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***Doc.# BD81018 v1.0.0***

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***BULLY DOG***

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**Call: 866-bullydog (866-285-5936)**



# **BULLY DOG**

**#1 IN PERFORMANCE**

## **INSTALLATION MANUAL**



### **Vehicle Application**

### **Part#**

Ford 7.3 L Power Stroke 4" Rapid Flow Aluminized Exhaust '99-'03

181510

Ford 7.3 L Power Stroke 4" Rapid Flow Aluminized Exhaust '99-'03 F-350, F-450, & F-550

181610





## TROUBLESHOOTING:

If you have questions during the installation of this product, please visit [www.bullydog.com/Product\\_Updates.php](http://www.bullydog.com/Product_Updates.php).

The latest version of these instructions can be found at the same location. Please review the Troubleshooting section on page 9 before calling technical support to cover most common issues. Technical support is available by calling 866-bullydog (866-285-5936).

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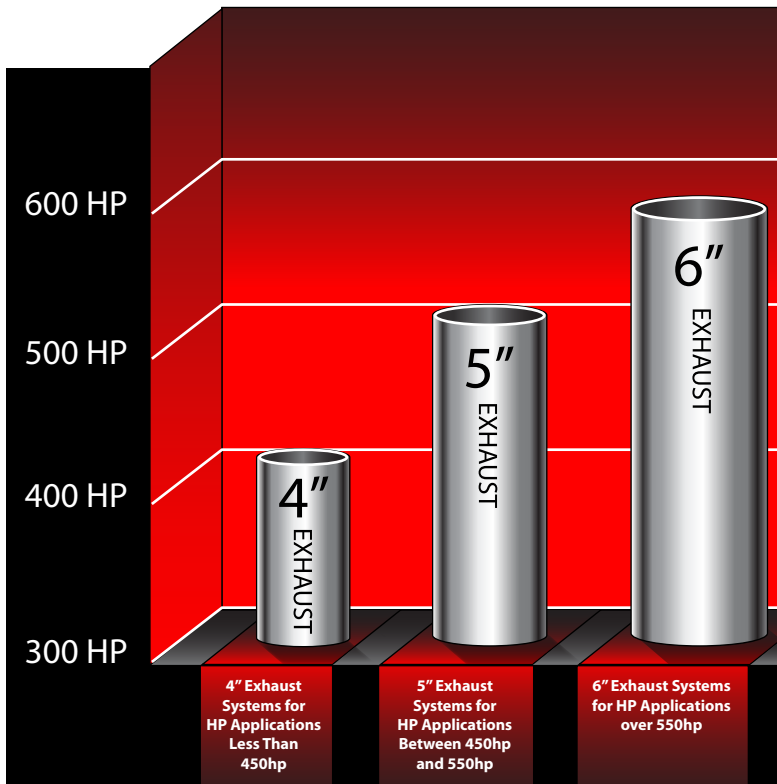
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## INTRODUCTION

The Bully Dog Rapid Flow Exhaust Systems have been specially designed to allow the lowest mandrel bends in the industry. The lower mandrel bends allow increased air flow which reduces exhaust temperatures, burns more fuel in the combustion chamber adding additional horsepower and fuel economy. This instruction set covers both the 4" Rapid Flow Aluminized Exhaust designed specifically for the 7.3L Power Stroke Excursion. And the 4" Rapid Flow Aluminized Exhaust designed specifically for the F-550 & F-650 trucks & Vans. Both systems install the same way with the only difference being the size of the second straight pipe. The 181610 includes two 48" straight pipes, while the 181510 has one 48" and one 24" straight pipe.

