FLOWMASTER®
Signature Series
EXHAUST SYSTEMS

Installation Instructions

738115

2021-24 FORD F-150 2.7T, 3.5T & 5.0L ENGINE

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.
1	26849H	Inlet Pipe	1
2	26277H	Extension Pipe	1
3	73249-Z	Muffler	1
4	26754H	Tailpipe Assembly	1
5	ST509BC	Tip	1
N/A	PK1066	Hardware Package includes:	1
6	505HAH	Front Clamp Hanger	1
7	MC300BS	3" Stainless Band Clamp	3
8	SF059H	Flange	1

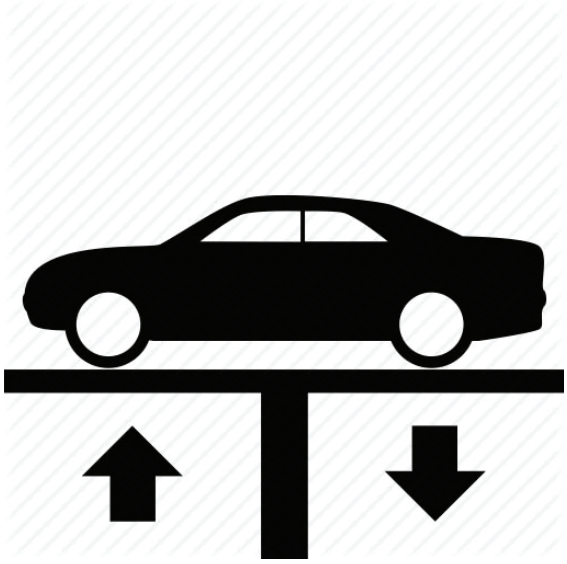
REMOVE STOCK EXHAUST SYSTEM:

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. Cut tailpipe at muffler exit. Disassemble hanger wires from isolators and remove tailpipe section from vehicle.

4. Support muffler and disassemble wire hangers from isolators. Remove and retain (x2 ea.) flange nuts and bolts, disconnect inlet pipe and remove exhaust system.

INSTALL FLOWMASTER EXHAUST SYSTEM:

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

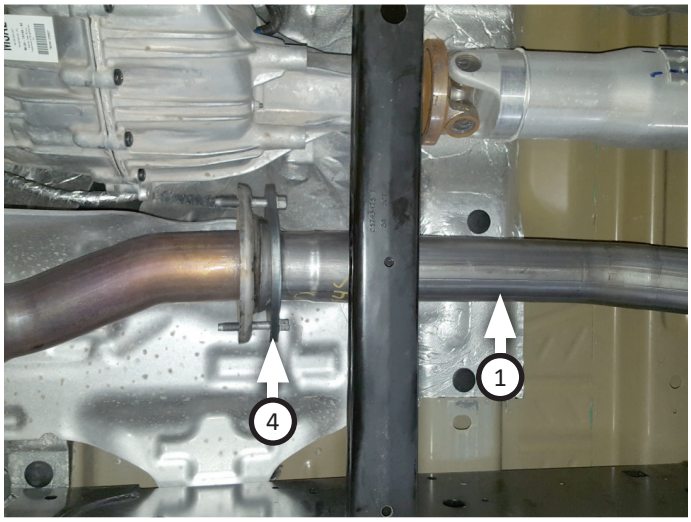
NOTE: The image in this step is intended for illustrative purposes only and may or may not accurately reflect components included in your kit.

6. Every slip fit connection in this kit must seat 3" deep except for muffler connections which must seat 2" deep. Find all slip fit components in your kit and mark them accordingly so your Flowmaster exhaust system fits properly onto your vehicle.

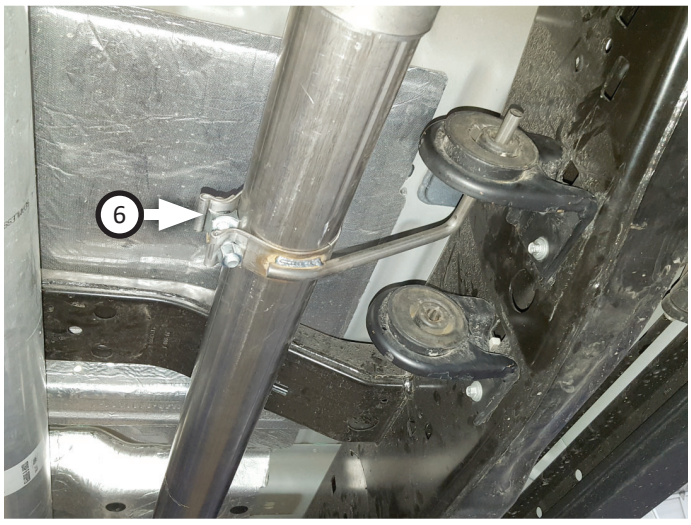
7. If your vehicle falls within the specifications listed below, apply the corresponding modifications or assembly combinations to this kit to ensure it will install properly.

