



FORCE II

409S® Stainless Steel

Installation Instructions for:
SYSTEM #817701
2014 FORD F-250/F-350 TRUCKS
FITS 6.2L ENGINES · ALL W.B.

03/20/14

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) To make removal of the stock system easier, you may choose to cut the stock tailpipe off where it exits the muffler. This can be done using a hacksaw or sawsall. This step is not mandatory, but makes removal easier. After cutting, remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and set the tailpipe aside.
- 3) Support the muffler with a stand and remove the two hangers at the rear of the muffler along with the hangers in front of the muffler from the rubber mounts on the vehicle. Then loosen the ring clamp at the muffler inlet connection. Once loose, slide the muffler off of the front pipe and set aside.

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) Place a supplied 3" clamp onto the expanded end of inlet pipe **#26480S** and slide onto the factory inlet pipe; line up the notch in the pipe with the tab on factory pipe. Connect the hanger on the pipe to the rubber mount on the vehicle. Place a 3" clamp over the inlet of muffler **#8530572-226** and slide onto the front pipe, use a stand to temporarily support the muffler. Tighten clamps enough to hold in place, but still allow for adjustment.
- 3) Install a provided 3" clamp onto both muffler outlets, then place the right side tailpipe **#26481S** into position over the rear axle and into the right side muffler outlet. Connect the hangers at the front and rear of the pipe to the rubber mounts on the vehicle. Tighten the clamp enough to hold but still allow for adjustment.
- 4) At the rear of the frame on the drivers' side of the vehicle (next to the spare tire) there is a single 3/8" torx bolt on the bottom of the frame. **See Figure 1 below.** Remove the bolt, and place hanger **#HA211** up to the bottom of the frame with the hanger rod pointing to the outside of the vehicle. Replace the bolt with the bolt and washer included in the parts kit and tighten securely. Place the supplied **HA168** rubber hanger onto **HA211**. **See Figure 2 below.**
- 5) Place the front section of the left side tailpipe **#26482S** into position over the rear axle and into the left side muffler outlet. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold but still allow for adjustment.
- 6) Place a supplied clamp over the expanded end of the rear section of the left side tailpipe **#26483S**, slide completely onto the back of the front section and connect the hanger on the pipe to the rubber mount installed in step 4 above. Tighten the clamp enough to hold but still allow for adjustment.

- 7) Connect exit pipes **#26484S** or **#26485S** onto the ends of both over axle pipes. Place a 3" clamp onto the slip-fit connections and tighten enough to hold in place. Place the two **ST462** stainless tips onto the exit pipes and tighten the pinch bolts enough to hold in place. Rotate the exit pipe and tip to the desired position.
- 8) Adjust the position of all pipes and muffler and tailpipe to provide a satisfactory fit. Maintain a minimum of 3/4" clearance around all parts of the system; while keeping suspension travel and vibration in mind.
- 9) Tighten down all clamped connections securely. After the system is secure, place the supplied black 1/2" hanger keepers onto the end all round stock hangers. The 7/16" hanger keeper goes onto the end of the 211HA rear frame hanger. This will prevent the hangers from slipping out of the rubber mounts.
- 10) 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	26480S
1	Muffler	8530572-226
1	Right Tailpipe	26481S
1	Left Tailpipe, Front	26482S
1	Left Tailpipe, Rear	26483S
2	Side Exit Pipe (R/L)	26484S
2	Rear Exit Pipe (R/L)	26485S
2	Stainless Tip	ST462
1	Parts kit	PK781
1	Hanger Bracket	211HA
7	3" Band Clamp	MC300BS
1	Rubber Mount	HA168
1	M8-1.25 x 28mm Bolt	HW228
1	5/16" Flat Washer	HW302
5	1/2" Hanger Keeper	HW503
1	7/16" Hanger Keeper	HW502



Figure 1



Figure 2



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Installation diagram for:
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