*Note: This instruction set and the Rapid Flow Exhaust systems included are made for the '99-'03 Ford Excursion with the 7.3L Power Stroke or the '99-'03 F-350, F-450 or F-550 trucks & vans with the 7.3L Power Stroke with an auxiliary tank.*

## BULLY DOG'S RULE OF THUMB FOR EXHAUST SIZES

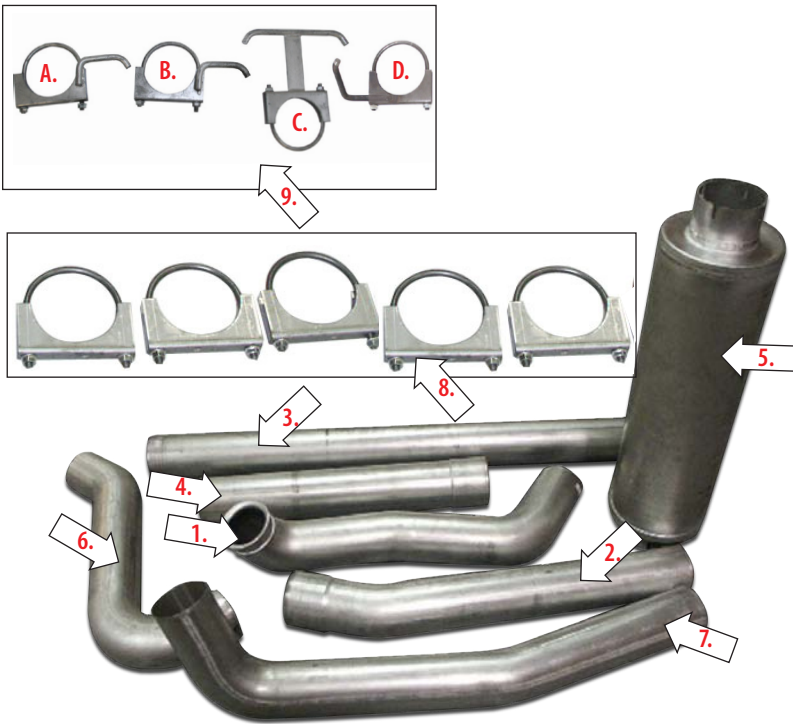


## BILL OF MATERIALS

1. Down Pipe
2. Second Piece Down Pipe
3. 48" Straight Pipe (2 pieces 181610)
4. 24" Straight Pipe (not included 181610)
5. Muffler
6. Front Piece Tail Pipe
7. Tail Pipe Tip
8. Clamps (3 pieces)
9. Hangers (4 pieces)
- A. Second piece Down Pipe
- B. Straight Pipe
- C. Rear of Muffler
- D. Front Piece Tail Pipe

## TOOLS NEEDED

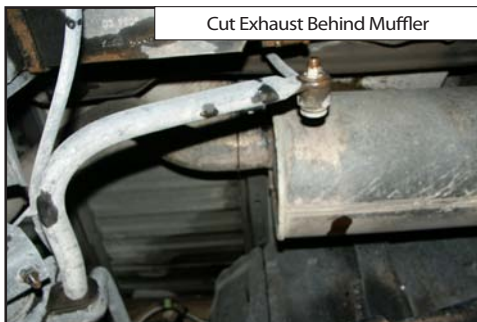
- 9/16" Wrench
- Sawzall
- Silicone Spray Lubricant
- 7/16" Deep Socket
- Socket Wrench
- Channel Locks



## REMOVAL OF STOCK EXHAUST SYSTEM

*In these steps you will remove the stock exhaust system.*

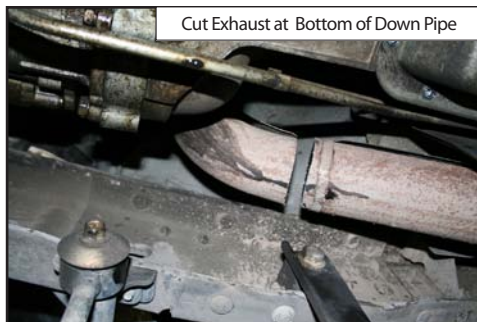
1. Use a sawzall to cut the exhaust immediately behind the muffler.



