

FLOWMASTER™

FORCE II™

SYSTEM #17345

1999-04 FORD F-250, 133" AND 155" W.B.

ALSO CREW CAB/ F-350 168.4"W.B WITH V10/V8 ENGINES

10/11/07

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) Support the muffler with a jack stand or muffler stand to support it when the hangers are removed from the rubber mounts.
- 3) Loosen the 3" band clamp, first one forward from front of muffler and slip muffler and tailpipe off (you may need to heat this connection with a torch to make removal easier). To remove the system in one piece, remove the bottom bolt from the right rear shock and pull the shock to the rear to clear the tailpipe. Or you can cut the tailpipe just behind the muffler and remove the system in two pieces.
- 4) Then using a pry bar, separate the four rubber hangers that support the stock exhaust system, one in front of the muffler, two directly behind the muffler and one at the rear of the tailpipe. A lubricant such as WD40 or lithium grease will ease separation.
- 5) Carefully remove the stock tailpipe and muffler from the vehicle and set aside.

Installation: (If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high tempature paint over the welded areas can help to prevent surface rust and premature corrosion.) **Note: 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.**

- 1) Connect the hanger/clamp assembly #217HA to the two rubber mounts on the vehicle where the stock muffler hangers were located.
- 2) Install inlet pipe #TB315 onto the back of the stock inlet pipe and clamp using the 3" clamp provided, tighten enough to hold in place, but still allow for adjustment.
- 3) Slip the inlet of the muffler #53073 onto the back of the inlet pipe #TB315 and install the 3" clamp provided. Place the rear of the muffler into the clamp hanger #217HA. Tighten the clamp on the inlet enough to hold in place but still allow for adjustment.
- 4) Insert tailpipe #26167 into the outlet of the muffler, then slide on clamp hanger #278HA around back of tailpipe and into the stock hanger mount on the vehicle. Then tighten down both clamp hanger enough to hold but still allow for adjustment.

- 5) Place stainless tip #ST429 onto the back of tailpipe #26167 rotate tip to desired position and tighten clamp enough to hold in place but still allow for adjustment.
- 6) Adjust the position of the muffler and tailpipe to provide adequate clearance for suspension travel. Maintain a minimum of ¾" clearance between the Flowmaster system and the drivetrain, all chassis components, brake lines and fuel lines.
- 7) Tighten down all clamped connections securely. Note: For a cleaner fit, the slip fit connections can be welded and the clamps removed. After the system is secure, slide the 7/16" hanger keepers onto the clamp hanger at the rear of the muffler. Also slide the ½" hanger keeper onto the hanger welded to the rear of the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.

Note: We recommend welding all slip fit connections.

Packing List for Force II System #17345

<u>Qty.</u>	<u>Description</u>	<u>Part #</u>
1	Inlet pipe	TB315
1	Muffler	53073
1	Tailpipe	26167
1	Stainless Tip	ST429
1	Part kit	PK416
1	Clamp Hanger	278HA
1	Clamp hanger	217HA
2	3" clamps	MC300G
2	7/16"Hanger keeper	HW502
1	½" Hanger Keeper	HW503

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