



FORCE II™

409S Stainless Steel

Installation Instructions SYSTEM #817510 2005-2009 FORD MUSTANG V6 ENGINE

04/22/13



1) Loosen the 15mm nut on the clamped connection between the muffler and over-axle pipe and also the over-axle pipe to the factory Y-pipe.



2) Unbolt the mounting brackets that mount the muffler to the frame (these are the two that connect the hangers on the *muffler body* to the frame). The mount connecting the hanger welded to the *inlet pipe* should remain bolted to the frame. Once these two hangers are unbolted, lower the muffler from the vehicle. Do not discard the OEM mounting brackets or hardware as they will be used in the installation of the new system. Lower the factory over-axle pipe from the vehicle and set aside.



3) To install the new Flowmaster Scavenger X-pipe assembly **#16676S**, the factory Y-pipe must be removed. To do this, measure back 14.00" from the weld at the rear of each of the catalytic converters and make a mark on both pipes. Be sure to double check that the measurements are correct and cut both pipes on the marks. Remove any burrs.



4) Because there is no cutout in the rear valance for the left side tailpipe, it will be necessary to make a new cutout. Follow the instructions on the attached template to properly align and make the cutout.



5) Place a 2¼" band clamp onto the inlets of the new Scavenger X-pipe assembly **#16676S**. Place the assembly up into position and fully slide onto the back of the factory front pipes, support the rear of the assembly with a stand. Tighten the clamps enough to hold but still allow for adjustment. Flowmaster embossing should be facing the ground. Note: Some vehicles may have hangers located under the crossmember that will interfere with the scavenger pipe installation. These hangers will need to be cut or ground off.



6) Place a 2¼” clamp onto the slip-fit of over-axle pipe **#16679S** and slide onto the back of the right Scavenger outlet and support with a stand. Repeat this step with the left over-axle pipe **#16680S**.



7) Install the OEM hanger bracket removed from the rear of the factory muffler **#852467-229**. Place the muffler up into position and connect the muffler inlet to the over-axle pipe. Bolt the hanger bracket to the frame using the OEM hardware. Connect the hanger on the front of the muffler to the factory mount on the vehicle.



8) Install the OEM hanger bracket removed from the front of the factory muffler onto the rear hanger of muffler **#852467-230**. Place the muffler up into position and connect the muffler inlet to the over-axle pipe. Bolt the hanger bracket to the frame using the OEM hardware.



9) Place the **HA168** rubber hanger onto the hanger welded to the front of the muffler. Connect hanger assembly **#415HA** to the rubber mount and secure to the existing hole in the frame using the supplied 5/16” x 1” thread cutting bolt.

10) Adjust the position of all pipes and mufflers to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

