



2004-2008 FORD F-150 5.4L 2WD/ 4WD EXHAUST SYSTEM INSTALLATION INSTRUCTIONS

Thanks for purchasing Stainless Works Exhaust System for your 2004-2008 2WD/ 4WD F-150 5.4L SUPERCAB with 6.5' bed or SUPERCREW with 5.5" or 6.5' bed. We have gone to great pains to make sure that our exhaust systems fit and sound great. Please follow these steps to ensure that your installation goes as planned.

1. Stainless Works recommends the use of Hi-Temp RTV sensor safe silicon gasket maker as an option to or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.
2. Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.
3. 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 and jack stands are required for safety reasons.

INSTALLATION FOR EXHAUST SYSTEM TO FACTORY CONNECTION PT.

4. Disconnect battery.
5. Raise and support vehicle.
6. Loosen double wide exhaust clamp at back of factory Y-pipe and save clamp for later use.
7. Remove the hangers from the rubber insulators and remove the exhaust. If using a lift, the exhaust can be removed in one piece, but if not, the tailpipe may need to be cut in half for removal.
8. The pictures at the end of this document are headers to an under-bumper system, showing x-pipe and hanger locations before and after the mufflers and at the tips.
9. The following instructions are utilized to adjust the length of the Y-pipe based on the Truck cab/ bed configurations:
10. The Y-pipe length in the box is 29" long. This Y-pipe is designed to be cut to fit the following truck cab/bed configurations. Cut the front (the single pipe end) of the Y-pipe and deburr, according to the lengths described in the following table:

CAB/ BED	AMOUNT TO BE REMOVED FROM REAR OF Y-PIPE	FINAL Y-PIPE LENGTH
SUPERCREW/ 6.5' BED	0"	29"
SUPERCAB/ 6.5' BED	7"	22"
SUPERCREW/ 5.5' BED	13"	16"

11. Using OEM double wide clamp removed above, attach the Y-pipe to the factory connection point.
12. Install muffler inlets to rear of Y-pipe using (2) 2.5 clamps.
13. Install hanger on muffler inlets using (2) saddle clamps.
14. Install mufflers using (2) 2.5 clamps.
15. Install tail pipes and hanger at mufflers using (2) saddle clamps.
16. Install rear hanger to tail pipes using (2) saddle clamps.
17. Install tips using (2) clamps. Under bumper systems have additional hangers.
18. Starting at front of the system check for alignment, adjust and tighten system.
19. Lower vehicle and reconnect battery.

INSTALLATION FOR EXHAUST SYSTEM TO HEADERS

20. The following are to be completed after the installation instructions for headers contained in a separate document
21. Remove the exhaust hangers from the rubber insulators and remove the exhaust. If using a lift, the exhaust can be removed in one piece, but if not, the tailpipe may need to be cut in half for removal.
22. The pictures at the end of this document are headers to an under-bumper system, showing x-pipe and hanger locations before and after the mufflers and at the tips.
23. Install muffler inlets to X-pipe using (2) 2.5 clamps. Level the X-pipe.
24. Install hanger on pipes using (2) saddle clamps.
25. Install mufflers using (2) 2.5 clamps
26. Install tail pipes at mufflers.
27. Install rear hanger to tail pipes using (2) saddle clamps.
28. Install tips using (2) clamps. Under bumper systems have additional hangers.
29. Starting at front of the system check for alignment, adjust and tighten system.
30. Lower vehicle and re-connect battery.
31. 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.
32. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the car 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.

