



# **FORCE II™**

## **409S Stainless Steel**

### **SYSTEM #817544**

**1999-2003 FORD F-SERIES SUPER DUTY**  
7.3L POWERSTROKE TURBO DIESEL ENGINE  
ALL WHEELBASES

01/09/12

#### **Removal:**

- 1) Raise the vehicle and support with stands.
- 2) Use a pry bar to separate the six 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.
- 4) At the bottom of the stock downpipe there will be a two bolt flanged connection. Remove the two nuts and lower the rear portion of the exhaust system from the vehicle.
- 5) Using a hacksaw or sawsall cut the stock downpipe at a point 18" ahead of the bottom flange. This is necessary for removal. From the top of the engine there is a V-band clamp at the rear of the turbo housing that secures the downpipe. Use an 11mm deep socket to loosen and remove the single T-bolt/nut on this clamp. This will allow the upper portion of the downpipe to be removed down through the bottom side. It may be necessary to "whack" the pipe with a hammer from below in order to break the clamp loose.

#### **Installation:**

- 1) From the bottom, fit the upper downpipe **#46032S** up into position on the turbo outlet. Use the original V-band clamp to secure the pipe to the joint. Tighten the bolt on the clamp enough to hold, but still allow for adjustment.
- 2) From the rear, carefully slide the lower downpipe **#46033S** over the crossmember and up into position on the upper downpipe. Install a clamp at this connection but tighten only enough to hold in position. The clearance on this pipe is tight but final adjustment at the end of installation will provide adequate clearance.
- 3) Install the hanger clamp **#277HA** onto the front rubber mount on the vehicle.
- 4) Prepare the extension pipe **#46060S** by trimming as required:
  - Crew Cab/Long Bed – No trim required
  - Crew Cab/Short Bed – Trim 15 1/2"
  - Extra Cab/Long Bed – Trim 13 1/2"
  - Extra Cab/Short Bed – Trim 29 1/2"

- 5) Install the intermediate clamp/hangers **#429HA** and **#276HA** into the rubber frame mounts that support the extension pipe in front of the muffler. (The second rubber mount is not present on some wheelbases and will not require the extra clamp/hanger.)
- 6) Slip the muffler onto the rear of the extension pipe. Tighten the clamp enough to hold, but still allow for adjustment.
- 7) Connect the clamp/hanger **#430HA** to the two rubber mounts just above the muffler outlet connection and use to support the rear of the muffler. Tighten the clamp enough to hold, but still allow for adjustment.
- 8) Place tailpipe **#46035S** into position over the axle and into the muffler outlet. Connect the hanger at the rear of the pipe with the rubber mount on the vehicle. Install a 4" clamp at the muffler outlet connection and tighten enough to hold, but still allow for adjustment.
- 9) Adjust the position of all pipes and muffler to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind.
- 10) Tighten all clamped connections down securely. Place a supplied hanger keeper onto the ends of all 4 clamp hangers as well as the tailpipe hanger. The keepers prevent the hanger rods from pulling out of the rubber mounts on the vehicle.
- 11) 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 Downpipe	46032S
1	Lower Downpipe	46033S
1	Connector Pipe	46060S
1	Muffler	14020100-Z
1	Tail Pipe	46035S
1	Parts Kit	PK595
1	Front Clamp/Hanger Assy.	277HA
1	Mid Clamp/Hanger Assy.	276HA
1	Muffler Inlet Clamp/Hanger Assy.	429HA
1	Rear Clamp/Hanger Assy.	430HA
2	4" Band Clamps	MC400BS
6	1/2" Hanger Keepers	HW503



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Installation diagram for:  
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