



**Installation Instructions**  
**817940**  
**1967-72 GM TRUCKS**  
**4.6L, 5.0L, 5.3L, 5.7L, 6.5L, 6.6L ENGINE**  
**4 Wheel Drive**

**OVERVIEW:**

1. Take a moment to read and understand these instructions before installing your Flowmaster performance system.

**NOTE:** Please inventory all parts now before continuing and if necessary, report any missing items to our tech line. This will avoid potentially stranding your vehicle until any missing replacement parts arrive.

ITM #	PART #	DESCRIPTION	QTY.
8	86681S	Right Muffler Exit	1
9	86682S	Left Muffler Exit	1
10	86683S	Right Exit Turndown	1
11	86684S	Left Exit Turndown	1
12	86685S	Right Side Exit	1
13	86686S	Left Side Exit	1
14	86687S	Right Rear Exit	1
15	86688S	Left Rear Exit	1
N/A	PK1043	Hardware Package includes:	1
16	520HA	Left Front Frame Hanger	1
17	521HA	Right Front Frame Hanger	1
18	MC250BS	2½" Stainless Band Clamp	10
19	MC200BS	2" Stainless Band Clamp	1
20	HA168	Red Rubber Hanger	2
21	HA572	Universal Bracket	2
22	HW225	⅝"-18 x ¾" Bolt	4
23	HW204	⅝"-18 X 1 Hex Cap Screw	4
24	HW302	⅝" Flat Washer	4
25	HW308	⅝" Lock Washer	4
26	HW102	⅝"-18 Nut	4

ITM #	PART #	DESCRIPTION	QTY.
1	86675S	Right Header Adapter	1
2	86676S	Left Header Adapter	1
3	86677S	Right H-Pipe	1
4	86678S	Left H-Pipe	1
5	86679S	Right Muffler Inlet	1
6	86680S	Left Muffler Inlet	1
7	842546-Z	Muffler	2

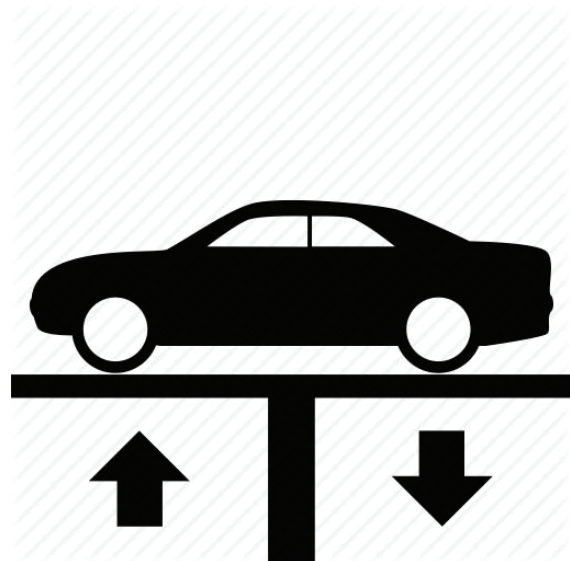
**PREPARE VEHICLE FOR KIT INSTALLATION:**

2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

**WARNING:**  
 Avoid serious burns! Allow your vehicle time to cool completely before touching any factory engine components.

**To ease preparation and installation of your new kit:**

- Apply penetrating lubricant to mounts, bolts and clamps before you remove them.
- Use stands as necessary to support parts as you detach them from your vehicle and again as you install new parts.



3. Remove existing system from header collector or manifold down pipes rearward.

### INSTALL FLOWMASTER EXHAUST SYSTEM:

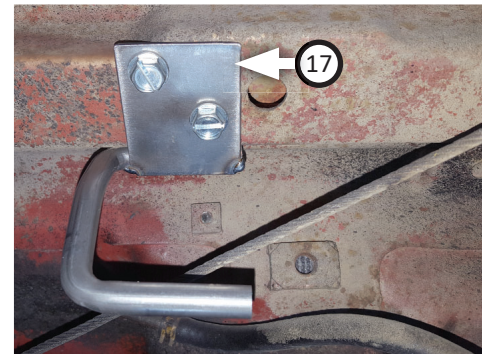
4. Remove nuts from stock and Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.

**NOTE:** The image in this step is intended for illustrative purposes only and may or may not accurately reflect components included in your kit.

