



# FORCE II™

**409S Stainless Steel**

Installation Instructions for:

**SYSTEM #817552**

**2012-2015 FORD FOCUS**

2.0L ENGINE · \*HATCHBACK ONLY\*

03/11/15

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the two front flange bolts as well as the rubber hanger mounts that support the system. This will greatly ease removal of the factory system.



2) To remove the factory exhaust system you will have to cut the system in half. Cutting just behind the round resonator in the center of the system will allow both halves of the system to be removed easily. After cutting, support the rear muffler with a stand and remove the three hangers on this section from their rubber mounts. You can now lower this section from the vehicle. This section may take some turning and twisting to get the pipe over the rear axle.



3) In front of the large center muffler, remove the two nuts at the flanged connection just behind the flex joint. Then remove the two bolts from the steel body brace behind the large muffler. Once unbolted, remove the hanger on this section from the rubber mount on the vehicle and lower from the vehicle and set aside. Save the gasket from between the two flanges for use with the Flowmaster system.



4) Using the 7/16" bolts, nuts and washers provided, bolt resonator assembly **15163S** to the back of the flex pipe flange. Be sure to replace the gasket. Support with a stand. Then reinstall the steel body brace removed in the previous step and tighten securely.



5) Place a supplied clamp onto the expanded end of pipe **#16738S** and slide onto the back of the resonator. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp just enough to hold, but still allow for adjustment.



6) Place a supplied clamp onto the expanded end of over-axle pipe **#16739S** and slip it onto the back of pipe **#16738S**. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold, but still allow for adjustment. **Note:** On 2014 model vehicles, the rubber hanger mount that would accept the hanger on pipe **#16739S** has been omitted from the vehicle, therefore this hanger will not be used.



7) To install muffler inlet pipe **#16740S**, remove the two bolts that attach the drivers' side muffler hanger to the frame, turn the hanger 180 degrees so that it is pointing to the outside of the vehicle and reinstall. Place a supplied clamp onto the expanded end of pipe **#16740S**. Connect the hanger on the pipe to the rubber mount on the vehicle then slide onto the back of pipe **#16739S**. Tighten the clamp enough to hold, but still allow for adjustment.



8) Place a provided clamp onto the inlet of muffler **#842453-Z** and connect to the end pipe **#16740S**. Level the muffler and support with a stand. Tighten the clamp enough to hold the muffler in position.



9) Place the wire hanger of clamp hanger **#440HA** into the rubber mount on the vehicle and then place the clamp over the muffler outlet. Place exit pipe **#16741S** into the muffler outlet and tighten the clamp enough to hold, but still allow for adjustment. Place the stainless tip **#ST339** onto the end of the exit pipe and adjust to the desired position. Tighten the clamp on the tip enough to hold, but still allow for adjustment.

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	Resonator Assembly	15163S
1	Muffler	842453-Z
1	Intermediate Pipe	16738S
1	Over-Axle Pipe	16739S
1	Muffler Inlet Pipe	16740S
1	Exit Pipe	16741S
1	Stainless Tip	ST339
1	Parts Kit	PK619
1	Clamp Hanger	440HA
4	2¼" Band Clamp	MC225BS
2	7/16" x 1½" Hex Bolt	HW224
2	7/16" Hex Nut	HW104
2	7/16" Flat Washer	HW304
2	7/16" Lock Washer	HW310
4	7/16" Hanger Keepers	HW502



Installation diagram for:  
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