



Installation Instructions for:  
**SYSTEM #817409**  
1968-1972 GM A-BODY  
\*\*2.5" STAINLESS PIPES\*\*

**409S® Stainless Steel**

**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) Slide the two rubber hangers **#HA168** onto the two hanger mounts that were installed in the previous step. Slide the two clamp hangers **#388HA** into bottom holes of the rubber hangers. The hanger rod should be inserted from the outside. 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.
- 4) Slide a clamp over each muffler inlet. Place H-pipe assembly **#86229S** in its approximate position underneath the vehicle and connect the back of the H-pipe into the muffler inlets and support with a stand. Tighten clamps just enough to hold but still allow for adjustment.
- 5) 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.
- 6) Place the right front section of tailpipe **#16621S** and the left front section of tailpipe **#16622S** into the outlet of mufflers.
- 7) Take the right rear section tailpipe **#16623S** and slide it onto the back of the right front section tailpipe **#16621S**. Use a clamp at this connection and tighten enough to hold, but still allow for adjustment. Slide clamp hanger **#325HA** onto the back of rear section tailpipe and slide the hanger rod into frame hanger that you installed in step 2.
- 8) Repeat the previous step on the left side using pipe **#16624S** and clamp hanger **#324HA**.
- 9) The front connector pipes **#TB754S (2)** 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.

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 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

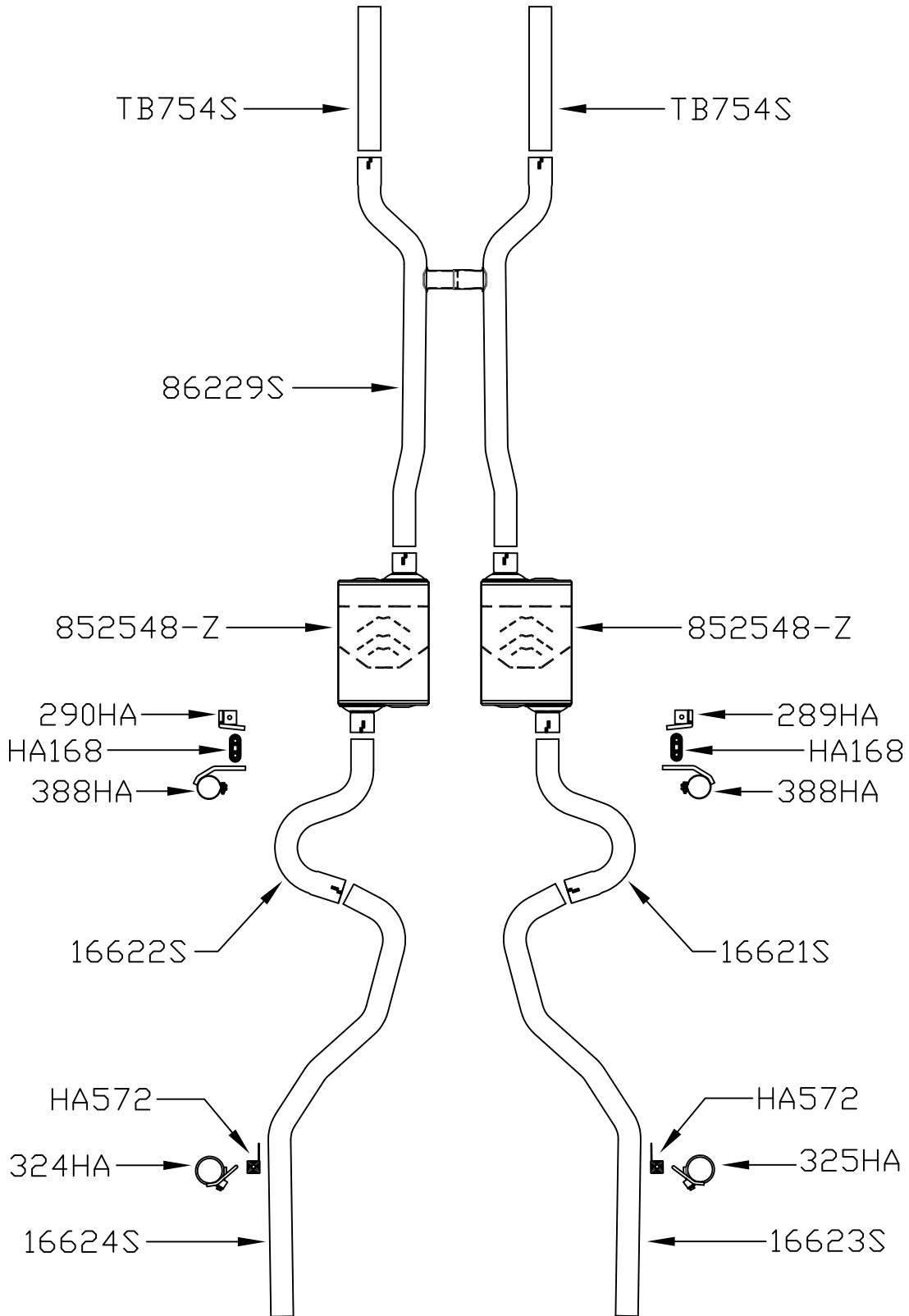
| <u>Qty</u> | <u>Part</u> | <u>Description</u>              |
|------------|-------------|---------------------------------|
| 2          | 852548-Z    | Muffler                         |
| 2          | TB754S      | Connector Pipe, (R/L)           |
| 1          | 86229S      | H- Pipe Assembly                |
| 1          | 16622S      | Left front section tailpipe     |
| 1          | 16624S      | Left rear section tailpipe      |
| 1          | 16621S      | Right front section tailpipe    |
| 1          | 16623S      | Right rear section tailpipe     |
| 1          | PK495       | Parts kit                       |
| 2          | 388HA       | Clamp Hanger Muffler (R/L)      |
| 1          | 289HA       | Muffler Hanger (R)              |
| 1          | 290HA       | Muffler Hanger (L)              |
| 1          | 325HA       | Clamp Hanger Tailpipe (R)       |
| 1          | 324HA       | Clamp Hanger Tailpipe (L)       |
| 2          | HA168       | Rubber Hanger                   |
| 2          | HA572       | Frame Hanger Rear (R/L)         |
| 4          | HW502       | 7/16" Hanger Keepers            |
| 6          | MC250BS     | 2.5" 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 |

