



Installation Instructions

817934

**1967-72 FORD F-100, 250 & 350
5.0L, 5.8L, 5.9 & 6.4L ENGINE
2WD Only, Long Bed, 131" Wheelbase
with Factory Auxillary Fuel Tank.**

OVERVIEW:

1. Take a moment to read and understand these instructions before installing your Flowmaster performance system.

NOTE: Please inventory all parts now before continuing and if necessary, report any missing items to our tech line. This will avoid potentially stranding your vehicle until any missing replacement parts arrive.

ITM #	PART #	DESCRIPTION	QTY.
9	86646S	Left Rear Exit Pipe	1
10	86666S	Left Dump Exit Pipe	2
11	86667S	Right Dump Exit Pipe	2
N/A	PK1031	Hardware Package includes:	1
12	519HA	Front Frame Hanger	1
13	MC250BS	2½" Stainless Band Clamp	8
14	HA572	Rear Hanger	2
15	HA602	Front Hanger	2
16	HA1640	Red Rubber Hanger	2
17	HW204	¼"-18 x 1 Bolt	6
18	HW102	¾"-18 Nut	6
19	HW302	¼" Flat Washer	12
20	HW308	¼" Lock Washer	6
21	HW501	¾" Hanger Keeper	4
22	HW502	¾" Hanger Keeper	4

ITM #	PART #	DESCRIPTION	QTY.
1	86650S	Left Inlet Pipe	1
2	86651S	Right Inlet Pipe	1
3	86629S	H-Pipe Assembly	1
4	842547-Z	Muffler	2
5	86630S	Left Tailpipe Assembly	1
6	86631S	Right Tailpipe Assembly	1
7	86632S	R/L Side Exit Pipe	2
8	86645S	Right Rear Exit Pipe	1

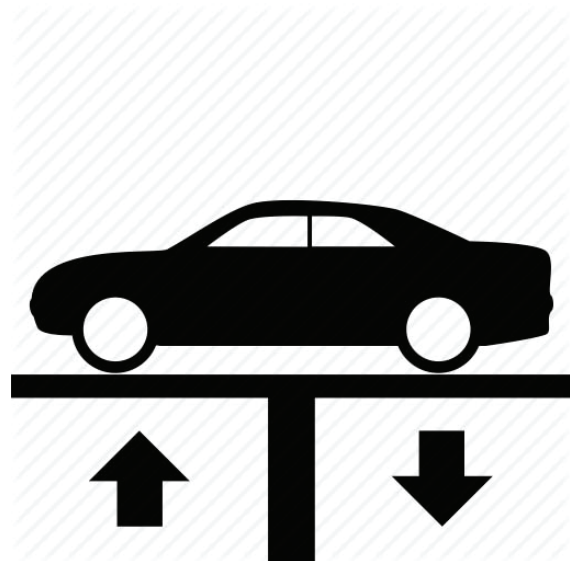
PREPARE VEHICLE FOR KIT INSTALLATION:

2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

WARNING:
Avoid serious burns! Allow your vehicle time to cool completely before touching any factory engine components.

To ease preparation and installation of your new kit:

- Apply penetrating lubricant to mounts, bolts and clamps before you remove them.
- Use stands as necessary to support parts as you detach them from your vehicle and again as you install new parts.



3. Remove existing system from header collector or manifold down pipes rearward.

INSTALL FLOWMASTER EXHAUST SYSTEM

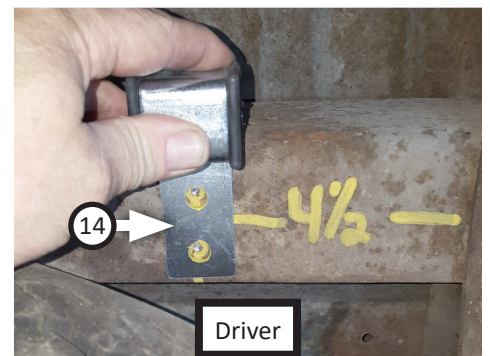
4. Remove nuts from Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.



5. Remove mount and fasteners indicated from vehicle frame.



6. On crossmember above spare tire, make two marks inward from intersecting frame; driver side: 4½" inward, passenger side: 2½" inward. Use (x2) **rear hangers (14)** oriented as shown to drill (x4) ⅝" mount holes.

