



## **FORCE II** **409S<sup>®</sup> Stainless Steel**

Installation Instructions for:  
**SYSTEM #817670**  
**1992-1996 CHEVROLET CORVETTE**  
**LT-1 & LT-4 MODELS ONLY**  
5.7L Engine

12/16/13

### **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) *1996 Vehicles Only:* Remove the oxygen sensor from the left side resonator pipe by first unplugging the plastic connector and then using a 1 inch wrench to remove the sensor itself. Use care, so as to not damage the sensor.
- 3) Using a 15mm socket, remove the bolt and nuts on the flange behind the left side catalytic converter, and loosen the band clamp at the slip-fit connection behind the right side converter.
- 4) Place jack stands under both of these pipes to support the front half of the system after it is disconnected.
- 5) Using a 13mm socket, remove the four bolts attaching the four spring hangers to the system; two in front of the resonator and the two behind the resonator.
- 6) Place jack stands under the rear of the system to support it when the muffler hangers are removed.
- 7) With a 13mm socket, remove the two nuts above the rear of each muffler that secures the rubber muffler hanger to the frame of the vehicle. Save the rubber hangers as they will be re-used with the new Flowmaster system.
- 8) Carefully lower the system and remove from underneath the vehicle. This step may require the help of an assistant.

### **Installation:**

- 1) Raise the resonator **#15179S** into the stock location under the vehicle and support with stands.
- 2) Place the provided 2 3/4" clamp onto the right side resonator inlet. Join the right side resonator pipe with the catalytic converter outlet. This is a slip-fit connection. This will allow the left side ball flange to be connected with the stock bolt and nuts.  
*Note: If the pipes do not align correctly with the converter outlets it may be necessary to loosen the bolts where they connect to the manifolds.*
- 3) With the 5/16" x 1" bolts and nuts provided, connect the two spring hangers to the resonator hanger mounts.

- 4) *1996 Vehicles Only:* Remove the plug from the oxygen sensor fitting on the Flowmaster resonator and reinstall the factory oxygen sensor into the fitting. Reconnect the plastic electrical connector.
- 5) Place a provided clamp onto both resonator outlets. Install mid pipe assembly **#86182S** into the left resonator outlet, rotate to its approximate position and tighten the clamp enough to hold in position. With the provided 5/16" x 1" bolts, connect the spring hanger on the vehicle to the mount on the pipe. Repeat this step on the right side with pipe **#86183S**.
- 6) Install a 2 1/2' clamp onto the inlet of right muffler **#842550-335**, then place onto the back of mid pipe **#86183S**. Then place the stock rubber hanger removed in step 7 above onto the welded hanger on the muffler. Push the rear of the muffler up into position with the rubber hanger against the frame and secure using the stock nuts. Repeat this step for the left side using muffler **#842550-336** and mid pipe **#86182S**.
- 7) Center the resonator between the seat belt bolts in the drive shaft tunnel. Tighten the left side flange connection and check to be sure the resonator is still centered.
- 8) Tighten the 2 3/4" clamp on the right side slip-fit connection securely.
- 9) Check the position of the mid pipe assemblies to be sure they will not interfere with the driveshaft or differential during suspension movement. Tighten the clamps down securely.
- 10) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind. Tighten down all clamped connections 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	Muffler, Right	842550-335	
1	Muffler, Left	842550-336	
1	Resonator	15179	
1	Left Mid Pipe	86182S	
1	Right Mid Pipe	86183S	
1	Parts kit	PK761	
4	2 1/2" clamps		MC250S
1	2 3/4" clamp		MC234S
1	O2 Sensor Plug		SF017
4	5/16" X 1" bolts		HW205
4	5/16" nuts		HW102
4	5/16" flat washers		HW302
4	5/16" lock washers		HW308



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