

Part # 1409451 w/stainless steel angle cut tips

Kit fits '96-'99 full-size GM 1/2 & 3/4 ton pickup, 2WD & 4WD, all wheel bases, w/350 c.i. 5.7L V-8, with dual 2" exhaust at the converters. This kit is a cat-back exhaust system.

Heartthrob Exhaust --Litchfield, MN

www.heartthroboxhaust.com

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.

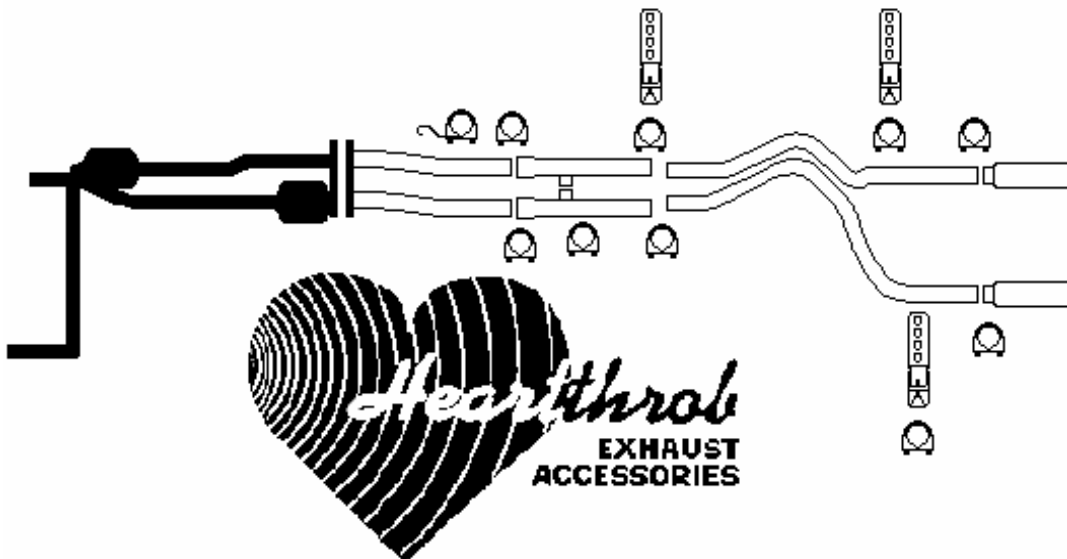
The entire risk as to the conformity of this product in any such state and as to repair, should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer of such product and it is not upon the seller, distributor, or manufacturer.

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:

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|--------------------------------------|------------------------------|---------------------------------------|
| 9) 2-1/4" clamps MC9214SS | 3) BR91930 swinger hanger | |
| 3) 5/16" x 1" bolt SS | 3) 5/16" nut SS | 3) 5/16" lock washer SS |
| 3) fender washer SS | 1) 521036 gasket | 1) 2-1/4" welded hanger clamp-#2933SS |
| 2) muffler tips-- angle cut-#8493518 | 1) right tail pipe--#1401356 | 1) flanged front pipe--#0430013 |
| 1) h-pipe--#0430005 | 1) left tail pipe--#1401355 | |



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

Kit #1409451 INSTRUCTIONS:

1) Remove the oxygen sensor from the truck and from the left side of the flanged front pipe after the converters. Remove the exhaust system at the flange behind the converters leaving only the original manifold pipes, rubber mounts for the hangers, and the catalytic converters on the truck. You will need to re-use the original nuts to fasten the flange to the exhaust.

NOTE: The included flanged front pipe will need to be cut to fit the regular cab and extended cab short box models. This pipe fits extended cab long box models without cutting. For extended cab short box models, cut off approximately 14". Regular cab short box cut off approximately 38", and cut off 24" for regular cab long box. To avoid problems, please verify that you are not cutting off too much by putting the system roughly in place and double checking the lengths before you do any cutting!!

2) Install the gasket to the O.E. flange at the converters. Install the flanged front pipe to the gasket and O.E. flange. Install the nuts to the bolts at the flange but don't tighten yet. You may install the original oxygen sensor at this point.

3) Install the 2-1/4" hanger clamp to the right side of the flanged front pipe at the front O.E. rubber hanger mount. Clamp to the pipe and slide the hanger to the O.E. rubber mount.

4) Install the i.d. ends of the h-pipe to the front extension pipe using 2-1/4" clamps at the connecting points. Use a 2-1/4" clamp to connect the individual pieces of the h-pipe together.

5) Locate or drill a 5/16" hole in the frame above one of the rear ends of the h-pipe. Use a 5/16" x 1" bolt, nut, lock washer and fender washer to connect a BR91930 swinger hanger to the frame. Whichever side the hanger is on, you will use the same 2-1/4" clamp that is used to connect a tail pipe and the h-pipe, and clamp this hanger to these parts.

6) Install the right tail pipe (it has 5 bends) making sure that you have at least 1/2" of clearance from the shock. Locate or drill a 5/16" hole in the frame after the rear axle. You will use this hole to mount another THU900 swinger hanger using a 5/16" x 1" bolt, nut, lock washer, and fender washer. Use a 2-1/4" clamp to connect the right tail pipe and the hanger. **NOTE:** do not tighten at this time, as you may want to cut the rear of the tail pipes to your preferred length. Trim to your desired length by holding up a tip and marking the required amount to cut off.

7) Install the muffler tip onto the right tail pipe. Use a 2-1/4" clamp to secure the tip to the tail pipe.

8) Install the left tail pipe (4 bends) 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. The left tail pipe crosses over the top of the drive shaft and then crosses over the top of the axle. It will be necessary to gain the proper clearance between the left tail pipe and the brake and breather lines by tying the lines away using a wire or cable tie. Again, you may want to trim the pipe to length, so do not tighten the clamp yet.

9) Locate the mounting hole (or drill if one is not present) directly above the rear of the left tail pipe and mount the BR91930 swinger hanger to the frame using a 5/16" x 1" bolt, nut, lock washer, and fender washer. Make sure the distance from the frame to the top of the pipe is equal to the hanger on the right side. Clamp the tail pipe to the hanger using a 2-1/4" clamp. As in step 4), trim the left tail pipe to your desired length. Make sure the tail pipe is cut to the same length as the right tail pipe.

10) Mount the other muffler tip to the left tail pipe using a 2-1/4" clamp.

11) 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
PART # 1409451**

_____ 2) muffler tips—all stainless steel angle
cut-#8493518

_____ 1) right tail pipe--#1401356

_____ 1) flanged front pipe--#0430013

_____ 1) h-pipe--#0430005

_____ 1) left tail pipe--#1401355

_____ 1) hardware kit

INSPECTED BY: _____

DATE: _____

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