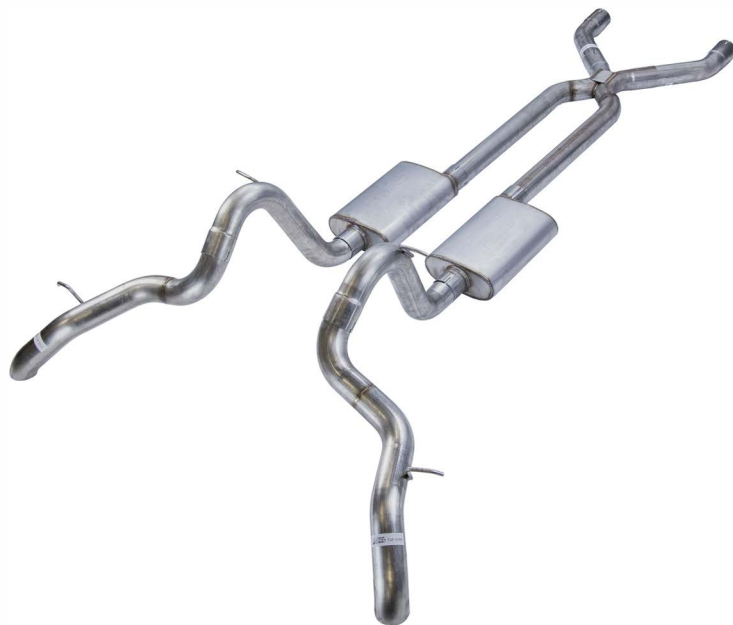


**SGF15:** Cross member back system w/o mufflers

**SGF15R:** Cross member back system w/ Pypes Race-Pro mufflers

**TGF15:** Tailpipes only kit

Thank you for your purchase of our 3" F-body exhaust system specifically designed for the Detroit Speed Quadra-Link rear suspension PN 041711.



### **BILL OF MATERIALS**

- 1 X-pipe
- 1 Tailpipe set (4pc)
- 2 Race-Pro mufflers
- 8 HVC24 band clamps
- 4 MHV6 hands and hardware

1. Begin your installation by placing the vehicle on a lift or four jack stands. It is not necessary to have the suspension hang this kit can be installed at ride height but it does make it easier.
2. Place one of the MHV6 hangers on each of the wire forms attached to each of the tail pipe sections. Next fish the rear tail pipe sections over the panard bar and rear housing mating them to the S shaped over the axle pipes. Use HVC24 clamps at this junction. Do not tighten completely. Tech Note: The wire forms for each tail pipe sections face the outside of the vehicle.
3. Next install the mufflers to the end of the tailpipes followed by the x-pipe assembly. The mufflers are correct when they are placed in the offset in / center out position. Use HVC24 band clamps to loosely secure the mufflers to the tailpipes and x-pipe to the mufflers.
4. Correct positioning of the x-pipe is when the X section is 8-10" behind the transmission yoke and lined up with the humps in the transmission cross member. Adjustments can be made to the x-pipe by trimming the back of the X for length and front legs where they go into the X section for width.
5. Now that you have all the components loosely installed you can begin the adjustment process. It's best to do this at ride height to guaranty proper clearance. Once you are happy with your clearances secure the hangers for the over the axle pipes to the bottom package shelf brace using the self-tapping screws provided. Followed by the rear tailpipe sections to the frame rail in the same manor.
6. Tighten all clamps at this point to lock the system in place.
7. Now connect your headers or manifolds to the exhaust system. Due to the variations in headers you may have to do some fabrication to make this connection. Pypes offers many solutions that may aid in this connection process.

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