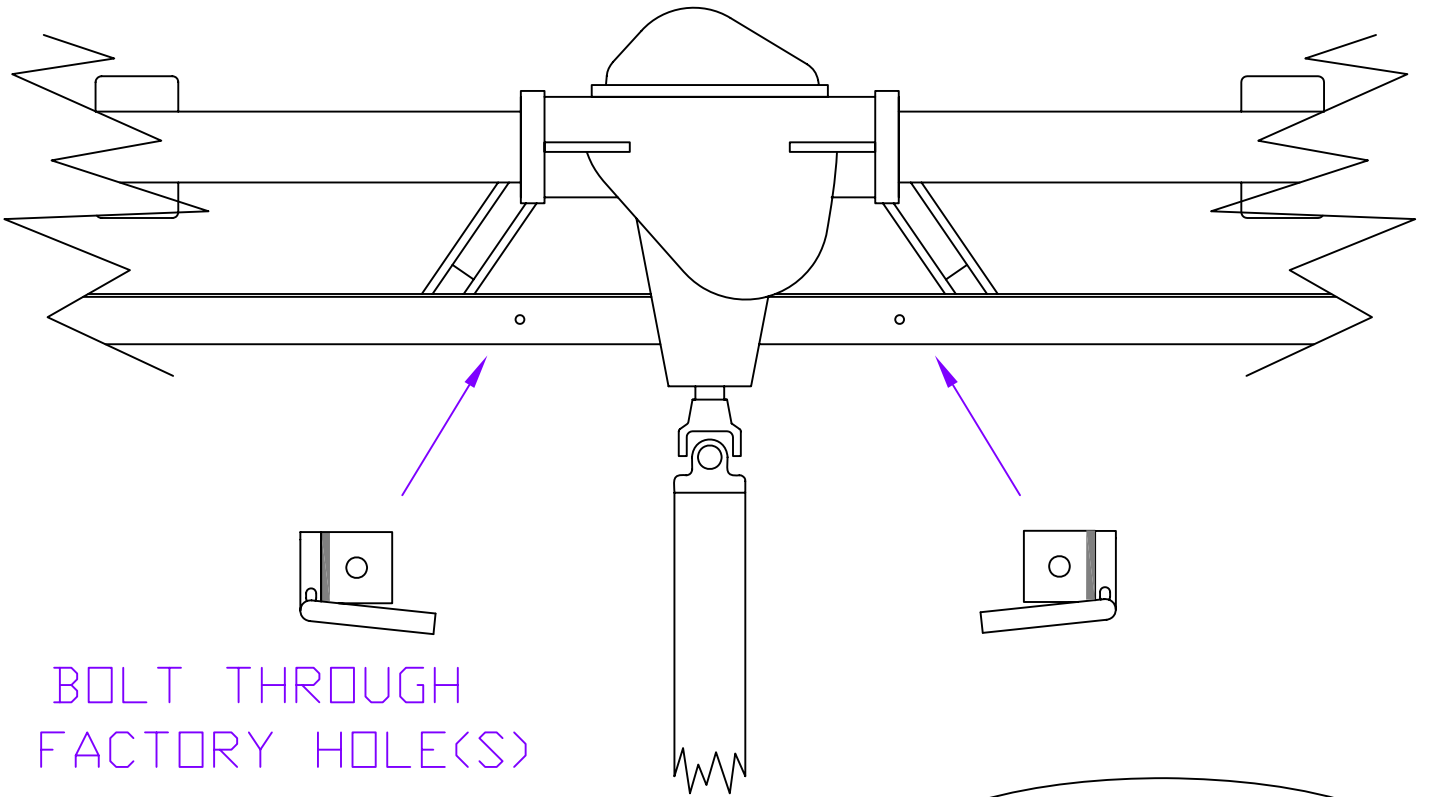


Installation diagram for:  
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BOLT THROUGH  
