

2025 RAM 1500 Standard Output DOWNPIPE & MIDPIPE INSTALLATION INSTRUCTIONS

Thank you for purchasing a Stainless Works Downpipe system for your 2025 Ram 1500. 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.



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(RAM25DP, RAM25MID-S0)

- a.** Stainless Works recommends the use of Hi-Temp RTV sensor safe silicone gasket maker as an option or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.
- b.** Disconnect the battery before starting to work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.
- c.** 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 hard level surface. Jack stands are required for safety.
- d.** 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.

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DISASSEMBLY

1. Disconnect the battery.
2. Raise and support the vehicle.
3. Remove (2) 16mm bolts at the rear 2 bolt flange and (2) 15mm nuts at the front 2 bolt flange. Remove the OEM mid section.
4. Remove the two factory clamps (16mm nut) that attach the factory mid pipe to the down pipe and set aside. These will be reused attaching the Stainless Works mid pipe to the factory or Stainless Works Downpipes.
5. Remove the front sway bar and let it hang to allow room for the factory downpipes to come out (4x 15mm bolt)
6. Unbolt front driveshaft (4x 15mm bolts)
7. Remove front driver side wheel and inside fender liner and set to the side.
8. Remove O2 sensors from midpipes, passenger side is easiest to reach from the hood, Driver side is easiest to remove from the driver side wheel well.
9. With the fender liner removed you should have easy access to the factory downpipe V-Band clamps and wastegate flange
10. Remove the 4 bolts at the bottom of the midpipe from the hanger bracket. (see photo)



Detail 3: OEM mid section



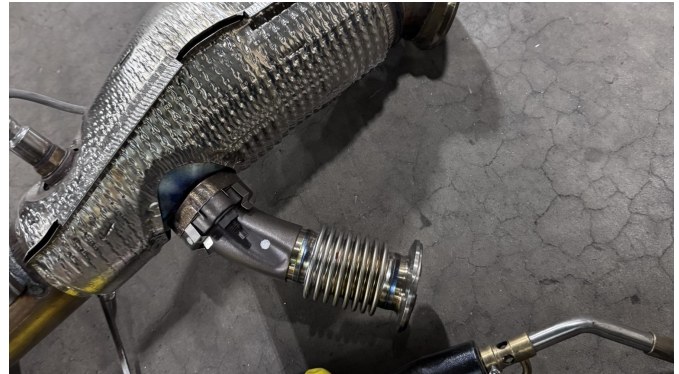
Detail 10: 4 bolts at bottom of downpipe

DISASSEMBLY *(continued)*

11. Remove single bolt (1x 13mm) from driver side and passenger side downpipe v-band.
12. There are 2 ways to remove the wastegate connection. You can either remove the single bolt on the v-band clamp OR remove the (2x 13mm) nuts at the flange side of the wastegate tube. (see photo)
13. With all clamps and bolts removed, carefully remove the factory downpipes. This will take some rotating and moving of each downpipe to get out.

ASSEMBLY

14. Install the passenger side downpipe first ensuring that you line up the wastegate flange to factory connection point.
15. Without the driver side downpipe connected it will be easier to connect the O2 sensor extension and plug the O2 sensor back in, as well as tighten down your wastegate flange and Downpipe V-Band.
16. Install passenger side downpipe with factory v-band clamp and tighten. Once tight, reconnect O2 sensor and connect O2 extension. Zip tie excess cable out of the way
17. Install the right and left mid pipes using the factory clamps. ***(If connecting to the Stainless Works midpipe, Install the resonators before the x-pipe.)***



Detail 3: Wastegate tube removed at v-band



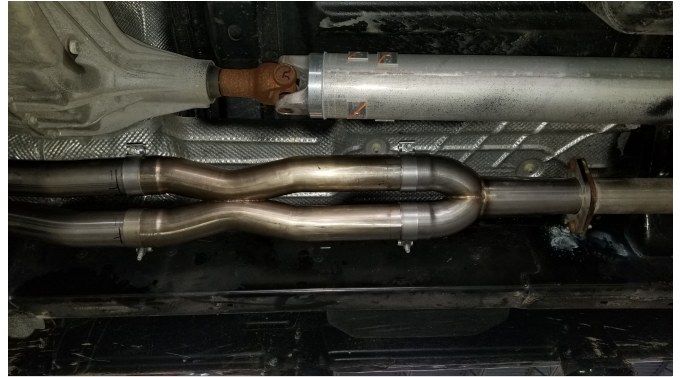
Detail 12: Wastegate location in vehicle

ASSEMBLY (continued)

18. Your system may require trimming depending on cab/bed configuration. Refer to the chart below for the amount to trim from the X-pipe. Measure from the outlet end, mark the tube, cut, and deburr before installing.
19. *For Factory Connection* - Install the X-pipe to the mid pipes using (2) 3" clamps. Then install the Y-pipe to the X-pipe using (2) 3" clamps. Bolt the Y-pipe flange to the factory connection using the factory hardware.
For Performance Connection - Install the smooth tube resonators to the mid pipes using (2) 3" clamps. Then install the X-pipe to the resonators using (2) 3" clamps. Continue with installation, following catback instructions.
20. Adjust and tighten the system from front to back.

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Factory Connect Configuration

CAB CONFIGURATION	BED LENGTH	WHEELBASE	CUT LENGTH
Quad Cab	6'4"	140.5"	13"
Crew Cab	5'7"	144.6"	9"
	6'4"	153.5"	0"

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ASSEMBLY (continued)

22. 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.
23. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the vehicle 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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Stainless Works Downpipe to Midpipe

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