



**409S® Stainless Steel**

Installation Instructions for:

**SYSTEM #817470**

**1996-1999 CHEVROLET/GMC C/K 1500 TRUCKS**  
5.7L EXTENDED CAB, SHORT BED

### 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 will make 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) Remove the Oxygen Sensor from the front pipe by first unplugging the wire at the clip connection on the cross member then unscrewing the sensor from the fitting on the pipe using a 7/8" wrench.
- 5) Support the muffler with a stand, then separate the wire hanger from the rubber mount in front of the muffler.
- 6) Remove the three 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 the inlet pipe assembly **#26046S** in position behind the flange that is welded to the back of the catalytic converters. Be sure to install gasket **#GA105** in between the two flanges. Connect the wire hanger to its rubber mount. Re-install the factory nuts on the flange connection and tighten securely. Reconnect the Oxygen Sensor to the fitting on the pipe and the wire connection on the cross member.
- 3) Connect the inlet of muffler **#8530702-Z** to the inlet pipe. Use a stand to support the muffler and install a 3" clamp. Tighten enough to hold but still allow for adjustment.
- 4) Using the bolts, washers and nuts provided, mount tailpipe hanger bracket **#166HA** to the frame rail on the left side of the vehicle. Replace the stock hanger on the right side of the vehicle with a second **#166HA**. (They bolt approximately in the same position on either side of the vehicle.) Place the rubber hanger mounts **#HA168** onto the hanger brackets you just installed.

- 5) Place tailpipe **#16313S** in position over the rear axle and slip into the right side muffler outlet. Install the hanger welded to the front of the tailpipe into the stock rubber mount behind the muffler and the rear hanger into rubber hanger **#HA168**. Repeat for the left side using tailpipe **#16312S**.
- 6) Connect exit pipes **#16317S or #16397S** to the ends of both tailpipes and place a provided 2-1/2" clamp onto these connections. Tighten enough to hold but still allow for adjustment. Place the two stainless tips onto the exit pipes and tighten the clamps enough to hold but still allow for adjustment. Rotate the exit pipes and tips to the desired position and tighten just enough to hold in place.
- 7) 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.
- 8) Tighten all clamped connections down securely. Place a hanger keeper onto each of the hanger rods. Slide them up to the rubber mounts to firmly hold the system in place.
- 9) To prevent the rear axle breather tube from contacting the left side tailpipe, and possibly 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.
- 10) For a cleaner appearance and more secure installation, we recommend welding all slip-fit connections.

#### **PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet pipe	26046S
1	Muffler	8530702-Z
1	Tailpipe, Right	16313S
1	Tailpipe, Left	16312S
2	Side Exit Pipe, (R/L)	16317S
2	Rear Exit Pipe, (R/L)	16397S
2	Stainless Tips	ST396
1	Gasket	GA105
1	Parts kit	PK543
2	Rubber Hanger	HA168
2	Hanger Mounting Bracket	166HA
4	2 1/2" Clamps	MC250BS
1	3" Clamp	MC300BS
4	3/8" X 1" Bolts	
4	3/8" Nuts	
4	3/8" Lock Washers	
4	3/8" Flat Washers	
1	Plastic Zip tie	
5	7/16" Hanger Keepers	
1	1/2" Hanger Keeper	



Installation diagram for:  
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