



**Installation Instructions**  
**SYSTEM #817559**  
**2006-2010 FORD EXPLORER**  
4.0L · V6 ENGINES

# FORCE II™

## **409S<sub>6</sub> Stainless Steel**

02/09/12

### **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 a penetrating lubricant onto the two flange bolts behind the catalytic converter and also the rubber mounts that support the system. This will greatly ease removal.
- 2) Using a sawzall or hacksaw you will need to cut the tailpipe behind the hanger located at the rear of the muffler. Cut just before the tailpipe starts to make an upward bend to go over the rear axle. Once cut, remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and lower the tailpipe from the vehicle.
- 3) Place a jackstand under the muffler to support it when hangers are removed. Using a 15mm wrench, remove the two bolts at the flanged connection between the muffler and the catalytic converters. Save the springs, nuts and bolts.
- 4) Using a pry-bar, separate the two rubber hangers that support the muffler and inlet pipe. Once removed, lower the muffler and inlet pipe from the vehicle. Be careful not to damage the gasket at the catalytic converter/muffler flange connection.

### **Installation:**

- 1) Connect inlet pipe **#16742S** to the flange at the back of the catalytic converters and connect the hanger on the pipe to the rubber mount on the vehicle. Re-install the stock bolts, nuts and springs removed in step 3 above and tighten securely.
- 2) Place a provided clamp onto the inlet of muffler **#852573-Z**, then slide the inlet of the muffler onto the rear of the inlet pipe and support the muffler with a stand.
- 3) Place a provided clamp onto the muffler outlet, then place over-axle pipe **#16743S** into position over the rear axle and into the muffler outlet. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold, but still allow for adjustment.
- 4) Place a provided clamp onto the slip-fit of exit pipe **#16744S**, then slide onto the back of the over-axle pipe and connect the hanger on the pipe to the rubber mount on the vehicle. Tighten the clamp enough to hold, but still allow for adjustment.
- 5) Place the **#ST396** stainless tip onto the end of the exit pipe and adjust to the desired position. Tighten the clamp on the tip enough to hold but still allow for further adjustment. We highly recommend tack welding the tip to the exit pipe to avoid possible loss of the tip.

6) Adjust the position of all pipes and muffler to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

7) After the system is secure, slide the 7/16" hanger keepers onto the ends of the hangers of the system. The keepers will hold the system firmly in place.

**PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Muffler	852573-Z
1	Inlet Pipe	16742S
1	Over-Axle Pipe	16743S
1	Exit Pipe	16744S
1	Stainless Tip	ST396
1	Parts kit	PK620
3	2 1/2" Clamps	MC250BS
3	7/16" Hanger Keepers	HW502



Installation diagram for:  
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