



**409S<sup>®</sup> Stainless Steel  
SYSTEM #817413  
1959-1964 CHEVROLET IMPALA**

06/24/11

**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 and tailpipe assembly with a stand. Using a flat blade screwdriver or pry bar remove the hangers from the rubber hangers. Remove the old pipes and hangers 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) Install **#328HA** hanger brackets (right and left front frame hangers) to existing holes in frame, using 5/16" self-tapping screws. *Note: Due to variances in years and OEM systems you may need to remove a hanger bracket on driver's side of frame to expose the necessary holes.* Place **#HA168** rubber hangers on when finished installing.
- 3) Install **#329HA** hanger bracket at the right rear of the frame to the leaf spring bracket using a 7/16" bolt, flat washer, lock washer and nut. When secured, place a **#HA168** rubber hanger onto it. Repeat on the left side using hanger **#330HA**.
- 4) Install **#16494S** left side mid pipe into position by sliding hangers into the rubber hangers attached to the frame hangers. Repeat for the right side using **#16495S**.
- 5) Once the mid pipes are in place there is a choice of four types of mufflers; 842544, 842554, 12518400 or 12518300. Take clamp **#MC250BS** and slide it on the front of the outlet pipe. Depending on the muffler you choose, slide the outlet of the muffler onto the front of the outlet pipes **#16494S** and **#16495S**. Slide the clamp over the muffler outlets and tighten enough to hold in place, but still allow for adjustment.
- 6) When the mufflers are in place, install the front adapter pipes **#16493S**. You must trim these pipes depending on the mufflers you selected. Below are the trims for the different mufflers we recommend for the kit.
  - Flowmaster HP II 12518300 or 12518400 – trim 14.75"
  - Delta 40 Series 842544 – trim 10.00"
  - Delta 50 Series 842554 – trim 14.00"

- 7) After you have made the proper cut, take clamps **#MC250BS** and slide them on the inlet of the mufflers. Slide the adapter pipes into the inlet of the mufflers. Tighten the clamp enough to hold, but still allow for adjustment.
- 8) Slide clamp **#MC250BS** onto the rear of the outlet pipe **#16494S**. Install the left side exit pipe **#16496S** before the rear tire. Tighten the clamp enough to hold, but still allow for adjustment. Repeat on the right side using outlet pipe **#16495S**.
- 9) Adjust the position of all mufflers and pipes 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 onto the ends of the hanger rods. This will prevent the hangers from slipping out of the rubber mounts.
- 11) For a more secure installation, we recommend welding all slip-fit connections.

#### **PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
2	Inlet Adapter Pipe(R/L)	16493S
1	Left Mid Pipe	16494S
1	Right Mid Pipe	16495S
1	Left exit pipe	16496S
1	Right exit pipe	16497S
1	Parts Kit	PK563
2	Front frame hanger R/L	328HA
1	Right rear frame hanger	329HA
1	Left rear frame hanger	330HA
8	Band Clamps	MC250BS
4	Rubber Hanger	HA168
2	3/8" X 1" Bolts	HW208
2	3/8" Nut	HW103
4	5/16" x 3/4" Cut thread bolt	HW225
4	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309
8	7/16" Hanger Keeper	HW502



Installation diagram for:  
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**AMERICAN THUNDER**

**409S. Stainless Steel**

