

Part # 1404360 w/stainless steel angle cut tips, 409 stainless steel dual kit

Kit fits '80-'96 full-size Ford 1/2 & 3/4 ton pickup, 2WD & 4WD, all wheel bases, F150 w/6 cyl. & V8, F250 except for 460 c.i. and 351 c.i. w/2-1/2" exhaust at the converter. For vehicles only with 2-1/4" exhaust at the converter.

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**DANGER WARNING:** Should the purchaser decide to install this exhaust product at home, be warned that pleasure car or light duty truck/van "bumper" jacks are intended for emergency use only. The use of frame contact jack stands in conjunction with a floor jack as main support is highly recommended to minimize accidental dropping of a vehicle while the installation proceeds.

Limitation of liability--Disclaimers: The regulation of emissions production, noise levels and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns and counties.

The manufacturer makes no warranties of merchantability, of fitness for a particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations or ordinances in the states where they may be sold to the ultimate purchaser, the consumer.

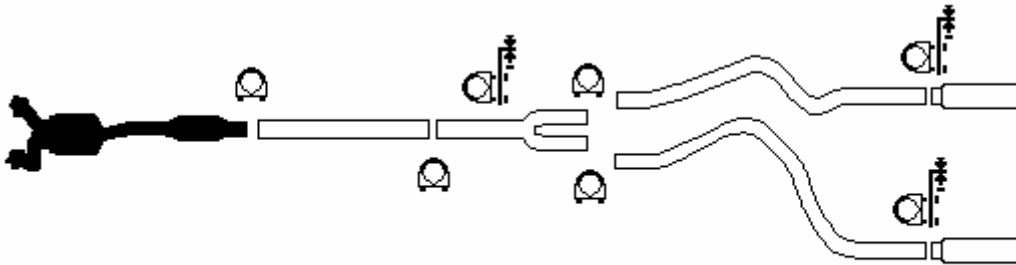
The entire risk as to the conformity of this product in any such state and as to repair, should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer of such product and it is not upon the seller, distributor, or manufacturer.

In this connection, retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, and or repair.

The foregoing statement limits the liability of the manufacturer.

**HARDWARE KIT:**

- 3) 5/16" nuts stainless steel
- 3) snapper grommets
- 3) SLB9 metal hangers stainless steel
- 2) muffler tips—all stainless angle cut--8493518
- 1) stainless steel left tail pipe--1404104
- 3) 5/16" x 1-1/2" bolts stainless steel
- 3) 5/16" lock washers stainless steel
- 1) stainless steel right tail pipe--1404103
- 1) stainless steel 2-1/4" id/od x 40" front extension pipe--1404454
- 3) fender washers stainless steel
- 7) 2-1/4" clamps stainless steel mc9214ss
- 1) stainless steel y-pipe--0430000



## Kit #1404360

### INSTRUCTIONS:

**NOTE:** do not tighten any clamps or nuts and bolts until the last step!! Before cutting any pipes it is a good idea to lay out all the included pipes along side the vehicle and get a good idea of how the pipes will hang on the vehicle. Please read the instructions fully and thoroughly before you begin.

- 1) Remove the old exhaust system, leaving only the y-pipe and the converter on the truck. Those with the 117" wheel base will **NOT** use the 2-1/4" straight pipe included in this kit. If your truck is a 117" wheel base, go to step 3).
- 2) Install the extension pipe to the converter. For vehicles with 138" and 133" wheel bases, the 2-1/4" x 40" extension pipe will need to be cut to fit. Cut the o.d. end (the end that is not swaged)--see sizing table below. Install the i.d. (swaged) end to the catalytic converter.
  - 155" wb: 2-1/4" x 40" no cutting required
  - 138" wb: 2-1/4" x 23-1/4"
  - 133" wb: 2-1/4" x 18-1/4"
  - 117" wb: extension pipe not required
- 3) Install the y-pipe to the 2-1/4" extension pipe, using a 2-1/4" clamp to connect the two pieces. Make sure that the y-pipe is mounted parallel to the ground. Locate the hole in the frame (or drill one if no hole is present) directly above the end of the y-pipe and install an LB9 hanger bracket to the frame using a snapper grommet, 5/16" x 1-1/2" bolt, nut, lock washer, and fender washer. Use a 2-1/4" clamp to connect the y-pipe and the hanger assembly (see illustration for the hanger assembly).
- 4) Install the right tail pipe (it has 5 bends) making sure that you have at least 1/2" of clearance from the shock. Locate the hole behind the original tail pipe hanger (if one is not present, you will need to drill a hole) and near the end of the tail pipe, and using a fender washer, 5/16" x 1-1/2" bolt, nut, and lock washer, mount one of the LB9 brackets to the frame. The hanger can be adjusted up or down for clearance. Use a 2-1/4" clamp to connect the right tail pipe and the hanger, but do not tighten at this time. **NOTE:** you may want to trim the right (and later the left) tail pipe to your desired length.
- 5) Mark where you want to cut the right tail pipe by holding up a tip next to the tail pipe. Trim the tail pipe to length. Install the muffler tip onto the right tail pipe. Use a 2-1/4" clamp to secure the tip to the tail pipe and hanger just installed.
- 6) Install the left tail pipe (5 bends) to the y-pipe using a 2-1/4" clamp, making sure that you have clearance between the rear brake line (bend bracket to the front if necessary), shock, and spare tire. You should end up with a 1/2" of clearance from the shock and the tire. Again, you may want to trim the pipe to length. **NOTE:** the tail pipe crosses over the top and behind the rear differential.
- 7) Locate the mounting hole (or drill if one is not present) directly above the rear of the left tail pipe and mount the hanger as in step 4) for the left tail pipe.
- 8) Repeat step 5) for the left tail pipe.
- 9) Tighten all clamps, nuts, and bolts. Check for leaks and for clearance of all brake and fuel lines, and for clearance of all chassis and frame components. We recommend tack welding the joints (not necessary though).

Build Sheet For: Deep Tone Dual Kit Stainless Steel 409

Part # 1404360

\_\_\_\_\_ 2) muffler tips—all stainless angle cut--8493518

\_\_\_\_\_ 1) stainless steel right tail pipe--1404103

\_\_\_\_\_ 1) stainless steel y-pipe--0430000

\_\_\_\_\_ 1) stainless steel left tail pipe—1404104

\_\_\_\_\_ 1) s/s 2-1/4” id/od x 40” front extension pipe--1404454

\_\_\_\_\_ 1) hardware kit

Inspected by: \_\_\_\_\_

Date: \_\_\_\_\_

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