

Vstar 650

Pipe mod for gutted pipes

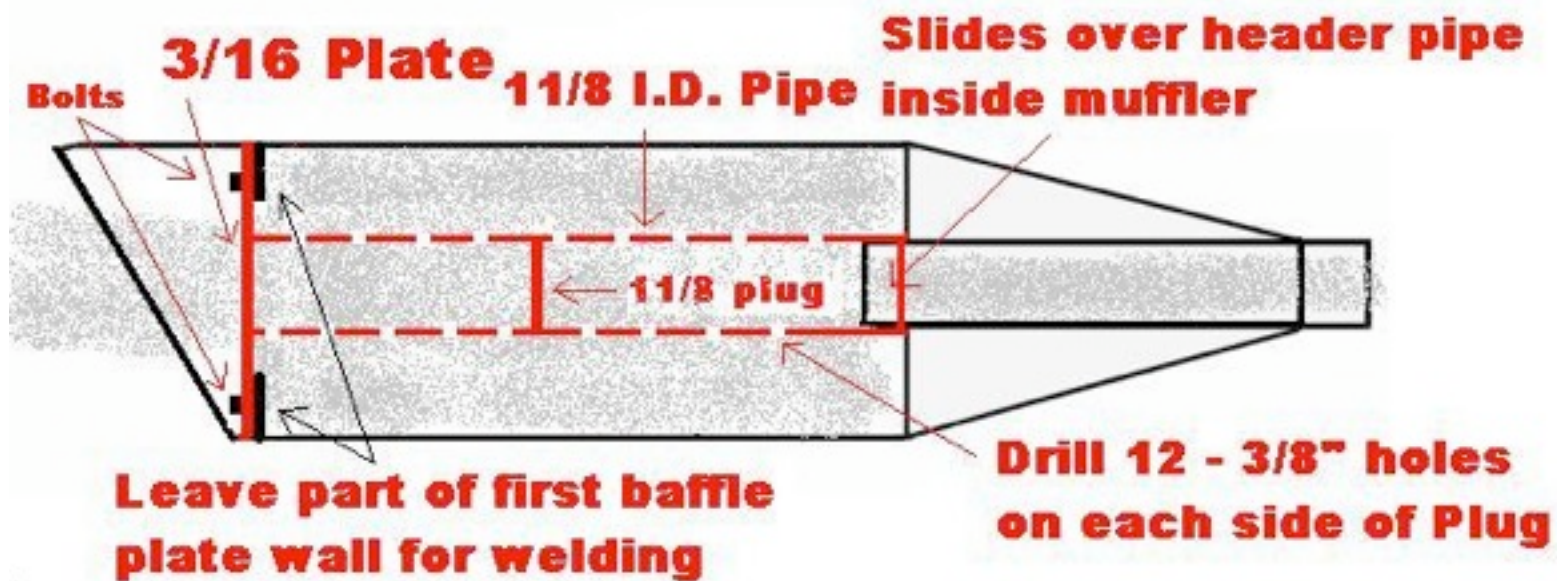
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I came up with this modification to quiet down the gutted pipes. This mod will work on all the pre cat pipes. It has not been tested on the cat pipes but may work on them also. This mod was designed for the slash cut pipes and works best if you have the second baffle wall left in the pipe but is possible to do if fully gutted. Good luck and I hope you find this mod helpful.

**Thanks to Dan Freed
For the help putting this file together.**

***This is the finished pipes after cleaning and paint
And believe me they sound great***





This is a view of how this works, the parts in red is what you are making you can weld or make it bolt in this is your choice