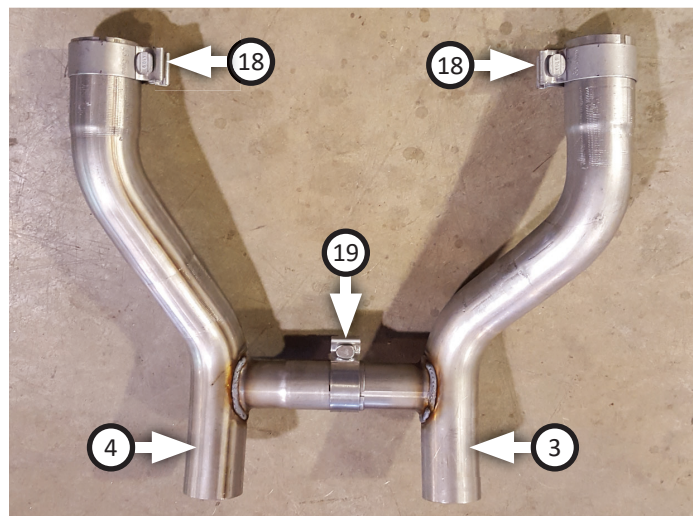


5. Mark center cross member inboard 8" from inside frame rail. Now use this mark and **left (16) front frame hanger** to create remaining inboard mark. Drill marked (x2) holes.

6. Mount (x2) left and **right (17) front frame hanger** oriented as shown with (x2 ea.) **bolts (22)**.

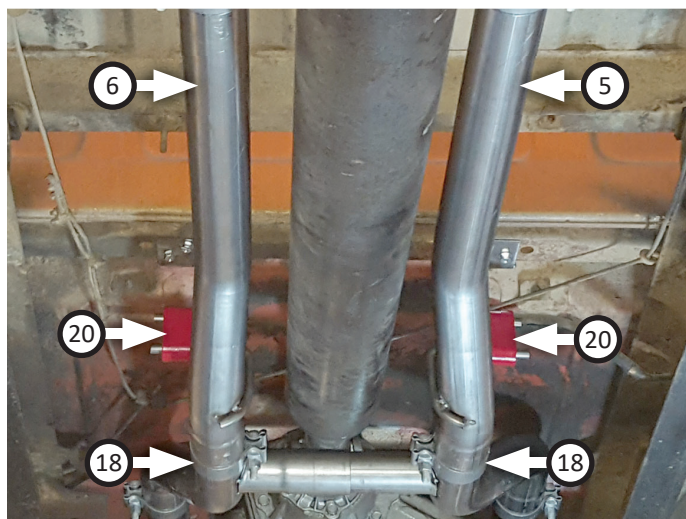


7. Connect **right (3) and left (4) headpipes** with **clamp (19)** but leave it loose. Place (x2) **clamps (18)** onto headpipes.



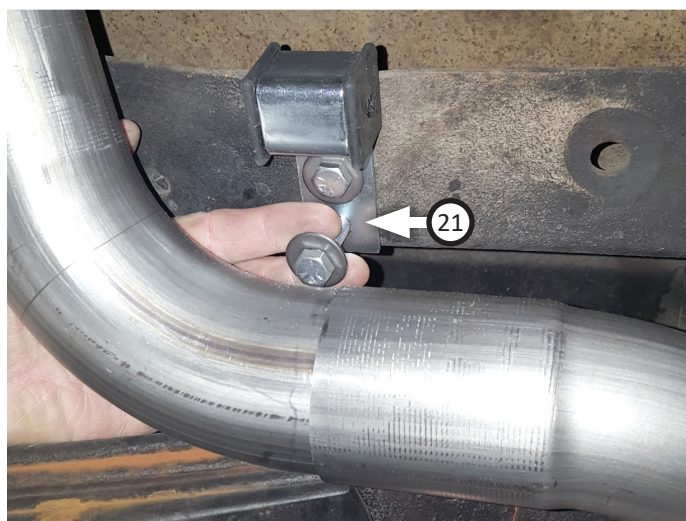
**NOTE:** Step 8 applies only to short bed model vehicles.

- For short bed model vehicles, trim 12" from rear section of **right (5)** and **left (6)** muffler inlets.
- Connect inlets to H-pipes using (x2) **clamps (18)** then hang assembly in position with (x2) **rubber hangers (20)**.