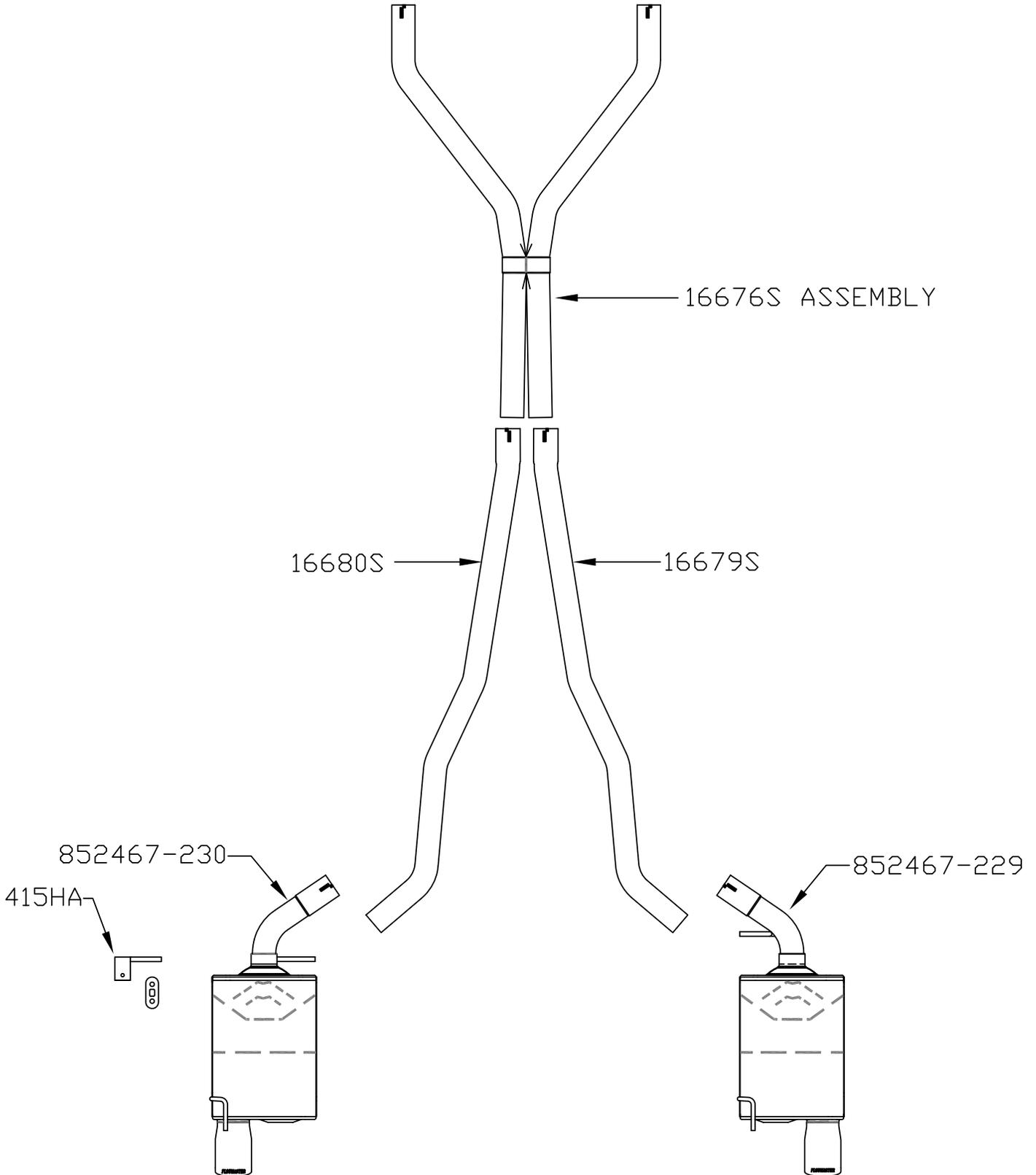
<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Left Muffler Assembly	852467-230
1	Right Muffler Assembly	852467-229
1	Scavenger Assembly	16676S
1	Left Intermediate Pipe	16680S
1	Right Intermediate Pipe	16679S
1	Parts Kit	PK576
1	Frame Hanger	415HA
6	2¼” Band Clamp	MC225BS
2	3/8” Hanger Keepers	HW501
2	7/16” Hanger Keepers	HW502
1	5/16” x 1” Bolt	HW229
1	Rubber Hanger	HA168



