



**FORCE II™**  
**SYSTEM #17462**  
**1997 FORD F-150 TRUCK**  
**V8 · ALL WHEEL BASES**  
**(DOES NOT FIT OFF ROAD PKG)**

12/07/09

**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) Separate the three rubber hangers on the muffler and tailpipe from their rubber mounts on the vehicle. Unbolt the hanger at the rear of the tailpipe from the frame. This hanger will not be used with the new system.
- 3) Support the muffler with a stand. Remove the clamp at the front of the muffler. Because this connection may be significantly crimped by the clamp, it may be necessary to heat or slice open this connection for ease of removal.
- 4) Remove the muffler and set aside.

**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) Place muffler **#525562-114** in position on the pipe from the catalytic converter. Install a 2 1/2" clamp and tighten securely.
- 3) Support the muffler by connecting the two muffler hangers to the rubber mounts.
- 4) Using the provided 3/8" bolts, nuts and washers bolt hangers **#197HA** to the frame on both sides of the vehicle using the two large oval holes located at the rear of the frame. Then slide the rubber hanger **#HA168** onto the round stock of the frame hanger.
- 5) Place the right side tailpipe **#16303** in position over the axle and slip over the right side muffler outlet. Place the rear hanger on the tailpipe into the rubber hanger **#HA168** (bottom hole).
- 6) Place the front section of the left side tailpipe **#16314** over the left side muffler outlet and insert the hanger into the left rubber hanger mount on the frame.
- 7) Connect the rear section of the left side tailpipe **#16302** onto the back of the front section by sliding the two sections together at the slip-fit connection over the rear axle. Place the rear hanger on pipe into the bottom hole of the rubber hanger **#HA168**. Install a 2 1/2" clamp on the over-axle slip-fit connection.

- 8) Connect exit pipes **#TB513** (rear exit) or **#16317** (side exit) onto the ends of both tailpipes and place a provided 2 1/2" clamp onto these connections. Tighten enough to hold but still allow for adjustment. Place the stainless tips onto the exit pipes and tighten the clamps enough to hold but still allow for adjustment. Rotate the exit pipes and tips to the desired distance from the bumper/fender so angle cut on tips is in desired location.
- 9) Adjust the position of all pipes and muffler to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind.
- 10) Tighten all clamped connections down securely. Place the supplied 7/16" hanger keepers on the round stock. These will prevent the hangers from slipping out of the rubber mounts.
- 11) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

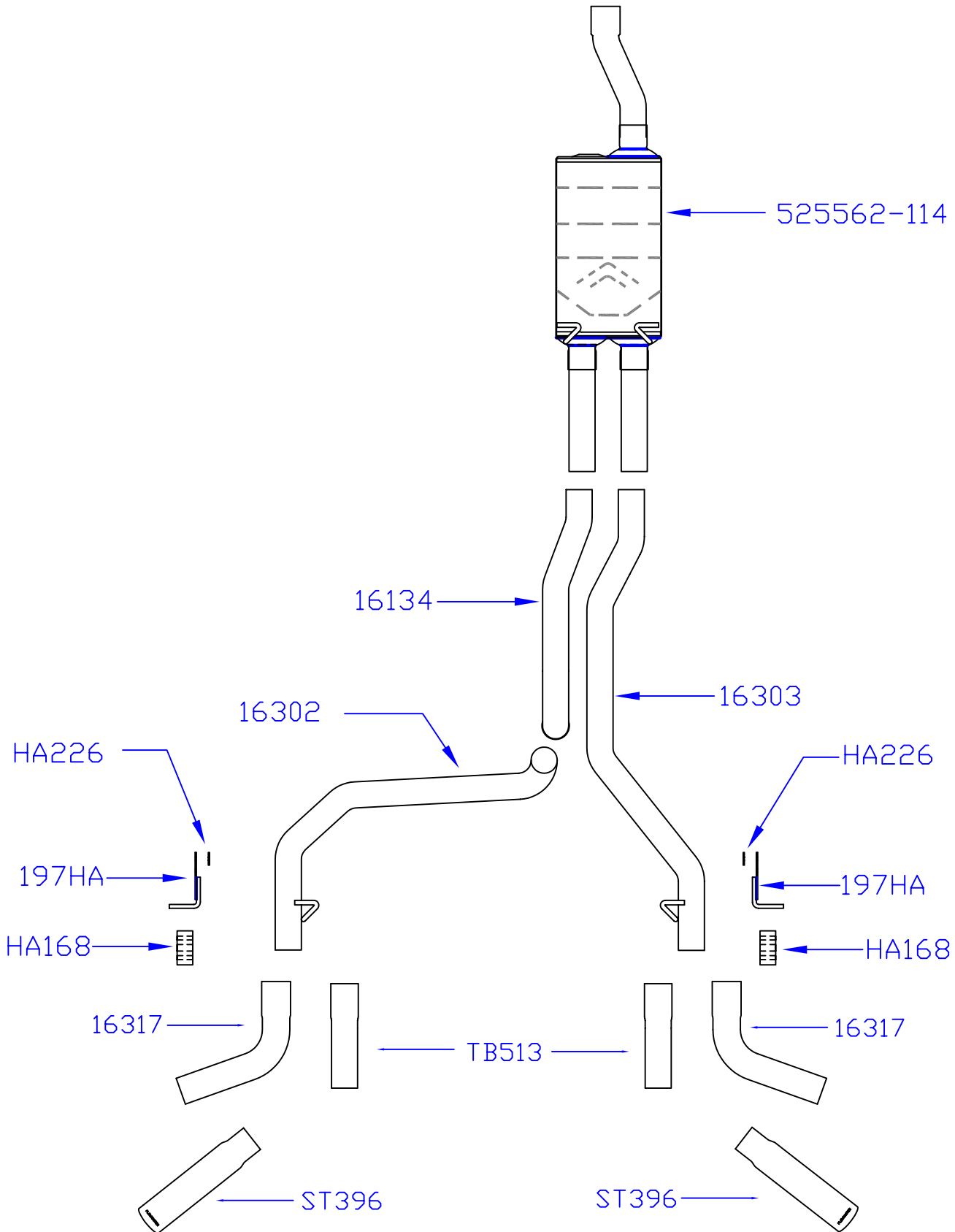
### **PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Muffler	525562-114
1	Tailpipe (R)	16303
1	Tailpipe (Front L)	16134
1	Tailpipe (Rear L)	16302
2	Side Exit Tailpipes (R/L)	16317
2	Rear Exit Tailpipes (R/L)	TB513
2	Stainless Tips (R/L)	ST396
1	Parts kit	PK367
6	2 1/2" clamp	MC250S
2	Rubber Hanger	HA168
2	Hanger plate	HA226
2	Hanger assembly	197HA
6	7/16" Hanger keepers	
2	3/8" x 1" Bolt	
2	3/8" Nut	
2	3/8" lock washer	



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Installation diagram for:  
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Technical Support (800) 544-4761