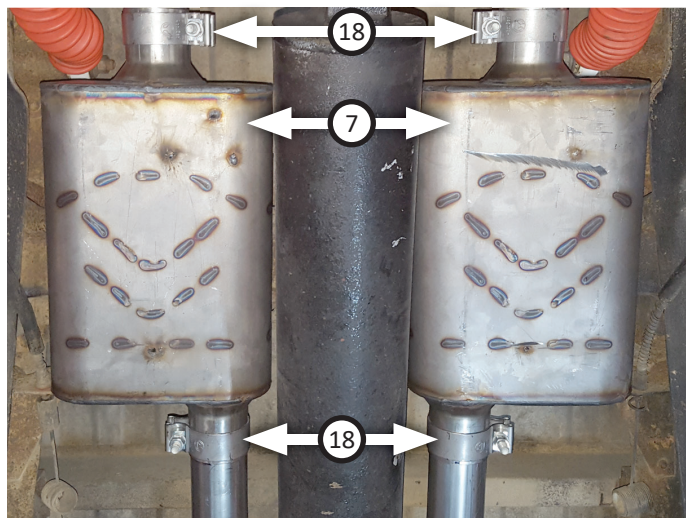
**NOTE:** Complete step for both driver and passenger sides.

- Mark line 10½" forward of leaf spring mount at bottom of frame. Square and center **bracket (21)** on line to mark holes, drill them then mount bracket with (x2 ea.) **screws (23)**, **flat (24)**, **lock (25)** washers and **nuts (26)**.



- Place (x2) **clamps (18)** onto **muffler (7)** then connect it to muffler inlet pipe. Tighten front clamp just enough to allow for adjustment.

**NOTE:** Complete step for both driver and passenger sides.



12. Route **left (9)** and **right (8)** muffler exit over axle and connect them to mufflers. Insert wire hangers into brackets then tighten clamps just enough to allow for adjustment.

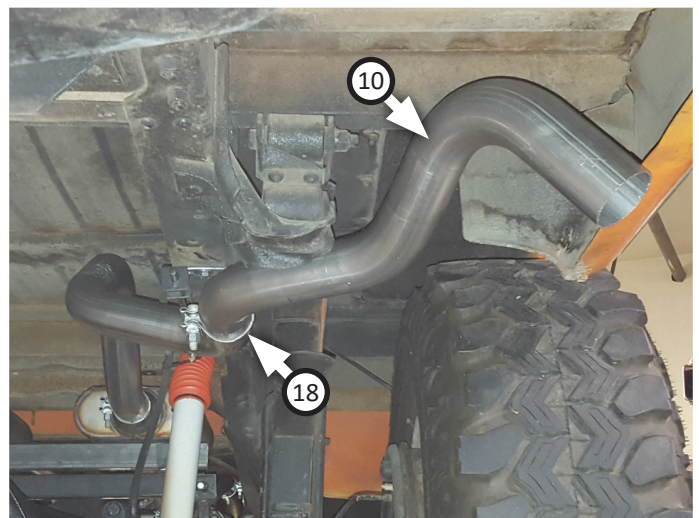
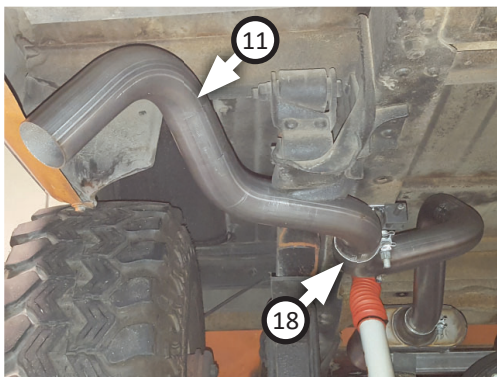


**NOTE:** This kit includes **turndown (10-11)**, **side (12-13)** and **rear (14-15)** exit pipes. For this installation, we will use the turndown pipes.

**NOTE:** For short and long bed vehicle models, trim tailpipes depending on exit pipe placement and preference.



13. Place **clamp (18)** onto **left (11)** and **right (10)** exit **turndown** pipes then connect them to muffler exit. Tighten clamps just enough to allow for adjustment.



14. It will be necessary to adapt from your existing headers or manifold downpipes to the Flowmaster H-pipe assembly. Due to the many different variables in header/manifold down pipe locations, we have included **right (1)** and **left (2) header adapters**. Additional fabrication may be necessary to connect exhaust.



15. Adjust exhaust components for fit; maintaining  $\frac{1}{2}$ " clearance and compensating for suspension, travel and vibration.
16. Recommended: Secure slip-fit connections with a 1-inch tack weld then spray high-temp paint over each weld to prevent rust and premature corrosion.



Congratulations, the installation of your FLOWMASTER performance exhaust system is now complete!





Installation Diagram  
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4 Wheel Drive