Cut Exhaust Behind Muffler

2. Cut the exhaust on one of the Straight Pipes in front of the muffler.

3. Use a Sawzall to cut the exhaust system at the bottom of the Down Pipe.



Cut Exhaust at Bottom of Down Pipe

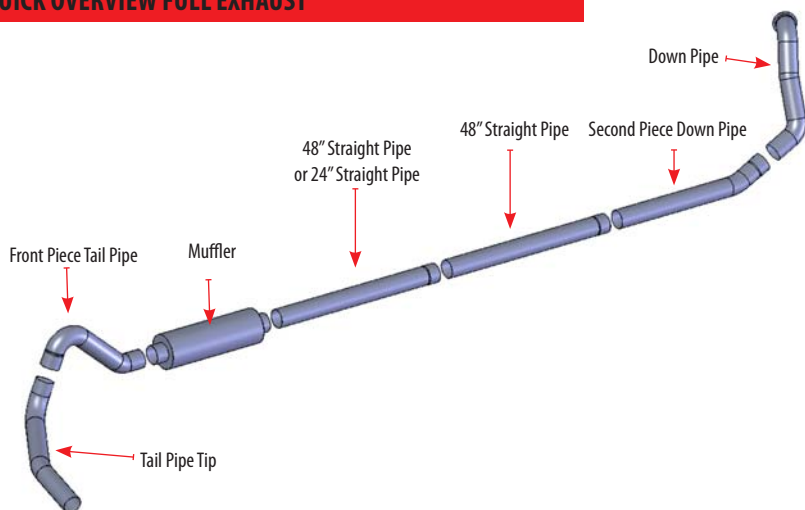
4. To make removing the Hangers an easier process, it is recommended that you use a silicone spray lubricant to spray each of the rubber hangers holding the stock exhaust.

5. Remove each piece of the stock exhaust system, including the stock exhaust hangers. To remove the Down Pipe use a 7/16" deep socket to loosen the stock band clamp. The stock band clamp will be used on the new system.

