



Installation Instructions

**817664**

**2009\*-21 TOYOTA TUNDRA**

**4.6L, 4.7L, 5.7L ENGINE**

**2/4 WD with 145" Wheelbase only**

\*Built after 08/2008

**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.
8	16547S	Side Exit Pipes R/L	2
9	ST461	Stainless Tips	2
N/A	PK502	Hardware Pack includes:	1
10	MC250BS	2½" Band Clamps	7
11	384HA	Left Inlet Pipe Clamp Hanger	1
12	353HA	Right Inlet Pipe Clamp Hanger	1
13	354HA	Left Rear Frame Hanger	1
14	HA566	Backing Plate	1
15	HA168	Rubber Hanger	1
16	HW103	¾" Nut	1
17	HW303	¾" Flat Washer	1
18	HW309	¾" Lock Washer	1
19	HW503	½" Hanger Keeper	1

ITM #	PART #	DESCRIPTION	QTY.
1	86092S	Left Inlet Pipe	1
2	86091S	Right Inlet Pipe	1
3	8525404-319	Muffler	1
4	16543S	Right Tailpipe	1
5	16542S	Left Front Tailpipe	1
6	16544S	Left Rear Tailpipe	1
7	16546S	Rear Exit Pipes R/L	2

**REMOVE STOCK EXHAUST SYSTEM:**

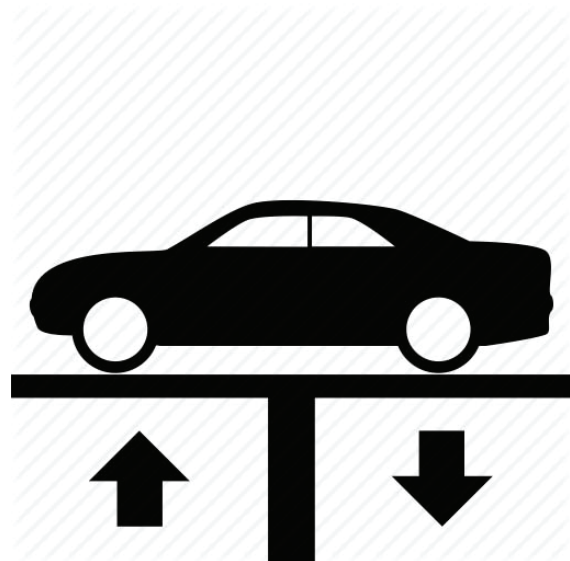
2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

**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:**

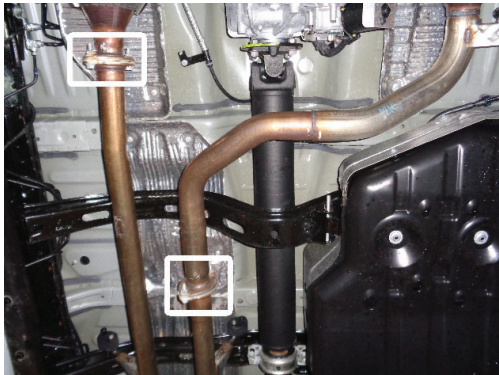
- Apply penetrating lubricant to mounts, bolts and clamps before you remove them.
- Use stands as necessary to support parts as you detach them from your vehicle and again as you install new parts.



3. Unbolt tailpipe connection where it exits muffler. Disassemble rear wire hanger from isolator then remove tailpipe section and set it aside.



4. Remove bolts (x4) at both front flanged connections. Disassemble wire hangers from isolators and remove muffler assembly. Retain bolts for later use.



