

2025 RAM 1500

MIDPIPE INSTALLATION INSTRUCTIONS

Thank you for purchasing a Stainless Works MidPipe 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.



**2025 Ram 1500
(RAM25MID)**

- 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.

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.



Detail 3: OEM mid section

ASSEMBLY

5. Install the right and left mid pipes using the factory clamps.
6. Your system may require trimming depending on cab/bed configuration. Refer to the chart below for the amount to trim from the X-pipe. If you are installing a Performance Connect System to a Stainless Works catback, you may find it easier to trim the (2) straight mid pipes instead. Measure from the outlet end, mark the tube, cut, and deburr before installing.

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"

7.
Install the X-pipe to the leads using (2) 3" clamps

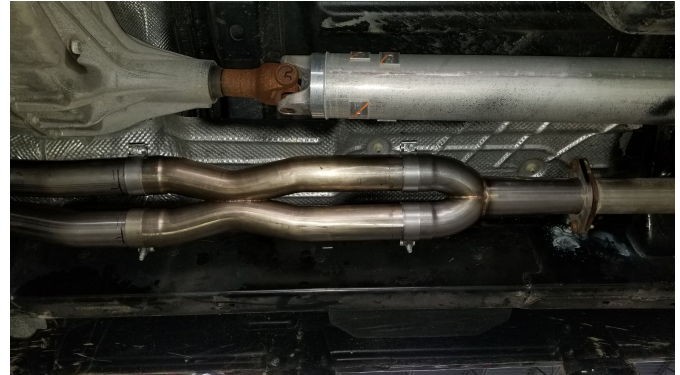
8.
For Factory Connection - Install the Y-pipe to the X-pipe using (2) 3" clamps. Bolt the Y-pipe flange to the factory connection using the factory hardware.

For Performance Connection - Install the performance connect mid pipes to the X-pipe using (2) 3" clamps. Connect to your Stainless Works catback by following the instructions provided with that kit.

9.
Adjust and tighten the system from front to back.

10.
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 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

11.
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.



Factory Connect Configuration



Performance Connect Configuration