



## **409S Stainless Steel SYSTEM #817273**

**1964 ½-1966 FORD MUSTANG**  
DOES NOT FIT CONVERTIBLE

05/18/11

### **Removal:**

- 1) Raise the rear of the vehicle and support securely with jack stands.
- 2) Remove the existing system from the header collector or manifold down pipes back.
- 3) The rear seat of the vehicle will have to be removed in order to install the hangers in Step 2.

### **Installation:**

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) Look on the underside of the vehicle on the back side of the rear seat pan. Measure from the frame in towards the center of the car 6 3/4" and make a mark. Then measure from the seam on the back of the seats down along your mark from the frame. Make a mark for your first hole 3/4" down and then make a mark for your second hole 3 1/2" down. Re-check the marks to confirm that they are 6 3/4" from the frame. Center punch both marks and drill them out to a 3/8" hole. These measurements will be the same on both sides. *(Note: See diagram 1 on page 3 of instructions.)*
- 3) Take the stud plate **#244HA** and push them from the inside of the vehicle into the holes you have just drilled. Take hanger assembly **#230HA** for the left side and hanger assembly **#229HA** for the right side and place them over the two bolts protruding through the floor. Secure the hangers to the body using the 3/8" nuts and lock washers provided.
- 4) After mounting the hangers into place, slide the rubber hanger **#HA168** onto the hangers. Place the clamp hanger **#391HA** into the bottom hole of the rubber hanger (both sides take the same clamp hanger.) Both clamp hangers will point towards the center of the vehicle.
- 5) On the frame at the rear of the vehicle there is either a flat plate bolted to the frame or just two holes punched in the frame. Unbolt the flat plate if it is there, then take hanger **#231HA** for the right side and hanger **#232HA** for the left side and mount them in those holes. You can bolt the plate on top of the hangers if you want. Make sure the welded hanger rod is towards the front of the vehicle. Use the 7/16" x 2 1/2" bolt, 7/16" flat washer, 7/16" lock washer and 7/16" nut. Also, place the backing plate **#HA313** on outside of frame for extra support when bolting hangers to the frame on the rear of the vehicle.

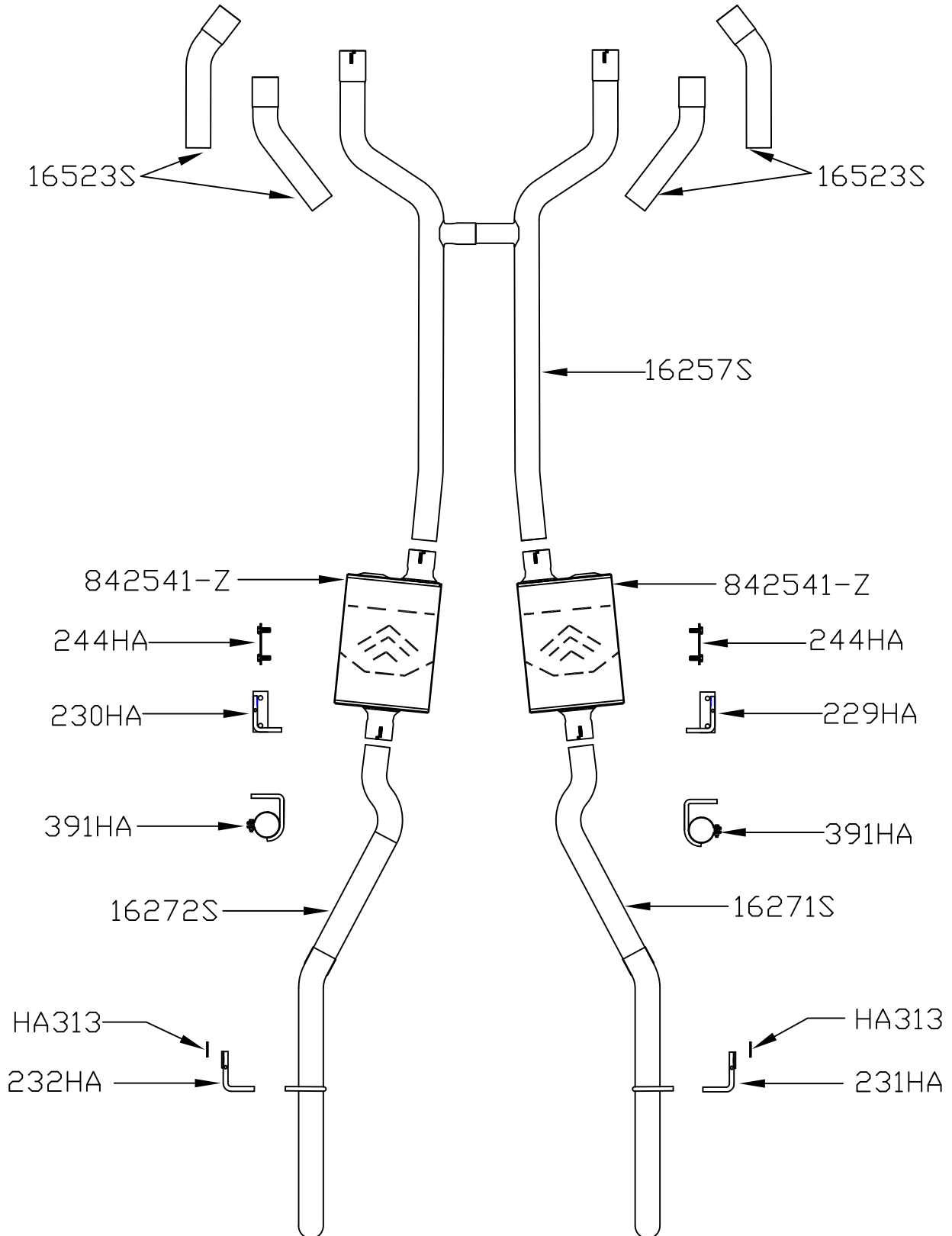
- 6) After mounting the rear hangers in place, slide the rubber hanger **#HA168** onto the hangers. Place the right tailpipe **#16271S** over the rear axle and so that the rear of the tailpipe exits between the fuel tank and the leaf spring. Slide the tailpipe hanger through the rubber hanger attached to the frame.
- 7) Install the left muffler **#842541-Z** by placing the outlet into the clamp hanger **#391HA**, rotate the muffler to get it level and support with a stand. Tighten the clamp/hanger enough to hold the muffler in place, but still allow for adjustment. Repeat for the right side using muffler **#842541-Z**.
- 8) Slide the front of the right tailpipe **#16271S** through the hanger **#391HA** and into the rear of the muffler. Repeat for the left side tailpipe **#16272S**.
- 9) Adjust the rear of the tailpipes so that the angle cut is rotated correctly and is centered between the gas tank and the leaf spring. Repeat this step for both sides of the vehicle.
- 10) Install the front H-pipe assembly **#16257S** by placing the rear of the front pipe assembly into the inlets of both mufflers and centering it in the drive line cavity. Support the front of the assembly with a stand, be sure that the muffler and front pipe assembly are level. Once the mufflers and front pipe assembly are in place, check the hangers at the rear of each muffler to see if they are hanging straight down, adjust the front pipe and the mufflers forward or back as needed to get the correct fit. Once the desired fit is achieved, place a 2 1/2" clamp onto the inlet of each muffler. Tighten enough to hold, but still allow for adjustment.
- 11) It will be necessary to adapt from your existing headers or manifold downpipes to the Flowmaster H-pipe assembly. Due to the many different variables in header/manifold down pipe locations, we have included 4 **#16523S** adapter pipes to aid in the fabrication of the connection between these two areas.
- 12) Remove temporary support and allow the system to suspend on the hangers.
- 13) Adjust the position of all pipes and muffler and tailpipe to provide a satisfactory fit. Maintain a minimum of 1/2" clearance around all parts of the system; while keeping suspension travel and vibration in mind.
- 14) Tighten down all clamped connections securely. Slide the 7/16" hanger keepers onto the end of the two hangers behind the muffler and also onto all round hanger mounts. These will prevent the rubber hangers from sliding off.
- 15) For a more secure installation, we recommend welding all slip-fit connections.



