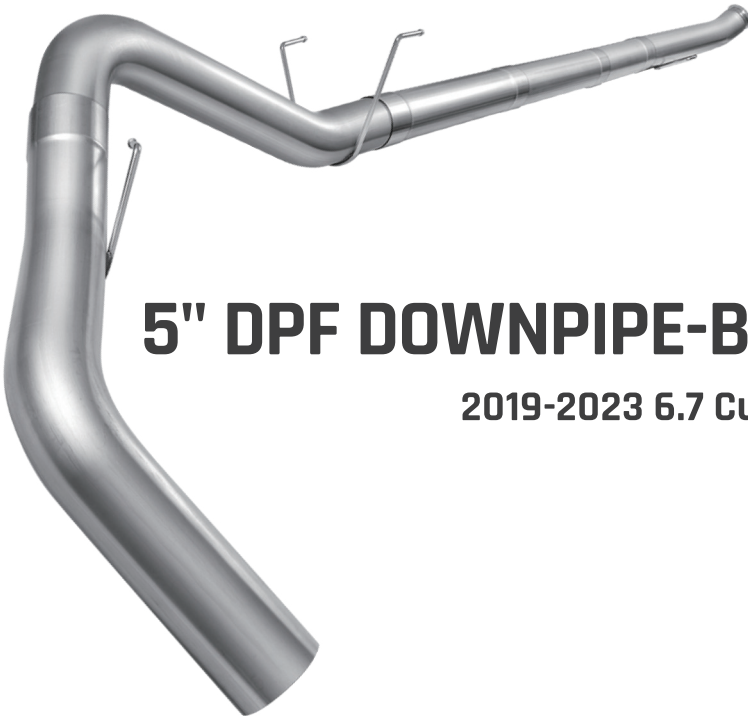








***SPELAB***

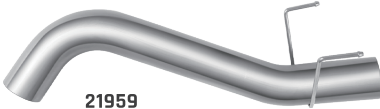


# **5" DPF DOWNPIPE-BACK**

**2019-2023 6.7 Cummins**

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**PACKING INCLUDE****50230****21958****21959****50020****21960****50030****WARNING**

Before you begin, verify that you received the right kit & each part listed is correct and in good condition.

**Note:** Always practice safe working standards using appropriate stands or having a second person on hand to help and allow for exhaust to completely cool before starting your.

**INSTALLATION NOTES**

**Note:** Prior to installation, please compare the parts that you have received with the bill of materials listed above to ensure that you have all the necessary parts for installation.

## INSTALLATION STEPS

**Step 1:** Start by removing the 6 factory sensors from the exhaust and disconnect any electrical connections to allow the factory parts to be removed safely.

**Step 2:** Starting at the back of the truck, undo the clamp holding the axle/tailpipe assembly to the filter and then remove this assembly from the rubber isolators on the frame so that the tailpipe assembly is free. Note: Wd40 or similar lubricant will make removing hangers from the rubber isolators much easier.

**Step 3:** Now you can remove the 4 nuts that hold the rear canister to the front. This will require a second person or set of stands to support the weight. CAUTION this part is heavy.

**Step 4:** The factory hanger bracket that is located next to the flange you unbolted can also be removed from the cross-member to make removal of the next canister much easier.



**Step 5:** Move to the front canister connection to the downpipe. Loosen the nut on the V band clamp until the clamp can be removed and now the canister can be removed from the truck. Note: Retain the factory gasket for reuse.

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**Step 6:** Start by Sliding your front pipe #21958 over the two cross-members and connect it to the downpipe using the factory clamp and gasket. Ensure the hanger is located in the rubber isolator. See Fig 1 & 2 Snug this connection enough to hold the pipe in place but so that it can be adjusted slightly with some effort.

**Step 7:** Now hang the axle and tailpipe combo, #21959 & 21960 so that the pipes are fully engaged in their respective hangers and are seated into each other.

**Step 8:** Using a stand to support it, install the muffler replacement #50230 onto the axle pipe.

**Step 9:** Measure the gap between your muffler and front pipe #21958, this is the length of extension you will need. This may require a combination of both extensions or trimming of an extension for a perfect fit depending on your wheel base. Do not forget to account for the overlap at each end of pipe when cutting and only cut from the non-expanded end.

**Step 10:** With your extension trimmed and in place you can now double check for proper alignment of the system and make any adjustments needed before tightening your clamps starting with the downpipe connection and working your way towards the rear of the truck. Torque your clamps between 45-50 foot pounds.(Note: A small mig weld should be applied under the clamp to the clamped connections of pipe for added security). DO NOT WELD CLAMPS.



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