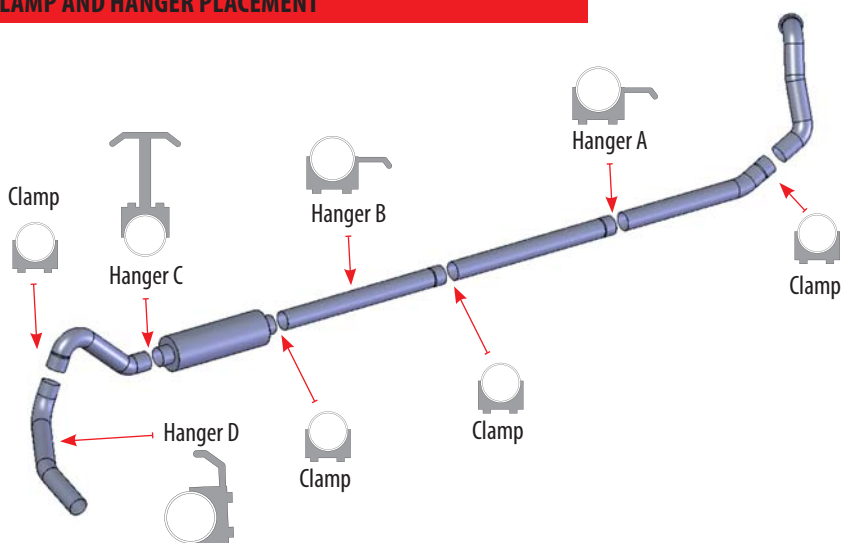


Remove Hangers

## QUICK OVERVIEW FULL EXHAUST



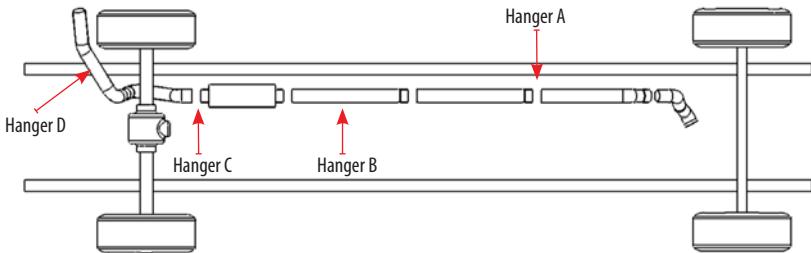
## CLAMP AND HANGER PLACEMENT



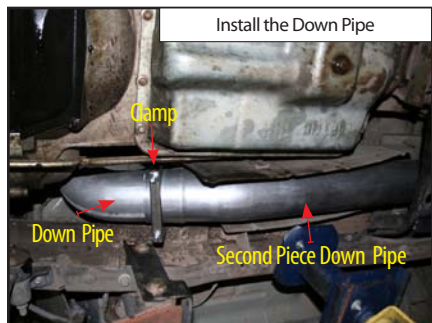
## INSTALLATION OF THE BULLY DOG RAPID FLOW EXHAUST SYSTEM

*In these steps you will install the Rapid Flow Exhaust System. Bully Dog's Exhaust Systems are one-cut systems, meaning that you should only have to cut one pipe or less if installed correctly.*

**IMPORTANT:** Do not over-tighten clamps. Too much torque will result in deformation of the exhaust. For best results when doing the installation, tighten the clamps enough to hold the exhaust pieces in place, but don't tighten down until the entire exhaust system is installed.

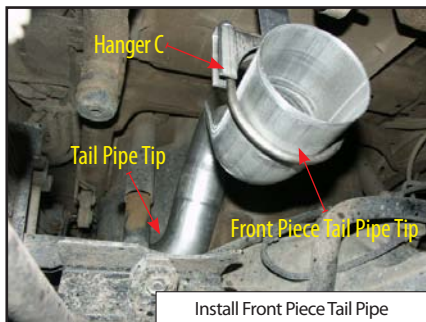


1. It is suggested that before installing the system on the truck, the Rapid Flow Exhaust System be laid out on a large flat surface to acknowledge the location of each piece.
2. Place all of the supplied Hangers into their appropriate locations as shown in the above diagram. Hanger A will also serve as a clamp between the Second Piece Down Pipe and a Straight Pipe. Hanger B will be located on a Straight Pipe and Hanger C will serve as both a hanger and clamp on the rear of the muffler. Hanger D will hold the Tail Pipe Tip.
3. Install the Down Pipe. You will use the stock band clamp to secure the Down Pipe to the turbo. Secure the Down Pipe by tightening the stock band clamp with a 7/16" deep socket.
4. Hang the Second Piece Down Pipe from Hanger A and secure the Second Piece Down Pipe to the Down Pipe using one of the supplied clamps. At this point, secure the connection so that the piece will stay, but do not tighten down until the entire exhaust is installed.
5. Connect one of the Straight Pipe Pieces into the Second Piece Down Pipe by tightening Hanger A enough so that the piece stays in place.

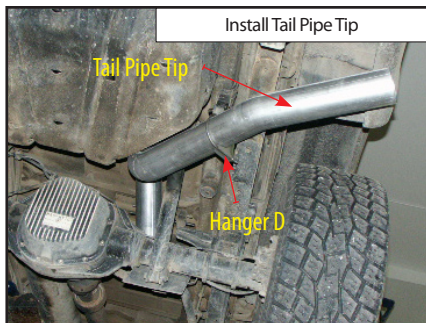


**NOTE:** At this point, you will skip installing the other Straight Pipe and Muffler and continue working towards the rear of the vehicle.