Installation diagram for:
SYSTEM #817510
2005-2009 MUSTANG
V6 ENGINE

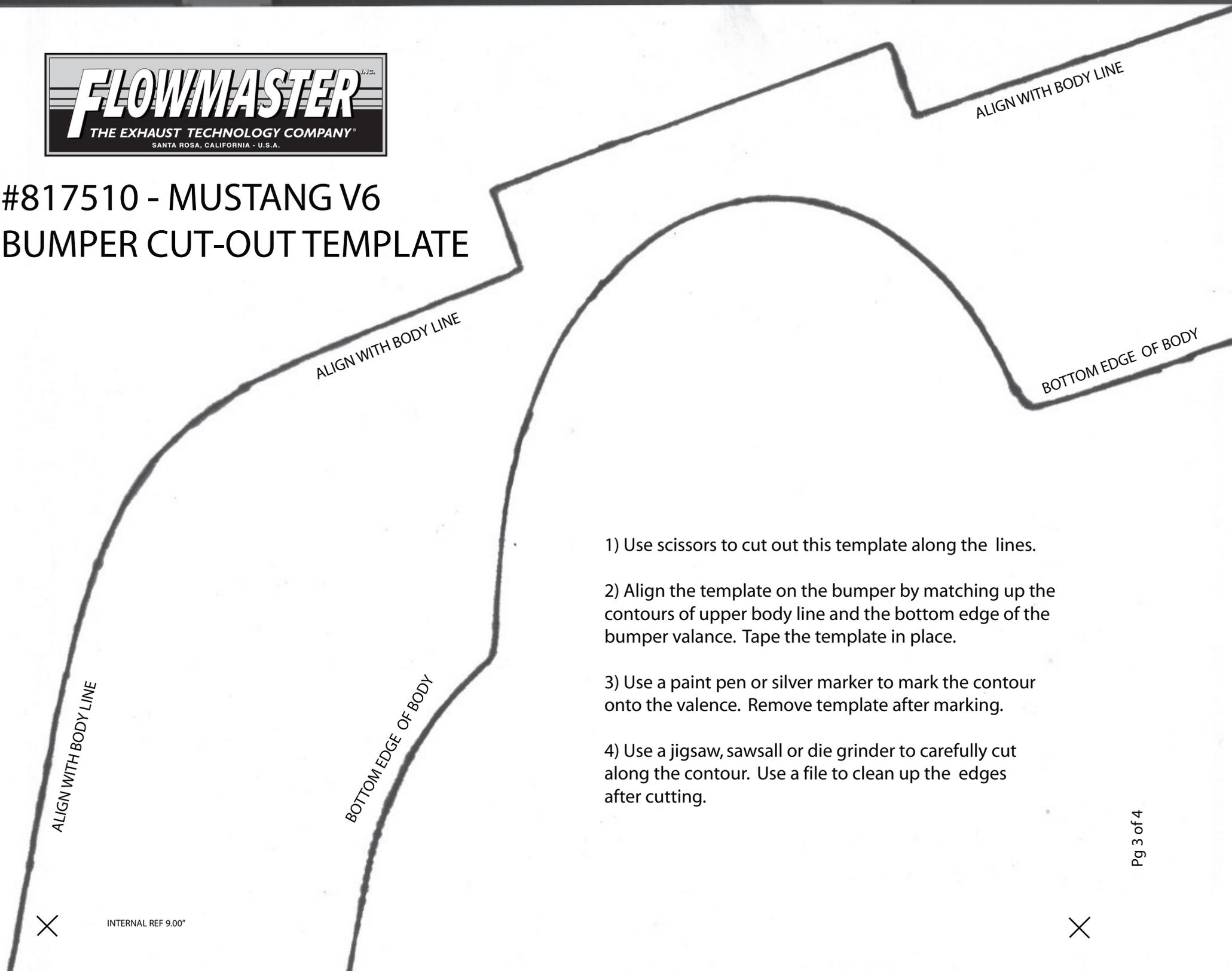
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#817510 - MUSTANG V6 BUMPER CUT-OUT TEMPLATE



ALIGN WITH BODY LINE

ALIGN WITH BODY LINE

BOTTOM EDGE OF BODY

ALIGN WITH BODY LINE

BOTTOM EDGE OF BODY



INTERNAL REF 9.00"



- 1) Use scissors to cut out this template along the lines.
- 2) Align the template on the bumper by matching up the contours of upper body line and the bottom edge of the bumper valance. Tape the template in place.
- 3) Use a paint pen or silver marker to mark the contour onto the valance. Remove template after marking.
- 4) Use a jigsaw, sawsall or die grinder to carefully cut along the contour. Use a file to clean up the edges after cutting.