



Installation Instructions for:

SYSTEM #817435

1999-2006 CHEVROLET/GMC C/K 1500 TRUCK

4.8L & 5.3L ENGINE • STANDARD CAB, SHORT BED



409S® Stainless Steel

Removal:

- 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) Using a hacksaw or sawsall, cut the stock tailpipe where it exits the muffler. (This step is not mandatory, but it makes removal a little 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 and 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 **#26124S** 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 the muffler **#8530562-Z** and connect it to the back of the inlet pipe. Use a stand to support the muffler and tighten the clamp enough to hold, but still allow for adjustment.
- 4) Using the provided 3/8" x 1.25" bolts, 3/8" washer and nuts and two square backing plates **#HA566** (Note: The backing plates go on both sides of the frame between the hanger, washers & bolts to cover the oblong holes so that the frame hangers won't bend into oblong hole.), 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** (see Fig. 1 on page 3). 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 on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold in place, but still allow for adjustment.
- 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 6. 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 4. 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, but still allow for adjustment. Place the stainless tips **#ST396** onto the ends of the chosen exit pipes and adjust to desired fit. Tighten firmly.
- 9) Adjust the position of all 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.
- 10) Tighten down all clamped connections securely. After the system is secure, slide the 1/2" hanger keepers onto the end of the inlet pipe and left rear muffler hanger. Slide the 7/16" hanger keepers onto the rear tailpipe and frame hangers. This will prevent the hangers from slipping out of the rubber mounts.
- 11) To prevent the rear axle breather tube from contacting the left side tailpipe and possible being damaged, use the enclosed zip tie to fasten the rear axle breather tube to the brake line bracket, located on the frame. Be sure to allow enough slack in the hose for the suspension to fully compress and extend.
- 12) For a more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe	26124S
1	Muffler	8530562-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" Ring Clamps	MC250BS
1	3" Ring 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



Figure 1



Installation diagram for:
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AMERICAN THUNDER

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