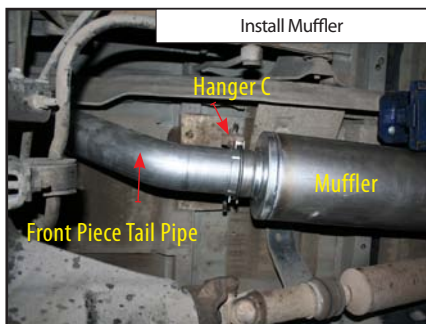
6. Hang the Front Piece Tail Pipe from Hangers C. Ensure that the bend of the Front Piece Tail Pipe is directly over the axle.

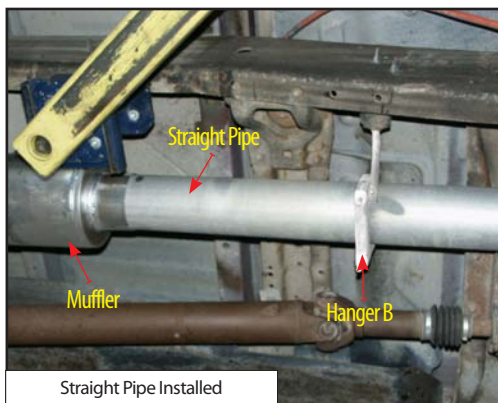
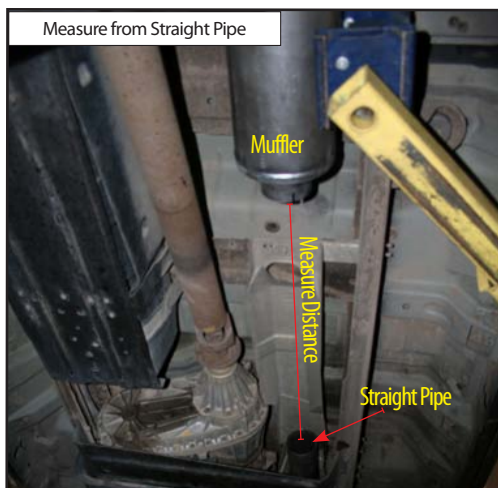


7. Install the Tail Pipe Tip by sliding it into the Front Piece Tail Pipe. Hang the combined pieces from Hanger D.



8. Install the Muffler by connecting it into the Front Piece Tail Pipe and then tightening Hanger C.





9. At this point it is time to install the other Straight Pipe. You will need to measure the Straight Pipe to the correct length, keeping in mind that you will need to have an extra 3 inches of overlap when you cut the pipe.

10. Once the entire exhaust system is installed, inspect the system to ensure that no part of the exhaust is in direct contact with the chassis or body; adjustments may be necessary.

11. Return to each of the Clamps and tighten with a 9/16" wrench. Again, do not over tighten Clamps. Having any part of the exhaust system in direct contact with any part of the body or chassis will cause the exhaust to rattle.

12. Stainless Steel Tips are available from Bully Dog to give your truck that polished, classy, look.

Part Number:180450

4" Systems

Part Number:180291

Part Number: 180466



TROUBLESHOOTING/FAQ

| CONDITION                                            | POSSIBLE SOURCES | ACTION                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
|------------------------------------------------------|------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Which is better a 4" exhaust or a 5" exhaust system? | General          | It really depends on the application. A bigger exhaust system will allow more airflow and lower exhaust temperatures. However too large of an exhaust system without other increases in horsepower will lower back pressure and give the vehicle a sluggish start. Bully Dog recommends a 4" Rapid Flow Exhaust system for horsepower applications under 450 hp. 5" Rapid Flow Exhaust Systems are recommended for applications running between 450 to 550 horsepower. |
| Exhaust Rattle                                       | Exhaust Sounds   | Either one of the clamps is not tight or the exhaust is coming in contact with the chasis or body. Adjust the exhaust to ensure that no contact is made.                                                                                                                                                                                                                                                                                                               |
| Exhaust is too loud                                  | Exhaust Sounds   | If your exhaust seems too loud, Bully Dog can sell you another muffler which will allow you to double stack mufflers. This extra muffler would take place of one of the straight pipes included with this system.<br><br>Part # 185011                                                                                                                                                                                                                                 |
| Exhaust is not loud enough                           | Exhaust Sounds   | If your exhaust is too quiet (and is being used exclusively for off-road use) you can purchase another staight pipe to replace your muffler.<br><br>Part # 185017                                                                                                                                                                                                                                                                                                      |

