

INSTRUCTIONS FOR KIT #2404450      DUAL SIDE FRONT EXHAUST KIT

FITS 1980-1996 FULL-SIZE FORD 1/2 & 3/4 TON 2WD & 4WD PICKUPS W/6 CYLINDER, 5.0L, AND 5.8L V-8 WITH 2-1/4" EXHAUST AT CONVERTER. THIS KIT FITS ALL WHEEL BASE MODELS. DOES NOT FIT 351 OR 460 C.I. WITH 2-1/2" EXHAUST AT THE CONVERTER.

**NOTE:** DO NOT TIGHTEN ANY CLAMPS OR BOLTS UNTIL THE LAST STEP!

1) REMOVE THE EXHAUST SYSTEM AT THE CLAMP BEHIND THE CONVERTER LEAVING ONLY THE ORIGINAL Y PIPE AND THE CATALYTIC CONVERTER ON THE TRUCK.

2) SLIP THE FRONT PIPE INTO PLACE. WITH THE TAIL PIPES IN THE REAR OF THE MUFFLER, HOLD UP THE MUFFLER AND TAIL PIPES IN A POSITION THAT CLEARS ALL CHASSIS COMPONENTS. THE TAIL PIPES WILL NEED TO EXIT SO THAT THE SHACKLE OF THE LEAF SPRING IS SPACED IN BETWEEN THE TWO TAIL PIPES. MAKE SURE THAT THIS IS THE CASE BEFORE YOU CUT THE EXTENSION PIPE. MARK THE FRONT PIPE--SEE NOTE ON LENGTH TO CUT. MAKE SURE TO ACCOUNT FOR AT LEAST 2" OF THE PIPE TO GO INTO THE MUFFLER. CUT THE FRONT PIPE.

**NOTE:** THE EXTENSION PIPE WILL FIT THE EXTENDED CAB SHORT BOX AND LONG BOX TRUCKS WITHOUT CUTTING. ON ALL OTHER VEHICLES THE EXTENSION PIPE WILL NEED TO BE CUT FROM THE 3" O.D. END (THE END THAT IS NOT SHRUNK) AS NECESSARY. FOR REGULAR CAB SHORT BOX (117" W.B.) CUT OFF APPROXIMATELY 21", AND CUT OFF APPROXIMATELY 5" FOR REGULAR CAB LONG BOX (133" W.B.). FOR EXTENDED CAB LONG BOX (155" W.B.) YOU WILL NEED THE EXTRA 20" EXTENSION PIPE AND 3" CLAMP, WHICH ARE NOT NEEDED ON THE SHORTER WHEEL BASE TRUCKS.

3) USE A 2-1/4" CLAMP TO ATTACH THE EXTENSION PIPE TO THE CONVERTER PIPE, AND FOR EXTENDED CAB LONG BOX, INSTALL THE 20" EXTENSION PIPE TO THE LONGER EXTENSION PIPE USING A 3" CLAMP.

4) USE A 3" MUFFLER CLAMP TO ATTACH THE INLET OF THE MUFFLER AND THE EXTENSION PIPE TOGETHER.

5) INSTALL THE SHORT TAIL PIPE TO THE OUTSIDE OUTLET (PASSENGER SIDE) USING A 2-1/2" CLAMP.

6) INSTALL THE LONG TAIL PIPE TO THE INSIDE (NEAREST TO THE DRIVE SHAFT) OUTLET OF THE MUFFLER USING A 2-1/2" CLAMP.

7) INSTALL THE DUAL 2-1/2" WELDED CLAMP TO THE TAIL PIPES JUST OUTSIDE OF THE FRAME.

8) LOCATE OR DRILL A 5/16" HOLE IN THE FRAME ABOVE THE LEFT TAIL PIPE AFTER THE MUFFLER, BUT BEFORE THE BEND AND INSTALL THE BR91930 SWINGER HANGER TO THE FRAME USING A 5/16" BOLT, NUT, LOCK WASHER, AND FENDER WASHERS. USE A 2-1/2" CLAMP TO CONNECT THE LEFT TAIL PIPE TO THE BR91930 SWINGER HANGER.

9) LOCATE OR DRILL A 5/16" HOLE IN THE FRAME ABOVE THE LEFT TAIL PIPE AFTER THE BEND, BUT BEFORE THE LEAF SPRING AND INSTALL THE BR91930 SWINGER HANGER TO THE FRAME USING A 5/16" BOLT, NUT, LOCK WASHER, AND FENDER WASHERS. USE A 2-1/2" CLAMP TO CONNECT THE LEFT TAIL PIPE TO THE BR91930 SWINGER HANGER.

10) TIGHTEN ALL CLAMPS AND BOLTS AND CHECK FOR CLEARANCE OF THE FRAME, BODY, AND BRAKE AND FUEL LINES.

**HARDWARE KIT FOR KIT #2404450:**

- 4) 2-1/2" CLAMPS stainless steel
- 2) 3" CLAMPS stainless steel
- 1) 2-1/4" CLAMP stainless steel
- 2) 5/16" NUT stainless steel
- 2) 5/16" X 1 BOLT stainless steel
- 2) 5/16" LOCK WASHER stainless steel
- 4) FENDER WASHERS stainless steel
- 2) SWINGER HANGER-BR91930
- 1) 2-1/2" DUAL WELDED HANGER CLAMP-# 2960ss stainless steel

- 1) stainless steel MUFFLER #7421SS
- 1) stainless steel MIDDLE EXTENSION PIPE 20" ID/OD
- 1) stainless steel RIGHT TAIL PIPE #2005550-3
- 1) stainless steel FRONT EXTENSION PIPE #2004450-1
- 1) stainless steel LEFT TAIL PIPE #2005550-2

Part # 2404450

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.

**DANGER WARNING:** SHOULD THE PURCHASER DECIDE TO INSTALL THIS, OR ANY OTHER 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.



BUILD SHEET FOR: Dual Side Front Kits 409 s/s

PART #S: 2404450

- \_\_\_\_\_ 1) stainless steel MUFFLER #7421SS
- \_\_\_\_\_ 1) stainless steel mid extension pipe 20" ID/OD
- \_\_\_\_\_ 1) stainless steel RIGHT TAIL PIPE #2005550-3
- \_\_\_\_\_ 1) stainless steel front extension pipe #2004450-1
- \_\_\_\_\_ 1) stainless steel LEFT TAIL PIPE #2005550-2
- \_\_\_\_\_ 1) hardware kit

inspected by: \_\_\_\_\_

date: \_\_\_\_\_

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