



FORCE II

409S® Stainless Steel

SYSTEM #817422

2005-2007 FORD F250 / F350

V8 & V10 ENGINES · FITS ALL WHEELBASES INCLUDING CREWCAB

08/08/11

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) Support the muffler with a jackstand or muffler stand to support it when the hangers are removed from the rubber mounts.
- 3) 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 the 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.
- 4) 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.
- 5) Carefully remove the stock tailpipe and muffler from the vehicle and set aside.

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) Connect the hanger/clamp assembly **#409HA** to the two factory rubber mounts on the vehicle where the stock muffler hangers were located.
- 3) Install inlet pipe **#TB479S** onto the back of the stock inlet pipe and clamp using a provided 3" clamp. Tighten just enough to hold in position.
- 4) Slip the inlet of the muffler **#853073-Z** onto the back of the inlet pipe **#TB479S** and install the hanger/clamp assembly **#408HA** into the factory rubber hanger. Place the rear of the muffler into the clamp hanger **#409HA**. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.

- 5) Insert tailpipe **#26167S** into the outlet of the muffler and slide on clamp hanger **#337HA** around the back of the tailpipe and into the stock hanger mount on the vehicle. Tighten down both clamp hangers enough to hold in place, but still allow for adjustment.
- 6) Place stainless tip **#ST429** onto the back of tailpipe **#26167S**. Rotate the tip to the desired position and tighten clamp enough to hold in place, but still allow for adjustment.
- 7) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.
- 8) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the clamp hanger at the rear of the muffler. Slide the 1/2" hanger keepers onto the hanger welded to the rear of the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.
- 9) 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	TB479S
1	Muffler	853073-Z
1	Tailpipe	26167S
1	Stainless Tip	ST429
1	Part kit	PK553
1	Clamp Hanger	409HA
1	Clamp Hanger	408HA
1	Clamp Hanger	337HA
2	3" Clamps	MC300BS
2	7/16"Hanger Keeper	HW502
1	1/2" Hanger Keeper	HW503



Installation diagram for:
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