## WARRANTY & DISCLAIMER

### REMEMBER, THIS IS A PERFORMANCE PRODUCT, USE AT YOUR OWN RISK.

*This product is not intended to be used to break the law.*

Do not use this product until you have carefully read the following agreement. This agreement sets forth the terms and conditions for the use of this product. The installation of this product indicates that the buyer has read and understands this agreement and accepts the terms and conditions. Never exceed recommended vehicle or tire top speed ratings.

### DISCLAIMER OF LIABILITY

Bully Dog Technologies, LLC. Its distributors, jobbers, and dealers (hereafter Seller) shall be in no way responsible for the product's proper use and service. THE BUYER HERBY WAIVES ALL LIABILITY CLAIMS.

The Buyer acknowledges that he is not relying on the Sellers skill or judgment to select or furnish goods suitable for any particular purpose and that there are no liabilities which extend beyond the description on the face hereof, and the Buyers hereby waives all remedies or liabilities expressed or implied, arising by law or otherwise, (including without any obligation of the Seller with respect fitness, merchantability and consequential damages) or whether or not occasioned by the Seller's negligence.

The Seller disclaims any warranty and expressly disclaims any liability for personal injury or damages. The Buyer acknowledges and agrees that the disclaimer of any liability for personal injury is a material term for this agreement and the Buyer agrees to indemnify the Seller and to hold the Seller harmless from any claim related to the item of the equipment purchased. Under no circumstances will the Seller be liable for any damages or expenses by reason of use or sale of any such equipment.

The Seller assumes no liability regarding the improper installation or misapplication of its products. It is the installer's responsibility to check for proper installation and if in doubt contact the manufacturer.

The Buyer is solely responsible for all warranty issues from the manufacturer.

### LIMITATION OF WARRANTY

BULLY DOG TECHNOLOGIES, LLC. (Hereafter "Seller") gives Limited Warranty as to description, quality, merchantability, and fitness for any particular purpose, productiveness, or any other matter of Seller's product sold herewith. The Seller shall be in no way responsible for the products proper use and service and the Buyer hereby waives all rights other than those expressly written herein. This warranty shall not be extended, altered or varied except be a written instrument signed by Seller and Buyer.

The Warranty is Limited to one (1) year from the date of sale and limited solely to the parts contained within the products kit. All products that are in question of Warranty must be returned prepaid to the Seller and must be accompanied by a dated proof of purchase receipt. All Warranty claims are subject to approval by BULLY DOG TECHNOLOGIES, LLC.

Under no circumstances will the Seller be liable for any labor charged or travel time incurred in diagnosis for defects, removal, or reinstallation of this product or any other contingent expenses.

Under no circumstances will the Seller be liable for any damage or expenses incurred by reason of the use or sale of any such equipment.

IN THE EVENT THAT THE BUYER DOES NOT AGREE WITH THIS AGREEMENT: THE BUYER MAY PROMPTLY RETURN THIS PRODUCT, IN A NEW AND UNUSED CONDITION, WITH A DATED PROOF OF PURCHASE TO THE PLACE OF PURCHASE WITHIN TEN (10) DAYS FROM DATE OF PURCHASE FOR A FULL REFUND.

THE INSTALLATION OF THIS PRODUCT INDICATES THAT THE BUYER HAS READ AND UNDERSTANDS THIS AGREEMENT AND ACCEPTS ITS TERMS AND CONDITIONS.