WHEEL BASE	BODY STYLE	BED LENGTH	INLET ASSY:	MODIFICATION
141"	Regular Cab	8'	Inlet Pipe only	Trim 4" from inlet pipe
145"	SuperCrew	5'5	Inlet Pipe only	None
145"	SuperCab	6'5	Inlet Pipe only	None
157"	SuperCrew	6'5	Inlet+Extension	Trim 6" from extension pipe
163"	SuperCab	8'	Inlet+Extension	None

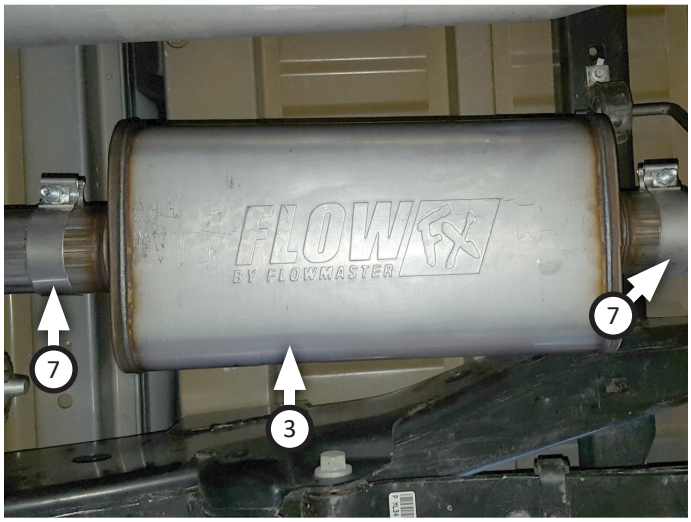
8. Place **flange (8)** on **inlet pipe (1)** then connect assembly to head pipe. Fasten flanges with (x2 ea.) nuts and bolts (removed step 4) just enough to hold parts. Orient inlet pipe straight with its bend facing down for proper fit.



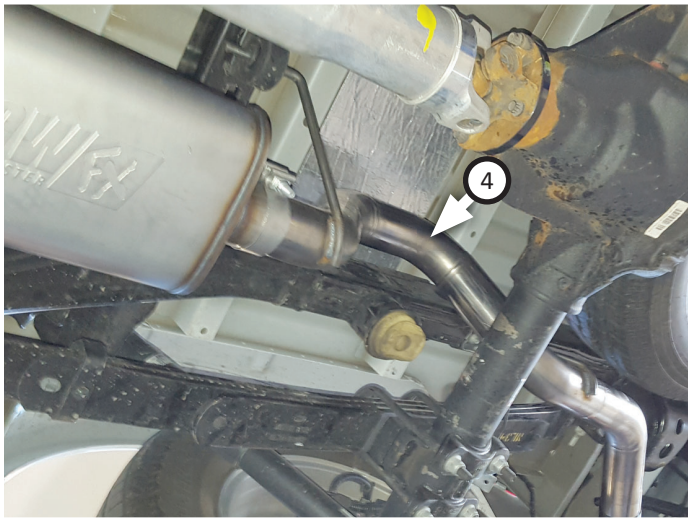
9. Slide **front clamp hanger (6)** over back of inlet pipe then insert it into factory isolator. Leave clamp loose.



