



Installation Instructions
SYSTEM #817611
2002-2004 AUDI A6 QUATTRO
4.2L V8 ENGINE

FORCE II™

409S Stainless Steel

11/27/12

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the nuts at the clamped connections behind the catalytic converters and the rubber hanger mounts that support the system. This will greatly ease removal of the factory system.



2) Begin by loosening the clamps at the slip connections behind the catalytic converters. Support the rear of the system with stands and starting at the rear, remove the hangers on the system from the rubber mounts on the vehicle. Then with the help of an assistant, lower the stands and slide the system rearward to remove from the front pipe. Lower the system from the vehicle.



3) Unbolt the factory cross brace from the factory system, it will be reused with the new Flowmaster system.



4) Place a provided 2" clamp onto the reduced ends of Scavenger assembly **#16896S**. Place the assembly up into position onto the back of the factory front pipes; connect the hangers at the rear of the assembly to the rubber mounts on the vehicle. Once adjusted, the rubber hangers should be hanging straight up and down. Tighten the clamps at the front of the assembly enough to hold, but still allow for adjustment.



5) Place a provided 2¼" clamp onto the inlet of muffler **12412400-Z** and slide onto the right outlet of Scavenger assembly **16896S**. Repeat this step with the other muffler on the left side of the vehicle. Support the mufflers with a stand and tighten the clamps enough to hold, but still allow for adjustment.



6) Place a provided 2¼” clamp onto the right muffler outlet and place the front of pipe **#16901S** into the muffler outlet. Tighten the clamp enough to hold, but still allow for adjustment. Repeat this step on the left side with pipe **#16900S**.



7) Place a provided 2¼” clamp onto the inlet of right side resonator assembly **#15171S** and slide onto the back of pipe **#16901S**. Connect the hanger at the rear of the assembly to the rubber mount on the vehicle and tighten the clamp enough to hold, but still allow for adjustment. Repeat this step on the left side with resonator assembly **#15172S**.



8) Using the 5/16” nuts, bolts and washers provided, attach the cross brace removed from the factory system to the two tabs welded to the mid pipes of the new system.

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. Place the included 1/2” hanger keepers onto the two front Scavenger hangers as well as the two rear resonator hangers. These will prevent the hanger from slipping out of the rubber mount.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
1	Scavenger Assy.	16896S	
2	Mufflers	12412400-Z	
1	Left Mid Pipe	16900S	
1	Right Mid Pipe	16901S	
1	Right Resonator Assy.	15171S	
1	Left Resonator Assy.	15172S	
1	Parts Kit	PK680	
2	2” Band Clamp		MC200BS
6	2¼” Band Clamp		MC225BS
4	½” Hanger Keepers		HW503
2	5/16”-18 x 1” Bolt		HW204
2	5/16” Nut		HW102
2	5/16” Flat Washer		HW302
2	5/16” Lock Washer		HW308



Installation diagram for:
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