FACTORY HOLE(S)

DIAGRAM 1  
(BOTTOM VIEW)

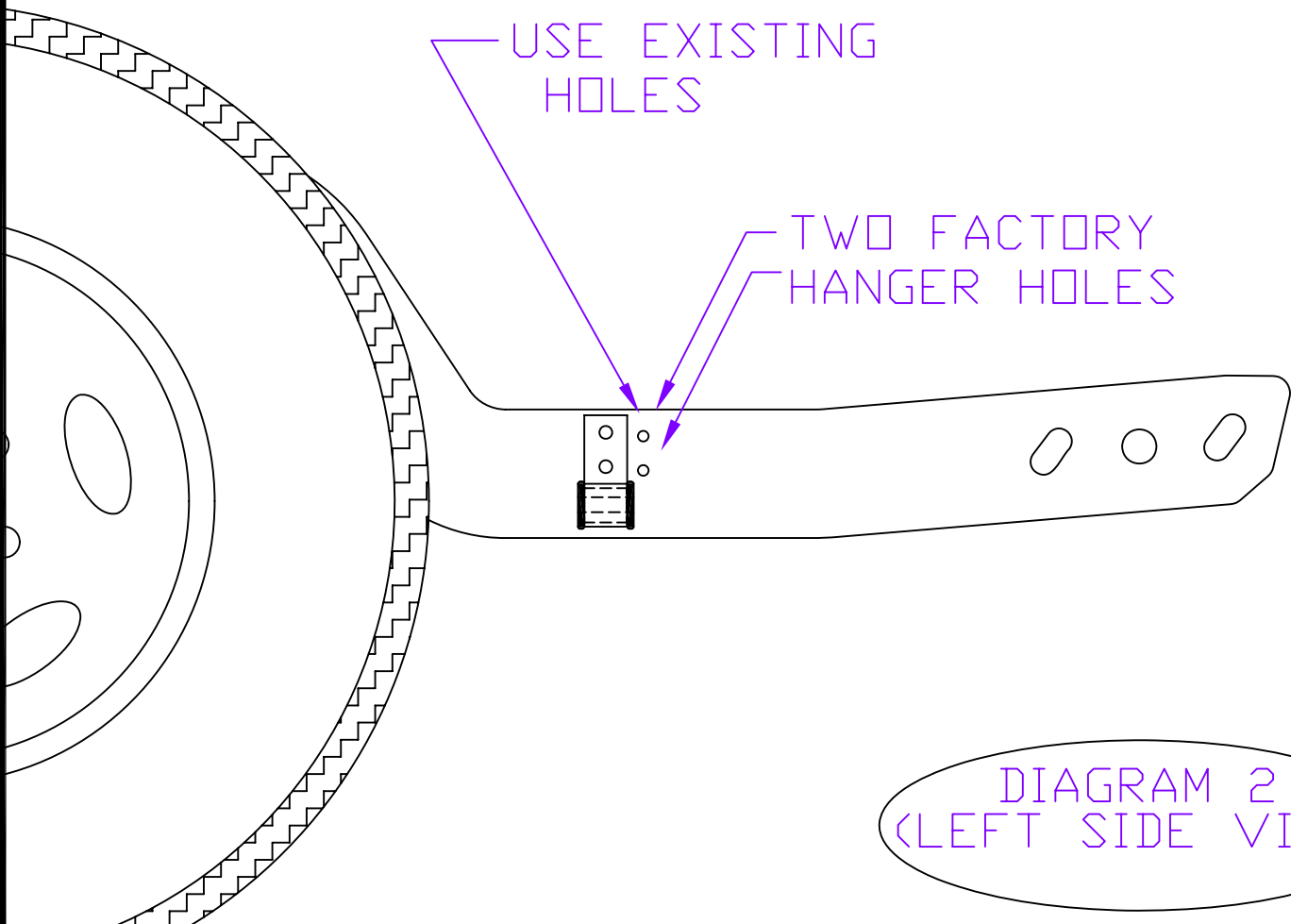


DIAGRAM 2  
(LEFT SIDE VIEW)