



FORCE II™

409S Stainless Steel

Installation Instructions for:
SYSTEM #817646
2008-2010 FORD SUPERDUTY TRUCKS
6.4L POWERSTROKE DIESEL ENGINE
4" DUAL DPF BACK SYSTEM
ALL WHEELBASES

04/22/13

- 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 a penetrating lubricant onto the bolt at the clamped connection between the DPF unit and the factory muffler and also the four rubber hangers that support the stock muffler and tailpipe.
- 2) Support the muffler with a stand and remove the bolt at the clamped connection in front of the factory muffler. Remove the four hangers on the tailpipe and muffler from the rubber mounts on the vehicle. Slide the muffler and tailpipe back to disconnect from the DPF unit and then forward, over the rear axle and remove from the vehicle.
- 3) Place the provided 3.50" clamp onto the small end of adapter pipe **#TB425S** and then slide onto the back of the DPF unit. Tighten the clamp securely.
- 4) Trim extension pipe **#46184S** if necessary according to the following measurements before placing onto the back of adapter pipe **#TB425S**. Place the provided 4" clamp onto this connection and tighten enough to hold.

Standard Cab / Long Bed, 137" Wheelbase Models: **Extension pipe 46184S not used.**

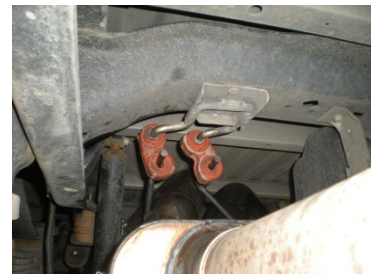
Extended Cab / Standard Bed, 141.8" Wheelbase Models: **Trim 30.50" from 46184S.**

Crew Cab / Standard Bed, 156.2" Wheelbase Models: **Trim 16.25" from 46184S**

Extended Cab / Long Bed, 158" Wheelbase Models: **Trim 14.50" from 46184S.**

Crew Cab / Long Bed, 172.4" Wheelbase Models: **Do not trim 46184S, place directly onto TB425S.**

- 5) To allow the installation of the Flowmaster system, the factory rubber hanger that supports the rear of the muffler will need to be removed from the vehicle and cut in half. This will allow the hangers on the right and left tailpipes to move independently of each other. Re-install after cutting.



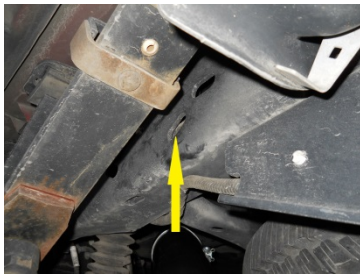
- 6) Place a supplied 4" clamp onto the inlet of muffler **#8540152-Z** and slide onto the back of inlet pipe **#TB425S** or extension pipe **#46184S**. Tighten the clamp enough to hold, but still allow for adjustment.

7) Place a provided 4" clamp onto the right muffler outlet. Place pipe **#46171S** in position over the rear axle and connect the hanger on the pipe to the rubber mount on the vehicle. Then place the tailpipe into the right muffler outlet and tighten the clamp enough to hold, but still allow for adjustment.

8) Place a provided 4" clamp onto the expanded end of pipe **#46173S**, connect the hanger on the pipe to the rubber mount on the vehicle. Then connect the front of the pipe to the rear of pipe **#46171S**. Confirm that the two pipes are fully slid together and tighten the clamp enough to hold, but still allow for adjustment.

9) Place a provided 4" clamp onto the left muffler outlet. Place pipe **#46172S** in position over the rear axle and connect the hanger on the pipe to the rubber mount on the vehicle. Then place the tailpipe into the left muffler outlet and tighten the clamp enough to hold, but still allow for adjustment.

10) At the rear of the truck on the left side, there is an oblong hole in the frame beside the spare tire, see first photo below. Using frame hanger **460HA**, backing plate **HA566** and one of the provided 7/16" x 1.50" bolts, nut and lock washer, bolt 460HA to the outside of the frame using HA566 on the inside of the frame as a backing plate. Fasten securely. Then place the provided **HA168** rubber hanger onto the bottom of the hanger mount.



11) Place a provided 4" clamp onto the expanded end of pipe **#46174S**, connect the hanger on the pipe to the rubber mount installed in the step above. Then connect the front of the pipe to the rear of pipe **#46172S**. Confirm that the two pipes are fully slid together and tighten the clamp enough to hold, but still allow for adjustment.

12) Place a supplied 4" clamp onto the inlet end of stainless tips **#ST475** and slide onto the end of the tailpipes and adjust to the desired location.

13) Adjust the position of the pipes and muffler 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.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Adapter Pipe	TB425S
1	Inlet Pipe Assy.	46184S
1	Muffler	8540152-Z
1	Right Tailpipe, Front	46171S
1	Left Tailpipe, Front	46172S
1	Right Tailpipe, Rear	46173S
1	Left Tailpipe, Rear	46174S
2	Stainless Tip	ST475
1	Parts Kit	PK725
1	Left Frame Hanger	460HA
1	3½" Band Clamp	MC350BS
8	4" Band Clamp	MC400BS
1	Back-up Plate	HA566
1	7/16" x 1.50" Bolts	HW224
1	7/16" Nuts	HW104
1	7/16" Lock Washers	HW310
2	7/16" Hanger Keepers	HW502
4	½" Hanger Keepers	HW503
1	Rubber Hanger	HA168



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