



409S® Stainless Steel

Installation Instructions for:
SYSTEM #817425
2000-2006 TOYOTA TUNDRA
4.7L • V8 ENGINE • ALL W.B.

04/28/11

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) Unbolt the ring clamp from the connection between the catalytic converter and the exhaust system. Save the clamp and the gasket.
- 3) Slide the muffler and tailpipe assembly toward the rear of the vehicle. This will dislodge the hangers from their rubber mounts on the vehicle.
- 4) Slide the exhaust assembly toward the front of the vehicle and out from under the truck and set aside.

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) Mount rear hangers **#245HA**. If you have a trailer hitch, remove the third bolt in from the bumper on both sides of the hitch. Reuse the bolt when bolting up hanger **#245HA**. If you do not have a trailer hitch, locate the third threaded hole from the bumper and bolt up the two hangers using the 12mm cap screws, 12mm lock washers. Use 4 of the **#HA418** spacers (2 for each side) to make up for thickness of the trailer hitch. (Mount hanger in the same manner as the drawing indicates, to the outside.) Also place the rubber hanger **#HA168** on the round rod of **#245HA** as shown in the drawing.
- 3) Place the right tailpipe **#16291S** over the axle and slide the hanger that's welded to the rear of the pipe into the bottom hole of rubber hanger **#HA168**. Slide the front hanger into the stock rubber mount on the vehicle. Repeat this step for the left side using tailpipe **#16292S**.
- 4) Place the muffler assembly **#8530552-146** into position behind the converter in the same manner as the stock system, insuring the gasket is in place. Reinstall the ring clamp onto the connection, checking to see that the muffler is level and then tighten.
- 5) Slide the two tailpipes into the muffler outlets. Then install one of the included 2 1/2" clamps onto each of the outlets. Tighten enough to hold, but still allow for adjustment.

- 6) Slide either the side exit pipes **#16317S** or the rear exit pipe **#16318S** onto the ends of both over axle pipes. Place a 2 1/2" clamp onto these slip-fit connections and tighten enough to hold, but still allow for adjustment. Place two stainless tips **#ST396** onto the exit pipes and tighten the hose clamp enough to hold, but still allow for adjustment. Rotate the exit pipe and tip to the desired distance from the fender or bumper so that the angle cut on the tips are in the desired locations.
- 7) Adjust the position of the muffler and tailpipe to provide adequate clearance for suspension travel. Maintain a minimum of 3/4" clearance between the Flowmaster system and the drivetrain and chassis components.
- 8) Tighten down all clamped connections securely and slide the hanger keepers onto the hanger rod to prevent them from sliding out of rubber mounts.
- 9) For a more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

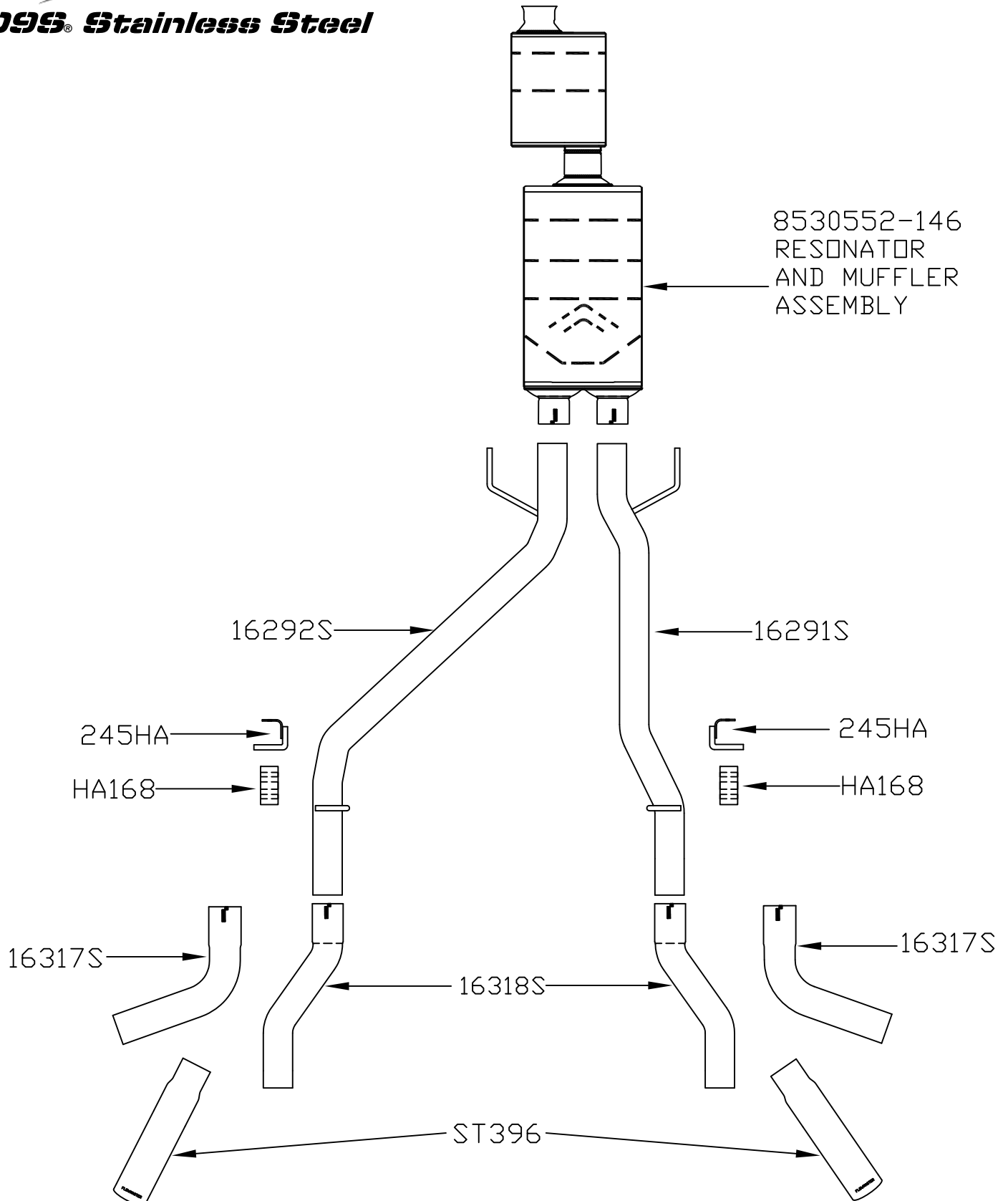
<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Muffler/Resonator	8530552-146
1	Right Tailpipe	16291S
1	Left Tailpipe	16292S
2	Rear Exit Pipe (R/L)	16318S
2	Side Exit Pipe (R/L)	16317S
2	3" Stainless Tip	ST396
1	Parts Kit	PK534
2	Tailpipe Hanger	245HA
2	Rubber Hanger	HA168
4	Square Spacers	HA418
4	2 1/2" Clamps	MC250S
2	12mm Cap Screws	HW218
2	12mm Lock Washers	HW312
6	7/16" Hanger Keepers	



**AMERICAN
THUNDER**

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Installation diagram for:
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