

2020+ SILVERADO / SIERRA 2500 6.6L GAS

CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works catback exhaust system for your 2020 + Chevy Silverado / GMC Sierra . Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



**2020 GMC Sierra 2500 6.6L
(CT220CBR/L)**

a.

Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

b.

Your exhaust system can be installed by a weekend warrior but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a level hard surface. Jack stands are required for safety reasons.

c.

You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.

d.

When installing your catback system, make certain that the hangers at the end of the exhaust have at least $\frac{3}{4}$ " of clearance to the bumper. The exhaust will grow over $\frac{1}{2}$ " in length and can possibly damage the bumper. If the end of the hangers are too close to the bumper, then you must make sure that you have everything pushed forward onto the slip fit joints more fully.

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DISASSEMBLY

1. Disconnect the battery.
2. Raise and support the vehicle.
3. Loosen nuts at factory flanged connection point, after the catalytic converters.
4. Remove 5 rubber hangers from exhaust system.
5. Remove exhaust system from vehicle. Unbolting & removing the driveshaft will give more clearance for this step.
6. Tap out factory studs in flanged OEM connection (if utilizing OEM manifolds).

ASSEMBLY

7. Out of the box, this system is designed to fit Crew Cab - Standard Bed configuration. Locate the straight catback lead pipes. Use the chart to the right to determine your wheelbase and cut length. Measure from the outlet end (without the expansion) to the distance shown. Mark the tube and cut to remove the length shown. Deburr the cut end.
8. Install X- pipe **OR** Y-pipe using the captive flanged connection (Y-pipe not used for performance connect systems. Performance connect systems attach to X-pipe).
9. Install hanger and left and right muffler inlet pipes using (2) 3" clamps.
10. Install mufflers using (2) 3" clamps.

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Detail 3: Factory catback connection point & rubber hanger



Detail 4: Rubber hangers at rear of OEM muffler

Cab Configuration	Bed Length	Wheelbase	Cut Length
Regular Cab	Long Bed	139.5	17.5
Double Cab	Standard Bed	147.5	9.5
Crew Cab	Short Bed	147.5	9.5
	Standard Bed	157.0	0.0

Detail 7: CB lead pipe cut chart

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11.

Install left and right tails to mufflers using (2) 3" clamps.

12.

Install rear hanger assembly into insulators just behind the mufflers. Use (2) 3" saddle clamps to secure to tails.

13.

Install tail hanger assembly onto the tailpipes, behind the rear axle, using (2) 3" band clamps.

14.

Install and align the (2) tips using (2) 3" band clamps. We recommend rolling the tips so that the slash cut matches the angle of the body.

15.

Adjust and tighten the system from front to back. Keep the mufflers level from side to side as the tubes are adjusted.

16.

Be 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 ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

17.

After double checking for clearance and making sure all lines, wires and hoses are secured, drive the truck for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.

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Detail 12: Hanger assemblies behind mufflers



Detail 13: Rear tail hanger assembly, viewed from rear of vehicle.



Detail 14: System installed. View from rear of vehicle.

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800.878.3635

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