



## Installation Instructions SYSTEM #817613

2002-2008 AUDI A4 QUATTRO  
1.8L & 2.0L TURBO CHARGED ENGINES

# FORCE II™

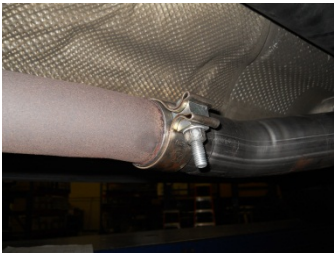
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11/27/12

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the nuts at the clamped connection behind the catalytic converter. Also, spray 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 connection behind the catalytic converter. 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) Place a provided 2 1/4" clamp onto the reduced end of inlet pipe **#16905S**. Place the pipe onto the back of the factory front pipe and rotate to its approximate position in the center channel of the vehicle. Tighten the clamp at the front of the inlet pipe enough to hold, but still allow for adjustment.



4) Place a provided 2 1/2" clamp onto the expanded end of Y-pipe assembly **#16906S**. Place the pipe up into position onto the back of pipe **#16905S** and connect the hangers on the assembly to the rubber mounts on the vehicle. Once adjusted, the rubber hangers should be hanging straight up and down. Tighten the clamp at the front of the assembly enough to hold, but still allow for adjustment.



5) Place a provided 2" clamp onto the inlet of right side muffler assembly **#852060-297** and slide onto the right outlet of Y-pipe **#16906S**. 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 muffler assembly **#852060-296**



6) Using the 3/8" nuts, bolts and washers provided, attach cross brace #454HA to the brackets welded to the right and left muffler assemblies.



7) Place a provided 2 1/4" clamp onto the slip-fit of stainless tip #ST468 and slide it onto the outlet of the right muffler assembly. Adjust to the desired position and tighten the clamp enough to hold, but still allow for adjustment. Repeat this step on the left side of the vehicle.

8) 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	Inlet Pipe	16905S
1	Y-Pipe Assy.	16906S
1	Left Muffler Assy.	852060-296
1	Right Muffler Assy.	852060-297
2	Stainless Tip	ST468
1	Parts Kit	PK681
1	Rear Cross Brace	454HA
2	2" Band Clamp	MC200BS
3	2 1/4" Band Clamp	MC225BS
1	2 1/2" Band Clamp	MC250BS
2	3/8"-16 x 1" Bolt	HW208
2	3/8" Nut	HW103
2	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309
4	1/2" Hanger Keepers	HW503



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Installation diagram for:  
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