



409S Stainless Steel

Installation Instructions for:
SYSTEM #817585
1967-1974 MOPAR "A" BODY
2 1/2" HEADER BACK SYSTEM

Installation:

- 1) Remove the existing exhaust system from the vehicle. Also, remove any hangers used to support the exhaust system.



- 2) On the inside of the rear frame rails, roughly 10" forward of the bumper, you will find large holes that will be used to mount the tailpipe hanger brackets. You should see a round hole in the center of the frame rail. Place a supplied 3/8" x 3" bolt with a **#HA226** square backing plate installed through the hole from the outside of the frame to the inside. Place a **#HA572** hanger bracket onto the end of the bolt and secure with the nuts and lock washers provided.



- 3) On the rear section of the floor pan, just ahead of the rear axle, there are two bolts that secure the rear seat belts in place. From the inside of the vehicle, you will need to remove the rear seat back to gain access to the bolts. Once you have the rear seat back out, remove the bolts securing the seat belts to the floor. Replace the stock bolts with the 7/16"-16 x 2" Grade 8 Bolts provided. From the underside, place the right muffler hanger **#449HA** over the new bolt and use the provided 7/16" nut and lock washer to secure. Slide a **#HA168** rubber hanger onto the hanger mount. Repeat this step with the left side hanger **#448HA**. **Note:** The fourth photo above shows the left side hanger **#448HA** installed.



4) Place both tailpipes **#16793S** and **#16794S** up over the rear axle and connect the hangers on the tail pipes to the rubber mounts installed in Steps 2 & 3 above.



5) Place a provided 2 1/2" clamp onto the muffler outlets, then place the mufflers up into position and onto the front of the tailpipes. Slide the mufflers fully onto the tailpipes and support the mufflers with a stand. Tighten the clamps enough to hold, but still allow for adjustment. Be sure the rubber hangers are hanging vertically straight up and down.



6) Slide a 2 1/2" clamp over each muffler inlet. Place Scavenger pipe assembly **#16789S** in its approximate position underneath the vehicle and connect the back of the Scavenger assembly into the muffler inlets and support with a stand. Tighten the clamps enough to hold, but still allow for adjustment.

7) The front adapter pipes **#16523S** are long enough to allow for many different header or manifold downpipe configurations, therefore, it will be necessary to determine the proper length of the connector pipes. Be sure that the muffler hangers are straight up and down and that all clearances are good before trimming the adapter pipes. Once the proper length is determined, trim the front adapter pipes to fit.

8) Once the adapter pipes are cut to proper length, raise them into position and connect them to the Scavenger pipe and header collectors or manifold down pipes using a standard header flange, Flowmaster Venturi Cone or Flowmaster Ball Flange kit.

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 7/16" hanger keepers on the round stock sticking through the rubber hangers. This will prevent the hangers from slipping out of the rubber mounts.

11) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

Packing List

<u>Qty</u>	<u>Description</u>	<u>Part</u>
4	Adapter Pipes	16523S
1	Scavenger Assembly	16789S
2	Muffler	852548-Z
1	Right tailpipe	16793S
1	Left tailpipe	16794S
1	Parts kit	PK642
1	Left Muffler Mount	448HA
1	Right Muffler Mount	449HA
2	Rear Hanger Mount (R/L)	HA572
6	2½" Clamps	MC250BS
2	Rubber Hanger	HA168
2	Back Up Plate	HA226
4	7/16" Hanger Keepers	HW502
2	3/8"-16 x 3" Bolt	HW227
2	3/8"-16 Nut	HW103
2	3/8" Lock Washer	HW309
2	3/8" Flat Washer	HW303
2	7/16"-20 x 2" Bolt, G8	HW232
2	7/16"-20 Nut, G8	HW112
2	7/16" Lock Washer	HW310



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Installation diagram for:
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