



FORCE II
409S® Stainless Steel

Installation Instructions for:
SYSTEM #817446
2008-2010 FORD F250, F350 TRUCKS SUPERDUTY
FITS V8 & V10 ENGINES · ALL W.B.

10/04/11

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 jack stand or muffler stand when the hangers are removed from the rubber mounts.
- 3) Loosen the 3" band clamp, first one forward from the front of the muffler, and slip the muffler and tailpipe off. You may need to heat this connection with a torch to make removal easier. Please be extremely careful when using the torch. 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) Then 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 removal.
- 5) Carefully remove the stock tailpipe and muffler from the vehicle and set aside.

Installation:

- 1) Connect the hanger/clamp assembly **#400HA** to the two factory rubber mounts on the vehicle where the stock muffler hangers were located at the rear of the muffler.
- 2) Install inlet pipe **#TB536S** onto the back of the stock inlet pipe, then place clamp/hanger assembly **#399HA** over the back of the inlet pipe and connect to the rubber mount on the vehicle. Tighten the clamp just enough to hold the pipe in position.
- 3) Place the provided 3" clamp onto the inlet of muffler **#8530580-Z**, then slide the muffler onto the back of inlet pipe **#TB536S**. Place the rear of the muffler into the clamp hanger **#400HA**. The muffler will be in a vertical position. Tighten the clamp on the inlet just enough to hold in position.
- 4) Insert tailpipe **#26260S** into the outlet of the muffler and then slide the hanger on the tailpipe into the stock hanger mount on the vehicle. Tighten down the clamp hanger just enough to hold in position.
- 5) Place stainless tip **#ST429** onto the back of tailpipe **#26260S**. Rotate tip to desired position and tighten the clamp just enough to hold in position.

- 6) Adjust the position of the muffler and tailpipe to provide adequate clearance for suspension travel. Maintain a minimum of 3/4" clearance between Flowmaster system and the drivetrain and chassis components.
- 7) 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. Also, slide the 1/2" hanger keeper onto the clamp hanger at the muffler inlet pipe. This will prevent the hangers from slipping out of the rubber mounts.
- 8) 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	TB536S	
1	Muffler	8530580-Z	
1	Tailpipe	26260S	
1	Stainless Tip	ST429	
1	Part kit	PK536	
	1	Rear Clamp Hanger	400HA
	1	Front Clamp Hanger	399HA
	1	3" Clamp	MC300BS
	2	7/16"Hanger Keeper	HW502
	1	1/2" Hanger Keeper	HW503



Installation diagram for:
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