



409S[®] Stainless Steel

Installation Instructions for:
SYSTEM #817541
2011-2014 CHEVY/GMC 2500HD/3500HD TRUCKS
6.0L (GAS) · V8 ENGINE · CREW CAB / 6.5' BED ONLY

07/19/13

Removal:

- 1) Disconnect the negative side of the battery cable. 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) Loosen the factory flanged connection behind the catalytic converter using a deep 15mm socket and ratchet. Set the two nuts aside, they will be reused in Step #2 of installation.
- 3) Using a pry bar, separate the five hangers on the stock exhaust system from the rubber mounts on the vehicle. A lubricant such as WD40 or lithium grease will ease separation.
- 4) Carefully remove the stock tailpipe and muffler from the vehicle and set aside. The factory exhaust system will come out in one piece, or you can cut the tailpipe just behind the muffler and remove the system in two pieces.

Installation:

- 1) Install the inlet pipe **#36044S** onto the factory flanged connection, also sliding both hangers into the factory rubber mounts on the vehicle. Reuse the factory 15mm nuts and tighten enough to hold in place, but still allow for adjustment. **Note:** On 2013 model trucks, you must trim 4.00" from the back of the **#36044S** inlet pipe, 2011 & 2012 models do not require this trim.
- 2) Place a provided 3 ½" clamp onto the inlet of muffler **#8535572-Z** and place onto the back of inlet pipe **#36044S** and support with a stand. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.
- 3) Slide rubber hanger **#HA168** onto the end of **226HA**, then using the supplied bolts, washers, nuts and backing plates **#HA566**, mount the assembly 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 & bolts to cover the oblong holes so that the frame hangers won't bend into the oblong holes.*
- 4) Place two of the supplied 3" clamps over the right and left outlets of the muffler. Place right tailpipe **#26403S** into position over the rear axle, and slide into the right muffler outlet. Connect the two hangers on the pipe to the rubber mounts on the vehicle. Pipe should be approximately 3/4" away from the shock when adjusted.

- 5) Place left front tailpipe section **#26402S** into position over the rear axle and slide into the left muffler outlet. Place a supplied 3" clamp onto the back of the pipe. Place left rear tailpipe section **#26404S** onto the front section, and connect the hanger welded to the rear of the pipe into the rubber hanger installed in step 3 above. Pipe should be centered between the shock and the spare tire when adjusted. Tighten the clamps just enough to hold in position.
- 6) Slide the side exit pipes **#26405S** for the right and **#26406S** for the left or the rear exit pipes **#26407S** for the right and **#26408S** for the left onto the ends of the over axle pipes and place a supplied 3" clamp onto these slip-fit connections. Tighten just enough to hold in position. Place the two stainless tips **#ST462** onto the exit pipes and tighten them enough to hold position. Rotate the exit pipes and tips to the desired distance from the body or bumper, so that the angle cut on the tips are in the desired location.
- 7) Adjust the position of the pipes and muffler to provide a satisfactory fit. A minimum 3/4" clearance around all parts of the system must be maintained while keeping suspension travel and vibration in mind.
- 8) Tighten down all clamped connections securely. After the system is secure, slide the 1/2" hanger keepers onto both the hangers on the inlet pipe, the clamp hanger at the rear of the muffler and the 7/16" hanger keeper on the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.
- 9) 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	36044S
1	Muffler	8535572-Z
1	Right Tailpipe	26403S
1	Left Tailpipe, Front	26402S
1	Left Tailpipe, Rear	26404S
1	Right Side Exit	26405S
1	Left Side Exit	26406S
1	Right Rear Exit	26407S
1	Left Rear Exit	26408S
2	Stainless Tips	ST462
1	Part kit	PK740
1	Left Frame Hanger	226HA
5	3.00" Clamp	MC300BS
1	3.5" Clamp	MC350BS
2	Backing Plate	HA566
1	Rubber Hanger	HA168
1	3/8" x 1 1/4" Bolt	HW209
1	3/8" Flat Washer	HW303
1	3/8" Lock Washer	HW309
1	3/8" Nut	HW103
1	7/16" Hanger Keeper	HW502
6	1/2" Hanger Keeper	HW503



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