

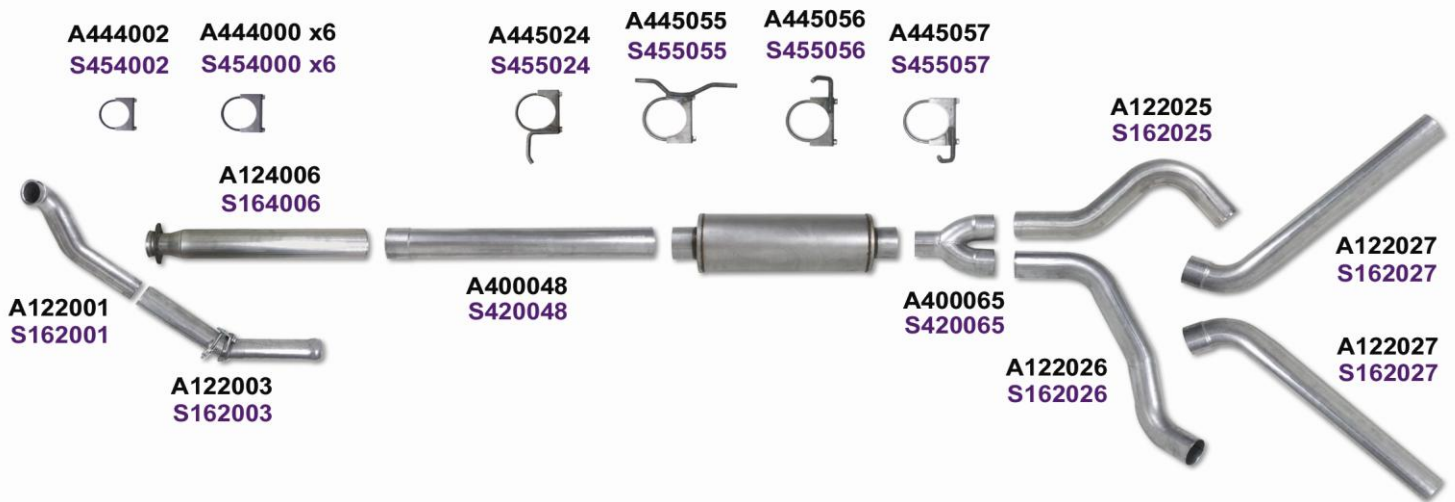
Installation Instructions

K4309S

1994-1997.5 Ford 7.3L F250-F350 Off-road 4" Dual SS

Tools needed: 9/16" end wrench or socket, 7/16" deep socket, hacksaw or sawzall, aerosol lubricant.

(If your vehicle is equipped with a catalytic converter, it is unlawful to remove.)



Removal of Original System

- 1) Start under the hood. Remove the band clamp that holds the down pipe to the turbo charger by loosening the nut on the "T" bolt and prying the clamp loose at the 3 pinch points. Save this clamp for re-use.
- 2) The stock down pipe must be cut, halfway up, near the bell housing. Remove the top portion from under the hood and the bottom section from under the vehicle.
- 3) From under the truck, cut the intermediate pipe 4" behind the catalytic converter. Unbolt the catalytic converter from the down pipe and set it aside.
- 4) Cut the tail pipe just behind the muffler.
- 5) Spray the stock hanger points with aerosol lube and pry rubber mounts from the system. Remove the old system.
- 6) Remove the spare tire and spare tire hanger brackets.

Installation of New Performance System

(Hint: Do not fully tighten any clamps until the complete system is installed and aligned.)

- 1) From under the truck, locate the horizontal firewall/body seam that runs near the bell housing. This area needs to be bent away from the bell housing using a large pry bar or port-a-power to allow the new down pipe to fit. (For quicker install, cut the seam in two or three places and then bend it outward.)
- 2) From under the truck, install the top down pipe (162001) onto the turbo.
- 3) From under the truck, install the lower down pipe (162003) onto the top down pipe using the clamp (454002).
- 4) Bolt the off road test pipe (164006) onto the outlet of the lower down pipe (162003).
- 5) Install the "Y" pipe (420065) into the outlet of the muffler with a clamp (454000).
- 6) Hang the muffler in the stock location using the hanger clamp (455055) on the upper outlet of the y-pipe muffler. This determines the placement of the rest of the system. (The "Y" pipe is installed vertically.)
- 7) Measure between the outlet of the test pipe (164006) and the inlet of the muffler. Add 5" to this measurement for the slip joints and cut the straight pipe (420048) to fit. Install the cut pipe (420048) between the test pipe (164006) and the muffler with a clamp (454000) at front and a clamp (454000) on the muffler inlet. Install the hanger clamp (455024) in the stock location.
- 8) Install the drivers side 1st section tail pipe (162026) into the upper outlet of the "Y" pipe using the hanger clamp (455055) all ready installed. Rotate the pipe as needed to pass next to the shock absorber and over the rear axle on the driver's side.
- 9) Install the passengers' side 1st section tail pipe (162025) into the lower outlet of the "Y" pipe with a bare clamp (454000). Rotate the pipe as needed to pass next to the shock absorber and over the rear axle on the passenger's side.
- 10) Install the tail pipes (162027) into the outlets of the over-the-axle tail pipes with bare clamp (454000) at each joint. Rotate as needed to level the outlet behind the rear tires.
- 11) Install the hanger brackets in the existing hole in the frame rail on the driver's side and passengers' side. Install the rubber mounts to the hanger brackets using the bolts supplied.
- 12) Install the hanger clamps (Pass. 455056, Driver 455057) on the tail pipes (162027) using the installed rubber hangers.
- 13) Starting at the turbo, align and tighten all the pipes and clamps. Start the engine and check for leaks.

Rev. BCR 8-16-16

****Disclaimer****

This application was designed as a performance cosmetic upgrade. Towing a 5th wheel or bumper tow trailer with more than 500 lbs. tongue weight may result in damage to your vehicle and/or the exhaust system