



Installation Instructions

**817659**

**1970-73 CORVETTE STINGRAY**

**FORCE II**

**409S Stainless Steel**

**Removal:**

Rev. 2-23-23

1) Remove existing exhaust system starting 2.75" behind crossmember. Unbolt factory hangers at rear of mufflers; these will not be used with your Flowmaster system.

**Installation:**



1) Starting just behind cross-member, place provided 2.25" clamp onto expanded ends of X-pipe assembly **86171S**, then slide it onto rear of manifold pipes (verifying connections are secure). Place stand under assembly rear and tighten clamps just enough allow for later adjustment.

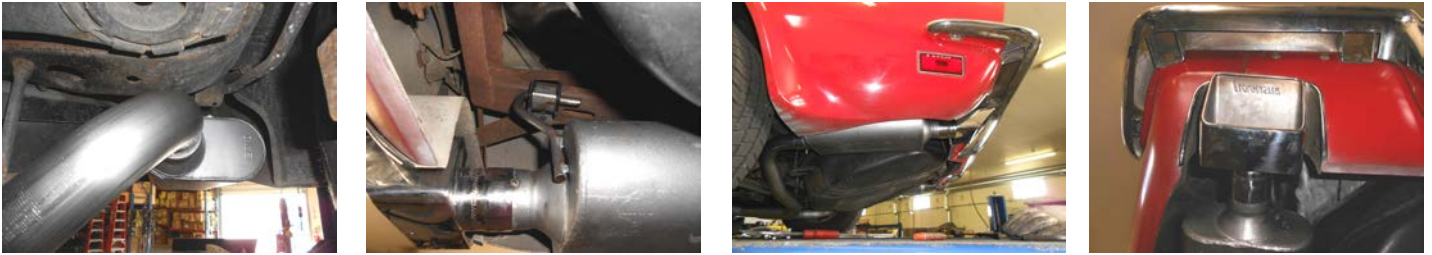


2) Place a provided clamp onto both outlets of X-pipe assembly **86171S**. Place the expanded end of mid pipe **86231S** onto the right outlet of the X-pipe assembly. Rotate the pipe up into position and support the rear of the pipe with a stand. Tighten the clamp enough to hold, but still allow for adjustment. Repeat this step on the left side of the vehicle with pipe **86232S**.

3) Place one of the supplied **HA602** rubber mounts onto the wire hanger of right muffler assembly **842456-353**. Place a provided clamp onto the muffler inlet, then place the assembly onto the back of the mid pipe and slide the two fully together. Support the muffler with a stand. Using a supplied 3/8" bolt, nut, washer and lock washer, bolt the **HA602** hanger to the hole in the frame above the muffler outlet.



4) Place one of the supplied **HA602** rubber mounts onto the wire hanger of left muffler assembly **842456-352**. Place a provided clamp onto the muffler inlet, then place the assembly onto the back of the mid pipe and slide the two fully together. Support the muffler with a stand. Using a supplied 3/8" bolt, nut, washer and lock washer, bolt the **HA602** hanger to the hole in the frame above the muffler outlet.



5) Adjust the position of the pipes and mufflers to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind. Tighten all clamped connections down securely.

6) 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	X-Pipe Assembly	86171S
1	Right Mid Pipe	86231S
1	Left Mid Pipe	86232S
1	Left Muffler	842456-352
1	Right Muffler	842456-353
1	Parts kit	PK786
6	2 1/4" Clamp	MC225BS
2	Rubber Hanger	HA602
2	3/8" x 1" Bolt	HW208
2	3/8" Nut	HW103
2	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309



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Installation Diagram

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