



409S Stainless Steel

Installation Instructions for:

SYSTEM #817648

2011-2015 GM 2500HD & 3500HD TRUCKS

6.6L DURAMAX TURBO DIESEL ENGINE

(ALL EXCEPT STANDARD CAB – LONG BED)

08/07/14

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 a penetrating lubricant onto the two rubber hangers that support the stock tailpipe.



2) Locate the Diesel Particulate Filter; it's the last emissions device in the exhaust system. Use the measurements below and measure back from the weld at the back of the DPF and make a mark on the pipe. Cut the factory tailpipe off at this mark. After cutting, remove the two hangers on the tailpipe from the rubber mounts on the vehicle and lower the tailpipe from the vehicle. Use a file or die-grinder to remove any burrs from the pipe.

Extended Cab – Standard Bed: Trim 2.00" back from DPF unit. Also trim 6.50" from the front of tailpipe sections **#46176S** and **#46177S**. See diagram.

Extended Cab – Long Bed: Trim 10.00" back from DPF unit.

Crew Cab – Standard Bed: Trim 5.00" back from DPF unit.

Crew Cab – Long Bed: Trim 19.50" back from DPF unit.



3) Place a supplied 4" clamp onto the muffler inlet and place onto the exit of the DPF unit. Level the muffler and support with a stand, tighten the clamp on the inlet enough to hold the muffler in place.



4) On the passenger side of the vehicle, just forward of the shock, remove the factory rubber mount from the frame hanger welded to the cross member. Place a 4" clamp onto the right muffler outlet and then place pipe **#46177S** up into position and slide into the right muffler outlet. Place a small amount of grease onto the hanger on the pipe as well as the factory hanger mount on the vehicle and slide on one of the provided HA168 rubber mounts as show in the picture. Tighten the clamp on the muffler outlet enough to hold, but still allow for adjustment.



5) Place a clamp onto the expanded end of pipe **#46179S** and slide over the back of pipe **#46177S**. 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) There are two holes in the frame on the rear drivers side of the vehicle that will be used to mount the **461HA** hanger assembly. See photo for location. Place the two 3/8" bolts into backing plate **HA1120**. Place the backing plate on the inside of the frame with the two 3/8" bolts toward the inside of the vehicle. Place the **461HA** frame hanger over the two bolts and secure using the nuts and washers provided. Place the provided **HA168** rubber hanger onto the bottom of the frame hanger.



7) Place the front section of the left tailpipe **#46176S** into position over the rear axle and connect the hanger on the pipe to the rubber mount on the vehicle. Place a clamp onto the left muffler outlet and then place the pipe into the muffler outlet. Tighten the clamp enough to hold, but still allow for adjustment.



8) Place a clamp onto the expanded end of pipe **#46178S** and slide over the back of pipe **#46176S**. Connect the hanger on the pipe to the rubber mount installed in Step 6 above and tighten the clamp enough to hold, but still allow for adjustment.



9) Place a supplied 4" clamp onto the expanded end of stainless tip **#ST475** and slide onto the end of the tailpipes and adjust to the desired location.

10) Adjust the position of the tailpipe and tip to provide a satisfactory fit. 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 the clamps down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. Place the supplied 1/2" hanger keeps onto the end of both of the tailpipe hangers, these will keep the hangers from slipping out of the rubber mounts.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Muffler	8540152-Z
1	Left Tailpipe, Front	46176S
1	Right Tailpipe, Front	46177S
1	Left Tailpipe, Rear	46178S
1	Right Tailpipe, Rear	46179S
2	Stainless Tip	ST475
1	Parts Kit	PK723
1	Frame Hanger	461HA
1	Backing Plate	HA1120
7	4" Band Clamp	MC400BS
2	Rubber Hanger	HA168
4	1/2" Hanger Keepers	HW503
2	3/8" x 1 1/2" Bolt	HW210
2	3/8" Nut	HW103
2	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309



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Installation diagram for:
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