



FORCE II™

Installation Instructions for:
SYSTEM #17475
1999-2006 CHEVROLET/GMC C/K 1500 TRUCK
4.8L & 5.3L EXTENDED CAB, SHORT BED

12/08/09

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height and support securely with jack stands.
- 2) Using a hacksaw or sawsall, cut the stock tailpipe off where it exits the muffler. (This step is not mandatory, but will make removal easier.)
- 3) Separate the two wire hangers on the tailpipe from the rubber mounts on the vehicle. Remove the tailpipe and set aside.
- 4) Support the muffler with a stand, then separate the wire hanger from the rubber mount in front of the muffler.
- 5) Remove the two nuts at the muffler to cat flange connection. Remove the muffler 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) Place the resonator assembly **#15109** in position behind the catalytic converter. Connect the wire hanger to its rubber mount and re-install the factory nuts on the flange connection and tighten securely.
- 3) Connect the inlet of muffler **#530712** to the inlet pipe. Use a stand to support the muffler and install a 3" clamp. Tighten enough to hold in place, but allow for adjustment.
- 4) Using the provided bolts, washers, nuts and backing plate **#HA226**, mount tailpipe hanger bracket **#226HA** to the frame on the left side of the vehicle using the angled oblong hole on the frame rail. Repeat this step on the right side of the vehicle using hanger bracket **#227HA**. (*They bolt approximately in the same position on either side of the vehicle.*) Slide the rubber hanger **#HA168** onto the ends of the hanger brackets. Remove the rubber hanger from the stock mount.
- 5) Place tailpipe **#16429** in position over the rear axle and slip into the right side muffler outlet. Connect the hanger welded to the rear of the pipe to the rubber hanger **#HA168** installed in Step 3. Pipe should be approximately 3/4" away from the shock when adjusted. Repeat for the left side using tailpipe **#16248** and center between the shock and the spare tire.
- 6) Connect hanger **#228HA** to the rubber mount behind the muffler and clamp to the left side tailpipe.

- 7) Connect exit pipes **#16317 or #16397** to the ends of both tailpipes and place a provided 2 1/2" clamp onto these connections. Tighten enough to hold but still allow for adjustment. Place the two stainless tips onto the exit pipes and tighten the clamps enough to hold but still allow for adjustment. Rotate the exit pipes and tips to position and tighten just enough to hold in place.
- 8) Adjust the position of all pipes and muffler to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind.
- 9) Tighten all clamped connections down securely. Place the supplied 1/2" hanger keepers onto the end of the inlet pipe and rear muffler hanger. Slide the 7/16" hanger keepers on to the rear tailpipe and frame hangers and slide them up to the rubber mounts to firmly hold the system in place.
- 10) To prevent the rear axle breather tube from contacting the left side tailpipe, and possibly being damaged, use the enclosed **zip tie** to fasten the rear axle breather tube to the brake line bracket located on the frame. Be sure to allow enough slack in the hose for the suspension to fully compress and extend.
- 11) 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	15109
1	Muffler	530712
1	Tailpipe, Right	16249
1	Tailpipe, Left	16248
2	Side Exit Pipe, (R/L)	16317
2	Rear Exit Pipe, (R/L)	16397
2	Stainless Tips	ST396
1	Parts kit	PK344
1	Frame Hanger, Left	226HA
1	Frame Hanger, Right	227HA
1	Rear Muffler Hanger	228HA
2	Rubber Hanger	HA168
2	Backing Plate	HA226
4	2 1/2" Clamps	MC250S
1	3" Clamp	MC300G
2	3/8" X 1" Bolts	
2	3/8" Nuts	
2	3/8" Lock Washers	
2	3/8" Flat Washers	
1	Plastic Zip tie	
4	7/16" Hanger Keepers	
2	1/2" Hanger Keeper	



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Installation diagram for:
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