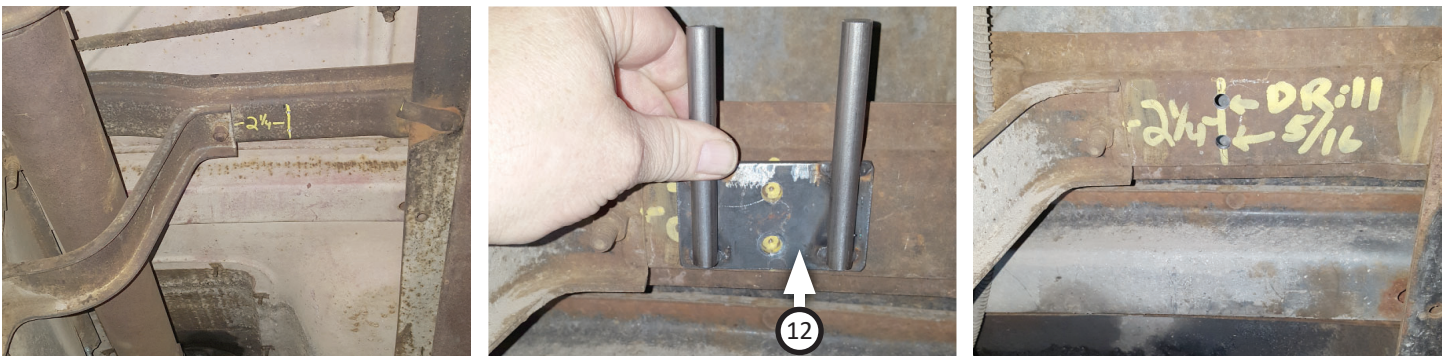


NOTE: In some applications one or both of these holes may already exist. If so, make sure they are properly sized.

7. Drill (x2) $\frac{5}{16}$ " holes in passenger side of vehicle frame just forward of rear tires.



8. Mark line on front crossmember $2\frac{1}{4}$ " outward from tank bracket as shown. Use **front frame hanger (12)** oriented as shown to drill (x2) $\frac{5}{16}$ " mount holes.



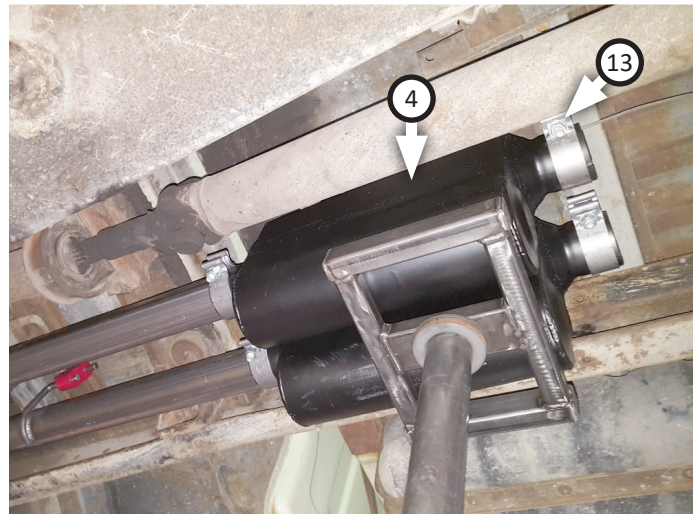
9. Fasten front frame hanger to crossmember with (x2) **bolts (17)**, (x4) **flat washers (19)**, (x2) **lock washers (20)** and (x2) **nuts (18)**. Place (x2) **rubber hangers (16)** onto hangers as shown.



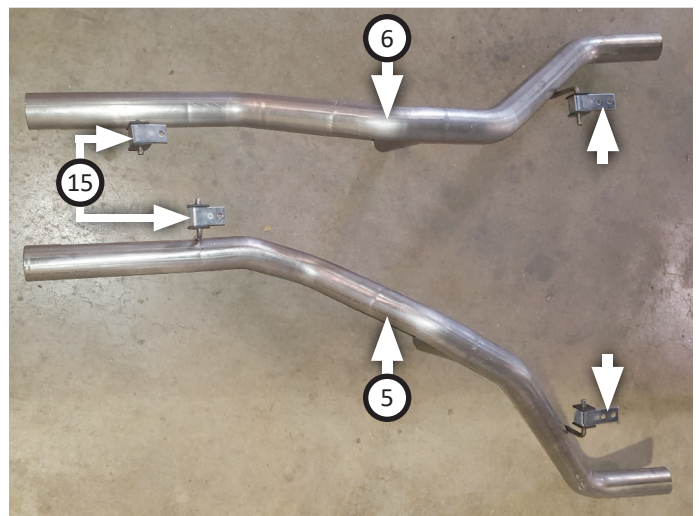
10. Hang **h-pipe assembly (3)** in front frame hanger as shown.



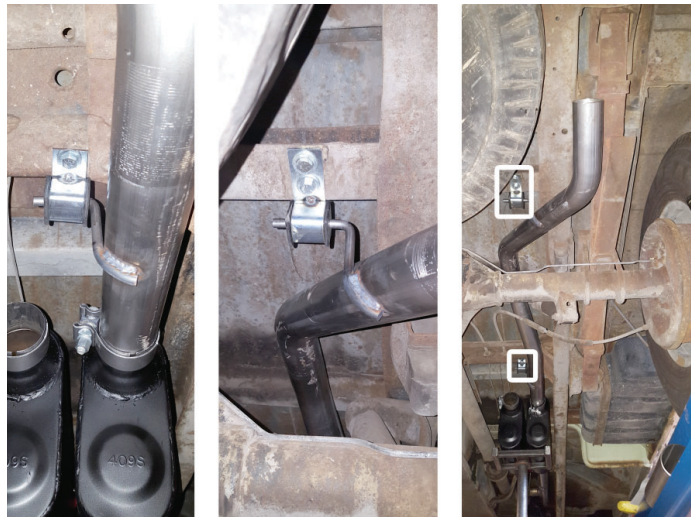
11. Place (x2 ea.) **clamps (13)** onto **mufflers (4)** then connect them to h-pipe assembly. Tighten clamps just enough to allow for later adjustment. Place (x2) **clamps (13)** onto end of mufflers.



