



Installation Instructions for:
SYSTEM #817683
1996-2002 DODGE VIPER GTS
8.0L V10 ENGINE – REAR EXIT



4099₆ Stainless Steel

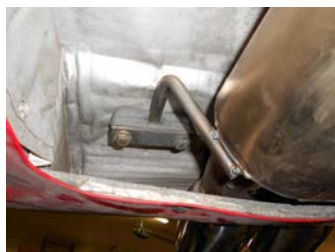
02/26/14

1) The first step in the removal of the stock exhaust system is to remove the side covers from the vehicle. Beginning on one side of the vehicle, remove the four hex screws attaching the side cover to the bottom of the vehicle. Next, open the hood and remove the two screws directly behind the front tire attaching the side cover to the body. Then open the vehicle door and using a small flat blade screwdriver, remove the four covers that cover the screws on the inner sill plate. After removing the covers, remove the four hex bolts attaching the side cover to the vehicle. With the help of an assistant, pull the cover straight out from the vehicle to remove.



2) Using a penetrating lubricant, spray the rubber hangers that support the exhaust system from the catalytic converters back. Also, spray the nuts on the clamped connections behind the catalytic converters as well as the two just forward of the rear muffler assembly. This will greatly ease the removal of the system.

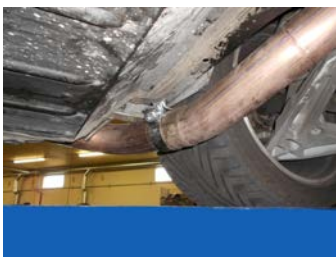
3) At the back of the vehicle, loosen the clamps that connect the muffler to the center section of the exhaust system. Support the muffler with a stand and unbolt the rubber mounts at the rear of the muffler from the body, also unbolt the mount at the front of the muffler from the frame. Slide the muffler rearward to disengage both muffler inlets from the mid pipes. Lower the muffler from the vehicle.



4) In the center of the right and left mid pipe assembly, on top of the pipe, you will find an O2 sensor. Using a 7/8" wrench, remove the sensor from the pipe. At the side of the vehicle, loosen the clamp between the resonator and the catalytic converter. Once the clamp is loose unbolt the rubber mount that supports the mid pipe assembly from the frame of the vehicle. You should now be able to remove this section from the vehicle. Remove the rubber mount from the two hangers on the pipe; this rubber mount will be reused with the Flowmaster system. Repeat this step on the other side of the vehicle.



5) On the right side of the vehicle, place a provided 2½" clamp onto the reduced end of pipe **26441S**. Place the rubber mount removed in the step above onto the two hangers on the pipe and slide the reduced end over the back of the catalytic converter. Using the factory bolts, reinstall the rubber mount to the frame of the vehicle and tighten the clamp on the catalytic converter enough to hold, but still allow for adjustment. Repeat the step on the left side with pipe **#26442S**.



6) On the right side of the vehicle, place a provided 3" clamp onto the expanded end of mid pipe assembly **26443S**. Route the pipe up over the frame and connect to the back of front pipe **26441S**, rotate the pipe to achieve equal clearance around the pipe and tighten the clamp enough to hold, but still allow for adjustment. Re-install the O2 sensor removed in step 4 above into the fitting on the new Flowmaster pipe. Repeat this step on the left side with pipe **#26444S**.

7) Remove the rubber hanger mount from the front of the factory muffler, then using the factory shoulder bolts and 2 included nuts, washers and lock washers, secure the mount to the included HA1288 relocate bracket. Then using the included 5/16" bolts, washers and lock washers bolt the relocate bracket to the frame of the vehicle.



8) Remove the two rubber hanger mounts from the rear of the factory muffler assembly and slide them onto the hangers of the new Flowmaster muffler assembly **8530554-348**. Place a provided 3" clamp over both muffler inlet tubes, then slide the assembly over the back of both mid pipe assemblies, while also connecting the hanger at the front of the muffler to the bracket installed in step 7 above. Push the rear of the muffler up into position and support the rear of the muffler with a stand. Using the factory hardware secure the rear rubber mounts to the body of the vehicle.



9) Adjust the position of all pipes and muffler to provide a satisfactory fit. A minimum 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind. Tighten all clamped connections down securely. For a more secure installation, we recommend welding all slip-fit connections.

10) After the system is installed and secure, reinstall the side covers onto the vehicle in the reverse order as the removal in step 1 above. Be sure all fasteners are secure.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Right Front Pipe	26441S
1	Left Front Pipe	26442S
1	Right Mid Pipe	26443S
1	Left Mid Pipe	26444S
1	Muffler Assembly	8530554-348
1	Parts Kit	PK772
1	Relocate Bracket	HA1288
4	3" Band Clamp	MC300BS
2	2 1/2" Band Clamp	MC250BS
2	5/16" x 1" Bolt	HW204
2	5/16" Nut	HW102
4	5/16" Flat Washer	HW302
4	5/16" Lock Washer	HW308



Installation diagram for:
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