



## **409S Stainless Steel SYSTEM #817436**

**2004-2006 CHEVROLET/GMC 1500 TRUCK (NON HD)  
4.8L & 5.3L ENGINE • CREW CAB/5.5 FOOT BED**

8/09/11

### **Removal:**

- 1) 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.
- 2) Using a hacksaw or sawsall, cut the stock tailpipe off where it exits the muffler. (This step is not mandatory, but it makes removal a little easier.) Separate the two wire hangers on the tailpipe from the rubber mounts on the vehicle. Remove the tailpipe and set aside.
- 3) Support the muffler with a stand and separate the wire hanger in front of the muffler from the rubber mount on the vehicle. Using a 15mm wrench, remove the two nuts at the flange connection behind the converter. Remove the muffler and set aside.

### **Installation:**

- 1) Place inlet pipe **#26143S** into position behind the catalytic converter and connect the wire hanger on the pipe to the rubber mount on the frame. Re-install the two nuts back onto the flanged connection.
- 2) Place the provided 3" ring clamp over the inlet of the muffler. Slide the inlet of muffler **#8530562-Z** onto the back of the inlet pipe. Use a stand to support the muffler, and tighten the clamp enough to hold in place, but still allow for adjustment.
- 3) Using the provided bolts, washers, nuts and backing plate **#HA566** provided, mount tailpipe hanger **#226HA** to the frame on the left side of the vehicle using the angled oblong hole on the frame rail. (Note: The backing plates **#HA566** go on both sides of the frame between the hanger, washers and bolts to cover the oblong holes so the frame hangers won't bend into oblong hole.) Repeat this step on the right side of the vehicle using hanger **#227HA**; they both bolt in approximately the same position on either side of the vehicle. Slide rubber hanger **#HA168** onto the ends of both **#226HA** and **#227HA**. Remove the rubber hanger from the stock mount and discard.
- 4) Place a supplied 2 1/2" clamp onto the right outlet of the muffler. Place tailpipe **#16521S** into position over the rear axle and slide into the right muffler outlet. Connect the hanger that is welded to the rear of the pipe to the rubber hanger **#HA168** installed in Step 3. Pipe should be approximately 3/4" away from the shock when adjusted. Tighten clamp to hold in position.

- 6) Connect hanger **#401HA** (for 04-05 trucks) or hanger **#402HA** (for 06 trucks) to the rubber mount behind the muffler and place around the left side outlet muffler. Do not tighten at this time.
- 5) Place the front section of left tailpipe **#16522S** into position over the rear axle and slide into the left muffler outlet. Place a clamp over the expanded end of pipe. Place the rear section of left tailpipe **#16524S** into the front section and connect the hanger at the rear of the pipe to the rubber hanger **#HA168**, installed in Step 3. Pipe should be centered between the shock and the spare tire when adjusted. Tighten the clamps on both pipes enough to hold, but still allow for adjustment.
- 7) Place a 2 1/2" clamp onto the slip-fits of either the side exit pipes **#16317S** or rear exit pipes **#16397S** and place them onto the over axle pipes. Tighten the clamps enough to hold in place, but still allow for adjustment. Place the **#ST396** stainless tips onto the exit pipes and rotate the exit pipe and tip to the desired distance from the fender or bumper, so that the angle cut on the tips are in the desired location.
- 8) Adjust the position of all pipes and muffler to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.
- 9) Tighten down all clamped connections securely. After the system is secure, slide the 1/2" hanger keepers onto the end of the inlet pipe and rear muffler hanger. Slide the 7/16" hanger keepers onto the rear tailpipe and frame hangers. This will prevent the hangers from slipping out of the rubber mounts.
- 10) To prevent the rear axle breather tube from contacting the left side tailpipe and possible being damaged, use the enclosed zip tie to fasten the breather tube to the brake line bracket, located on the frame. Be sure to allow enough slack in the hose for the suspension to fully compress and extend.
- 11) For a more secure installation, we recommend welding all slip-fit connections.

## PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe	26143S
1	Muffler	8530562-Z
1	Tailpipe, Right	16521S
1	Tailpipe, Left Front	16522S
1	Tailpipe, Left Rear	16524S
2	Rear Exit pipes R/L	16397S
2	Side Exit Pipes R/L	16317S
2	Stainless Tips	ST396
1	Parts Kit	PK541
4	2 1/2" Clamps	MC250BS
1	3" Clamp	MC300BS
1	Frame Hanger, Left	226HA
1	Frame Hanger, Right	227HA
1	Rear Muffler Hanger (04-05)	401HA
1	Rear Muffler Hanger (2006)	402HA
4	Backing Plate	HA566
2	Rubber Hanger	HA168
2	3/8" Nuts	HW103
2	3/8" X 1 1/4" Bolts	HW209
2	3/8" Flat Washers	HW303
2	3/8" Lock Washers	HW309
4	7/16" Hanger Keepers	HW502
2	1/2" Hanger Keepers	HW503
1	Plastic Zip Tie	HW504



Installation diagram for:  
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