



Installation Instructions
SYSTEM #817623
2012-2013 FIAT 500
1.4L NON TURBO CHARGED ENGINE

FORCE II™

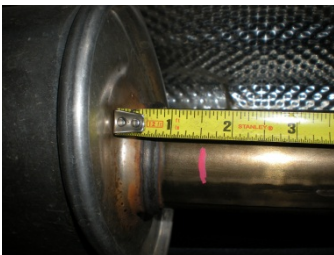
409S Stainless Steel

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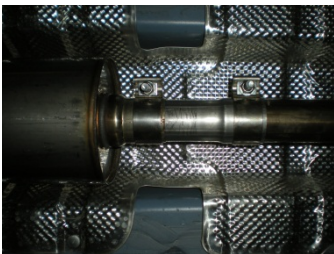
1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the bolt at the clamped connection just in front of the rear axle and also the rubber hanger mounts that support the system. This will greatly ease removal of the factory system.



2) Begin by loosening the clamp at the slip connection just in front of the rear axle. Remove the two hangers on the rear muffler assembly from the rubber mounts on the vehicle and separate the rear section from the mid-section at the slip connection. Lower the rear section from the vehicle.



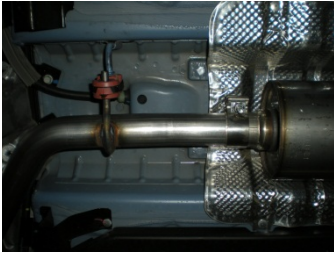
3) The system will now need to be cut just in front of the mid resonator assembly. Measure forward 1.50" from the end cap of the resonator and make a mark, support the resonator with a stand. Then using a hack saw or sawzall, cut through the pipe on your mark. Remove the hanger on this section from the rubber mount on the vehicle. Lower the resonator and over-axle pipe from the vehicle.



4) Place a provided 2" clamp onto the expanded end of inlet pipe **#16876S** and slide onto the back of the factory front pipe. Tighten the clamp enough to hold, but still allow for adjustment.



5) Place a provided 2" clamp onto the muffler inlet and slide onto the back of inlet pipe **#16876**. Tighten the clamp on the muffler inlet enough to hold, but still allow for adjustment.



6) Place a provided 2" clamp onto the muffler outlet and place the front of pipe **#16877S** into the muffler outlet. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold, but still allow for adjustment. Inlet pipe **#16876S** may need to be rotated to allow the hanger to fit properly in the rubber mount.



7) Place a provided 2" clamp onto the expanded end of over-axle pipe **#16878S**. Place the pipe over the rear axle and connect the hangers at the rear of the pipe to the rubber mounts on the vehicle. Slide the assembly forward and slide down onto pipe **#16877S**. Slide the pipes fully together and tighten the clamp at the slip connection enough to hold, but still allow for adjustment.



8) Place stainless **#ST465** onto the back of the over-axle pipe and adjust to the desired position. Tighten the clamp on the tip enough to hold, but still allow for adjustment.

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 7/16" hanger keeper onto the end of the mid pipe hanger; this 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 | 16876S |
| 1 | Muffler | 12014310-Z |
| 1 | Mid Pipe | 16877S |
| 1 | Over-Axle Pipe | 16878S |
| 1 | Stainless Tip | ST465 |
| 1 | Parts Kit | PK676 |
| 4 | 2" Band Clamp | MC200BS |
| 1 | 7/16" Hanger Keepers | HW502 |



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Installation diagram for:
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