



FORCE II™

409S® Stainless Steel SYSTEM #817641

2013 RAM 2500/3500 SERIES TRUCKS
6.7L CUMMINS DIESEL ENGINE · ALL WHEELBASES
4" DPF BACK TAILPIPE

03/29/13

Removal:

- 1) To make the removal of the stock system easier, you may choose to cut off the stock tailpipe where it exits the muffler; this can be done using a hacksaw or sawsall. After cutting, remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and set the tailpipe aside. This step is not mandatory, but makes removal easier.
- 2) Just behind the DPF unit there is a bracket supporting an O2 sensor wire bolted to the exhaust pipe. Remove the bolt from the bracket and leave hanging, this bracket and bolt will attach to the fitting on the new Flowmaster tailpipe.
- 3) Remove the clamp at the back of the DPF unit. Use a pry bar to separate the two hangers at the front of the tailpipe from the rubber mounts on the vehicle. (A lubricant of some type on the hangers will make removal easier.) Remove the muffler assembly from the vehicle.

Installation:

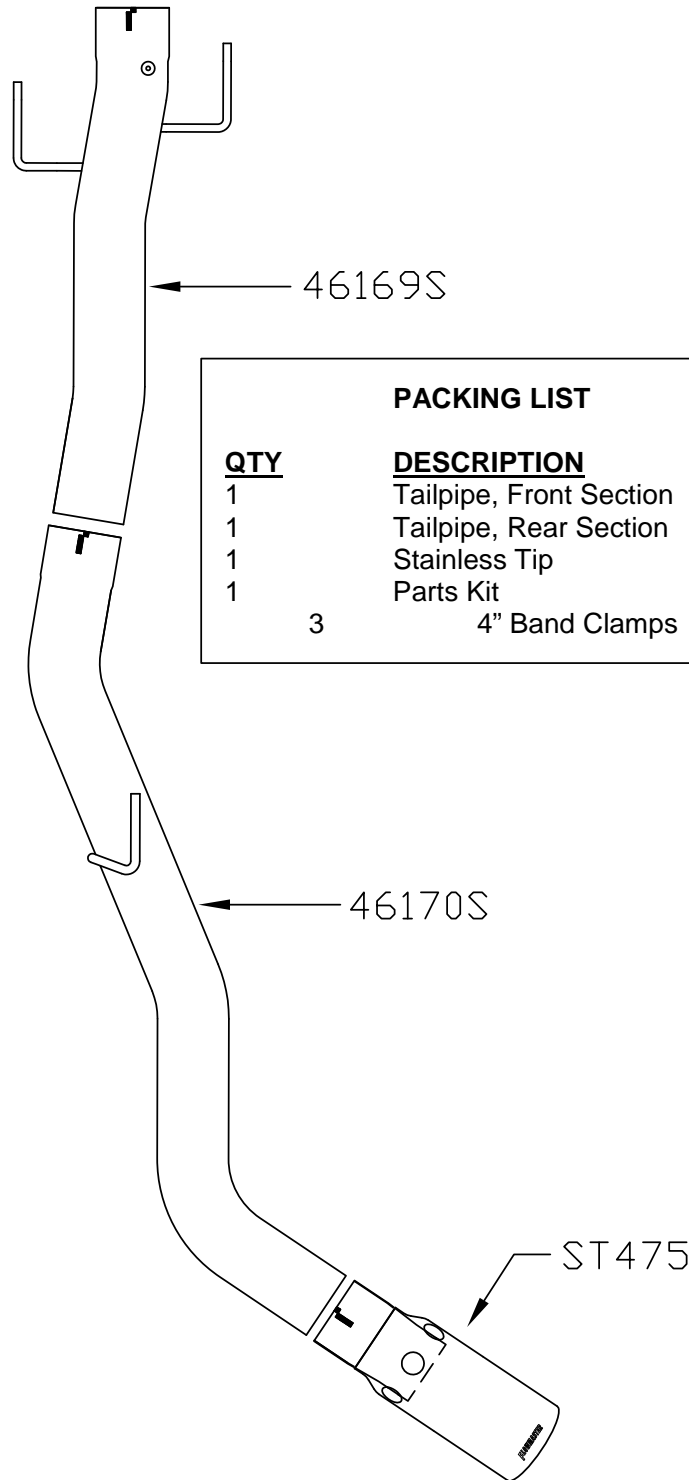
- 1) Place a supplied 4" clamp onto the expanded end of tailpipe **#46169S**, then place onto the back of the DPF unit, while also connecting the two hangers on the pipe to the rubber mounts on the vehicle. Tighten the clamp on the DPF unit enough to hold, but still allow for adjustment. Replace the O2 sensor support bracket removed in step 2 above.
- 2) Place a supplied clamp onto the expanded end of exit pipe **#46170S**, then put in place over the rear axle and connect to front section **#46169S**. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold. Place a supplied clamp onto stainless tip **#ST475**, then place onto the back of the exit pipe and adjust to the desired rotation. Tighten the clamp enough to hold but still allow for adjustment. *We strongly recommend placing a one inch weld on each side of the tip once final adjustment has been achieved.*
- 3) The system should now be adjusted to achieve a proper fit. Once you are satisfied with the overall fit, all clamps should be tightened at each one of the slip fit connections. Although not required, we highly recommend that all connections be fully welded after installation.



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Installation diagram for:
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 4" DPF BACK SYSTEM



PACKING LIST		
QTY	DESCRIPTION	PART#
1	Tailpipe, Front Section	46169S
1	Tailpipe, Rear Section	46170S
1	Stainless Tip	ST475
1	Parts Kit	PK716
3	4" Band Clamps	MC400BS