



**409S® Stainless Steel**  
**SYSTEM #817390**  
**1968-1970 MOPAR "B" BODY**  
**2 1/2" HEADER BACK SYSTEM**

06/05/12

**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) On the inside of the rear frame rails, roughly 10" forward of the bumper, you will find holes that will be used to mount the tailpipe hanger brackets. You should see a square hole with a round hole just below it. Carefully place the 3/8" bolts through the square hole and back so that they stick out of the round hole. Place the hanger brackets **#310HA** (left side) and **#311HA** (right side) onto the bolts and secure with nuts and lock washers. Slide a rubber hanger **#HA168** onto each of the hanger mounts.
- 3) On the right rear section of the floor pan, just ahead of the rear axle, there is a factory hanger bracket spot welded in place. Fasten the hanger mount **#309HA** to the inner side of the bracket with a 3/8" bolt washer and nut. Slide rubber hanger **#HA168** onto the hanger mount. Slide clamp hanger **#447HA** into the bottom hole of the rubber hanger. The hanger rod should be inserted from the inside, out. (See diagram.)
- 4) On factory single exhaust vehicles on the left side there are no factory locations for a hanger, so you will need to drill some holes (*on factory dual exhaust vehicles use factory holes and bolt up hanger #318HA*). Take the hanger mount **#308HA** and try to mirror the location of the right hanger as close as you can. Mark the two hole locations and drill the pan with a 3/8" bit. Now you must go inside the vehicle and remove the rear seat. Go back and fasten the hanger mount in place with **#244HA** through the holds and replace the seat. Fasten the hanger mount in place with 3/8" nuts and washers. Slide a rubber hanger **#HA168** onto the hanger mount. Then slide clamp hanger **#447HA** into the bottom hole of the rubber hanger. The hanger rod should be inserted from the inside, out.
- 5) Place the mufflers up into position and support with stands, then place the outlets of the mufflers into the clamp hangers and tighten just enough to hold in position.
- 6) Slide a 2 1/2" clamp over each muffler inlet, then place H-pipe assembly **#16424S** in its approximate position underneath the vehicle and connect the back of H-pipes into the muffler inlets and support with a stand. Tighten the clamp just enough to hold in position.
- 7) Place both tailpipes **#16425S** and **#16426S** up over the rear axle and into the outlets of the mufflers. Slip the hanger rods at the rear of the pipes into the rubber hangers that were installed in Step 2.

- 8) The front connector pipes **#16421S** and **#16422S** are long enough to allow for many different header combinations, therefore, it is necessary to determine the proper length of the connector pipes. Once the proper length is determined, trim the front connector pipes to fit.
- 9) Once the connector pipes are cut to proper length, raise them into position and connect them to the H-pipe and header collectors or manifold down pipes using a standard header flange, Flowmaster Venturi Cone or Flowmaster Ball Flange kit.
- 10) 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.
- 11) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers on the round stock sticking through the rubber hangers. This will prevent the hangers from slipping out of the rubber mounts.
- 12) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

### Packing List

<u>Qty</u>	<u>Description</u>	<u>Part</u>
2	Muffler	852546-Z
1	Connector Pipe, (L)	16422S
1	Connector Pipe, (R)	16421S
1	H- Pipe Assembly	16424S
1	Left tailpipe	16426S
1	Right tailpipe	16425S
1	Parts kit	PK632
4	2½" Clamps	MC250BS
2	Muffler Clamp Hanger (R/L)	447HA
1	Muffler Hanger Mount (L)	318HA
1	Muffler Hanger Mount (L)	308HA
1	Muffler Hanger Mount (R)	309HA
1	Tailpipe Hanger Mount (L)	310HA
1	Tailpipe Hanger Mount (R)	311HA
1	Hanger Mounting Plate	244HA
4	Rubber Hanger	HA168
4	3/8"x 1" Bolt	HW208
5	3/8" Flat Washer	HW303
5	3/8" Lock Washer	HW309
5	3/8" Nuts	HW103
8	7/16" Hanger Keepers	HW502



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**Installation diagram for:  
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