



FORCE II™
SYSTEM #17411
2003-2006 FORD EXPEDITION
V8 ENGINES

02/21/14

Removal:

- 1) Disconnect the negative side of your battery cable. 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 jack stand or muffler stand to support it when the hangers are removed from the factory rubber mounts.
- 3) To remove the stock tailpipe, loosen the factory band clamp using a 15mm socket or wrench, then using a pry bar remove the factory rubber hanger and slide tailpipe off and set aside. *(Note: A lubricant or lithium grease will make removal of all factory rubber hangers easier)* Save the factory rubber hanger it will be reused in Step 4 of installation. Using a 15mm socket or wrench remove the four nuts on the sway bar and set aside. Swing the sway bar down and let it hang out of the way.
- 4) Next using a pry bar, separate the factory rubber hanger that supports the stock exhaust system directly behind the muffler. Using a hacksaw or sawsall cut the stock over-axle pipe behind the muffler and carefully remove it by sliding it towards the front of the vehicle and set aside.
- 5) Remove the two factory rubber hangers on the inlet pipe assembly. Next using a 14mm socket unbolt the two bolt flanged connection and carefully remove the stock muffler and inlet pipe assembly 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) Install the supplied inlet pipe assembly **\$480TB** onto the stock flanged connection reusing the two factory bolts. Slide both hangers welded to the pipe into the factory rubber hangers on the vehicle. Tighten the flanged connection using a 14mm socket enough to hold, but still allow for adjustment.
- 3) Place a supplied **#MC300G** clamp over the inlet of the muffler **#53051**. Slide the muffler onto the back of the inlet pipe **#480TB** and support with a stand. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.

- 4) Place a supplied **#MC300G** clamp over the outlet of the muffler. Insert the supplied over-axle pipe **#26240** into the outlet of the muffler and into place over the rear axle. Slide the hanger welded to the pipe into the stock hanger mound on the vehicle. Tighten down the clamp on the outlet enough to hold in place, but still allow for adjustment.
- 5) Place a supplied **#MC300G** clamp over the slip-fit end of the **#26241** exit pipe. Slide the exit pipe over the back of the over-axle pipe installed in Step 3 and slide the factory rubber mount removed in Step 3 of removal back onto the vehicle and onto the hanger welded to the exit pipe. Tighten down the clamp enough to hold in place, but still allow for adjustment.
- 6) Place stainless tip **#ST429** onto the back of the exit pipe **#26241** rotate tip to desired position and tighten tip using a 7/16" socket and wrench enough to hold in place, but still allow for adjustment. We recommend welding two half inch welds onto the tip/tailpipe/exit pipe to prevent loss of tip after final adjustment.
- 7) 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.
- 8) Tighten down all clamped connections securely. After the system is secure, slide the hanger keepers onto the hanger welded to the inlet pipe assembly **#480TB** and the over-axle pipe **#26240**. This 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 to prevent surface rust and premature corrosion.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe	480TB
1	Muffler	53051
1	Over-axle Pipe	26240
1	Exit Pipe	26241
1	Stainless Pipe	ST429
1	Parts Kit	PK478
3	3" Clamps	MC300G
3	1/2" Hanger Keepers	HW503



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Installation diagram for:
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