



FORCE II™

409S Stainless Steel

Installation Instructions for: SYSTEM #817616

2008-2010 FORD F-250, F-350 AND F-450 TRUCKS
6.4L POWERSTROKE DIESEL ENGINE
ALL WHEELBASES, 4" DPF BACK SYSTEM

11/05/12

- 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 bolt at the clamped connection between the DPF unit and the factory muffler and also the four rubber hangers that support the stock muffler and tailpipe.
- 2) Support the muffler with a stand and remove the bolt at the clamped connection in front of the factory muffler. Remove the four hangers on the tailpipe and muffler from the rubber mounts on the vehicle. Slide the muffler and tailpipe back to disconnect from the DPF unit and then forward, over the rear axle and remove from the vehicle.
- 3) Place the provided 3.50" clamp onto the small end of adapter pipe **#TB425S** and the slide onto the back of the DPF unit. Tighten the clamp securely.
- 4) Trim extension pipe **#46166S** if necessary, according to the following measurements before placing onto the back of adapter pipe **#TB425S**. Place the provided 4" clamp onto this connection and tighten enough to hold.

Standard Cab / Long Bed, 137" Wheelbase Models: **Extension pipe 46166S not used.**

Extended Cab / Standard Bed, 141.8" Wheelbase Models: **Trim 30.50" from 46166S.**

Crew Cab / Standard Bed, 156.2" Wheelbase Models: **Trim 16.25" from 46166S**

Extended Cab / Long Bed, 158" Wheelbase Models: **Trim 14.50" from 46166S.**

Crew Cab / Long Bed, 172.4" Wheelbase Models: **Do not trim 46166S, place directly onto TB425S.**

- 5) Place a supplied 4" clamp onto the inlet of muffler **#815440S-Z** and slide onto the back of inlet pipe **#TB425S** or extension pipe **#46166S**. Tighten the clamp enough to hold, but still allow for adjustment.
- 6) Place a supplied 4" clamp onto the muffler outlet. Place tailpipe **#46167S** into position over the rear axle and slide into the muffler outlet. Connect the three hangers on the tailpipe to the rubber mounts on the vehicle and tighten the clamp on the muffler outlet enough to hold, but still allow for adjustment.
- 7) Place a supplied 4" clamp onto the expanded end of stainless tip **#ST475** and slide onto the end of the tailpipe and adjust to the desired location.

8) Adjust the position of the pipes and muffler to provide a satisfactory fit. 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 the clamps 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	Adapter Pipe	TB425S
1	Extension Pipe	46166S
1	Muffler	815440S-Z
1	Tailpipe Assy.	46167S
1	Stainless Tip	ST475
1	Parts Kit	PK675
	1 3.50" Band Clamp	MC350BS
	3 4" Band Clamp	MC400BS



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Installation diagram for:
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4" DPF BACK SYSTEM

