



**AMERICAN  
THUNDER**

**409S. Stainless Steel**

Installation Instructions for:  
**SYSTEM #817412**  
1964-1967 GM "A" BODY  
\*\*2.50" STAINLESS PIPES\*\*

### Installation:

- 1) Raise the vehicle up on a hoist or rack to working height.
- 2) On the rear control arm mount/crossmember frame section, 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 mount the rear muffler hangers. Use these stock locations to mount hanger **#298HA** on the left side and hanger **#297HA** on the right. Use the 5/16" x 1" bolts and nuts provided. **See Diagram 1.**
- 3) On the main outer frame rails of the vehicle, slightly behind the rear axle, there will be a single mounting hole on each side of the vehicle which will be used to mount the rear tailpipe hangers. Use these stock locations to mount hanger **#302HA** on the left side and hanger **#303HA** on the right. Use the 3/8" thread cutting bolts provided. The holes may need to be drilled out to a 5/16" diameter. **See Diagram 2.**
- 4) Slide the four rubber hangers **#HA168** onto the hanger rods. Slide the two muffler hangers **#388HA** into the rubber hangers, and then place the outlets of the mufflers into the clamp hangers.
- 5) Place H-pipe assembly **#86227S** in its approximate position underneath the vehicle and connect the back of the H-pipes into the inlets of the mufflers and support with a stand. Before connecting the H-pipe, slide a clamp over the muffler inlets, then connect to the H-pipe and tighten clamps enough to hold, but still allow for adjustment.
- 6) Place the right and left side front tailpipe sections **#16492S** into outlet of mufflers and tighten the clamp hangers just enough to hold, but still allow for adjustment. Place rubber hangers on the two tailpipe clamp hangers **#359HA** and **#360HA**. Connect them to the frame mounts installed in Step 3 and onto the back of the over-axle pipe.
- 7) Take the right rear section tailpipe **#16491S** and slide it onto the back of the right front section tailpipe **#16492S**. Slide clamp hanger **#360HA** onto the back of right rear section tailpipe **#16491S** and slide the hanger rod into rubber hanger **#HA168** installed in Step 3.
- 8) Take the left rear section tailpipe **#16490S** and slide it onto the back of the left front section tailpipe **#16492S**. Use a clamp at this connection (*slide clamp on front section tailpipe before connecting to rear section*) and tighten enough to hold, but still allow for adjustment. Slide clamp hanger **#359HA** onto the back of the left rear section tailpipe **#16490** and slide the hanger rod into rubber hanger **#HA168** that you installed in Step 3.

- 9) The front connector pipes **#TB754S** 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) When you have cut the connector pipes to the 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 “Flowmaster” venture cone.
- 11) Adjust the position of the mufflers and all pipes to provide the proper 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.
- 12) Tighten down all clamped connections securely. After the system is secure, slide the 7/16” hanger keepers onto the round stock sticking through the rubber hangers provided in the parts kit. This will prevent the hangers from slipping out of the rubber mounts.
- 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>Description</u>	<u>Part#</u>
2	Muffler	852548-Z
2	Connector Pipe (R/L)	TB754S
1	H- Pipe Assembly	86227S
2	Front section tailpipe (R/L)	16492S
1	Left rear section tailpipe	16490S
1	Right rear section tailpipe	16491S
1	Parts kit	PK496
2	Clamp Hanger Muffler (R/L)	388HA
1	Muffler Hanger (R)	297HA
1	Muffler Hanger (L)	298HA
1	Clamp Hanger Tailpipe (R)	360HA
1	Clamp Hanger Tailpipe (L)	359HA
4	Rubber Hanger	HA168
1	Frame Hanger Rear (R)	303HA
1	Frame Hanger Rear (L)	302HA
8	7/16” Hanger Keepers	HW502
4	2.5” Band Clamps	MC250BS
2	5/16”x 1” Bolt	HW204
4	5/16” Flat Washer	HW302
2	5/16” Lock Washer	HW308
2	5/16” Nuts	HW102
2	3/8” Cut Thread Hex Bolt	HW222
2	3/8” Flat Washer	HW303



Installation diagram for:  
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