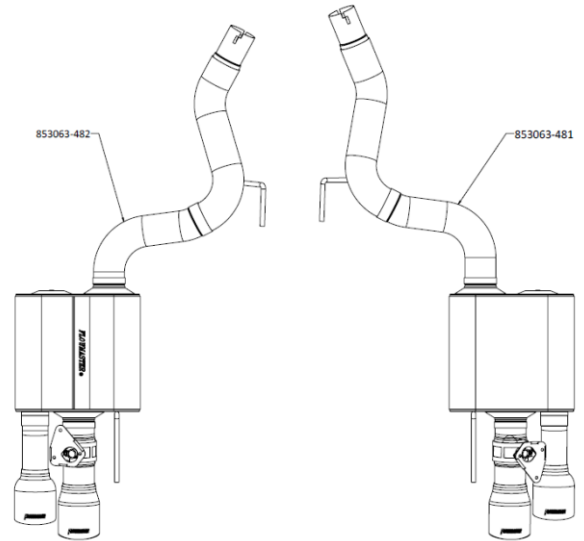




409S, Stainless Steel

**Installation Instructions for:
SYSTEM #817799
2018 MUSTANG GT
5.0L · V8 ENGINE
Fits vehicles with Active Performance Exhaust**

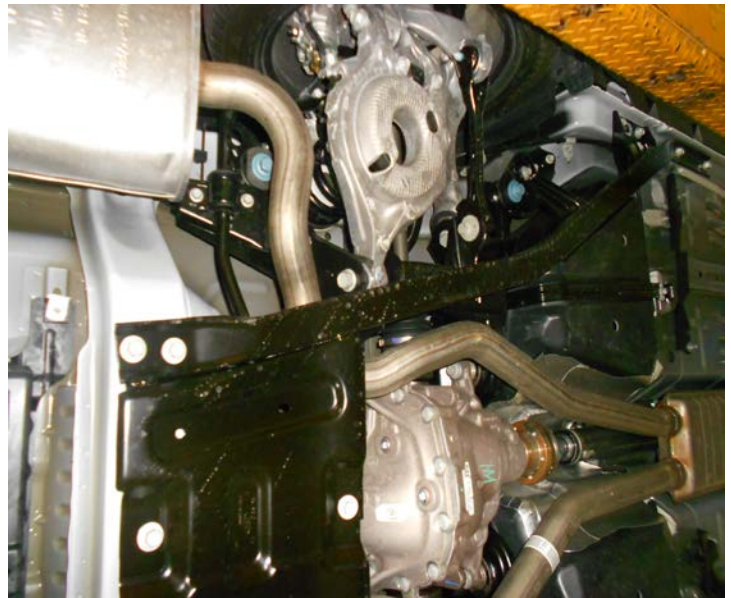
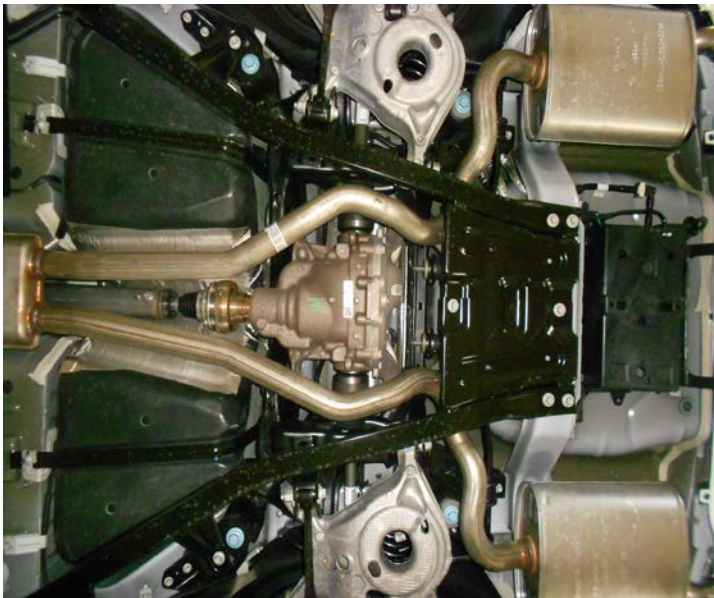


PACKING LIST		
<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Right Muffler Assembly.	853063-481
1	Left Muffler Assembly.	853063-482
1	Hardware Pack	PK795
2	2½" Clamp	MC250BS

