



## **409S<sup>®</sup> Stainless Steel SYSTEM #817480**

**2005-2009 DODGE MAGNUM RT/CHARGER RT/CHRYSLER 300C**  
5.7L HEMI V-8 · INCLUDES ALL WHEEL DRIVE

12/04/09

### **Removal:**

- 1) Raise vehicle and support securely with stands. To ease the removal of the stock system, spray a penetrating lubricant onto the rubber hangers.
- 2) Using a 13mm socket unbolt the left tailpipe assembly at the flanged connection at the rear of the muffler. Slide the three hanger rods out of the rubber mounts on the vehicle and remove the left tailpipe assembly
- 3) Then using a 13mm socket, unbolt the body brace between the catalytic converters and the muffler assembly. (Save this brace and the four nuts for reinstallation after the Flowmaster system is installed)
- 4) Support the right side muffler with a stand, then using a 15mm socket, loosen the clamps at the slip fit connections behind the catalytic converters. Remove the three remaining hanger rods from their rubber mounts on the vehicle and slide the system back off of the head pipes.

### **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) Begin by placing supplied clamp **#MC250BS** onto each of the slip fits of Scavenger pipe **#16466S**. Then place the Scavenger pipe onto the back of the stock head pipes (make sure the Flowmaster embossing is facing the ground). Level and center the assembly in the drive line tunnel and support with a stand. Tighten the two clamps enough to hold but still allow for adjustment. Then reinstall the body brace using the nuts removed in Step 3 (make sure there is clearance between the Scavenger pipe and the cross-member).
- 3) Place a supplied clamp onto the inlet of each muffler **#852546-Z**. Then slide the mufflers onto the back of the Scavenger pipe assembly. Level the mufflers and tighten the clamps enough to hold but still allow for adjustment.
- 4) Place a supplied clamp onto the left muffler outlet, then place left tailpipe **#16594S** into position and slide the hangers into the factory rubber mounts. Slide tailpipe into the muffler outlet. Rotate so hangers are level and tighten clamp enough to hold but still allow for adjustment. Repeat this step for right tailpipe **#16593S**.

- 5) Take the stainless tips **#ST339** and slide them onto the outlets of the resonators that are part of the tailpipes. Adjust to satisfactory fit and tighten enough to hold but still allow for adjustment.
- 6) Reinstall the body brace that was removed in step 3 using the original bolts.
- 7) Adjust the position of all the pipes and mufflers to provide a satisfactory fit. A minimum of 1/2" clearance around all parts of the system must be maintained; while keeping suspension travel and vibration in mind. Pay close attention to the area around the body brace. It is best to jack, or lift up the scavenger pipe assembly before tightening the system up to ensure proper clearance. After all adjustments have been made, you may now securely tighten all clamps.
- 8) After the system is secure, slide the 7/16" hanger keepers onto the ends of the hangers located at the rear of the vehicle. These will prevent the hangers from slipping out of the rubber mounts.
- 9) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help prevent surface rust and premature corrosion.

### **PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
2	Mufflers	852546-Z
1	Scavenger Assembly	16466S
1	Left Tailpipe	16594S
1	Right Tailpipe	16593S
2	Stainless Tips	ST339
1	Parts Kit	PK508
6	2 1/2" Clamp	MC250BS
6	7/16" Hanger Keepers	HW502



Installation diagram for:

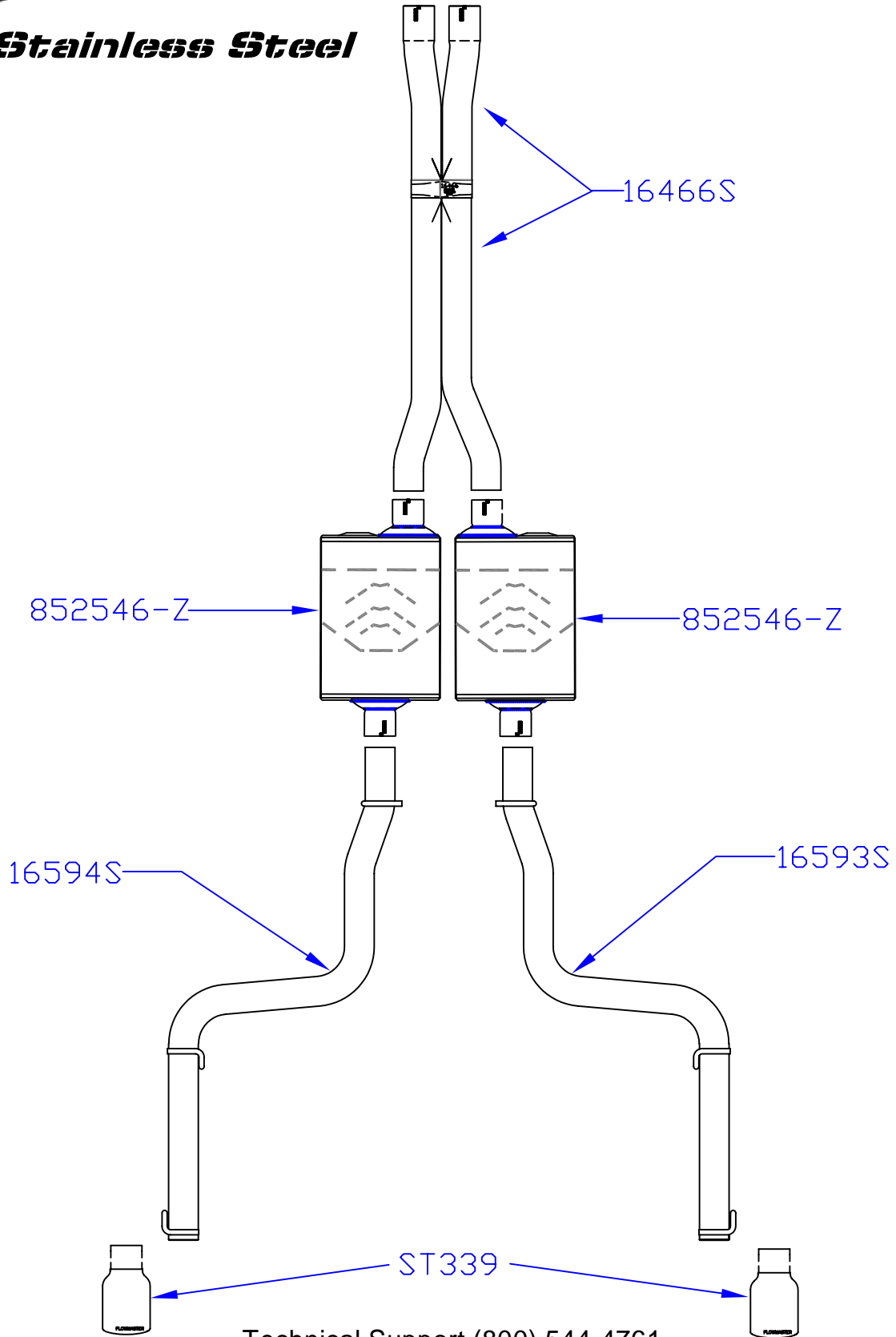
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THUNDER**

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Technical Support (800) 544-4761