



FORCE II

409S Stainless Steel

Installation Instructions for:

SYSTEM #817619

2011-2013 FORD F-250, F-350 AND F-450 TRUCKS

6.7L POWERSTROKE DIESEL ENGINE

4" DPF BACK SYSTEM

03/18/13

- 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 three bolts at the flanged connection in front of the factory muffler and also the three rubber hangers that support the stock tailpipe.
- 2) Support the muffler with a stand and remove the three nuts at the flanged connection in front of the factory muffler. Remove the three hangers on the tailpipe from the rubber mounts on the vehicle. Slide the muffler and tailpipe forward, over the rear axle and remove from the vehicle.
- 3) Using the 7/16" nuts, bolts and washers provided, bolt inlet pipe assembly **#597TBS** to the back of the mating flange on the exhaust system. Tighten securely.
- 4) Trim extension pipe **#46165S** if necessary, according to the following measurements before placing onto the back of adapter pipe **#597TBS**. Place a provided 4" clamp onto this connection and tighten enough to hold.

Crew Cab / Standard Bed, 156.2" Wheelbase Models: **Trim 16.25" from 46165S.**
 Super Cab / Long Bed, 158" Wheelbase Models: **Trim 14.50" from 46165S.**
 Crew Cab / Long Bed, 172.4" Wheelbase Models: **Do not trim 46165S, place directly onto TB425S.**
- 5) Place a provided 4" clamp onto the expanded end of tailpipe **#46164S**. Then place the tailpipe into position over the rear axle and slide onto the back of extension pipe **#46165S**. Connect the three hangers on the tailpipe to the rubber mounts on the vehicle and tighten the clamp at the front of the tailpipe outlet enough to hold but still allow for adjustment.
- 6) 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.
- 7) 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	Inlet Pipe Assy.	597TBS	
1	Extension Pipe	46165S	
1	Tailpipe Assy.	46164S	
1	Stainless Tip	ST475	
1	Parts Kit	PK674	
3	4" Band Clamp		MC400BS
3	7/16" x 1.50" Bolts		HW224
3	7/16" Nuts		HW104
6	7/16" Flat Washers		HW304
3	7/16" Lock Washers		HW310



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Installation diagram for:
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