



FORCE II

409S Stainless Steel

Installation Instructions for:

SYSTEM #817653

2011-2013 RAM 1500 SERIES TRUCKS

3.6L ENGINE – WITHOUT FACTORY EQUIPPED DUAL TAILPIPES

04/23/13

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) To make removal of the stock system easier, you may choose to cut the stock tailpipe off where it exits the muffler. This can be done using a hacksaw or sawsall. After cutting, remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and set aside. This step is not mandatory, but makes removal easier.
- 3) Support the muffler with a stand and remove the two hangers at the rear of the muffler along with the hangers in front of the muffler from the rubber mounts on the vehicle. Then loosen the ring clamp at the muffler inlet connection. Once loose, slide the muffler off of the front pipe and set aside.

Installation:

- 1) Connect adapter pipe **#TB687S** to the factory inlet pipe; line up the notch in the adapter with the tab on factory pipe. Then slide a 3" clamp onto the inlet pipe slip fit, tighten the clamp securely.
- 2) Place a supplied 3" clamp onto the muffler inlet and slide the muffler onto the back of the adapter pipe, level the muffler and support with a stand. Tighten the clamp enough to hold, but still allow for adjustment.
- 3) Place a supplied 2.50" clamp onto the right muffler outlet then place the right side tailpipe **#86043S** into position over the rear axle and into the muffler outlet. Connect the hangers at the front and rear of the pipe to the rubber mounts on the vehicle. Tighten the clamp enough to hold, but still allow for adjustment.
- 4) At the rear of the frame on the drivers side of the vehicle (next to the spare tire) there is a pair of hanger mounts welded to the bottom of the frame. Place the supplied **HA168** rubber hanger onto the inner hanger of this pair.
- 5) Place a 2.50" clamp onto the left muffler outlet then place the front section of the left side tailpipe **#86044S** into the left side muffler outlet and connect the hanger on the front of the pipe to the rubber mount on the vehicle. Tighten the clamp enough to hold, but still allow for adjustment.
- 6) Place a 2.50" clamp onto the expanded end of pipe **#86045S**, then connect to the back of pipe **#86044S** by sliding the two sections together at the slip-fit connection over the rear axle. Place the hanger at the rear of the tailpipe into the rubber mount installed in step 4 above. Tighten the clamp enough to hold, but still allow for adjustment.

7) Connect either the rear exit pipes **#86046S** or side exit pipes **#86047S** to the back of both over axle pipes. Place a 2-1/2" clamp onto the slip-fit connections and tighten enough to hold in place. Place the two stainless tips onto the exit pipes and tighten the pinch bolts enough to hold in place. Rotate the exit pipe and tip to the desired position.

8) Adjust the position of the pipes and muffler to provide a satisfactory fit. 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 the clamps 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	Adapter Pipe	TB687S
1	Muffler	8530522-Z
1	Right Tailpipe	86043S
1	Left Tailpipe, Front Section	86044S
1	Left Tailpipe, Rear Section	86045S
2	Rear Exit Pipe (R/L)	86046S
2	Side Exit Pipe (R/L)	86047S
2	Stainless Tip	ST436
1	Parts kit	PK727
5	2-1/4" Camp	MC225BS
2	3" Clamp	MC300BS
1	Rubber Mount	HA168



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Installation diagram for:
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