Installation diagram for:  
**SYSTEM #817273**  
1964 1/2 - 1966 FORD MUSTANG  
DOES NOT FIT CONVERTIBLE

# FORCE II™

409S Stainless Steel



## PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
2	Muffler	842541-Z
4	Adapter Pipes	16523S
1	H-pipe Assembly	16257S
1	Right Tailpipe	16271S
1	Left Tailpipe	16272S
1	Parts Kit	PK545
2	Muffler Hanger	391HA
1	Top Right muffler Hanger	229HA
1	Top Left Muffler hanger	230HA
1	Right Tailpipe Hanger	231HA
1	Left Tailpipe Hanger	232HA
2	Muffler Mounting Plate	244HA
4	2 1/2" Clamp	MC250BS
4	Rubber Hanger	HA168
2	Backing plates	HA313
8	7/16" Hanger Keepers	
4	7/16" x 2 1/2" Bolts	
4	7/16" Nuts	
4	7/16" Flat Washers	
4	7/16" Lock Washers	
4	3/8" Nuts	
4	3/8" Lock Washers	

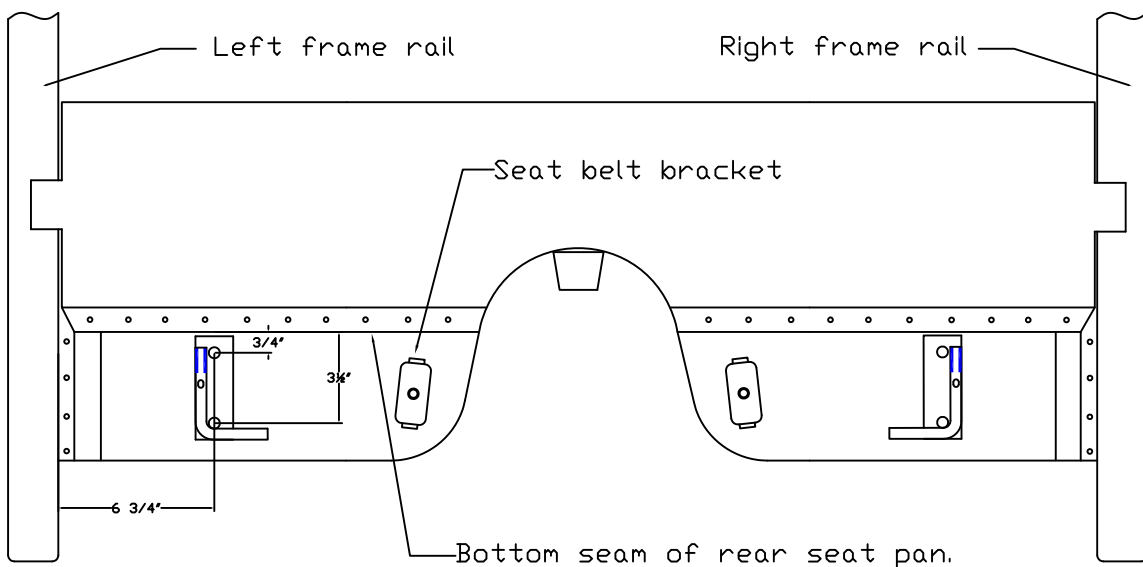


Diagram of installation step 1.