



## **409S Stainless Steel**

Installation Instructions for:  
**SYSTEM #817200**  
1968-1972 GM A-BODY  
3" SYSTEM

### **Installation:**

- 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) On the frame of the vehicle, slightly forward of the rear axle, there are a set of two mounting holes on each side of the vehicle (use the two inner holes) which will be used to fasten the rear muffler hanger mounts. Use these stock locations to secure hanger **#290HA** on the left side and hanger **#289HA** on the right side. Use the 5/16" x 1" bolts and nuts provided. See Diagram #1.
- 3) On the rear portion of the frame, roughly 8" behind the rear wheel you should see two vertically aligned 5/16" holes that were used for the factory hangers. Use those holes and bolt on hanger **#HA572** using the two 5/16" x 3/4" cut thread hex bolts provided in the parts kit. See Diagram #2.
- 4) Slide a **#HA168** rubber hanger onto the **#289HA** & **#290HA** hanger mounts installed in the previous step. Slide clamp hanger **#426HA** (right side) into bottom hole of the rubber hangers. The hanger rod should be inserted from the outside. Install left side hanger **#426HA** in the same way. Place the mufflers up into position with stands and place the outlets of the mufflers into the clamp hangers. Tighten enough to hold in place but still allow for adjustment.
- 5) Place a provided 3" clamp over each muffler inlet. Place H-pipe assembly **#26146S** in its approximate position under the vehicle and connect the back of the H-pipe into the muffler inlets, support with a stand. Tighten the clamps enough to hold but still allow for adjustment.
- 6) Place the front section of the right tailpipe **#26149S** into the right muffler outlet and the front section of left tailpipe **#26148S** into the left muffler outlet.
- 7) Place a 3" clamp onto the slip-fit of right tailpipe section **#26151S** and slide it into the back of front section **#26149S**. Tighten the clamp enough to hold, but still allow for adjustment. Slide clamp hanger **#291HA** onto the back of rear section **#26151S** and slide the hanger rod into frame hanger **#HA572** installed in step 2.
- 8) Place a 3" clamp onto the slip-fit of left tailpipe section **#26150S** and slide it into the back of front section **#26148S**. Tighten the clamp enough to hold, but still allow for adjustment. Slide clamp hanger **#291HA** onto the back of rear section **#26150S** and slide the hanger rod into frame hanger **#HA572** installed in step 2.
- 9) The front connector pipes **#26145S** are long enough to allow for many different header combinations, therefore, it is necessary to determine the proper length of the connector pipes. Once

the proper length is determined, trim the front connector pipes to fit. To accommodate for width, cut the ends of the pipes where they enter into the H-pipe.

- 10) Once the connector pipes are cut to proper length, raise them into position and connect them to the H-pipe and header collectors or manifold down pipes using a standard header flange or venture cone.
- 11) Adjust the position of all pipes and muffler 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.
- 12) Tighten all clamped connections down securely. Install the 7/16" push-on hanger keepers on the round stock sticking through the rubber muffler hangers.
- 13) For a more secure installation, we recommend welding all slip-fit connections.

