



FORCE II™

409S® Stainless Steel

Installation Instructions for:
SYSTEM #817621
2007-2012 DODGE RAM 2500/3500 SERIES TRUCKS
6.7L CUMMINS DIESEL ENGINE · ALL WHEELBASES
4" DPF BACK SYSTEM

10/16/12

Removal:

- 1) To make the removal of the stock system easier, you may choose to cut off the stock tailpipe where it exits the muffler; this can be done using a hacksaw or sawsall. After cutting, remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and set the tailpipe aside. This step is not mandatory, but makes removal easier.
- 2) Remove the clamp on the muffler inlet. Use a pry bar to separate the two hangers at the front of the muffler from the rubber mounts on the vehicle. (A lubricant of some type on the hangers will make removal easier.) Remove the muffler assembly from the vehicle.

Installation:

- 1) Place a supplied 4" clamp onto the inlet of muffler assembly **#815440-294**. Then place onto the back of the diesel particulate filter while also connecting the hangers on the muffler to the rubber mounts on the vehicle. Slide fully forward and tighten the clamp on the muffler inlet securely.
- 2) Install tailpipe **#46161S** by first placing a 4" clamp onto the muffler outlet. Place the tailpipe into position over the rear axle and slide the rear hanger on the tailpipe into the rubber mount on the vehicle. Then slide into the muffler outlet. Tighten the clamp on the muffler outlet enough to hold, but still allow for adjustment.
- 3) Place a supplied clamp onto the expanded end of exit pipe **#46158S**, then place onto the back of the over axle pipe and adjust to the desired distance from the fender. Tighten the clamp enough to hold. Place a supplied clamp onto stainless tip **#ST475**, then place onto the back of the exit pipe and adjust to the desired rotation. Firmly tighten the tip clamp using a 7/16" wrench, socket and ratchet.

Note: Exit pipe #46158S has been left long enough to correctly position the tip on vehicles equipped with dual rear wheels. To properly place the tip on standard trucks, trim 5.00" from the end of the exit pipe. *We strongly recommend placing a one inch weld on each side of the tip once final adjustment has been achieved.*

- 4) The system should now be adjusted to achieve a proper fit. Once you are satisfied with the overall fit, all clamps should be tightened at each one of the slip fit connections. Although not required, we highly recommend that all connections be fully welded after installation.

PACKING LIST

<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART#</u>
1	Muffler Assembly	815440-294
1	Tailpipe	46161S
1	Exit Pipe	46158S
1	Stainless Tip	ST475
1	Parts Kit	PK663
4	4" Ring Clamps	MC400BS
3	1/2" Hanger Keepers	HW503



Installation diagram for:
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