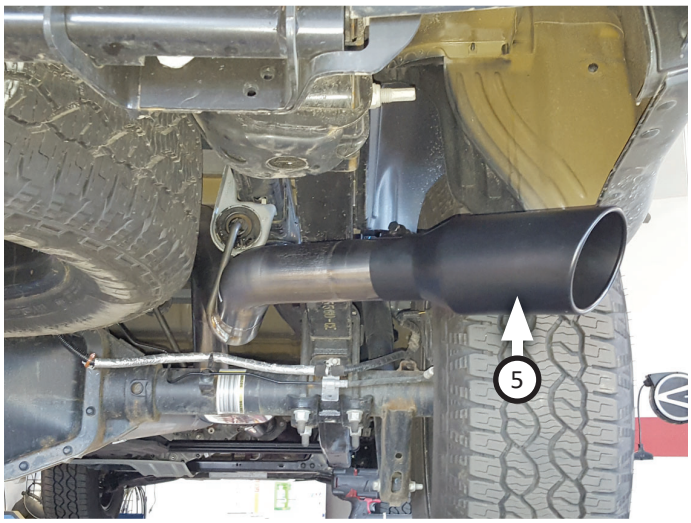
10. If applicable, place **clamp (7)** onto **extension (2)** then connect it to inlet pipe.
11. Place **clamp (7)** onto **muffler (3)**, slide it 1¾" onto inlet or extension pipe and support with a stand. Level muffler and tighten clamp at inlet enough to hold parts. Place **clamps (7)** onto muffler outlet.



12. Route **tailpipe (4)** over axle then connect it to muffler. Insert its wire hangers into isolators then tighten clamp just enough to allow for adjustment.



13. Place **tip (5)** onto muffler and tighten inlet. Rotate it to desired distance from body or bumper, so angle cut is properly positioned.



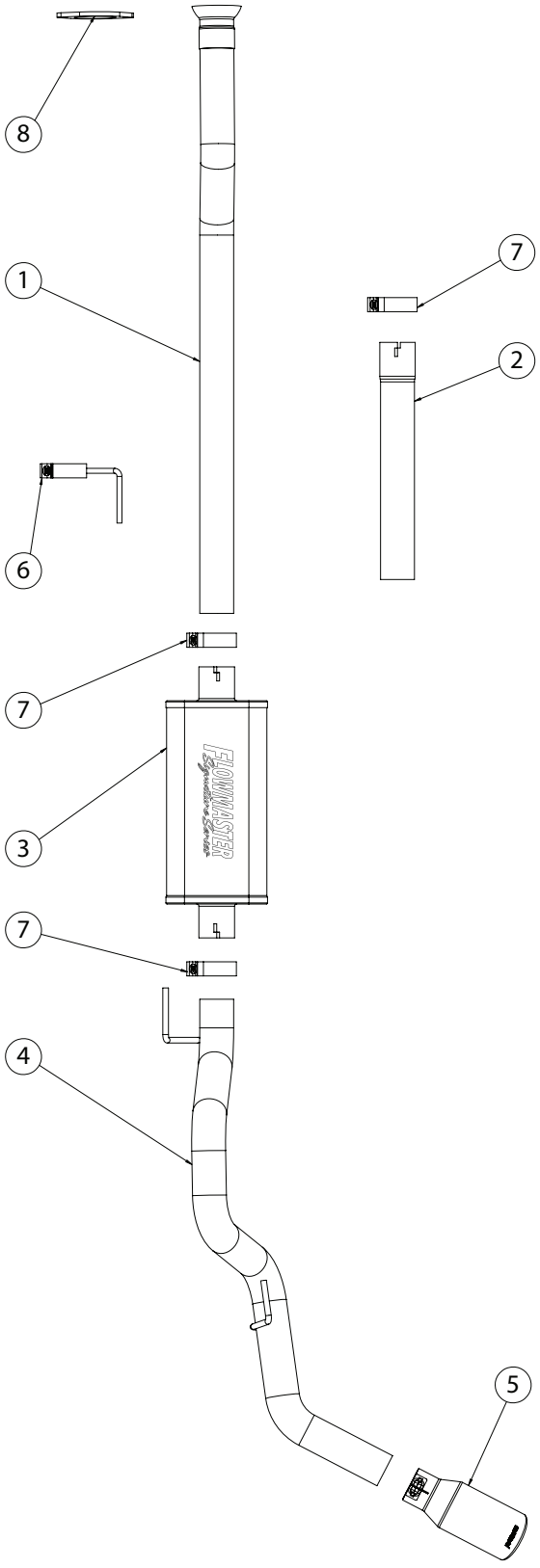
14. Adjust exhaust components for fit; maintaining ½" clearance and compensating for suspension, travel and vibration, then tighten all clamps.
15. Recommended: Secure slip-fit connections with a 1-inch tack weld then spray high-temp paint over each weld to prevent rust and premature corrosion.

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

FLOWMASTER INC.
THE PERFORMANCE TECHNOLOGY COMPANY

FLOWMASTER Signature Series EXHAUST SYSTEMS

Installation Diagram

738115

2021-24 FORD F-150
2.7T, 3.5T & 5.0L
ENGINE