This is all the supply's needed to complete this mod

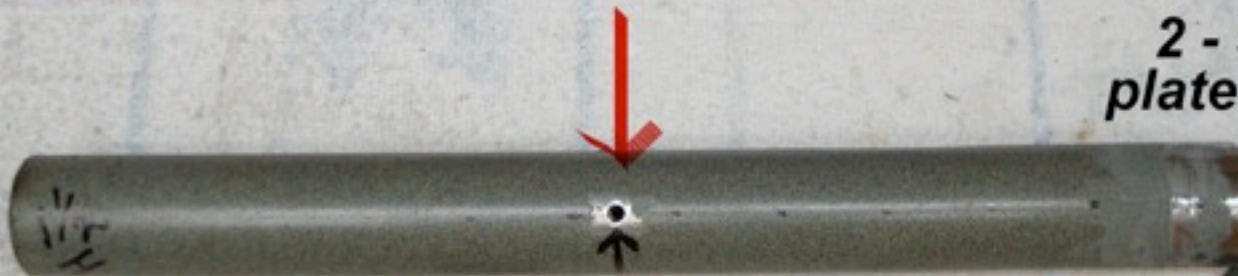
2 - 1 1/8 ID X 12" Pipe



***Find center and drill 3/16" hole
on each side of pipe
to spotweld freeze plug in place***



***2 - 3 7/16" Dia.
plate w/ 1 1/4 hole***



2 - 1 1/8 Freeze plug



***Insert freeze plugs and spotweld
before drilling any holes, It makes it easier to
insert the freeze plugs***

