



FORCE II™ SYSTEM #17198

1987-1993* FORD F250 / F350
7.4L ENGINES • ALL WHEELBASES
*W/ 2 1/2" CATALYTIC CONVERTERS

11/25/09

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) Apply a penetrating lubricant to the muffler clamp nuts at the catalytic converter connection and the three rubber hangers that support the rear of the system. (This will greatly ease the removal.)
- 3) With a 15mm wrench, remove the muffler clamp at the catalytic converter to muffler connection.
- 4) Put a stand under the rear of the system to support it when the rubber hangers are disconnected.
- 5) Using a pry bar, disconnect the three rubber hangers at the rear of the system.
- 6) Slide the system back to separate the muffler from the catalytic converter. It may be necessary to heat the connection with a torch to loosen it.
- 7) Remove the system from under the vehicle.

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) Slip pipe **#TB230** for S.C./L/B. or **#TB316** for E.C./L/B. onto the rear of the catalytic converter and install a 3" clamp. Tighten just enough to hold in position.
- 3) For Crew Cab, place connector pipe **#TB322** on the back of **#TB316** and install a 3" clamp. Tighten just enough to hold in position.
- 4) Raise muffler **#53073** into position and connect it to the rear of the inlet pipe. (Be sure to install inlet forward.) Install the 3" clamp hanger **#179HA** and tighten just enough to hold in position.
- 5) Place pipe **#26041** in position over the rear axle. Slip into the rear of the muffler and install the 3" clamp hanger **#180HA**. Connect the three rubber hangers to support the pipes and tighten clamp just enough to hold in position.

- 6) Slip pipe **#26042** onto the rear of **#26041**. Install a 3" clamp and tighten just enough to hold in position.
- 7) Adjust the position of all 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.
- 8) Using the four band clamps provided, secure the heatshield to the top of the muffler. Tighten the clamps securely using an 8mm socket or standard screwdriver.
- 9) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the end of the over-axle pipe hanger and the clamp hangers **#179HA** and **#180HA**. This will prevent the hangers from slipping out of the rubber mounts.
- 10) To prevent the rear axle breather tube from contacting the left side tailpipe and possible being damaged, use the enclosed zip tie to fasten the rear axle breather tube to the brake line bracket, located on the frame. Be sure to allow enough slack in the hose for the suspension to fully compress and extend.
- 11) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Short Adapter Pipe	TB230
1	Long Adapter Pipe	TB316
1	Connector Pipe	TB322
1	Muffler	53073
1	Axle-Pipe	26041
1	Exit-Pipe	26042
1	Heatshield Kit	51022
1	Parts Kit	PK314
2	Clamp Hanger	179HA
1	Clamp Hanger	180HA
4	3" Clamp	MC300G
1	2 1/2" Clamp	MC250S
5	7/16" Hanger Keepers	



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Installation diagram for:
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