



FORCE II™

409S® Stainless Steel

Installation Instructions

SYSTEM #817570

2003-2008 TOYOTA 4RUNNER V6
4.0L V6 & 4.7L V8 ENGINE

02/23/12

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. Spray all factory rubber hanger mounts as well as the front and rear flange bolts with a lubricant, this will greatly ease removal.



2) Unbolt the tailpipe connection behind the muffler using a 14mm socket or wrench, then remove the factory tailpipe hanger from the rubber mount on the vehicle and set tailpipe aside.



3) Using a 14mm socket or wrench, remove the two factory spring-loaded bolts at the inlet pipe flange connection and set aside (these will be used later).



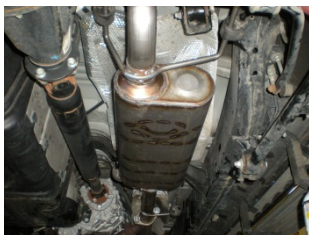
4) Support the muffler with a stand and separate the four hangers on the muffler and front pipe assembly from the rubber mounts on the vehicle. Lower the stand and remove the assembly from the vehicle.



5) For V6 models, use inlet pipe **#16756S**, for V8 models use inlet pipe **#16759S**. Place the inlet pipe into position and slide the two hangers on the pipe into the rubber mounts on the vehicle. Take the supplied M10x1.25x65MM bolts and slide on a flat washer and then a steel sleeve. Place the factory spring over the sleeve, re-install the bolts onto the flanged connection and tighten securely.



6) Place the supplied 2½" clamp onto the inlet of muffler **#852572-Z** and slide onto the inlet pipe and support with a stand. Level the muffler and tighten the clamp enough to hold, but still allow for adjustment.



7) Place the supplied hanger clamp assembly **#444HA** onto the outlet of the muffler and into the factory rubber mounts on the vehicle. Tighten just enough to hold in position.



8) Place tailpipe assembly **#16757S** up over the rear axle and into the muffler outlet. Connect the hanger at the rear of the pipe to the rubber mount on the vehicle. Adjust the tip to the desired rotation and tighten the clamp enough to hold, but still allow for adjustment.

9) Adjust the position of all pipes and mufflers to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. 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	Muffler	852572-Z
1	V6 Inlet Pipe	16756S
1	V8 Inlet Pipe	16759S
1	Tailpipe	16757S
1	Parts Kit	PK625
1	Rear Muffler Hanger	444HA
1	2-1/2" Band Clamp	MC250BS
2	M10x1.25x65MM Bolt	HW231
2	1/2" x 1 1/2" Steel Spacer Tube	HW506
2	3/8" Flat Washer	HW303



Installation diagram for:
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