



FORCE II™

409S Stainless Steel

Installation Instructions for:

SYSTEM #817617

2007-2010 CHEVY/GMC 2500HD/3500HD TRUCKS
6.6L DURAMAX DIESEL ENGINE
4" DPF BACK SYSTEM

03/03/17

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. Spray a penetrating lubricant onto the three bolts at the flanged connection behind the factory DPF unit and also the two rubber hangers that support the stock muffler and tailpipe.

2) Support the muffler with a stand and remove the three nuts at the flanged connection behind the DPF unit. Remove the two hangers on the muffler and tailpipe assembly from the rubber mounts on the vehicle. Slide the muffler and tailpipe forward, over the rear axle and remove from the vehicle.

3) Using the 7/16" nuts, bolts and washers provided, bolt inlet pipe assembly **#597TBS** to the back of the mating flange on the exhaust system. Tighten securely.

4) Trim extension pipe **#46168S** if necessary, according to the following measurements before placing onto the back of inlet pipe **#597TBS**. Place the provided 4" clamp onto this connection and tighten enough to hold.

Crew Cab, Standard Bed, 153" Wheelbase Models: **Extension pipe 46168S not used.**

Extended Cab, Long Bed, 157.5" Wheelbase Models: **Trim 9.50" from 46168S.**

Crew Cab, Long Bed, 167" Wheelbase Models: **Do not trim 46168S, place directly onto 597TBS.**

5) Place a supplied 4" clamp onto the inlet of muffler **#815440-Z** and slide onto the back of inlet pipe **#597TBS or 46168S**. Tighten the clamp enough to hold, but still allow for adjustment.

6) Place a supplied 4" clamp onto the muffler outlet. Place tailpipe **#46163S** into position over the rear axle and slide into the muffler outlet. Connect the two hangers on the tailpipe to the rubber mounts on the vehicle and tighten the clamp on the muffler outlet enough to hold but still allow for adjustment.

7) Place a supplied 4" clamp onto the expanded end of stainless tip **#ST475** and slide onto the end of the tailpipe and adjust to the desired location.

8) Adjust the position of the pipes and muffler to provide a satisfactory fit. 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 the clamps down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. Place the supplied 1/2" hanger keeps onto the end of both of the tailpipe hangers, these will keep the hangers from slipping out of the rubber mounts.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
1	Inlet Pipe Assy.	597TBS	
1	Extension Pipe	46168S	
1	Muffler	815440-Z	
1	Tailpipe Assy.	46163S	
1	Stainless Tip	ST475	
1	Parts Kit	PK672	
4	4" Band Clamp		MC400BS
2	1/2" Hanger Keeper		HW503
3	7/16" x 1.50" Bolts		HW224
3	7/16" Nuts		HW104
6	7/16" Flat Washers		HW304
3	7/16" Lock Washers		HW310



Installation diagram for:
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