



# FORCE II™

**4095<sup>®</sup> Stainless Steel**

Installation Instructions for:  
**SYSTEM #817622**  
**2012-2014 CADILLAC ESCALADE**  
6.2L · V8 ENGINE \*W/FACTORY DUAL TAILPIPES

10/24/13

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the clamp bolt of the rear resonator assembly and also 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 clamp on the inlet of the rear resonator assembly. Remove the three hangers on this assembly from the rubber mounts on the vehicle. Remove the resonator assembly from the vehicle and set aside.



3) Support the large muffler in the center of the vehicle with a stand and remove the hangers on the muffler and over-axle pipe assembly from the rubber mounts on the vehicle. Loosen the clamp at the ball connection behind the catalytic converter and with the help of an assistant, lower the remainder of the system from the vehicle. The clamp will be re-used with the Flowmaster system.



4) Place inlet pipe **#599TBS** into position behind the catalytic converter and connect the hanger on the pipe to the rubber mount on the vehicle. Then using the factory clamp secure the inlet pipe to the converter. Be sure that the hanger is level and tighten the clamp enough to hold, but still allow for adjustment. Place the provided 4" clamp over the back of the inlet pipe in preparation for the next step.



5) Place the Y-pipe portion of muffler assembly **#14020100-295** into position over the rear axle and connect the inlet of the muffler to the back of inlet pipe **#599TBS**. Connect the two hangers on the muffler assembly to the rubber mounts on the vehicle. Slide the 4" clamp onto the muffler inlet and tighten enough to hold, but still allow for adjustment.



6) Place a provided 3" clamp onto the inlet of the right resonator assembly #15169S. Place the assembly up into position and connect the hanger on the assembly to the rubber mount on the vehicle. Slide the assembly to the rear and then slide the inlet onto the right y-pipe outlet. Slide the pipes fully together and tighten the clamp at the inlet enough to hold, but still allow for adjustment.



7) Place a provided 3" clamp onto the inlet of the left resonator assembly #15170S. Place the assembly up into position and connect the hanger on the assembly to the rubber mount on the vehicle. Slide the assembly to the rear and then slide the inlet onto the left y-pipe outlet. Slide the pipes fully together and tighten the clamp at the inlet enough to hold, but still allow for adjustment.

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 ends of the inlet pipe and muffler hangers; these will prevent the hangers from slipping out of the rubber mounts.

**PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Inlet Pipe Assembly	599TBS
1	Muffler Assembly	14020100-295
1	Right Resonator Assy.	15169S
1	Left Resonator Assy.	15170S
1	Parts Kit	PK677
	1 4" Band Clamp	MC400BS
	2 3" Band Clamp	MC300BS
	3 1/2" Hanger Keepers	HW503



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409S<sub>6</sub> Stainless Steel

Installation diagram for:  
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