



FORCE II

Installation Instructions:

17229

**1999-04 FORD F-250 & F-350 TRUCKS
SUPER DUTY CHASSIS
V8 & V10 ENGINE**

2/4 Wheel Drive
133, 155 & 168.4 inch Wheelbases

Removal:

2/20/2020

- 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.
- 2) Loosen the 3" band clamp, first one forward from front of muffler, then slip muffler and tailpipe off. Remove the bottom bolt on the shock to get the system off on one piece if desired. Or, you can cut the tailpipe off between the muffler and rear-end and leave the shock bolt alone.
- 3) Support the muffler with a jack stand or muffler stand to support it when hangers are removed from rubber mounts or tailpipe is cut off.
- 4) Cut the tailpipe off where it exits the muffler. Using a pry bar, separate the four rubber hangers that support the stock exhaust system, one at the inlet of the muffler, two directly behind the muffler and one at the rear of the tailpipe. A lubricant such as WD40 or lithium grease will ease separation.
- 5) Carefully remove the stock tailpipe and muffler from the vehicle and set aside.

Installation:

- 1) Connect the hanger/clamp assembly **#217HA** to the two rubber mounts on the vehicle where the stock muffler hanger was located.
- 2) Install inlet pipe **#TB315** onto the back of the stock inlet pipe and clamp using the 3" clamp provided. Tighten enough to hold in place, but still allow for adjustment.
- 3) Slip the inlet of the muffler **#53073** onto the back of the inlet pipe **#TB315** and install the 3" clamp provided. Place the rear of the muffler into the clamp hanger **#217HA**. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.
- 4) Insert tailpipe **#26100** into the outlet of the muffler, then insert the hanger welded to the rear of the tailpipe into the stock hanger mount on the vehicle. Tighten down the clamp hanger enough to hold, but still allow for adjustment.
- 5) Place exit pipe **#26105** on the end of the tailpipe and install a 3" clamp. Tighten just enough to hold in position.
- 6) Adjust the position of the pipes and muffler to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.

7) Tighten down all clamped connections securely. Slide the 7/16" hanger keepers onto the clamp hanger at the rear of the muffler. Then slide the 1/2" hanger keeper onto the hanger welded to the rear of the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.

8) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe	TB315
1	Muffler	53073
1	Tailpipe	26100
1	Exit Pipe	26105
1	Parts Kit	PK326
1	Clamp Hanger	217HA
3	3" Clamps	MC300G
2	7/16" Hanger Keeper	
1	1/2" Hanger Keeper	



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Installation Diagram:

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