



## **409S® Stainless Steel**

### Installation Instructions for:

## **SYSTEM #817428**

**1999-2006 CHEVROLET/GMC, C/K 1500 TRUCKS**  
EXTENDED CAB, SHORT BED, 4.8L & 5.3L ENGINES

### Removal:

- 1) Raise the vehicle up on a hoist or rack to working height and support securely with jack stands.
- 2) Using a hacksaw or sawsall, cut the stock tailpipe off where it exits the muffler. **(This step is not mandatory, but it makes removal easier.)**
- 3) Separate the two wire hangers on the tailpipe from the rubber mounts on the vehicle. Remove the tailpipe and set aside.
- 4) Support the muffler with a stand, then separate the wire hanger from the rubber mount in front of the muffler.
- 5) Remove the two nuts at the muffler to cat flange connection. Remove the muffler 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 inlet pipe **#26247S** into position behind the catalytic converter. Connect the wire hanger to its factory rubber mount, and re-install the factory nuts on the flange connection.
- 3) Slide a supplied **#MC300BS** clamp over the inlet of muffler **#8530462-Z** and connect it to the back of the inlet pipe. Use a stand to support the muffler, next tighten the clamp enough to hold in place but still allow for adjustment.
- 4) Using the bolts, washers, nuts and backing plates **#HA566** provided, mount tailpipe hanger **#226HA** to the frame on the left side of the vehicle using the angled oblong hole on the frame rail. Repeat this step on the right side of the vehicle using hanger **#227HA**; they both bolt in approximately the same position on either side of the vehicle. Slide rubber hanger **#HA168** onto the ends of both 226HA and 227HA. Remove the factory rubber hanger from the stock mount.
- 5) Slide a supplied **#MC250BS** clamp over the right side muffler outlet and slip the right side tailpipe **#16521S** into the same muffler outlet. Tighten the clamp enough to hold in place but still allow for adjustment. Connect the hanger that is welded to the rear of the pipe to the rubber hanger **#HA168** installed in step 3. Pipe should be approximately 3/4" away from the shock when adjusted.

- 6) Slide a supplied **#MC250BS** clamp over the left side muffler outlet and slip the left front tailpipe **#16648S** into position over the rear axle, and into the same muffler outlet. Connect the hanger rod to the rubber mount and tighten the clamp enough to hold in place.
- 7) Slide a supplied **#MC250BS** clamp over the back of the left front tailpipe. Place the left rear tailpipe **#16524S** into the outlet of the same left front tailpipe installed in step 5. Tighten the clamp enough to hold in place but still allow for adjustment. Connect the hanger that is welded to the rear of the pipe into the rubber hanger **#HA168** installed in step 3. The pipe should be centered between the shock and the spare tire when adjusted.
- 8) Connect either **#16317S** for side exit or **#16397S** for rear exit onto the ends of the tailpipes and install a supplied **#MC250BS** clamp on each side. Tighten the clamps enough to hold in place but still allow for adjustment. Place stainless tips **#ST396** onto the ends of the chosen exit pipes and adjust to desired fit and tighten firmly.
- 9) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. A minimum 3/4" of clearance around all parts of the system must be maintained, while also keeping suspension travel and vibration in mind.
- 10) Tighten all clamped connections down securely. Place the supplied 1/2" hanger keepers onto the end of the inlet pipe and left rear muffler hanger. Slide the 7/16" hanger keepers on to the rear tailpipe and frame hangers. Slide them up to the rubber mounts to firmly hold the system in place.
- 11) To prevent the rear axle breather tube from contacting the left side tailpipe, and possibly being damaged, use enclosed zip tie to fasten rear axle breather tube to the brake line bracket located on the frame. Be sure to allow hose enough slack for the suspension to fully compress and extend.
- 12) 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 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>
1	Inlet Pipe	26247S
1	Muffler	8530462-Z
1	Tailpipe, Right	16521S
1	Tailpipe, Left Front	16648S
1	Tailpipe, Left Rear	16524S
2	Side Exit Pipes (L / R)	16317S
2	Rear Exit Pipes (L / R)	16397S
2	Stainless Tips	ST396
1	Parts Kit	PK519
1	Frame Hanger, Left	226HA
1	Frame Hanger, Right	227HA
2	Rubber Hanger	HA168
4	Backing Plate	HA566
5	2 1/2" Band Clamps	MC250BS
1	3" Band Clamp	MC300BS
2	3/8" X 1-1/4" Bolts	HW209
2	3/8" Nuts	HW103
2	3/8" Lock Washers	HW309
2	3/8" Flat Washers	HW303
1	Plastic Ziptie	HW504
4	7/16" Hanger Keepers	HW502
2	1/2" Hanger Keepers	HW503



Installation diagram for:

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**AMERICAN THUNDER**

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