



# **FORCE II**

## **409S<sub>®</sub> Stainless Steel**

Installation Instructions for:  
**SYSTEM #817433**  
2007-2013 TOYOTA FJ CRUISER

10/11/12

### **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. Spray all factory rubber hangers with a lubricant for easier removal.
- 2) Unbolt the tailpipe connection behind the muffler using a 14mm socket or wrench, then remove the factory tailpipe hanger from the rubber mount on the vehicle and set tailpipe aside.
- 3) Using a 14mm socket or wrench remove the two factory spring loaded bolts at the inlet pipe connection and set aside (these will be used later).
- 4) Slide the muffler and inlet pipe assembly toward the rear of the vehicle. This will separate the four hangers from the factory rubber mounts on the vehicle. Remove and set aside.

### **Installation:**

- 1) Place inlet pipe **#16519S** up into place, sliding the two hangers into the factory rubber mounts. Install the two 14mm spring loaded bolts to the flanged connection.
- 2) Place the inlet of the muffler **#852557-Z** onto the inlet pipe and support with a stand. Install the 2-1/2" clamp and tighten enough to hold the muffler in place, but still allow for adjustment.
- 3) Place the supplied hanger clamp assembly **#439HA** onto the outlet of the muffler and into the factory rubber mounts on the vehicle. Tighten just enough to hold in position.
- 4) Place tailpipe assembly **#16531S** into the outlet of the muffler and slide the tailpipe hanger into the factory rubber mount on the vehicle.
- 5) Place stainless tip **#ST339** onto the tailpipe and tighten enough to hold, but still allow for adjustment. Rotate the tailpipe/tip to the desired position.
- 6) Adjust the position of the pipes, muffler and tip 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.

7) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the hanger rods on tailpipe. This will prevent the hangers from slipping out of the rubber mounts.

8) 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	Muffler	852557-Z	
1	Inlet Pipe	16519S	
1	Tailpipe	16531S	
1	3" Stainless Tip	ST339	
1	Parts Kit	PK617	
	1	Rear Muffler Hanger	439HA
	1	2-1/2" Clamp	MC250BS



Installation diagram for:  
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