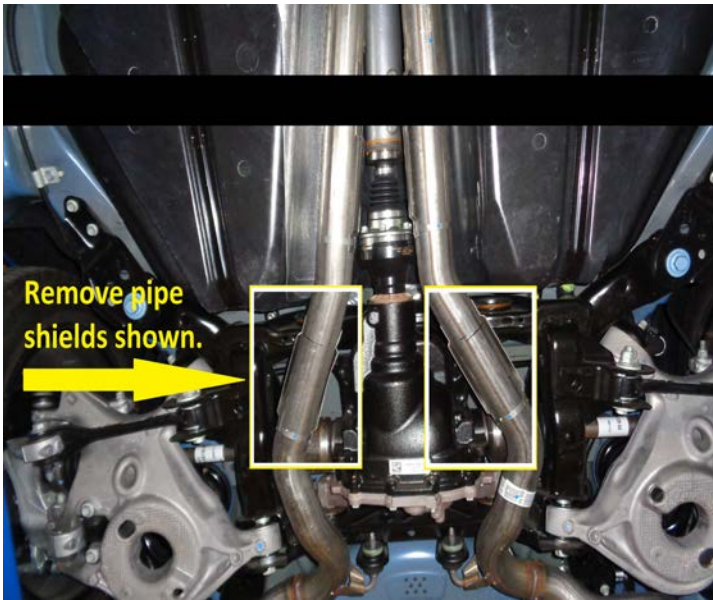
Removal:

01/31/18

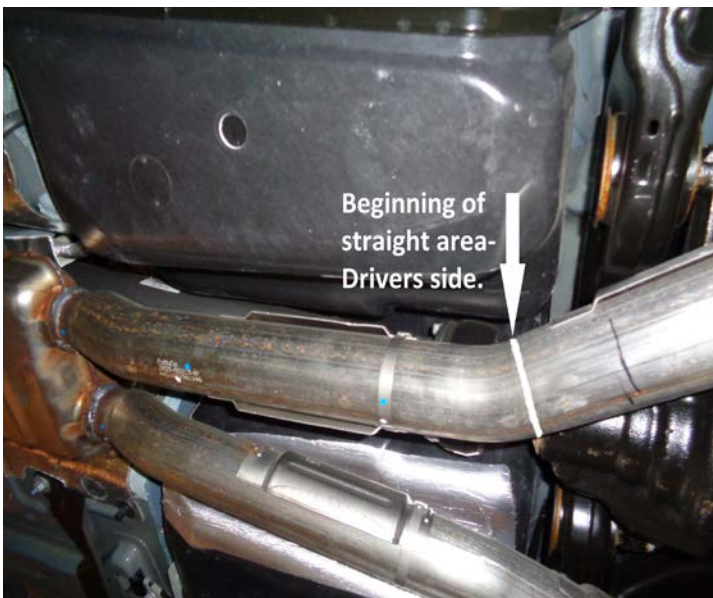
- 1) Raise the vehicle and support securely with stands. To ease the removal of the stock system, spray a penetrating lubricant onto the rubber hangers just behind the rear differential and also at the rear of the vehicle.



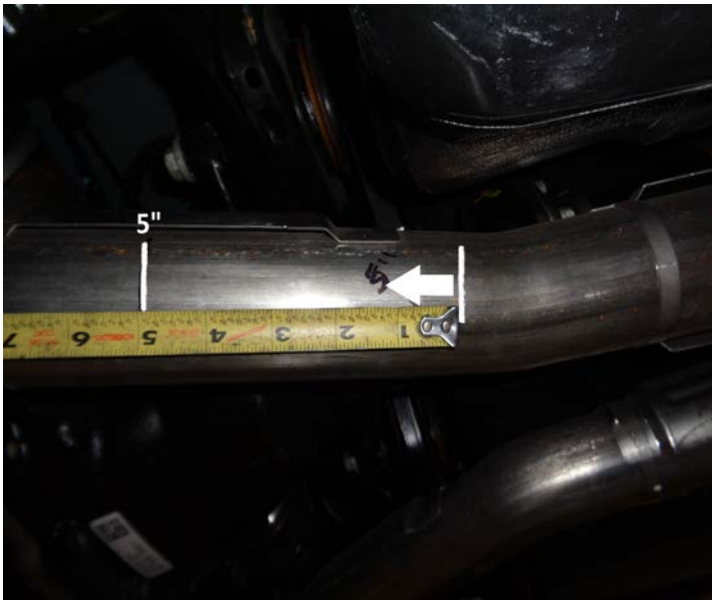
- 2) On convertible model vehicles, the body braces shown in the photos above will need to be removed in order to remove the factory system and install the Flowmaster system. Starting at the front of the right side (passenger) brace, loosen the front bolt and then work your way to the rear of the vehicle removing the next eight bolts, lower the brace from the vehicle. Repeat this step on the left side of the vehicle with the six bolts on that side.



