



**AMERICAN
THUNDER**

409S® Stainless Steel

Installation Instructions for:

SYSTEM #817342

2001-2006 CHEVROLET SUBURBAN/GMC YUKON XL

ALSO FITS: 2002-2006 CHEVROLET AVALANCHE

1/2 TON • 5.3L ENGINE

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height.
- 2) Support the muffler with a stand and using a hacksaw or sawsall, cut the stock exhaust system just in front of the muffler. Separate the two wire hangers on the tailpipe from their rubber mounts on the vehicle and carefully lower the muffler and tailpipe from the vehicle.
- 3) Using a 15mm wrench, remove the two nuts at the flanged connection just behind the catalytic converter. Separate the wire hanger from the rubber mount in front of the muffler and carefully lower the inlet pipe and set aside.

Installation:

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) Place the inlet pipe, resonator assembly **#15125S** in position behind the flange that is welded to the back of the catalytic converter. Connect the wire hanger to its rubber mount and re-install the factory nuts on the flange connection. Tighten enough to hold in place, but still allow for adjustment.
- 3) Connect the inlet of muffler **#8530562-Z** to the rear of resonator assembly **#15125S**. Use a stand to support the muffler. Install the provided 3" clamps to this connection and tighten enough to hold in place, but still allow for adjustment.
- 4) Slide tailpipe **#16403S** over the rear axle and into the right side muffler outlet. Connect the wire hanger to the rubber mount and install a 2 1/2" clamp onto the muffler outlet. Tighten enough to hold, but still allow for adjustment.
- 5) Take frame hanger **#247HA** and bolt it to the frame on the drivers side towards the rear of the vehicle, just past the shock and stabilizer arm. It is an oval hole towards the top of the frame that goes through both sides of the frame. Slide the 3/8" x 4" bolt through the **#247HA** hanger then through the frame from the outside to the inside. On the inside of the frame secure the hanger with spacer plate **#HA226**, 3/8" flat washer, 3/8" lock washer and the 3/8" nut, all provided in the parts kit. Make sure the hanger is pointing out and is straight up and down. Tighten securely. Place the rubber mount **#HA168** onto the end of the hanger rod.

- 6) Place the left front section of tailpipe **#16500S** into the left side muffler outlet and the slide hanger rod into the rubber mount. Take the rear section of tailpipe **#16406S** and maneuver it up above the rear end and slide the slip-fit end over the back of front section **#16500S**. Rotate pipe and slide the hanger rod into the rubber mount. Install a 2 1/2" clamp onto the connection and tighten enough to hold in place, but still allow for adjustment.
- 7) Take the two stainless tips **#ST339** and slide them over the ends of the tailpipes. Tighten the hose clamps enough to hold, but still allow for adjustment.
- 8) Adjust the position of muffler, pipes and tips 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.
- 9) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the end of the hangers welded to the resonator assembly and tailpipes. This will prevent the hangers from slipping out of the rubber mounts.
- 10) For a more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Resonator Assembly	15125S
1	Muffler	8530562 -Z
1	Right Tailpipe	16403S
1	Left Tailpipe Front Sec	16500S
1	Left Tailpipe Rear Sec	16406S
2	Stainless Tips	ST339
1	Parts Kit	PK566
1	3" Muffler Clamp	MC300BS
3	2.50" Muffler Clamp	MC250BS
1	Frame Hanger	247HA
1	Rubber Mount	HA168
1	Spacer Plate	HA226
1	3/8"x4" Bolt	HW220
1	3/8" Flat Washer	HW303
1	3/8" Lock Washer	HW309
1	3/8" Nut	HW103
1	1/2" Hanger Keepers	HW503
4	7/16" Hanger Keepers	HW502
1	8-1/2" Nylon Cable Tie	HW504



Installation diagram for:

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