



FORCE II

Installation Instructions

817451

2011-19 CHEVY/GMC 2500HD/3500HD

6.0L V8 ENGINE

Crew Cab, Short Bed

OVERVIEW:

1. Take a moment to read and understand these instructions before installing your Flowmaster performance system.

NOTE: Please inventory all parts now before continuing and if necessary, report any missing items to our tech line. This will avoid potentially stranding your vehicle until any missing replacement parts arrive.

ITM #	PART #	DESCRIPTION	QTY.
N/A	PK585	Hardware Package includes:	1
4	214HA	Rear Clamp Hanger	1
5	MC350BS	3½" Stainless Band Clamp	1
6	HW211	¾-16 x 2" HC Bolt	2
7	HW303	¾" Flat Washer	2
8	HW309	¾" Lock Washer	2
9	HW103	¾-16 Z 5 FH Nut	2
10	HW503	½" Hanger Keeper	4
11	HW502	¾" Hanger Keeper	1
12	HA168	Rubber Hanger	1

ITM #	PART #	DESCRIPTION	QTY.
1	36044S	Inlet Pipe Assembly	1
2	853550-Z	Force II Muffler	1
3	36042S	Tailpipe Assembly	1

REMOVE STOCK EXHAUST SYSTEM:

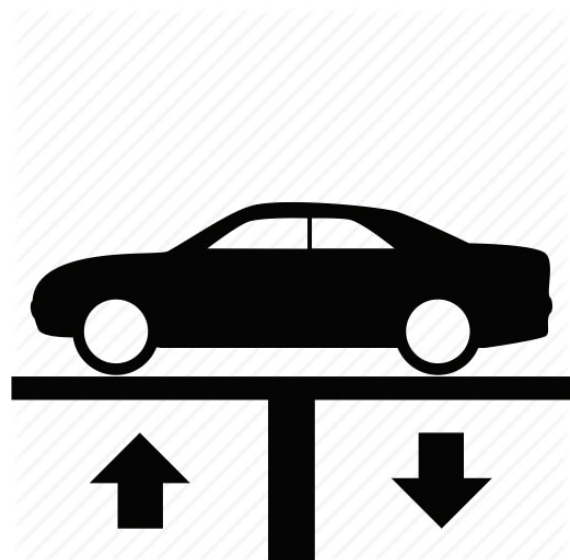
2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

WARNING:

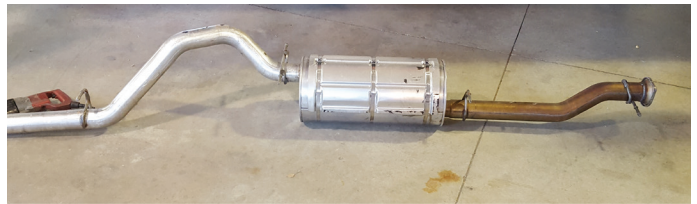
Avoid serious burns! Allow your vehicle time to cool completely before touching any factory engine components.

To ease preparation and installation of your new kit:

- Apply penetrating lubricant to mounts, bolts and clamps before you remove them.
- Use stands as necessary to support parts as you detach them from your vehicle and again as you install new parts.



3. Remove nuts (x2) at catalytic converter flange. Separate hangers (x5) from isolators then carefully remove exhaust system from vehicle. You may also cut exhaust behind muffler to remove it in two pieces.



4. Remove studs (x2) from catalytic converter flange on factory exhaust. You will be using different fasteners to install your new Flowmaster exhaust system.



