



FORCE II **409S® Stainless Steel** **SYSTEM #817135**

1987-1996 FORD F-150
4.9L, 5.0L & 5.8L ENGINES
ALL W.B. EXCEPT KING CAB LONG BED

05/27/11

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) Apply a penetrating lubricant to the muffler clamp nuts at the catalytic converter connection and the 3 rubber hangers that support the rear of the system. This will greatly ease the removal.
- 3) With a 15mm wrench, remove the muffler clamp at the catalytic converter to muffler connection.
- 4) Put a stand under the rear of the system to support it when the rubber hangers are disconnected.
- 5) Using a pry bar, disconnect the 3 rubber hangers at the rear of the system.
- 6) Slide the system back to separate the muffler from the catalytic converter. It may be necessary to slice the pipe or heat the connection with a torch to loosen it. Use extreme caution.
- 7) Remove the system from under the vehicle.

Installation:

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) Slip pipe **#TB220S** onto the rear of the catalytic converter and install a 2 1/4" clamp. Tighten down securely.
- 3) Pipe **#TB221S** must be trimmed for use on these applications:
 - 133" W.B. – Cut 22" off of non-slip fit end
 - 139" W.B. – Cut 16" off of non-slip fit end
 - 117" W.B. – Pipe **#TB221S** can be discarded
- 4) Slip pipe **#TB221S** onto the end of pipe **#TB220S** and install a 3" clamp. Tighten lightly.
- 5) Raise muffler **#853070-Z** into position and connect to pipe **#TB221S**. (Be sure to install inlet forward.) Install a 3" clamp and tighten lightly.

- 6) Place pipe **#26021S** in position over the rear axle and slip it into the rear of the muffler. Connect the 3 rubber hangers to support the pipe. Install a 3" clamp and tighten lightly.
- 7) Slip pipe **#26333S** onto the rear of **#26021S**. Install a 3" clamp and tighten lightly.
- 8) Install tip **#ST429** and tighten just enough to hold in place.
- 9) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. (The muffler will fit at an angle.) 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) Attach the heat shield to the top of the muffler by wrapping and firmly tightening the four band clamps around the muffler body using a 8mm socket or standard screwdriver.
- 11) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the end of the hangers welded to the over-axle pipe. This will prevent the hangers from slipping out of the rubber mounts.
- 12) For a more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
1	Adapter Pipe	TB220S	
1	Connector Pipe	TB221S	
1	Muffler	853070-Z	
1	Over axle Pipe	26021S	
1	Exit Pipe	26333S	
1	Stainless Tip	ST429	
1	Parts Kit	PK554	
4	3" Muffler Clamps		MC300BS
1	2 1/4" Muffler Clamp		MC225BS
3	7/16" Hanger Keepers		



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Installation diagram for:
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