3) Begin by removing the two pipe heatshields indicated in the first picture above. Cut thru the strap at the rear of the shield, then lift and lower the shield a few times to break the weld at the front of the shield. Remove.



4) Behind the factory center resonator, follow the pipes back just past the second bend of each pipe, make a mark on each pipe where the bend ends and the straight area begins. See above photos. At the rear of each muffler unplug the wire to the factory exhaust actuator and tuck the connection up out of the way until ready to re-connect to the new mufflers.



5) Measure back 5.00" from the beginning of the straight area marked in the previous step and make a mark on both pipes as shown in the first photo above. Support the exhaust system both in front and behind the area to be cut, then once you've double checked that the measurements are correct, cut both pipes at the marks. **Note: Due to the closeness of the pipes to the gas tank, use caution when cutting!** Using a 13mm wrench, unbolt the two hangers just behind the rear differential from the cross member. Carefully lower the stand under each muffler and slide the muffler assembly forward and out of the rear hanger mount. Lower the assemblies to the floor, leaving the front hangers attached. Carefully deburr the end of the pipes where cut with a file or die grinder. Finally, remove the two hanger mounts at the rear of the vehicle from the frame using a 13mm wrench, as you remove them place them with the factory muffler from the corresponding side.

Installation:



1) Place the new Flowmaster muffler units next to the factory units and swap the front and rear hanger mounts from the stock mufflers to the new mufflers. Also, place a provided 2.50" clamp onto the inlet of each assembly. Tighten the clamp just enough to hold in place.



2) On the factory mufflers, use a 10mm wrench to remove the three nuts securing the exhaust valve actuator to the exhaust valve. Place the three nuts and the grounding clip aside for re-installation on the new Flowmaster mufflers.



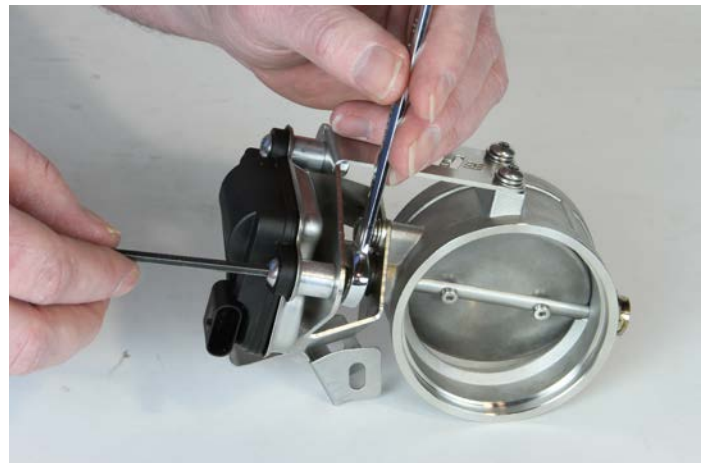
3) Lift the actuator with the heatshield and spring attached from the factory valve assembly.



4) **Installing the actuator onto the new valves:** Line up the spring arm with the notch in the valve shaft and lower into place. The holes in the actuator assembly should line up with the holes in the mount, rotate if required.



5) Place a supplied 1/4" Button head screw thru the grounding clip removed from the stock valve and then into the hole on the opposite side of the FM in the mounting plate. Place a supplied 1/2" spacer between the mount and the actuator heatshield, then follow with a supplied lock washer and nut on the bottom side of the mount.



6) Use the remaining 1/4" hardware to secure the actuator to the mount in the remaining two holes. Tighten securely using a 7/16" open end and 5/32" Hex wrench.



- 7) Place the right muffler assembly **#853063-481** up into position and slide onto the factory pipe approximately 2½". Support the assembly with a stand and remount the rear hanger mount to the frame and tighten securely. Remount the front hanger to the cross member and tighten securely. Leave the clamp on the inlet loose for now. Repeat this step with muffler assembly **#853063-482** on the left side of the vehicle.
- 8) On convertible model vehicles, reinstall the body braces starting with the left (Drivers) side of the vehicle, install the six bolts and tighten securely. Repeat this step on the right side of the vehicle with the eight bolts on that side, tighten securely. Reconnect the plug on the exhaust valve at the rear of each muffler.
- 9) Adjust and level the two muffler assemblies to provide a satisfactory fit, assuring that the tips are level and centered in the bumper cut-outs. A minimum of 1/2" clearance around all parts of the system must be maintained; while keeping suspension travel and vibration in mind. After adjustments have been made, you may now securely tighten the two muffler inlet clamps.
- 10) For a more secure installation, we highly recommend placing a minimum 1" weld on either side of the inlet slip-fit connections.