



FORCE II™

409S Stainless Steel

Installation Instructions SYSTEM #817566 2002-2005 FORD EXPLORER 4.0L & 4.6L ENGINES

04/11/13

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the two front flange bolts as well as the rubber hanger mounts that support the system. This will greatly ease removal of the factory system.



2) To remove the factory exhaust system you will have to cut the system in half. Cutting the tailpipe just before the pipe goes over the rear axle system will allow both halves of the system to be removed easily. After cutting, remove the rear hanger on the tailpipe from the rubber mount on the vehicle and lower this section from the vehicle. This section may take some turning and twisting to get the pipe over the rear axle.



3) Support the muffler with a stand; remove the two bolts at the flanged connection just in front of the muffler. Once unbolted, remove the two hangers on this section from the rubber mounts on the vehicle and lower from the vehicle and set aside. Save the bolts, nuts and springs for reuse with the Flowmaster system.



4) Place inlet pipe assembly **#86023S** up into position behind the factory flange and connect the hanger on the pipe to the rubber mount on the vehicle. Using the hardware removed in step 3 above, connect the two flanges together and tighten enough to hold in place, but still allow for adjustment.



5) Place a supplied clamp onto the muffler inlet, place the muffler onto the back of the inlet pipe, the muffler outlet will be toward the outside of the vehicle. Support the muffler with a stand and tighten the clamp enough to hold, but still allow for adjustment.



6) Place a supplied clamp onto the muffler outlet then place pipe **#86024S** into position and connect the hanger on the pipe to the rubber mount on the vehicle. Once the hanger is connected, place the pipe into the muffler outlet. Tighten the clamp enough to hold, but still allow for adjustment.



7) Place a supplied clamp onto the expanded end of exit pipe **#86025S** and from the rear of the vehicle, place the pipe up over the rear axle and connect to the back of pipe **#86024S**. Slip the two pipes fully together and connect the hanger on the pipe to the rubber mount on the vehicle. Tighten the clamp at the over-axle connection enough to hold, but still allow for adjustment.



8) Place the **#ST446** 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 adjustment.

9) Adjust the position of all pipes and mufflers 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.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Inlet Pipe Assembly	86023S
1	Muffler	852572-Z
1	Over-Axle Pipe	86024S
1	Exit Pipe	86025S
1	Stainless Tip	ST446
1	Parts Kit	PK720
3	2½" Band Clamps	MC250BS
2	7/16" Hanger Keepers	HW502



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Installation diagram for:
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