



2004 GTO 3" EXHAUST INSTALLATION INSTRUCTIONS

Thanks for purchasing Stainless Works 3" Muscleflow exhaust for your GTO. We have gone to great pains to make sure that our exhaust systems fit and sound great. Please follow these steps to ensure that your installation goes as planned.

1. Installing the 3" exhaust is best performed on a lift by a qualified technician. The factory exhaust system should be removed starting at the two bolt flanges behind the catalytic converters. Remove all factory pipes and muffler assembly.
2. Starting at the two-bolt flange, clean the gasket faces thoroughly and install the short stubs with the two bolt flanges welded to them into the x pipe assembly. Slide the stub/x pipe assembly into place and secure with bolts and nuts (two 3/8 X 1").
3. Next, slide the mufflers into place into the outlet of the x pipe assembly. The hanger assembly will slide over the outlet of the muffler and will be held in place using the supplied band clamps. The factory bushings are re-used and slid over the hanger rods.
4. For systems that exit through the factory valence:
 - a. The right tailpipe extension is inserted into the right muffler-this piece is approximately 16" long and is slipped into the outlet of the right muffler. The right tailpipe can then be inserted into the tailpipe extension, followed by the left tailpipe.
 - b. The tailpipe tip is then slipped over the tailpipes. Using the supplied hanger bracket (the rear hanger assembly is a flat plate with two saddle clamp shells welded to it), install the hanger rods into the factory rubber biscuits.
5. For systems that have the dual splitter tips that exit behind the rear tires:
 - a. The plastic cover in the right rear wheel well will need to be removed for exhaust tip clearance.
 - b. The left and right tailpipes are slipped into the muffler outlets. The two rear hangers will have a blue grommet installed in the top hole. Install a 3/8" X 1 1/2" bolt through the grommet and slip the 2" long hanger tab with two 3/8" holes over the bolt. The tailpipe hanger assembly is bolted into the rear floor using two studs with nylok nuts (the GTO has the nylok nuts already installed on the studs from the factory). These studs are located

near the frame rails and the left and right rear corners of the trunk well (the deepest part of the trunk floor). The hanger's will then clamp into place almost directly behind the coil springs using the supplied band clamps.

- c. The splitter tips are then installed using the supplied band clamps.
6. Once you are satisfied with the fit of the system, break the system apart and cut four small slots about 1/2" deep into the outer pipe of each joint, and Deburr the joint thoroughly. Cutting these small slots will allow the pipe to compress and seal uniformly at each joint. We also recommend using a light coating of red high temp RTV at each joint to make disassembling the system easier and also aid in sealing the joints.
7. Make sure to have adequate clearance around all wires, hoses and lines. **If anything is in contact with the exhaust system, it will melt.** Make sure to have at least 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.
8. After all pipes are lined up, tighten all clamps. We do highly recommend placing a small tack weld at each joint for added security.
9. After double-checking for clearance and making sure all lines, wires and hoses are secured, drive the car for 10-20 miles and re-check all clamps and clearances.