

2020+ FORD F250/350 7.3L

CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works catback exhaust system for your 2020+ Ford F250/350 7.3L. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



2020+ F250 7.3L
(FT220CBL/R)

a.

Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

b.

Your exhaust system can be installed by a weekend warrior but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a level hard surface. Jack stands are required for safety reasons.

c.

You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.

d.

When installing your catback system, make certain that the hangers at the end of the exhaust have at least $\frac{3}{4}$ " of clearance to the bumper. The exhaust will grow over $\frac{1}{2}$ " in length and can possibly damage the bumper. If the end of the hangers are too close to the bumper, then you must make sure that you have everything pushed forward onto the slip fit joints more fully.

DISASSEMBLY

1. Disconnect the battery.
2. Raise and support the vehicle.
3. In front of the first muffler, loosen the wide band clamp and pry back the lock tab.
4. Use a 13mm socket to remove the (2) bolts from the catback flange.
5. Unbolt the (2) 10mm bolts holding the exhaust hanger to the frame near the transmission.
6. Slide the exhaust free of all hangers and remove it from the truck.

ASSEMBLY

7. Your system may require trimming depending on cab/bed configuration. The chart to the right shows the amount to trim from the lead pipes. Measure from the outlet end, mark the tubes, cut, and deburr before installing.
8. Install the right side lead pipe and the hanger removed in step 6. Secure the tube using the factory wide band clamp.
9. Install the left lead pipe, with the 2-bolt flange. Use the provided 10mm hardware and washers.
10. Install the mid muffler using (2) 3" clamps.
11. Install the right and left muffler inlet pipes using (2) more 3" clamps.

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PAGE 2



Detail 6

Cab Configuration	Bed Length	Wheel base	Cut Length
Regular Cab	8'	142	18"
SuperCab	6'9"	148	12"
	8'	164	0" adjust slip fit overlap
Crew Cab	6'9"	160	0"
	8'	176	0" use long adapters

Detail 8: Lead pipe trim chart



Detail 11: Inlet connection and Mid-muffler installed

12.
Install the hanger assembly to the muffler inlet pipes using (2) 3" saddle clamps.

13.
Install both mufflers using (2) 3" clamps.

14.
Install the tailpipes over the axle and to the mufflers using the (2) hanger-clamp weldments. They are marked left and right.

15.
Install the rear tailpipe hanger assembly to the truck's hanger insulator then to the tails using (2) 3" clamps.

16.
Install the tips using (2) 3" clamps. Rotate the tips as needed to match the profile of the truck.

17.
Adjust and tighten the system from front to back.

18.
Be sure to have adequate clearance around all wires, hoses and lines. If anything is in contact with the exhaust system, it will melt. Make sure to have at least ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

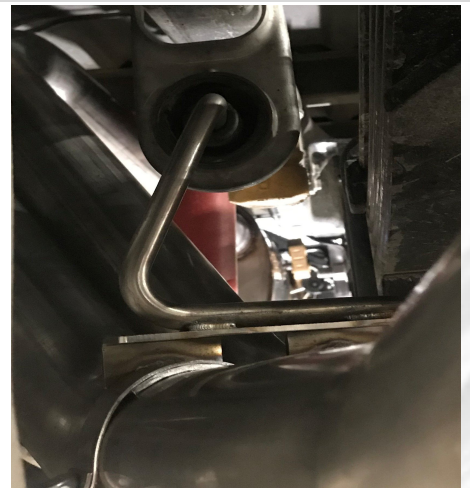
19.
After double checking for clearance and making sure all lines, wires and hoses are secured, drive the truck for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.



Detail 13: Inlet pipes to mufflers



Detail 15: Muffler to tailpipe connection



Detail 16: Rear tailpipe hanger (viewed from back right of vehicle)