### PACKING LIST

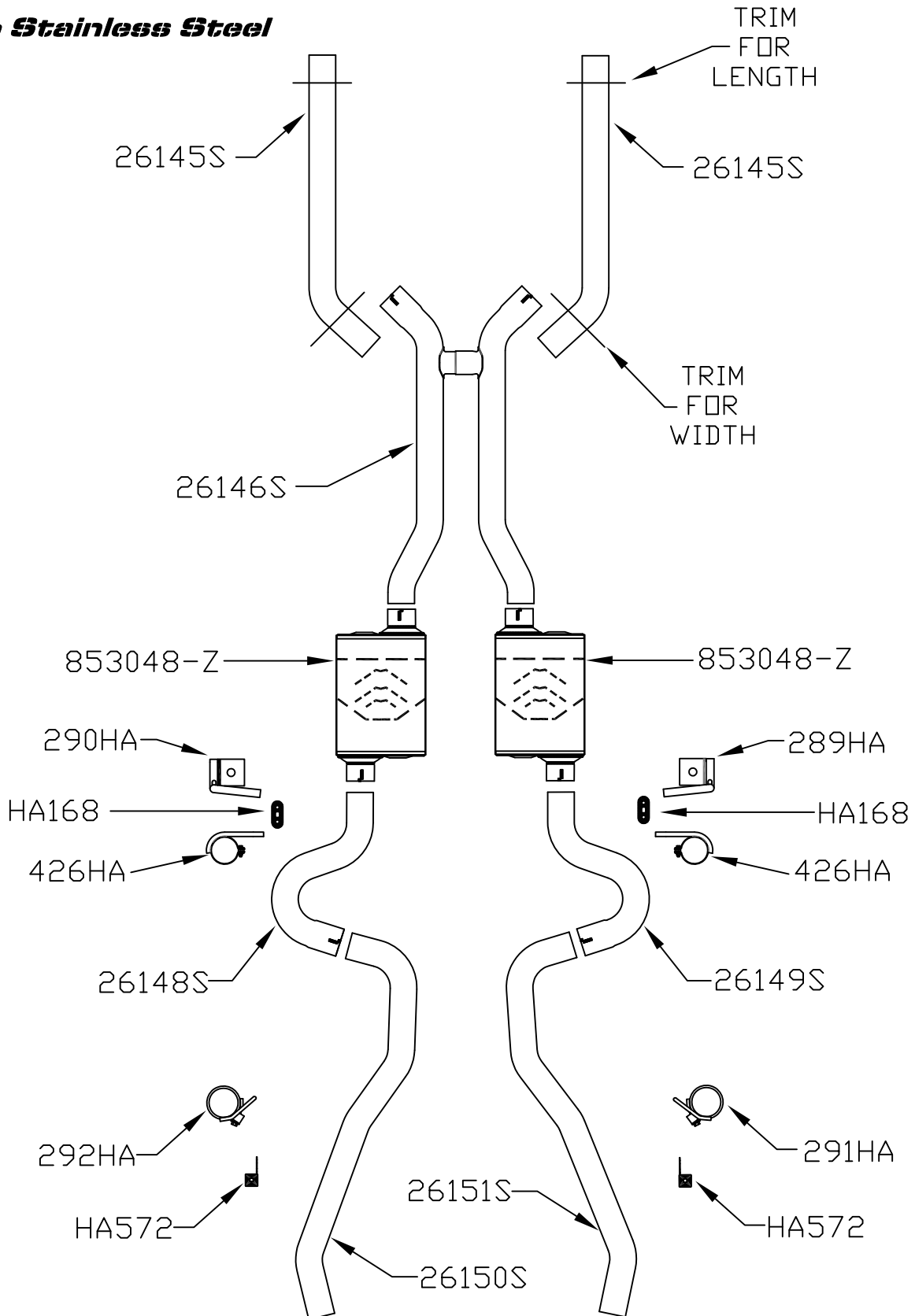
<u>Qty</u>	<u>Part</u>	<u>Description</u>
2	853048-Z	Super 40 Muffler
2	26145S	Connector Pipe, (R/L)
1	26146S	H- Pipe Assembly
1	26148S	Tailpipe, Left front section
1	26150S	Tailpipe, Left rear section
1	26149S	Tailpipe, Right front section
1	26151S	Tailpipe, Right rear section
1	PK594	Parts kit
2	426HA	Muffler Clamp Hanger R/L
1	289HA	Right Muffler Mount
1	290HA	Left Muffler Mount
1	291HA	Tailpipe Clamp Hanger R
1	292HA	Tailpipe Clamp Hanger L
2	HA168	Rubber Hanger
2	HA572	Rear Frame Hanger (R/L)
4	HW502	7/16" Hanger Keepers
6	MC300BS	3" Band Clamps
2	HW204	5/16"x 1" Bolt
4	HW302	5/16" Flat Washer
2	HW308	5/16" Lock Washer
2	HW102	5/16" Nuts
4	HW225	5/16"x 3/4" Cut Thread Hex Bolt

