



409S, Stainless Steel

Installation Instructions for: **SYSTEM #817551**

2010-2014 FORD F-150 TRUCK

FITS: 6.2L · V8 ENGINE

SUPER CAB & SUPER CREW MODELS WITH 5.5' BED ONLY

12/05/14

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) Begin by applying a lubricant to each of the rubber hanger mounts, as well as the clamp and flange bolts. This will make the removal and installation process much easier.
- 3) Remove the two bolts at the front flange connection and loosen the band clamp connection that is behind it on the inlet pipe. There is locking pin at this joint, to separate it you will have to slide the muffler assembly back a little bit, twist the front inlet pipe clockwise, and then you can slip the front inlet pipe back to remove.
- 4) Now you can slide the muffler tailpipe assembly to the rear to disengage the rubber hanger mounts that support it. Once free, the assembly can be removed by working it forward over the rear axle. (If you are working on the ground it may be easier to cut the tailpipe off at the rear of the muffler to simplify removal.)

Installation:

- 1) Depending on your cab/bed configuration, the inlet pipe **#36046S** may need to be trimmed to accommodate the difference in wheelbase length. Double check all measurements before cutting your inlet pipe:

Super Cab

5.5' Bed = Trim 12.0" off the rear of inlet pipe.

Super Crew

5.5' Bed = No trim of the inlet pipe required.

- 2) Place the inlet pipe onto the back of the existing OEM head pipe and fasten using the nuts, bolts and washers provided in the hardware kit. Tighten just enough to hold in place, but still allow for adjustment. The S-shaped pipe will be offset toward the frame of the vehicle.
- 3) Slide clamp hanger **#445HA** over the back of the inlet pipe and insert the hanger into the factory rubber mount. Do not tighten this clamp yet. **Note:** Super Crew Models: The front frame hanger must be moved slightly forward and down from its current location. Remove the bolts and move the clips to the set of mounting holes just forward and down from its current location. Re-secure the hanger to the frame.

- 4) Place the inlet of muffler **#853557-Z** thru the **#445HA** clamp hanger and onto the inlet pipe, support with a stand. Level the muffler and tighten the clamp just enough to hold in position, while still allowing for adjustment.
- 5) Slide a 3.50" clamp onto the muffler outlet neck. Place tailpipe **#36047S** into position over the axle and insert the hanger at the front and rear of the pipe into the rubber mounts on the vehicle and slide into the muffler outlet. Tighten the clamp just enough to hold, while still allowing for adjustment.
- 6) Adjust the position of all the pipes and muffler to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while keeping suspension travel and vibration in mind. After adjustments have been made, securely tighten all clamps and install the 2 7/16" hanger keepers onto the hanger rods.
- 7) 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	36046S
1	Muffler	853557-Z
1	Tailpipe	36047S
1	Parts Kit	PK626
1	Clamp Hanger	445HA
1	3½" Band Clamp	MC350BS
2	3/8"-16 x 3 1/2" Bolt	HW234
2	3/8" Nut	HW103
2	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309



Installation diagram for:
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**AMERICAN
THUNDER**

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