



Installation Instructions for:
SYSTEM #817639
1999-2002 CHEVY CAVALIER
2.2L & 2.4L ENGINES

FORCE II™

409S Stainless Steel

03/29/13

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 nuts at the flanged connection behind the catalytic converter and the rubber hangers that support the stock exhaust system.



2) In order to remove the stock exhaust system, the system must be cut in half. The best place to do this is just in front of the rear axle.



3) Support the rear muffler with a stand and slide the muffler assembly forward to release the hanger on the muffler from the rubber mount above the muffler. Then, slide the hanger just behind the rear axle from the rubber mount on the vehicle. Move the assembly toward the rear of the vehicle and remove.



4) At the center of the vehicle, remove the three bolts attaching the factory mid pipe to the rear of the catalytic converter. Once the flange is loose, lower the pipe from the vehicle.



5) Place inlet pipe **#16834S** along with gasket **#GA121** onto the back of the catalytic converter. Using the 3/8" bolts, nuts and washers provided secure the two flanges together and tighten securely. Place a provided 2 1/4" clamp onto the back of this pipe in preparation for the next step.



6) Place over-axle pipe **#86021S** into position over the rear axle and slide onto the back of inlet pipe **#16834S**. 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.



7) Place a provided clamp onto the inlet of muffler **#852460-304**. Connect the hanger on the body of the muffler to the rubber mount on the vehicle and then slide the inlet onto the back of over-axle pipe **#86021S**. Tighten the clamp on the muffler inlet enough to hold, but still allow for adjustment.



8) Place the **ST459** stainless tip onto the muffler outlet and adjust to the desired position. Tighten the clamp enough to hold, but still allow for adjustment.

9) Adjust the position of all pipes and mufflers 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 all connections down securely. For a more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
1	Inlet Pipe	16834S	
1	Over-Axle Pipe	86021S	
1	Muffler Assembly	852460-304	
1	Stainless Tip	ST459	
1	Parts Kit	PK656	
2	2 1/4" Band Clamp		MC225BS
1	Gasket		GA121
3	3/8" x 1 1/2" Bolt		HW210
3	3/8" Nut		HW103
3	3/8" Lock Washer		HW309
1	7/16" Hanger Keeper		HW502



Installation diagram for:
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