



FORCE II™ **409S Stainless Steel**

Installation Instructions for:
SYSTEM #817542
2001-2006 CHEVY/GMC 2500HD & 3500HD TRUCKS
6.6L DURAMAX TURBO DIESEL ENGINE
(ALL EXCEPT STANDARD CAB / LONG BED)

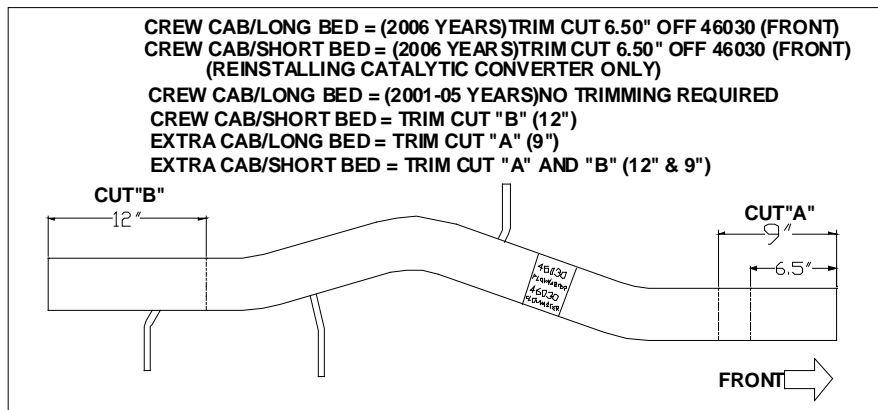
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Removal:

- 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) Use a pry bar to separate the four stock hangers from the rubber mounts on the vehicle. (A lubricant of some type will usually make this a little easier.)
- 3) Using a hacksaw or sawsall, cut the stock tailpipe off just behind the muffler. Remove the tailpipe after cutting. This step is not mandatory but makes removal easier. Then remove the four bolts at the flanged connection that is a couple feet in front of the muffler and remove the rear section of the exhaust system from under the vehicle.
- 4) If you DON'T have a catalytic converter, locate the V-band clamp where the lower down pipe attaches to the upper down pipe. Use an 11mm socket or wrench to loosen the nut nearly all of the way out. Then use a rubber mallet to tap on the down pipe and shock the connection loose. Lower the down pipe from under the vehicle. *Note: The upper section of the down pipe that connects to the turbo housing is not replaced.*
- 5) If you DO have a catalytic converter, it must be left on the vehicle. Connect the supplied adapter **#433TBS (2001-2005 model years)** onto the flanged outlet of the converter, using the original gasket and nuts. *Note: For 2006 model year trucks use adapter pipe **#TB424S**. Slide on after catalytic converter without flange connection.*

Installation:

- 1) Place the new turbo down pipe **#46029S** into the same position as the old one that was removed, making sure the two flared surfaces are matching up correctly. Slide the V-band clamp over the flared connection and begin tightening, checking that the down pipe is centered. Tighten the clamp until snug but loose enough for adjustment. *(Skip this step on converter equipped vehicles.)*
- 2) Slide clamp hanger **#273HA** onto the rear of the down pipe and into the upper hole of the rubber mount on the vehicle. Place a small amount of lubricant onto the threads of the clamp and tighten enough to hold, but still allow for adjustment.
- 3) See diagram below for trimming instructions on mid pipe **#46030S**.



- 4) Place a supplied 4" clamp onto the front of pipe **#46030S** and slip into the rear of pipe **#46029S**. (Note: Ring clamp can also be placed onto the converter adapter if applicable. For 2006 model years and keeping converter on you must cut approximately 6.50" off front end of pipe **#46030S** for the crew cab/long bed/short bed models only.) Rotate the pipe into position and connect the two hangers welded to the pipe into the rubber mounts on the vehicle. Tighten clamp enough to hold, but still allow for adjustment.
- 5) Place a supplied 4" clamp onto the inlet of muffler **#14020100-Z** and slide the muffler inlet fully onto the rear of pipe **#46030S**. Check to see that the muffler is level and tighten enough to hold, but still allow for adjustment.
- 6) Place clamp hanger **#427HA** onto the outlet of the muffler and connect to the rubber mount on the vehicle.
- 7) Place tailpipe **#46031S** into position by sliding it over the rear axle from the rear, and into the outlet of the muffler. Connect the hanger at the rear of the tailpipe to the rubber mount on the vehicle and tighten the clamp on the muffler outlet enough to hold, but still allow for adjustment.
- 8) Place the stainless tip **#ST430** onto the end of the tailpipe. The tailpipe has been left long enough to work on dually applications and will need to be trimmed back for single wheel models.
- 9) 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.
- 10) Tighten down all clamped connections securely. After the system is secure, slide the 1/2" hanger keepers onto the ends of the hanger rods. This will prevent the hangers from slipping out of the rubber mounts. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