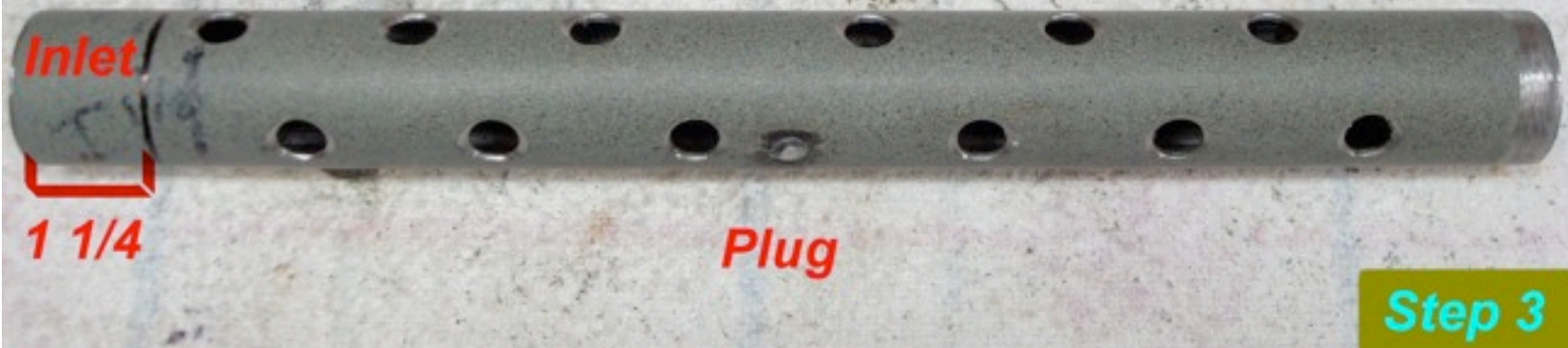
Step 1

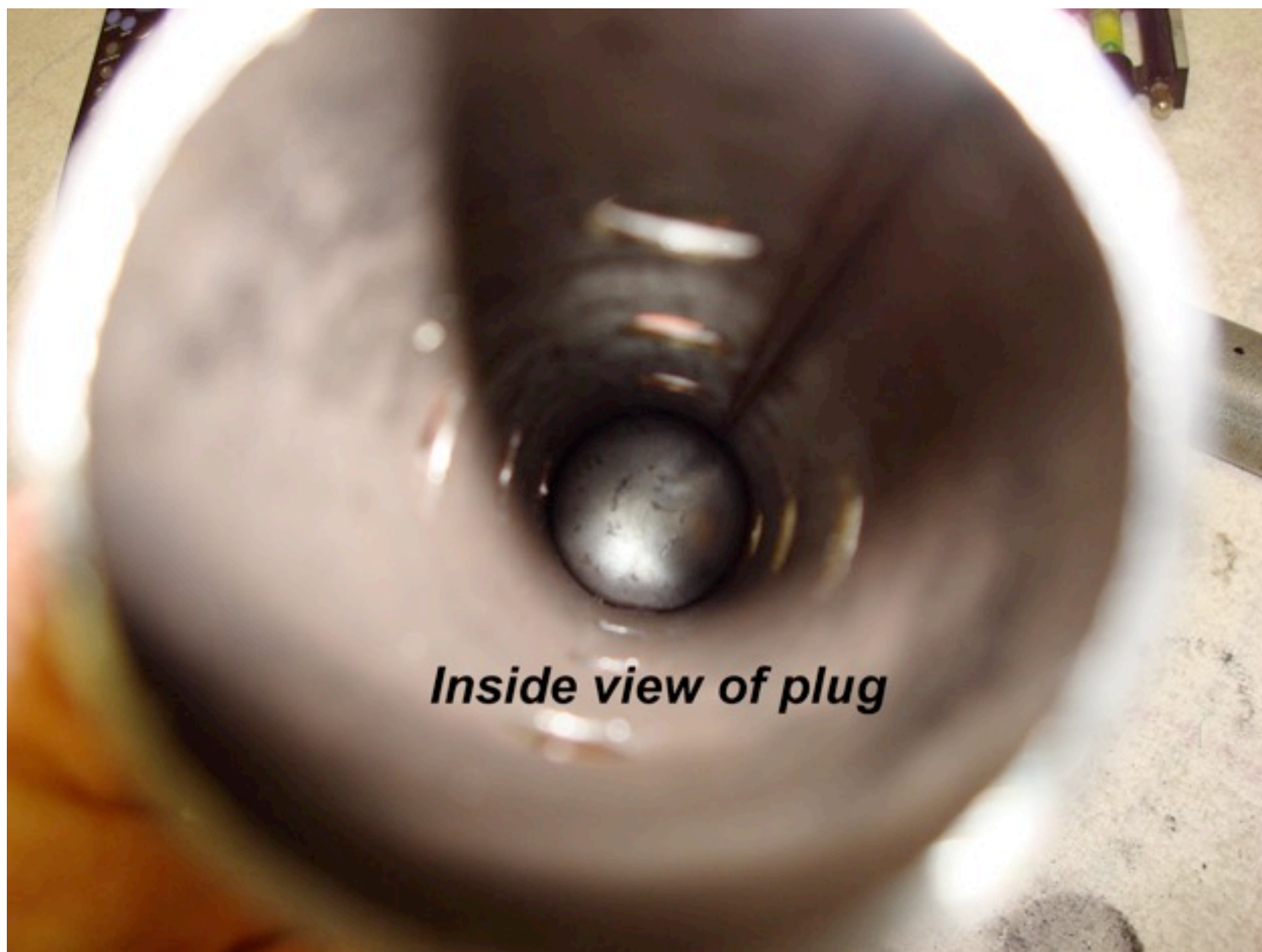
***This photo shows the plugs welded in place
and marked for the holes to be drilled***

Step 2

The pipe after it has been drilled. Drill 12 holes on each side of the plug. Here you can get creative as far as pattern, I drilled 3/8" holes at 1 1/2" apart offsetting the holes. If you only drill 12 holes do not drill smaller than 3/8" holes

