



409S[®] Stainless Steel SYSTEM #817355

**1970-1974 MOPAR "E" BODY
BARRACUDA / CHALLENGER
2½" System – V8 Engine**

08/28/12

Installation:

Due to various body styles and options available from 1970-1974, the factory exhaust mounting brackets on the rear seat pan can vary. Please take a moment to carefully read steps 3 through 5 of the installation instructions below to determine which style of mounts that you have and which included hangers to use with them.

- 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) On the bottom of the rear frame rails, forward of the bumper, you will find large brackets on each side of the vehicle that are secured with two bolts that screw vertically into the frame. Remove the bolts and insert spacer **#HA418** between the bracket and the frame at the front holes, then put the front bolts back in to hold the brackets in place. Slip the hanger mounts **#305HA** in between the frame and the brackets at the rear hole locations. Reinstall the rear bolts and tighten everything down securely. (The hanger mounts should point to the middle of the vehicle and be offset "down".) Install rubber hanger **#HA168** onto each hanger rod.
- 3) On the right rear section of the floor pan just ahead of the rear axle there is a factory hanger bracket spot welded in place. Fasten the hanger mount **#451HA** to the face of the bracket with a 5/16" bolt, washer and nut. Slide rubber hanger **#HA168** onto the hanger mount. Hanger **#451HA** should point to the middle of the vehicle. On factory dual exhaust cars, repeat this step on the left side with hanger **#452HA**.
- 4) The standard Barracuda/Challenger has no factory mounting locations for the left side muffler hanger, so you will need to drill some holes. Take the hanger mount **#306HA** and try to mirror the location of the right hanger (**#451HA**) as close as you can. Mark the two hole locations and drill the pan with a 3/8" bit. You must go inside the vehicle and remove the rear seat so that you can see the holes you drilled. Place the mounting plate **#244HA** through the holes and replace the seat. Go back and fasten the hanger mount in place with 3/8" nuts and washers. Slide rubber hanger **#HA168** onto the hanger mount. (Hanger **#306HA** should point to the middle of the vehicle.)
- 5) On some cars there are no brackets on the lower seat pan to mount the **#451HA** or **#452HA** hanger brackets to. In this instance, you will use hanger #'s **306HA** for the left side and **450HA** for the right side. These will be installed just like the hangers in step 4 above, however they will have to be installed onto the front tailpipe hangers and put in place for marking after all of the pipes and mufflers have been put in place and adjusted to the desired location.

- 6) Place the left tailpipe **#16808S** up over the rear axle and connect the hangers on the pipe to the rubber mounts installed in the steps above. Repeat this step for the right side using tailpipe **#16807S**.
- 7) Place a provided 2.50" clamp onto the muffler outlets, then slide the mufflers completely onto the tailpipes and support the mufflers with a stand. Tighten the clamps on the muffler outlets enough to hold, but still allow for adjustment.
- 8) Slide a provided 2½" clamp over each muffler inlet, then place the Scavenger assembly **#16804S** into its approximate position underneath the vehicle and connect the back of Scavenger assembly to the muffler inlets and support with a stand. Tighten the clamps just enough to hold in position.
- 9) The front connector pipes **#16803S** are long enough to allow for many different header combinations, therefore, it will be necessary to determine the proper length of the connector pipes and then trim the pipes to fit. Once the proper length is determined, trim the front connector pipes and raise them into position. Connect them to the Scavenger assembly and header collectors or manifold down pipes using a standard header flange, Flowmaster venture cone or Flowmaster Ball Flange kit.
- 10) Adjust the position of the muffler and pipes 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.
- 11) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers on the round stock sticking through the rubber muffler hangers. This will prevent the hangers from slipping out of the rubber mounts.
- 12) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

Installation notes:

Shifter Linkage Reverse Rod: 70-74 E-body applications equipped with a 4-speed Transmission will require a 70-72 style Shifter Linkage Reverse Rod to clear a 2.5" or 3" H-pipe or X-pipe.

70-72 style shifter reverse rods can be purchased thru Brewer's Performance Inc. Part #LR854.

Packing List

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
2	Muffler	852546-Z
2	Connector Pipe, R/L	16803S
1	Scavenger Assy.	16804S
1	Left Tailpipe	16808S
1	Right Tailpipe	16809S
1	Parts kit	PK645
2	Hanger Mounting Plate	244HA
2	Tailpipe Hanger Mount (R/L)	305HA
1	Muffler Hanger Mount (L)	306HA
1	'70 Muffler Mount (R)	450HA
1	71-74 Muffler Mount (R)	451HA
1	71-74 Muffler Mount (L)	452HA
6	2½" Clamps	MC250BS
4	Rubber Hanger	HA168
2	Spacers	HA418
5	3/8" Nuts	HW103
1	3/8" X 1" Bolt	HW208
5	3/8" Flat Washer	HW303
5	3/8" Lock Washer	HW309
2	5/16" x 1" Bolt	HW204
4	5/16" Flat Washers	HW302
2	5/16" Hex Nuts	HW102
2	5/16" Lock Washers	HW308
8	7/16" Hanger Keepers	HW502



Installation diagram for:
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