

Installation Guide: Solstice SQR-2 Kit

Always exercise caution when working on, under or around any vehicles. Serious injury or death could occur if safety measures are not followed.

Warnings and Safety Measures

- Allow the vehicle's exhaust system to cool before removal. Exhaust system temperatures may cause severe burns.
- If working without a lift, always consult vehicle manual for correct lifting specifications.
- Always wear safety glasses and ensure safe work area.
- Catalytic converter are to be used for off road use only.
- Professional installation is recommended.

Removing the Stock Exhaust System

1. Take out O2 sensor located in the front exhaust pipe with a 7/8 wrench or 22ml wrench.
2. Take of the two nuts (15ml) from the front pipe to catalytic converter connection.
3. Pull down on rear of the exhaust system by the muffler. When the 4 rubber hangers stretch, squirt soapy water into the rubber where the hangers go. You could use WD40 or grease but that would not be to good for the rubbers. It will starts to deteriorate them.

Using a fair size channel lock pliers, squeeze the backside of the rubber and the hanger rod. This will push the hanger knob into the rubber. Start all 4 like this. Then using a long screw driver or pry-bar take off the two front hangers (the two closest to the engine). The two rear ones are still in and will support the system while prying. From here you can actually pull the system out of the rear two hangers or pry them out.

4. Reuse the stock gasket and studs at the bottom of the catalytic converter, if you can.
5. The stock exhaust system is now disassembled and its time to put your new kit on!

For installation of new rear valence please go to the following thread: [click here](#)

Installing the Front Pipe Assembly

Note: If you snug everything first instead of fully tightening, it will allow room for movements and adjustments. Once the new system is on, snug, align, and then do your final tightening.

1. Use bolts and moulded gasket (they are provided.) Loosely connect the front pipe to catalytic converter while supporting the front pipe.

Note: Use stock nuts if you have a stock converter. Use the nuts & bolts that are provided if you have a SOLO converter.

2. Remove the stock floor pan bolt that lines up with the front pipe hanger bracket. Slide SOLO's extra rubber hanger over the front pipe bracket. Line the front pipe resonator exactly in the cavity and see where to install the floor pan bolt and hanger. Start the hanger bolt but don't tighten.
3. Line up the front pipes and then snug the pipe to converter.
4. Reinstall the front pipe oxygen sensor.

Installing SOLO's Rear Dual Assembly

1. Slide the rear assembly into the four rubber hangers at the back of your solstice.
 2. Using the bolts provided, loosely attach the rear dual section to the front assembly.
 3. Center and level your tips.
 4. Have someone hold your tips centered and level while you do perform the final tightening.
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Final Tightening

1. Align everything to a suitable level before you tighten. There is a lot of “wobble room” in this alignment.
 2. Many times, you have to push up on the front pipe to rear section connection to get the tips aligned.
 3. When everything looks good, tighten the front pipe to rear section connection.
 4. Finish tightening your final front pipe to cat.
 5. Tighten the floor pan bolt that is attaching the extra hanger.
 6. Drive away and... Enjoy Going Solo!
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For any questions or concerns, please do not hesitate to call:

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