



**409S Stainless Steel**

**Installation Instructions for:**

**SYSTEM #817473**

**1993\*-1995 CHEVROLET/GMC K 1500 TRUCKS**

5.0L & 5.7L EXTENDED CAB, SHORT BED 4WD

\*(FLANGED CONVERTER OUTLET)

**Removal:**

- 1) Raise the vehicle up on a hoist or rack to working height.
- 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) 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 the inlet pipe assembly **#26125S** into position behind the catalytic converter. Connect the wire hanger to its rubber mount and re-install the factory nuts on the flange connection and tighten securely.
- 3) Place a supplied 3" clamp onto the inlet of muffler **#8530452-176** and slide onto inlet pipe **#26125S**. Use a stand to support the muffler and tighten clamp enough to hold in place, but allow for adjustment. Place a supplied 2.50" clamp onto the outlets of the muffler.
- 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.) Install **#HA168** onto round stock of frame hanger.
- 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**. Tighten clamps enough to hold but still allow for adjustment.

- 6) Place a supplied clamp onto your choice of exit pipes **#16317S or #16397S** and slip onto the ends of both tailpipes. Tighten clamps 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 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 the supplied 1/2" hanger keeper onto the end of the inlet pipe hanger and the 7/16" hanger keepers onto the ends of the muffler, over axle and tailpipe hangers. 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 more secure installation, we recommend welding all slip-fit connections.

#### **PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet pipe	26125S
1	Muffler	8530452-176
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	Parts kit	PK558
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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**AMERICAN THUNDER**

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