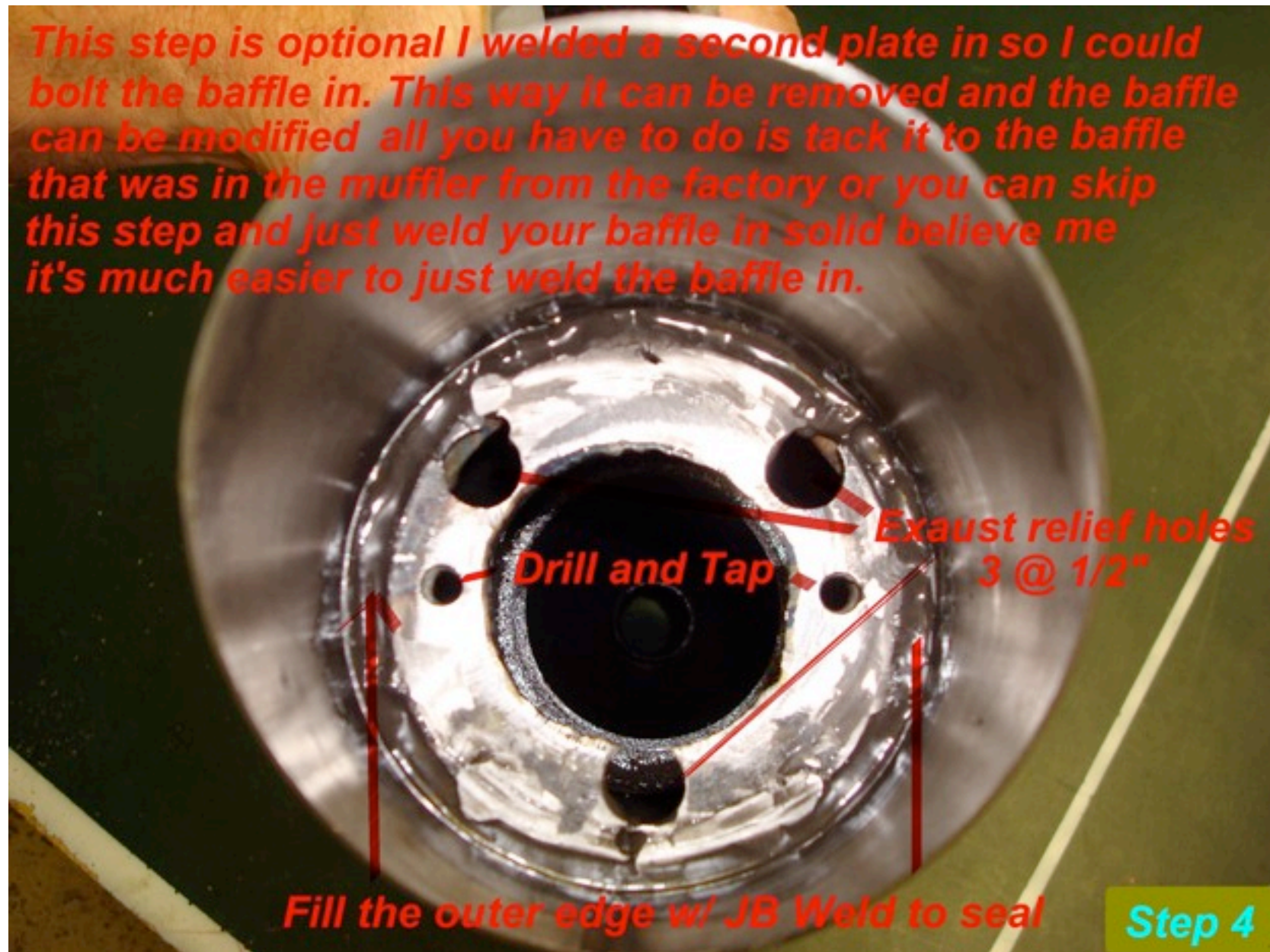
Allow 1 1/4" from edge of pipe to edge of first hole on the inlet end of pipe, This end slides over the tube inside the muffler