INSTALL FLOWMASTER EXHAUST SYSTEM

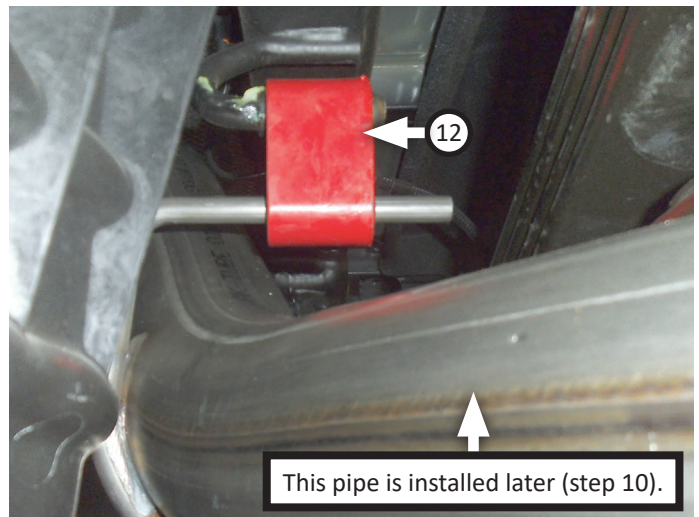
5. Remove nuts from stock and Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.

NOTE: The image in this step is intended for illustrative purposes only and may or may not accurately reflect components included in your kit.

6. Every slip fit connection in this kit must seat 3" deep except for muffler connections which must seat 2" deep. Find all slip fit components in your kit and mark them accordingly so your Flowmaster exhaust system fits properly onto your vehicle.

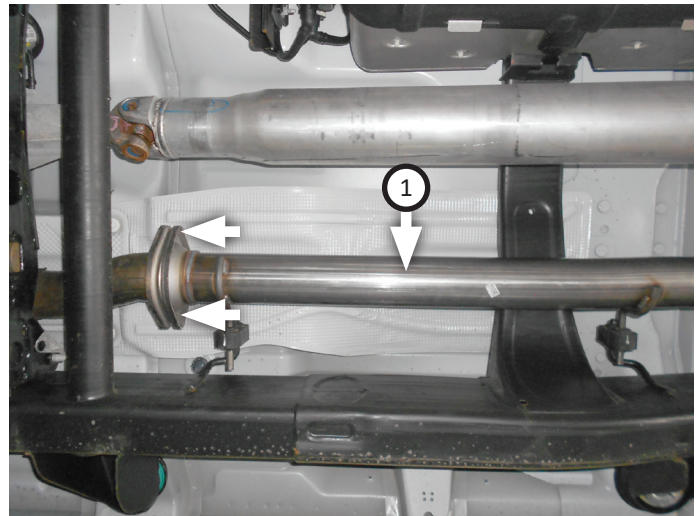


7. Remove factory rubber hanger from passenger rear of tailpipe. It may have a small metal clip easily removed with a screwdriver. Place **rubber hanger (12)** onto factory hanger rod.

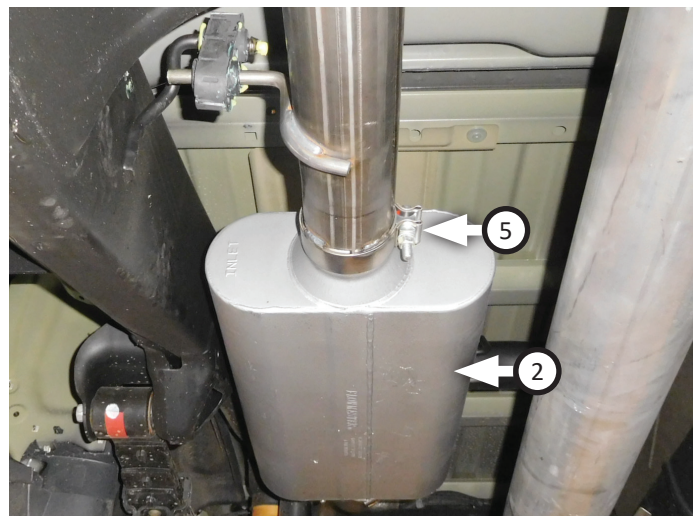


NOTE: For 2013-up model year trucks, you must trim 4" from back of inlet pipe. 2011 & 2012 models do not require this modification.

