



Installation Instructions for:
SYSTEM #817569
2009-2014 TOYOTA 4RUNNER V6
4.0L · V6 ENGINE

FORCE II™

409S Stainless Steel

11/04/13

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. Spray all factory rubber hanger mounts as well as the front and rear flange bolts with a lubricant, this will greatly ease removal.



2) Unbolt the tailpipe connection behind the muffler using a 14mm socket or wrench, then remove the factory tailpipe hanger from the rubber mount on the vehicle and set tailpipe aside.



3) Using a 14mm socket or wrench remove the two factory spring loaded bolts at the inlet pipe flange connection and set aside (the bolts and springs will be re-used with the new Flowmaster system).



4) Support the muffler with a stand and separate the four hangers on the muffler and front pipe assembly from the rubber mounts on the vehicle. Lower the stand and remove the assembly from the vehicle.



5) Place inlet pipe **#16754S** up into place, sliding the two hangers into the factory rubber mounts. Take the factory bolts and springs removed in step 3 above and re-install onto the flanged connection and tighten securely.



6) Place the supplied 2½" clamp onto the inlet of muffler **#852572-Z** and slide onto the inlet pipe and support with a stand. Level the muffler and tighten the clamp enough to hold but still allow for adjustment.



7) Place the supplied hanger clamp assembly **#443HA** onto the outlet of the muffler and into the factory rubber mounts on the vehicle. Tighten just enough to hold in position.



8) Place tailpipe assembly **#16755S** up over the rear axle and into the muffler outlet. Connect the hanger at the rear of the pipe to the rubber mount on the vehicle. Adjust the tip to the desired rotation and tighten the clamp enough to hold but still allow for adjustment. **Note:** Depending on the model year and or spare tire size, the spare tire may need to be dropped down to allow installation of the new Flowmaster tailpipe.

9) Adjust the position of all pipes and mufflers to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

<u>Qty.</u>	<u>Description</u>	<u>Part #</u>	
1	Muffler	852572-Z	
1	Inlet Pipe	16754S	
1	Tailpipe	16755S	
1	Parts Kit	PK624	
	1	Rear Muffler Hanger	443HA
	1	2-1/2" Band Clamp	MC250BS



Installation diagram for:
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