

## SCC40R

409 Stainless Steel cross-member back exhaust system for  
1986-91 L98 C4 Corvettes

**SCC40R:** 2-1/2" w/ x-pipe, Race Pro mufflers and rectangular tips



**Pypes Performance Exhaust**  
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Thanks again for purchasing your new 409 stainless steel Pypes Performance Exhaust cross-member back system. Please be sure to confirm all the components in the kit were received in your shipment before beginning installation. These kits will include (1) X-pipe kit, (2) mid-pipes, (2) tail-pipes, (2) Race Pro axle-backs, (8) band clamps, and (1) HCC40 "L" hanger. If you are still utilizing your factory manifolds, you will need additional down-pipes, DCC40. If you find any component missing, please contact our office at 800-421-3890 for replacement. Installation of this kit will require some simple hand tools; box wrenches, deep sockets w/ ratchet, extension, a saws-all and some penetrating lubricant. For a quicker and tighter installation, air tools are recommended. Fully welding the system is always recommended when possible. Technical assistance is available both online at [www.pypesexhaust.com](http://www.pypesexhaust.com) or 800-421-3890. Also, our online Installation Gallery is a great assistant during your installation, visit [www.pypesexhaust.com/pictures.html](http://www.pypesexhaust.com/pictures.html).

- (A) X-pipe Assembly
- (B) Mid-pipes
- (C) Tail-pipes
- (D) Mufflers
- (E) Tips

**1. Begin by placing the vehicle on a lift or four jack stands at maximum height to aid in an easier installation. To help ease the installation, pre-fit all the components into a complete system on your garage floor, using the diagram provided.**

**2. Remove the existing exhaust system from the headers or exhaust manifolds back.**

**3. Now it's time to install your new components. Begin by installing your down-pipes, manifold cars only.**

**4. The direct fit x-pipe will get installed next to the down-pipes or collector reducers. Some header applications require custom bent collectors due to the header not ending square and parallel to the car or do not line up with the x-pipe which was designed to clear both auto and manual transmissions. For proper system fit, your collectors must run parallel with your rocker panels.**

**5. Next, install the two cat delete mid-pipes. The "L" bracket provided in the kit will keep the mid-pipes at the correct distance apart and also hang the system from the frame. The short portion of the "L" will point up towards the floor of the vehicle. The provided nuts should be tightened to insure the pipes stay in position. The rubber strap will get bolted to the bracket and to the stud on the vehicle in the drive shaft tunnel.**

**6. Now, install the rear tailpipes. They will route under the rear and to the left and right sides of the vehicle.**

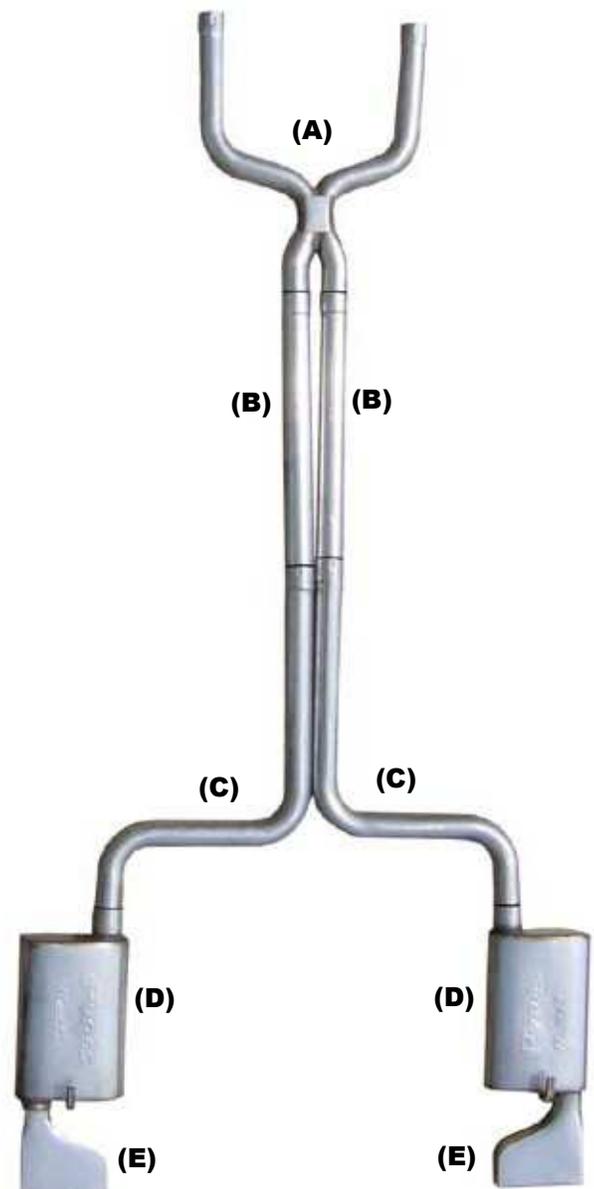
**7. Last, slide the axle-back mufflers onto the tail pipes. The hanger welded to the muffler body will hang in the factory bracket mounted to the frame.**

**8. Before tightening the clamps, make all the adjustment to the system for the proper fit. Begin tightening the clamps from front to back.**

**9. 409 stainless can be welded with your standard Mig welder and should be treated to prevent rust.**

**10. Again, some header applications require custom bent collectors due to the header not ending square and parallel to the car. For proper system fit, your collectors must point straight into the x-pipe extensions.**

Note: When tightening the HVC21/24/25/26 band clamps, make sure the I-block in the center of the clamp is centered against the head of the bolt. Failure to do so will result in the clamp not to tighten properly or the I-block to break.



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