## INSTALL FLOWMASTER EXHAUST SYSTEM

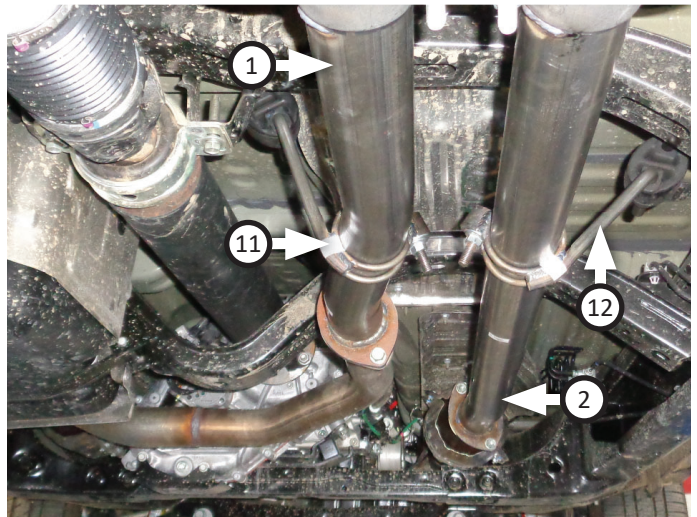
5. Remove nuts from stock and Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.

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

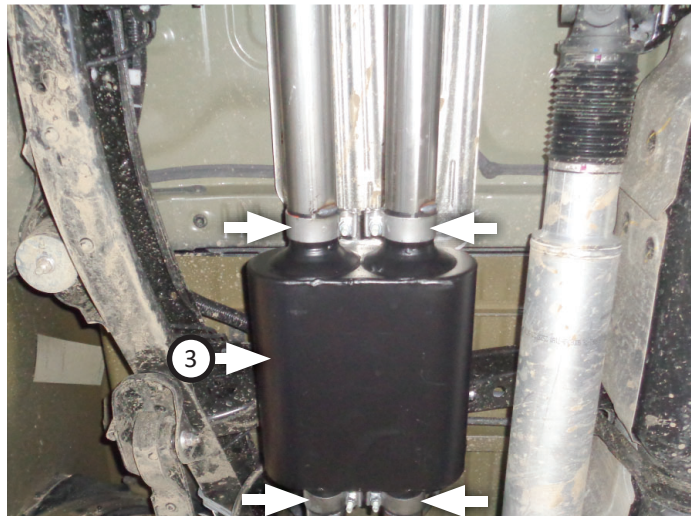
6. Every slip fit connection in this kit must seat 3" deep except for muffler connections which must seat 2" deep. Mark all slip fit components in your kit and mark them accordingly so your Flowmaster exhaust system fits properly onto your vehicle.



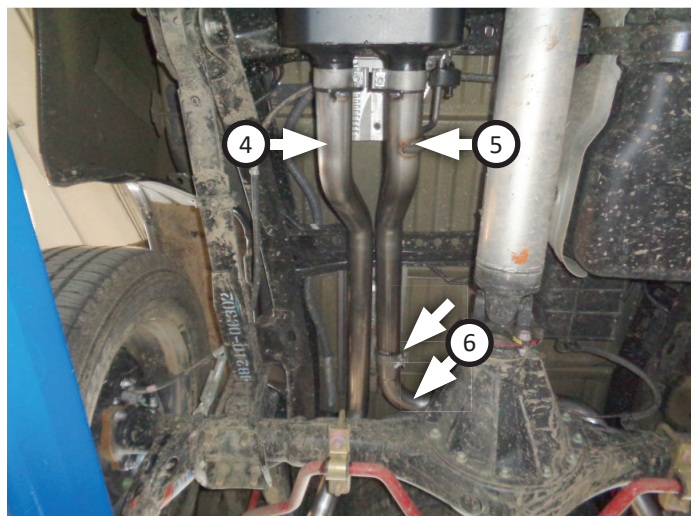
7. Connect **left (1)** and **right (2)** inlet pipes to flanges using bolts (x4) (removed step 4). Place **left (11)** and **right (12)** inlet pipe clamp hanger onto inlet pipes then insert them into isolators.



