



## ***4099<sup>®</sup> Stainless Steel*** **SYSTEM #817356**

**1993-1995 CHEVROLET CAMARO/PONTIAC FIREBIRD**  
3.4L & 3.8L • V6 ENGINE

08/16/11

### **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 inlet pipe off where it enters the muffler case. Remove the bolt that secures the rubber hanger to the bracket on the left tailpipe. This will allow you to remove the entire muffler tailpipe assembly.
- 3) The rear panhard bar must be rotated down to allow the over axle pipe to be removed. The bar runs above and parallel to the rear end housing. There are three bolts that secure it to the unibody which must be removed. There are also two small metal screws which fasten the bar to a heat shield that need to be removed. Once these are removed, pull the bar down as far as you can. (Keep all of the bolts as you will need to put them back.)
- 4) There are two small sheet metal screws that secure the heat shield to the body on the right side where the axle pipe runs over the panhard bar. These must be temporarily removed in order to get the new pipe into place.
- 5) Remove the nut that secures the hanger tongue to the bracket on the over-axle pipe (located on the right side just behind the rear axle.) Remove the two bolts that fasten the rubber mount to the body. Keep the rubber mount and bolts as they will be needed.
- 6) Remove the two bolts that secure the flange at the front pipe to cat connection. Remove the stamped crossmember/brace by removing the four mounting bolts. If you are working on a rack, you will be able to now swing the whole pipe down and negotiate it out from over the axle. If you are working on the ground, you will need to cut the pipe off before it goes over the axle in order to get it out.

### **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 the front pipe assembly **#16387S** in position behind the catalytic converter and use the provided bolts and washers to connect the flange. Tighten the bolts down enough to hold the pipe in place, but still allow for adjustment.
- 3) Negotiate the over-axle pipe **#16389S** up over the rear end. Install one of the 2 1/2" clamps over the front of the pipe and slip the pipe over the rear of the previously installed front pipe.
- 4) Slip the factory rubber mount onto the rear hanger and push the pipe up into position so that the hanger can be fastened back into place using the original two bolts.
- 5) The rear pan hard bar should now be pushed back up and bolted back into place. The heat shield should also be fastened back onto the bar.
- 6) Place the three remaining 2 1/2" clamps onto the muffler necks and tighten them enough to hold, but still allow for adjustment.
- 7) Lift the muffler into position and slide the neck marked "INLET" onto the over-axle pipe. Use a stand of some sort to temporarily support the muffler.
- 8) Install the left tailpipe **#16388S** by sliding into the muffler outlet. Connect the hanger to the factory rubber mount using the 5/16" bolt, nut and fender washer.
- 9) Install the right tailpipe **#16385S** by sliding the pipe into the muffler outlet.
- 10) Adjust the position of the muffler, pipes and tips 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. Tighten down all clamped connections securely.
- 11) For more secure installation, we recommend welding all slip-fit connections.



Installation diagram for:  
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**409S. Stainless Steel**

**PACKING LIST**

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Inlet Pipe Assembly	16387S
1	Over-Axle Pipe	16389S
1	Muffler	852583-Z
1	Right Tailpipe	16385S
1	Left Tailpipe	16388S
1	Parts Kit	PK571
4	2.5" Clamps	MC250BS
2	M10x1.50x60 Hex Bolt	HW213
2	M10 Split Lock Washer	HW311
1	5/16"-NC x 1 1/2" Hex Bolt	HW206
1	5/16"-NC Hex Nut	HW102
1	5/16" Split Lock Washer	HW308
1	5/16" Fender Washer	HW305