12. Hang (x2) **front hangers (15)** on front of **left (5)** and **right (6)** tailpipes. Hang (x2) rear hangers (step 6) onto rear of left and right tailpipes.



13. Route right tailpipe over axle and connect it to muffler. Fasten front and rear hangers to vehicle frame with (x3) **bolts (17)**, (x6) **flat washers (19)**, (x3) **lock washers (20)** and (x3) **nuts (18)**.

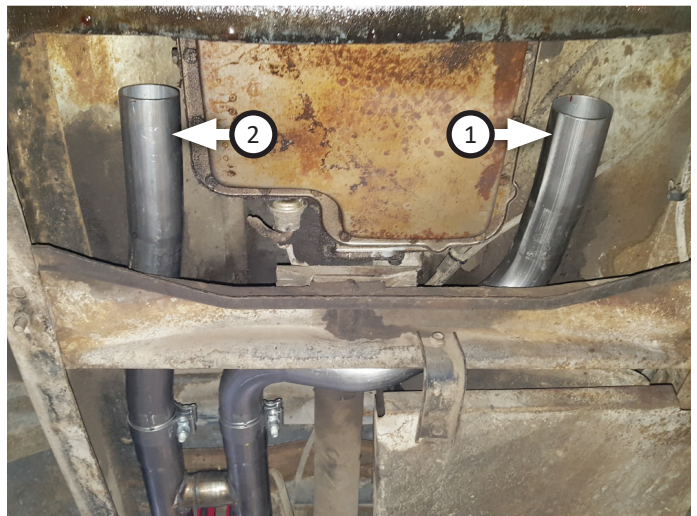


14. Route left tailpipe over axle and connect it to muffler. Fasten front and rear hangers to vehicle frame with (x3) **bolts (17)**, (x6) **flat washers (19)**, (x3) **lock washers (20)** and (x3) **nuts (18)**.



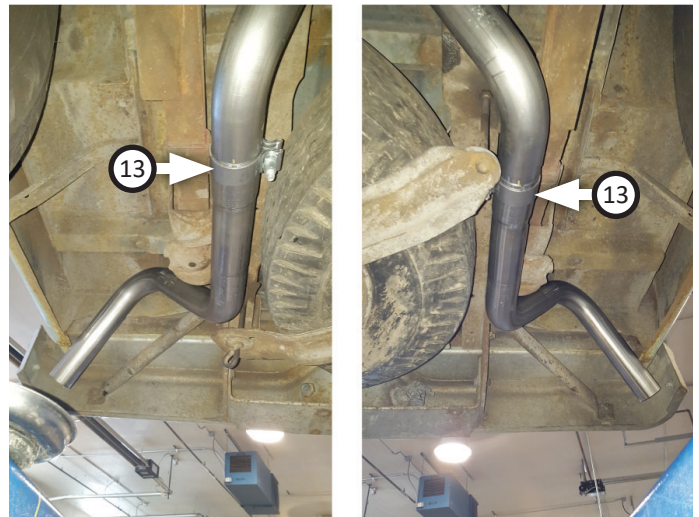
NOTE: Additional fabrication may be necessary for inlet pipes to fit your vehicle.

15. Use **left (1)** and **right (2)** inlet pipes, to connect factory exhaust and h-pipes, using (x2) **clamps (13)** to secure connections.



NOTE: This kit includes **rear (8-9), side (7) and dump (10-11)** exit pipes. The exit pipes are left long in order to let you decide how your exhaust should look. Choose which style you would prefer, then use corresponding parts to complete this step.

16. Place (x2 ea.) **clamps (13)** onto exit pipes and connect them to left and right tailpipes. Rotate exit pipes to desired distance from body or bumper, so they are properly positioned.



17. Adjust exhaust components for fit; maintaining $\frac{1}{2}$ " clearance and compensating for suspension, travel and vibration, then tighten all clamps. Finally, fit (x4 ea.) $\frac{3}{8}$ " **(21)** and $\frac{7}{16}$ " **(22)** hanger keepers onto each hanger.
18. Recommended: Secure slip-fit connections with a 1-inch tack weld then spray high-temp paint over each weld to prevent rust and premature corrosion.



Congratulations, the installation of your FLOWMASTER performance exhaust system is now complete!





Installation Diagram

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