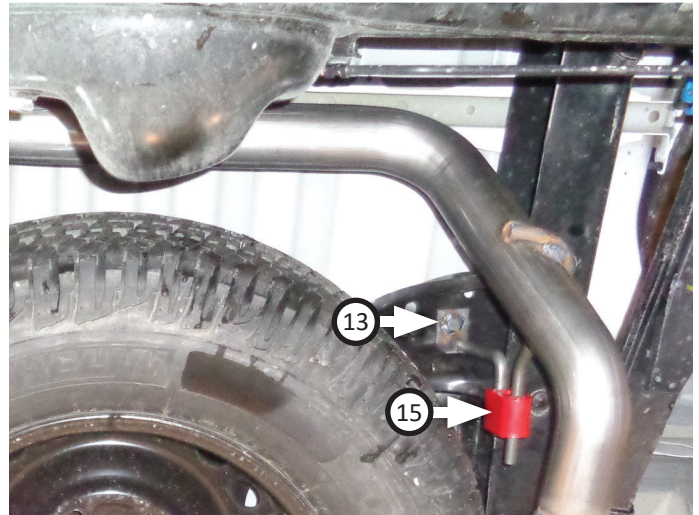
8. Place (x2) **clamps (10)** onto **muffler (3)** inlets then connect it to inlet pipes. Tighten clamps just enough to allow for adjustment. Then place (x2) **clamps (10)** onto muffler outlets.



9. Connect **right (4)** and **left front (5)** tailpipes to muffler outlets. Place **clamp (10)** onto left front tailpipe then connect **left rear tailpipe (6)** to it, routing it over axle. Insert wire hangers into isolators then tighten all clamps enough to allow for adjustment.

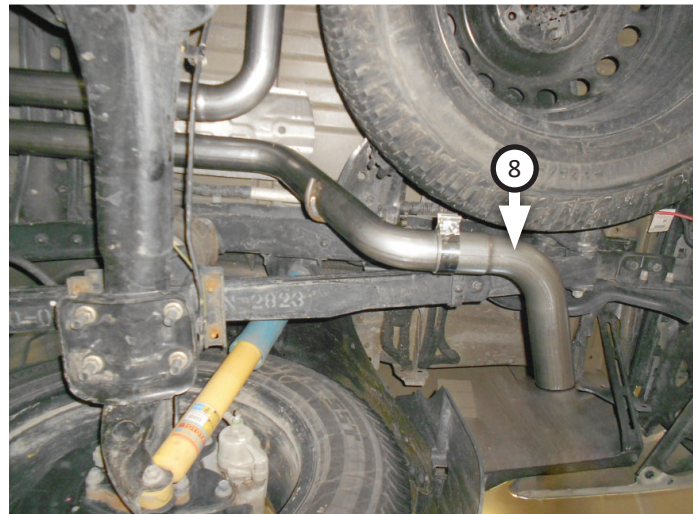


10. Install **left rear hanger (13)** across from center of spare tire. Locate square cavity on left rear frame rail. Look up into this cavity and locate large hole at top of frame. Install **backing plate (14)** on top side of frame, then place left rear hanger up into cavity using **flat washer (17)**, **lock washer (18)** and **nut (16)**. Tighten hanger then slide **rubber hanger (15)** onto hanger wire.



**NOTE:** This kit includes both side and rear exit pipes. A side exit is preferable for towing purposes, to avoid blowing fumes in or on vehicles you may be towing (eg: RV trailer, boat, etc). Otherwise, if you wish to equip your vehicle with a rear exit exhaust, use **rear exit pipes (7)** now in place of side exit pipes.

11. Place **clamp (10)** onto right tailpipe then connect **side exit pipe (8)**. Repeat this on left side tailpipe.



12. Install (x2) **stainless tips (9)** onto exit pipes then tighten inlets.



13. Adjust exhaust components for fit; maintaining ½" clearance and compensating for suspension, travel and vibration, then tighten all clamps. Finally, fit **hanger keeper (19)** onto sideways hanger.
14. 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.



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





Installation Diagram  
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