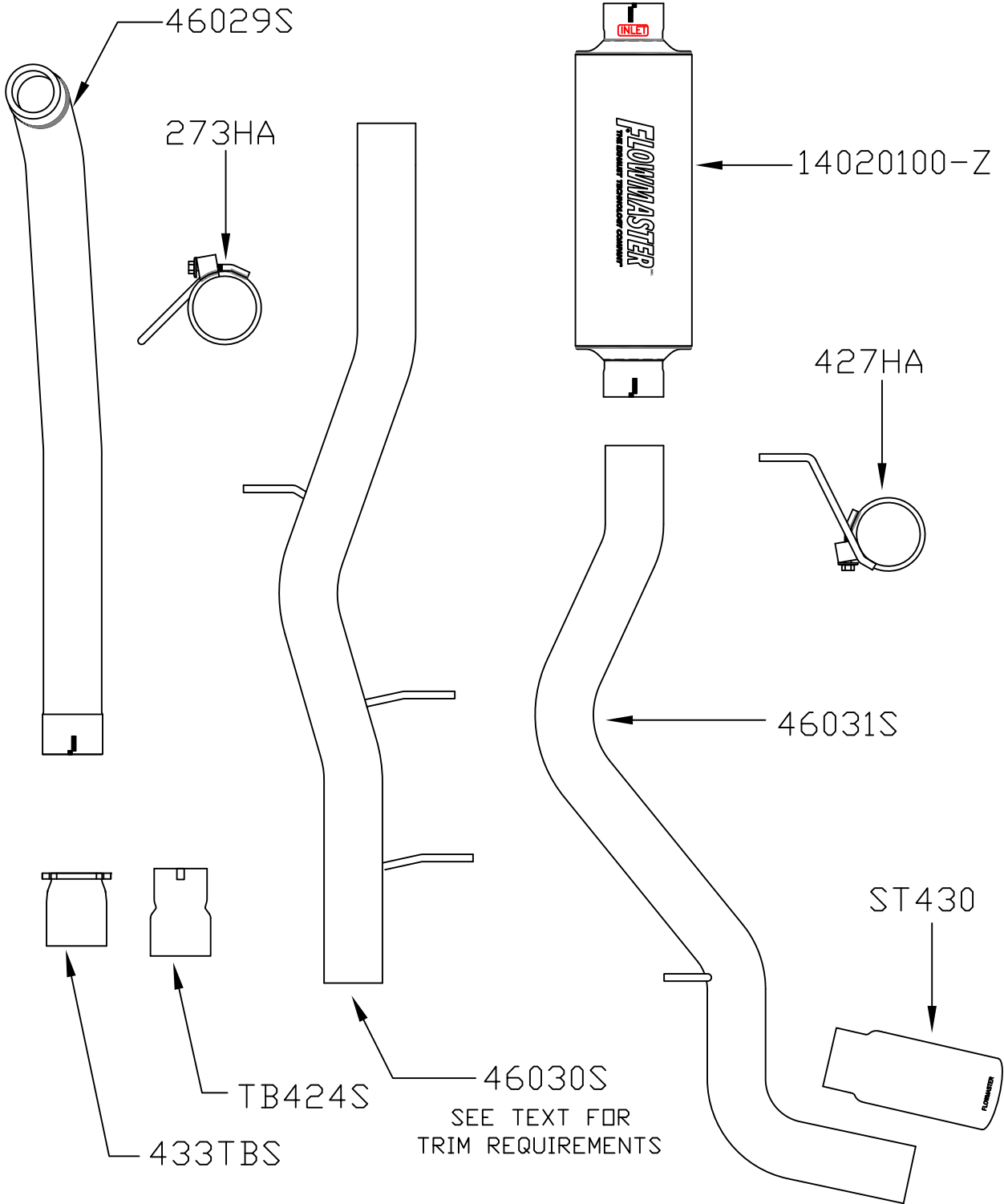
<u>Qty</u>	<u>Description</u>	<u>Part</u>	
1	Turbo Down pipe-Lower	46029S	
1	Intermediate Pipe	46030S	
1	Muffler	14020100-Z	
1	Tail Pipe	46031S	
1	Stainless Tip	ST430	
1	Flanged cat adapter	433TBS	
1	Adapter Pipe	TB424S	
1	Parts Kit	PK583	
	1	Clamp/Hanger Assy. Rear	427HA
	1	Clamp/Hanger Assy. Front	273HA
	2	4" Band Clamps	MC400BS
	1	3.50" Ring Clamp	MC350R
	4	1/2" Hanger Keepers	HW503



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SEE TEXT FOR TRIM REQUIREMENTS