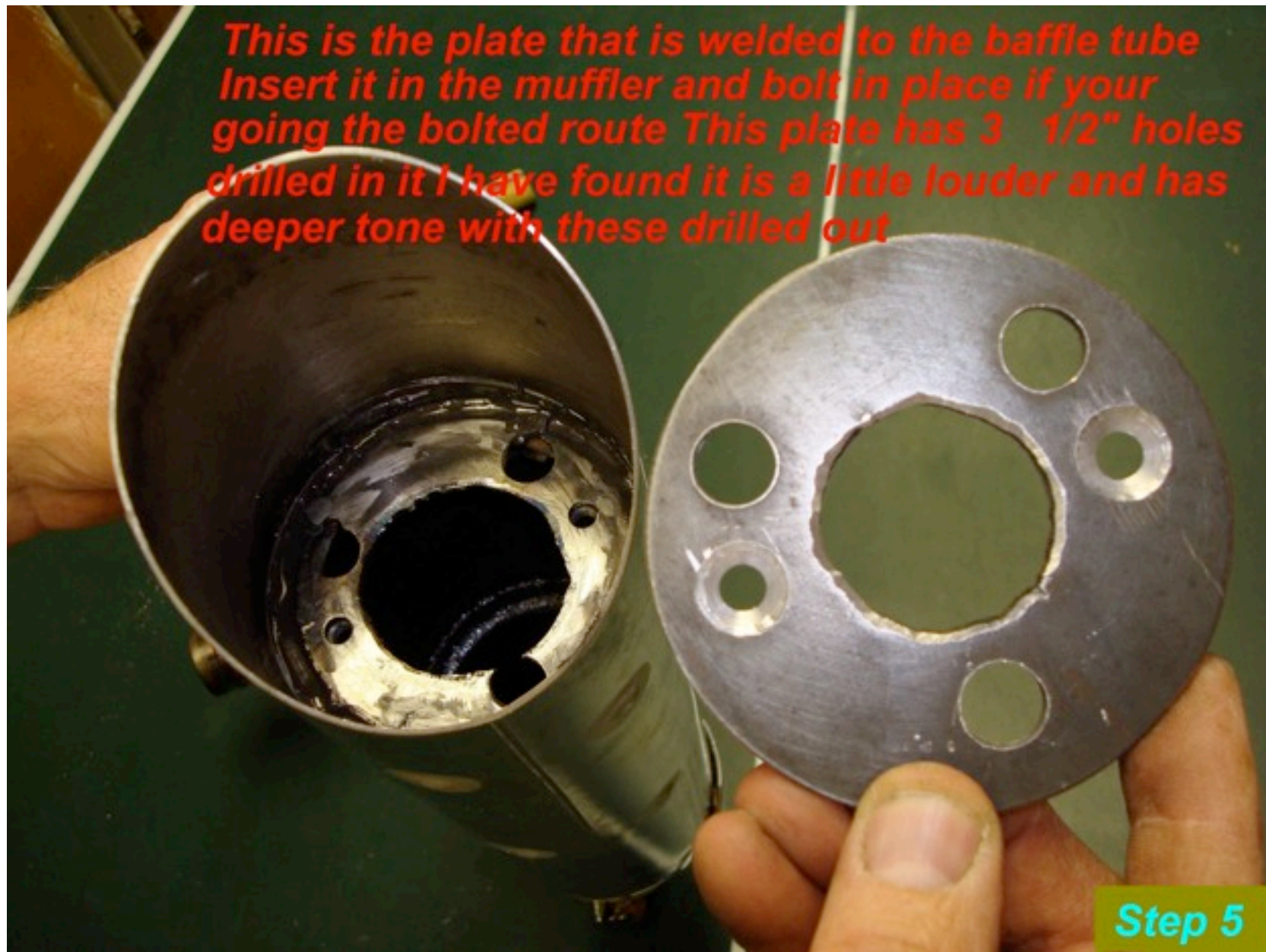
Inside view of plug

This step is optional I welded a second plate in so I could bolt the baffle in. This way it can be removed and the baffle can be modified all you have to do is tack it to the baffle that was in the muffler from the factory or you can skip this step and just weld your baffle in solid believe me it's much easier to just weld the baffle in.



Step 4

**This is the plate that is welded to the baffle tube
Insert it in the muffler and bolt in place if your
going the bolted route This plate has 3 1/2" holes
drilled in it I have found it is a little louder and has
deeper tone with these drilled out**



Step 5




plate in position and ready for the baffle tube

step 6

Insert baffle tube making sure it slides over the tube in the muffler. You can look through the other end to help you guide it in place



Step 7

***baffle in place and spot welded. After you spot weld it in
remove and weld the backside***



Step 8

Removing baffle to weld backside



Step 9

Backside welded. Now it's just a matter of grinding all your welds, making it pretty and paint with high temp paint. If your not doing the bolt in method at this point you can reinsert the baffle and weld in place. After welded in you can seal the outer edge w/ JB Weld then paint

This is what your finished baffle should look like weather you are doing the bolt in or weld in the baffle is still the same other then the small bolt holes in the plate

Step 10