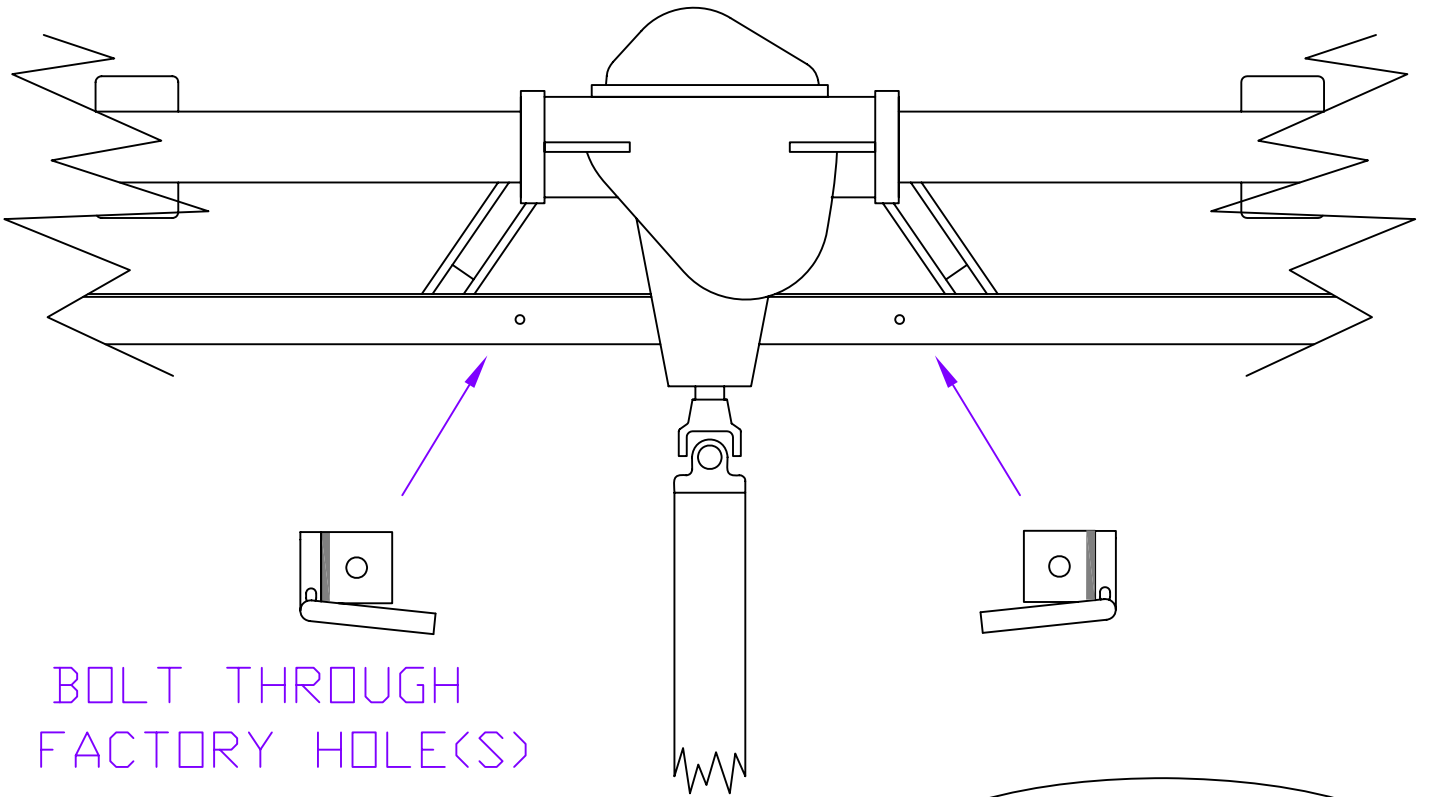


Installation diagram for:  
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1968-1972 GM A-BODY  
3" SYSTEM