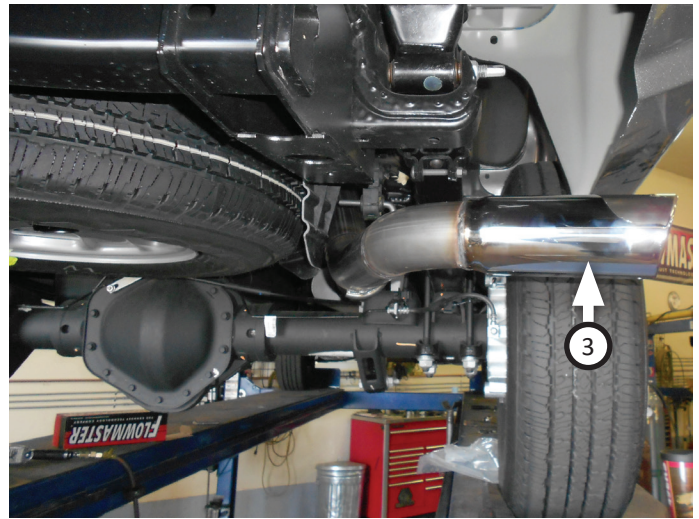
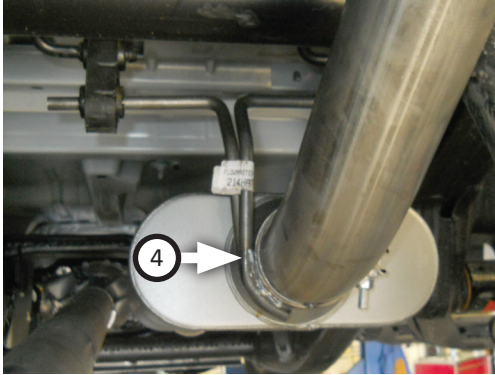
8. Connect **inlet pipe (1)** wire hangers to factory isolators behind catalytic converters, then secure flanges using (x2 ea.) **bolts (6)**, **flat washers (7)**, **lock washers (8)** and **nuts (9)**.



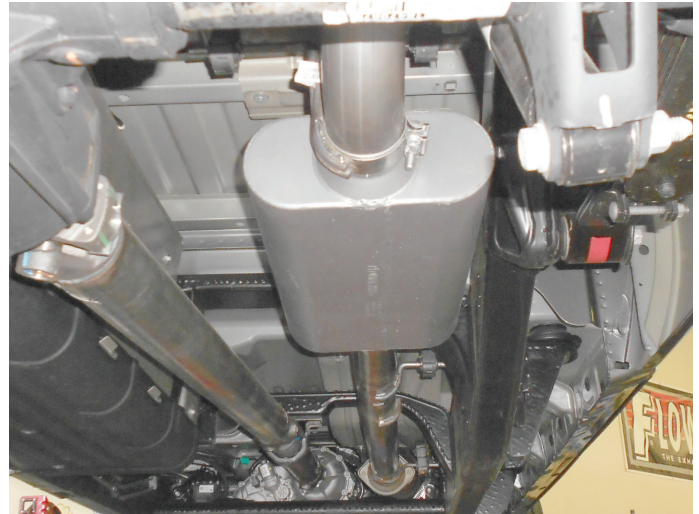
9. Place **clamp (5)** onto **muffler (2)** then connect it to inlet pipe. Tighten clamp just enough to allow for adjustment.



10. Place **rear clamp hanger (4)** onto muffler outlet and hang it in isolators. Route **tailpipe assembly (3)** over rear axle and connect it to muffler, insert wire hanger then tighten clamp hanger for later adjustment.



11. Adjust exhaust components for fit; maintaining $\frac{1}{2}$ " clearance and compensating for suspension, travel and vibration then fit $\frac{1}{2}$ " (x4) (10) and $\frac{7}{16}$ " hanger keepers onto each sideways hanger.
12. Recommended: Secure slip-fit connections with a 1-inch tack weld then spray high-temp paint over each weld to prevent rust and premature corrosion.



Congratulations, the installation of your FLOWMASTER performance exhaust system is now complete!





Installation Diagram
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