



FORCE II™
409S Stainless Steel
SYSTEM #817525
1998-2003 FORD F-150 TRUCK
V8 · ALL WHEELBASES

06/01/11

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) Begin by applying a lubricant to each of the rubber hanger mounts, as well as the clamp in front of the muffler. This will make the removal and installation process much easier.
- 3) Using a hacksaw or sawsall, cut the stock tailpipe off where it exits the muffler. (This step is not mandatory, but will make removal easier.)
- 4) Support the muffler with a stand and separate the three hangers on the muffler and tailpipe from their rubber mounts on the vehicle. Remove the tailpipe and set aside.
- 5) 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.
- 6) 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 the inlet pipe assembly **#26340S** into position on the pipe from the catalytic converter. Line up the notch in the pipe with the tab on the inlet pipe. Install a clamp but do not tighten at this time.
- 3) Slide a 3" clamp onto the inlet neck of the muffler **#853055-Z**. Then place the muffler onto the inlet pipe and support with a stand. Tighten the clamp just enough to hold in position, while still allowing for adjustment.
- 4) Slide a 3" clamp onto the muffler outlet neck. Place tailpipe **#26341S** into position over the axle and insert the hangers at the front and rear of the pipe into the rubber mounts on the vehicle and slide into the muffler outlet. Tighten the clamp just enough to hold, while still allowing for adjustment.
- 5) Place a 3" clamp onto the slip-fit of exit pipe **#26333S** and slide onto the back of tailpipe **#26341S**. Tighten the clamp just enough to hold, while still allowing for adjustment.

- 6) Place the stainless tip **#ST429** onto the end of the exit pipe and adjust to the desired location. Then tighten the tip enough to hold, but still allow for adjustment.
- 7) Adjust the position of all the pipes and muffler to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while keeping suspension travel and vibration in mind. After adjustments have been made, securely tighten all clamps and install the 2 7/16" hanger keepers onto the hanger rods.
- 8) For a more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe	26340S
1	Muffler	853055-Z
1	Tailpipe	26341S
1	Exit Pipe	26333S
1	Stainless Tip	ST429
1	Parts Kit	PK573
1	2.50" Clamp	MC250BS
3	3" Clamp	MC300BS
3	7/16" Hanger Keeper	HW502



Installation diagram for:
SYSTEM #817525
1998-2003 FORD F-150 TRUCKS
4.6L & 5.4L ENGINE

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