**Removal of Stock System:**

BD recommends that exhaust systems be professionally installed. Please use all necessary precautions to ensure a safe installation. Read all instructions provided before proceeding with the install. **Warning: Allow the exhaust system to cool before attempting to remove or you will be subject to severe burns. If the vehicle is to be jacked up, please make sure it is stable and secure before removing any parts.** Tip: A can of WD40 or something similar would be a great help in removing nuts and bolts on an old system. It also comes in handy when removing and installing the rubber grommets used with the hangers. Wearing safety glasses would be advisable.

1. Open your box and make sure everything is there and fits together before you start. Determine what you will be taking off the vehicle and spray it with the WD40. Most of the original systems are one piece at the back. You may have to lift the body of the vehicle to remove the muffler and tailpipe without cutting. Find something to support the muffler (i.e. jack stand) before you start removing the hangers. Spray the hangers with WD40. Using a large screwdriver or crowbar, lever the rubber grommets off. Save these as some will need to be reused.
2. Separate the stock exhaust at the slip joint at the muffler. Remove rear exhaust from rubber hangers, remove bottom shock bolt at rear of truck and remove the system from under the truck. Carefully remove the rear section as this part can be heavy and hard to handle. **Re-install the bottom shock bolt.**
3. With a 15mm wrench or socket, remove nut from band clamp in front of muffler.
4. Remove the extension pipe at the flange using a 15mm deep socket.
5. Remove down-pipe – From under the hood, remove band clamp with an 11mm deep socket at the turbo and cut the pipe in front of the transmission cross-member to remove. (Note: The stock down-pipe can be removed in one piece by removing the transmission cross-member. It is recommended that this procedure be done only by qualified trained professionals using tools and equipment designed for safety to carry out this process.)

Installation of BD Stainless Exhaust:

Installation tip: Mark all pipes that insert into expansion joints with marker for proper overlap and sealing to ensure that pipe is inserted enough to seal the slots in expanded portion of pipe. Whenever possible you want at least a $\frac{1}{2}$ " clearance between any exhaust pipes and points on the vehicle. Less than that could cause heat transfer or vibration. Pipes that clamp together should always overlap a minimum of 2". If the pipes are slotted, make sure they overlap enough or they will leak. When using the clamps, position them about a $\frac{1}{4}$ " to $\frac{1}{2}$ " from the end of the pipe making sure part of the clamp is behind the slots when tightening.

1. Install down-pipe. Do NOT fully tighten until all components are in place.
2. Install the mid-pipe using the pre-welded hanger into the OEM rubber hanger located on the frame.
3. Install the extension pipe over the down-pipe. Included is a 34" pipe which can be cut to an 18" extension to accommodate each wheelbase/cab design. Use the amount of pipe needed to align with hole to be cut in bed.
4. Starting at the front-pipe, tighten ALL connections. Start the vehicle and check for leaks as this is vital for safety, sound, and the best fuel performance. A few days after the installation check that everything is still in position and tightened.

This kit is designed to be used with BD universal stack components.

BD ENGINE BRAKE, INC.

Plant Address: A10-33733 King Rd, Abbotsford, BC, Canada V2S 7M9
 US Shipping Address: 88-446 Harrison St, Sumas, WA 98295 US Mailing Address: PO Box 231, Sumas, WA 98295
 Phone: 604-853-6096 Fax: 604-853-8749 Internet: www.bd-power.com



Part# 1049721

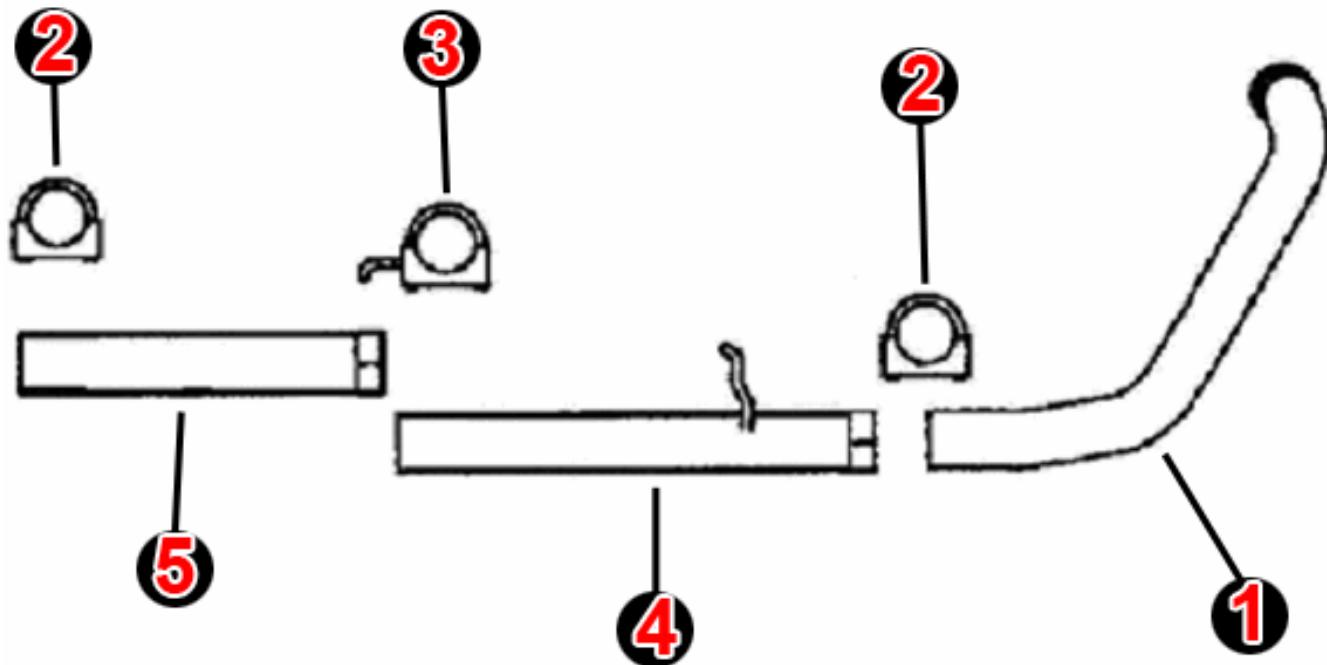
Downpipe-back Pipe kit for Stacks

1999-2003 Ford 7.3L Powerstroke
F250/F350 2WD/4WD

(Off-road only for models equipped with a Catalytic Converter)

-- Not Designed for Commercial Trucks --

(Depending on the wheelbase, Pipe #5 may have to be cut)



Picture #	Description	Quantity
1	Turbine Outlet Pipe	1
2	4" Exhaust Clamps	2
3	4" Exhaust Clamp w/ Hook	1
4	53½" Intermediate Pipe	1
5	34" Intermediate Pipe	1

BD recommends that exhaust systems be installed by a trained automotive technician. If these parts are installed by a do-it-yourself person, or end user, please take all necessary precautions to ensure a safe installation.

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