**AMERICAN THUNDER**

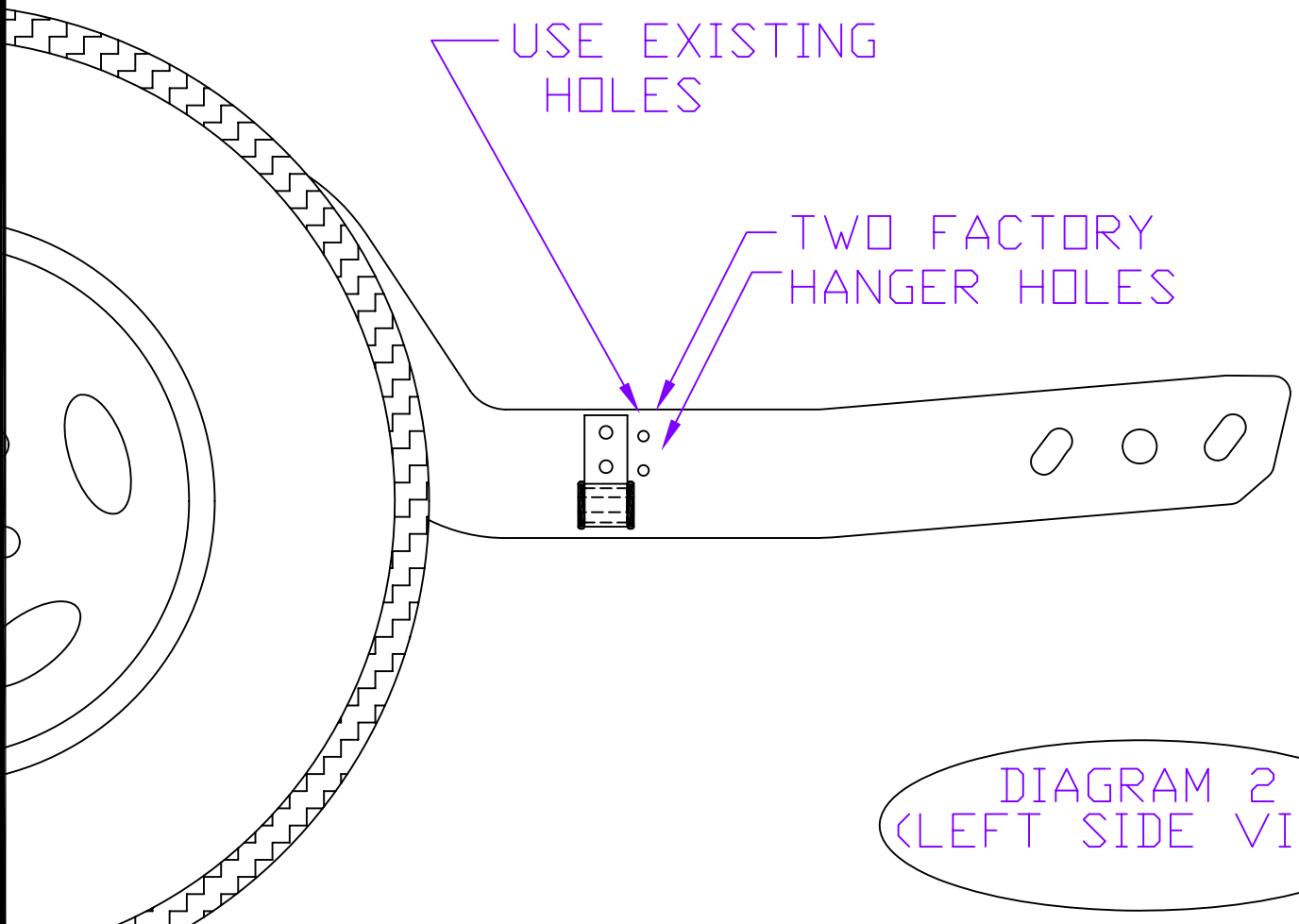
**409S<sup>®</sup> Stainless Steel**





BOLT THROUGH  
FACTORY HOLE(S)

DIAGRAM 1  
(BOTTOM VIEW)



USE EXISTING  
HOLES

TWO FACTORY  
HANGER HOLES

DIAGRAM 2  
(LEFT SIDE VIEW)