



409S® Stainless Steel

SYSTEM #817391

1971-1972 MOPAR "B" BODY

2 1/2" HEADER-BACK SYSTEM

06/05/12

Installation:

- 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. 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) On the inside of the rear frame rails, roughly 18" forward of the bumper, you will find holes that will be used to mount the tailpipe hanger mounts. You should see a square hole with a round hole just below it. Carefully place the 3/8" bolts through the square hole and back so that they stick out of the round hole. Then place the hanger mounts **#310HA** (left) and **#311HA** (right) onto the bolts and secure with nuts and lock washers. Slide a rubber hanger **#HA168** onto each of the hanger mounts.
- 3) Place both tailpipes **#16429S** and **#16430S** up over the rear axle. Slip the hanger rods at the rear of the pipes into the rubber hangers that were installed in Step 2.
- 4) Prepare the right side muffler by placing the clamp/hanger **#447HA** onto the outlet of one of the mufflers and tighten just enough to hold in place. (The hanger rod should point opposite to the offset of the inlet neck.) Now connect the hanger mounting bracket **#313HA** using rubber hanger **#HA168**. (Both hanger rods should point the same direction.) Repeat the above procedure to prepare the left side muffler using clamp hanger **#447HA**, mounting bracket **#308HA** and rubber hanger **#HA168**.
- 5) Place the mufflers up into position and support with stands, then insert the tailpipes into the muffler outlets.
- 6) Slide a 2 1/2" clamp over each muffler inlet, then place the H-pipe assembly **#16428S** in its approximate position underneath the vehicle and connect the back of the H-pipes into the muffler inlets. Support with a stand and tighten the clamps just enough to hold in position.
- 7) There are no factory locations for the rear muffler hangers, so you will need to mark the hanger positions and then drill some holes in the rear seat pan area. In order to do this, you will now need to adjust the position of all the pipes and muffler to achieve a good fit. Once everything is in place, mark the two hole locations for the two hanger mounting brackets and drill the pan with a 3/8" bit. Now you need to go inside the vehicle and remove the rear seat so that you can see the holes you drilled. Place the mounting plate **#244HA** through the holes and replace the seat. Fasten the hanger mounts in place with the 3/8" nuts and washers.

8) The front connector pipes **#16421S** and **#16422S** are long enough to allow for many different header combinations; therefore, it is necessary to determine the proper length of the connector pipes. Once the proper length is determined, trim the front connector pipes to fit. Trim to proper length then raise them into position and connect to the H-pipe and header collectors or manifold down pipes using a standard header flange, Flowmaster venture cone or Flowmaster Ball Flange Kit.

9) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. 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) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers on the round stock sticking through the rubber muffler hangers. This 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.

Packing List

<u>Qty</u>	<u>Description</u>	<u>Part</u>
2	Muffler	852546-Z
1	Connector Pipe, (L)	16422S
1	Connector Pipe, (R)	16421S
1	H- Pipe Assembly	16428S
1	Left tailpipe	16430S
1	Right tailpipe	16429S
1	Hardware kit	PK633
2	Muffler Clamp Hanger (R/L)	447HA
1	Muffler Hanger Mount (L)	308HA
1	Muffler Hanger Mount (R)	313HA
1	Tailpipe Hanger Mount (L)	310HA
1	Tailpipe Hanger Mount (R)	311HA
2	Hanger Mounting Plate	244HA
4	Rubber Hanger	HA168
4	2½" Clamps	MC250BS
2	3/8"x 1" Bolt	HW208
6	3/8" Flat Washer	HW303
6	3/8" Lock Washer	HW309
6	3/8" Nuts	HW103
8	7/16" Hanger Keepers	HW502



Installation diagram for:
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