



## **409S<sub>®</sub> Stainless Steel SYSTEM #817281**

**1967-1970 FORD MUSTANG**

DOES NOT FIT CONVERTIBLES OR STAGGERED SHOCKS

07/18/11

### **Removal:**

- 1) The rear seat of the vehicle will have to be removed in order to install the hangers described in Step 2.
- 2) Raise the vehicle up on a hoist or rack to working height. If you do not have access to a hoist or rack raise the vehicle and support securely with jack stands.
- 3) Remove the existing system from the header collector or manifold down pipes back.

### **Installation:**

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) If your 1967 or 1968 vehicle came with factory dual exhaust you will use your existing holes. All others look on the underside of the vehicle on the back side of the rear seat pan. Measure from the frame in towards the center of the vehicle 8" and make a mark, then measure from the seam on the back of the body 1 1/2" down and make a mark for your first upper hole. For the second lower hole measure 9 3/8" from the frame in and 2 3/8" down and make your mark. Re-check the marks to confirm that they are correct using the supplied muffler hangers **#358HA** and **#357HA**. Center punch both marks and drill them out to a 3/8" hole. These measurements will be the same on both sides. (Note: See diagram 1 on page 4 of these instructions.)
- 3) Take the stud plates **#361HA** and **#362HA** push them from the inside of the vehicle into the holes you have just drilled. Take hanger assembly **#358HA** for the left side and hanger assembly **#357HA** for the right side and place them over the bolts protruding through the floor. Secure the hangers to the body using the 5/16" nuts and lock washers provided and tighten firmly.
- 4) After mounting the hangers into place, slide the rubber hangers **#HA168** over the hanger rods. Place the clamp hangers **#391HA** into the bottom hole of the rubber hangers (both sides take the same clamp hanger). Both clamp hangers will point towards the passenger side of the vehicle.
- 5) On the right and left side frame at the rear of the vehicle there is either a flat plate bolted to the frame or just two holes punched in the frame. Unbolt the flat plate if it is there, take frame hangers **#HA572** and mount them into the forward holes towards the front of the vehicle. You can set the plate aside, it will not be needed. Use the supplied 3/8"x2 1/2" bolts, lock washers, flat washers and nuts. (Note: See diagram 2 on page 4 of these instructions.)

- 6) Place the right tailpipe **#16553S** over the rear axle and so that the rear of the tailpipe exits between the fuel tank and the leaf spring. Slide the tailpipe hanger into the rubber hanger **#HA572** attached to the frame installed in Step 4.
- 7) Install the right muffler **#842546-Z** by placing the outlet of the muffler into the clamp hanger assembly **#391HA** and over the tailpipe you just installed. Rotate the muffler to get it level and support with a stand. Tighten the clamp enough to hold in place, but still allow for adjustment.
- 8) Repeat step 6 and 7 using left tailpipe **#16552S** and muffler **#842546-Z**.
- 9) Adjust the rear of the tailpipes so that they are rotated correctly and are centered between the gas tank and the leaf springs. Repeat this step for both sides of the vehicle.
- 10) Install the front H-pipe assembly **#16550S** by placing the rear of the front pipe assembly into the inlets of both mufflers and centering it in the drive line cavity. Support the front of the assembly with a stand, be sure that the muffler and front pipe assembly are level. Once the mufflers and front pipe assembly are in place, check the hangers at the rear of each muffler to see if they are hanging straight down. Adjust the front pipe and the mufflers forward or back as needed to get the correct fit. Once the desired fit is achieved, place a clamp onto the inlet of each muffler and tighten just enough to hold in position.
- 11) It will be necessary to adapt from your existing headers or manifold down pipes to the H-pipe assembly installed in step 10. Due to the many different variables in header/manifold down pipe locations the pieces required to do this will need to be fabricated using the supplied four adapter pipes **#16556S**.
- 12) Remove temporary support and allow the system to suspend on the hangers.
- 13) Adjust the position of the mufflers and tailpipes to achieve a satisfactory fit. Be sure to provide adequate clearance for suspension travel. Maintain a minimum of 3/4" clearance between the Flowmaster system and the drivetrain and chassis components.
- 14) Place stainless tips **#ST396** onto the ends of the tailpipes and adjust to the desired fit. Tighten firmly.
- 15) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the hanger rods on the tailpipes to prevent them from sliding out of the rubber mounts.
- 16) For a more secure installation, we recommend welding all slip-fit connections.

## PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>PART #</u>
2	Muffler	842546-Z
1	H-pipe Assembly	16550S
4	Adapter Pipe	16556S
1	Right Tailpipe	16553S
1	Left Tailpipe	16552S
2	Stainless Tip	ST396
1	Parts Kit	PK546
2	Muffler Hanger	391HA
1	Right Muffler Hanger	357HA
1	Left Muffler Hanger	358HA
2	Frame Hanger	HA572
1	Right Hanger Stud Plate	361HA
1	Left Hanger Stud Plate	362HA
6	2 1/2" Clamp	MC250BS
2	Rubber Hanger	HA168
4	7/16" Hanger Keeper	HW502
2	3/8" x 2 1/2" Bolt	HW212
2	3/8" Nut	HW103
2	3/8" Lock Washer	HW309
4	3/8" Flat Washer	HW303
4	5/16" Nuts	HW102
4	5/16" Lock Washers	HW308

DIAGRAM 1

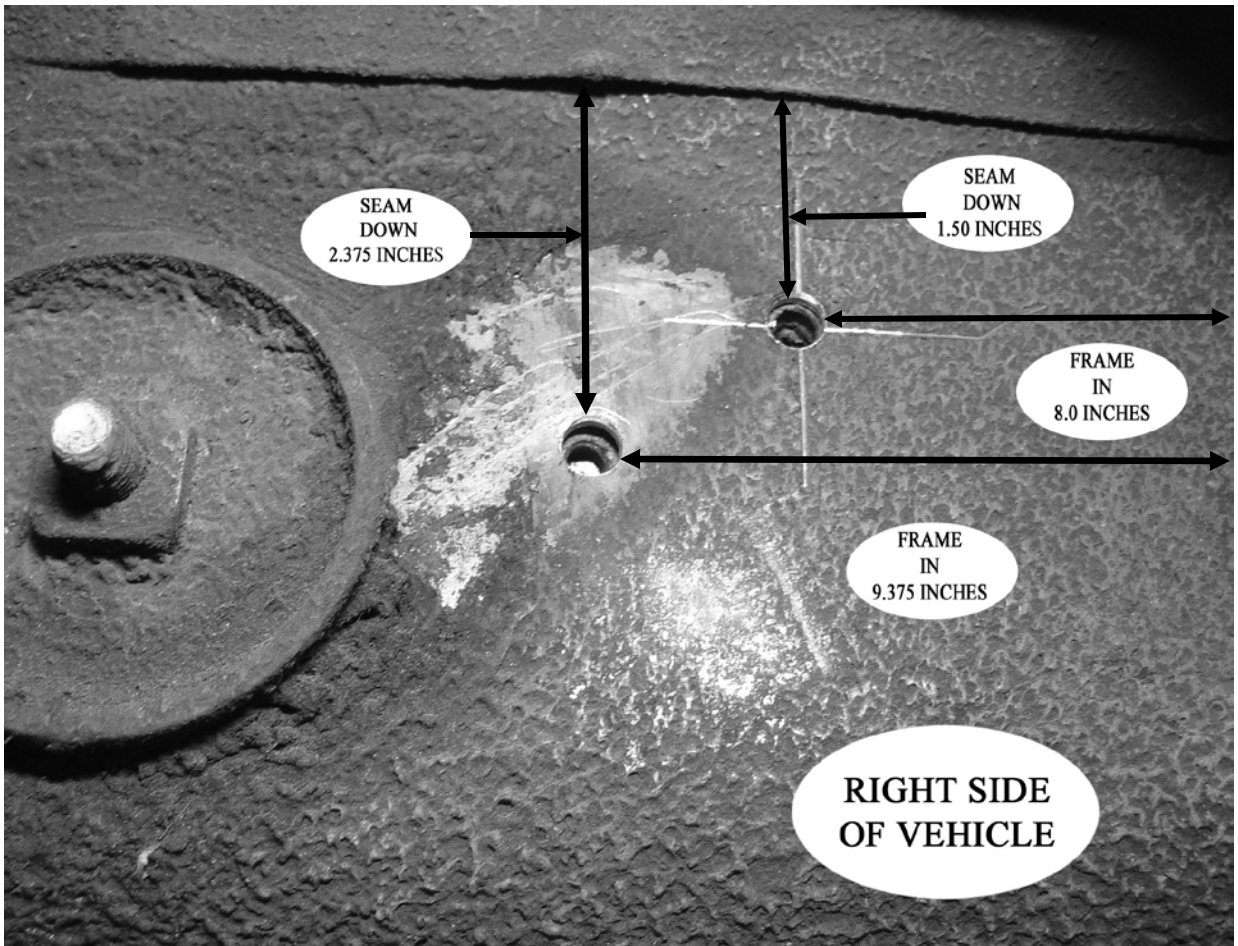


DIAGRAM 2





Installation diagram for:  
**SYSTEM #817281**  
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**4099<sup>®</sup> Stainless Steel**

