



FORCE II™
409S Stainless Steel
SYSTEM #817345
1999-2004 FORD F-250 & F-350 TRUCKS
V8 & V10 ENGINES

06/21/11

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height. If you do not have access to a hoist or rack raise the vehicle and support securely with jack stands.
- 2) Loosen the 3" band clamp, first one forward from front of muffler and slip muffler and tailpipe off. *(You may need to heat this connection with a torch to make removal easier.)* To remove system in one piece, remove the bottom bolt from the right rear shock and pull the shock to the rear to clear the tailpipe. Or you can cut the tailpipe just behind the muffler and remove the system in two pieces.
- 3) Using a pry bar, separate the four rubber hangers that support the stock exhaust system, one in front of the muffler, two directly behind the muffler and one at the rear of the tailpipe. A lubricant such as WD40 or lithium grease will ease separation.
- 4) Carefully remove the stock tailpipe and muffler from the vehicle and set aside.

Installation:

- 1) Connect the hanger/clamp assembly **#397HA** to the two rubber mounts on the vehicle where the stock muffler hangers were located.
- 2) Install inlet pipe **#TB315S** onto the back of the stock inlet pipe and clamp using the 3" clamp provided. Tighten enough to hold, but still allow for adjustment.
- 3) Slip the inlet of the muffler **#853073** onto the back of the inlet pipe **#TB315S** and install the 3" clamp provided. Place the rear of the muffler into the clamp hanger **#397HA**. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.
- 4) Insert tailpipe **#26167S** into the outlet of the muffler, then slide on clamp hanger **#278HA** around back of tailpipe and into the stock hanger mount on the vehicle. Tighten down both clamp hangers enough to hold, but still allow for adjustment.
- 5) Place stainless tip **#ST429** onto the back of tailpipe **#26167S** and rotate tip to desired position. Tighten clamp enough to hold, but still allow for adjustment.
- 6) Adjust the position of the muffler and tailpipe to provide adequate clearance for suspension travel. Maintain a minimum of 3/4" clearance between the Flowmaster system and the drivetrain and chassis components.

7) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the hanger rods on the tailpipes and slide the 1/2" hanger keeper onto the hanger welded to the rear of the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.

8) For a more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet pipe	TB315S
1	Muffler	853073
1	Tailpipe	26167S
1	Stainless Tip	ST429
1	Part kit	PK542
1	Clamp Hanger	278HA
1	Clamp Hanger	397HA
2	3" Clamps	MC300BS
2	7/16" Hanger keeper	HW502
1	1/2" Hanger Keeper	HW503



Installation diagram for:
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