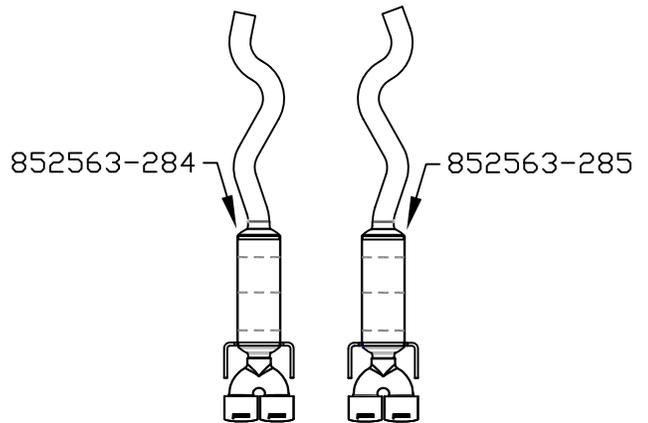




FORCE II

409S Stainless Steel

Installation Instructions for:
SYSTEM #817484
2009-2013 CHEVROLET CORVETTE C6
W/QUAD TIPS • *DOES NOT FIT Z06*



PACKING LIST			
Qty.	Description	Part#	
1	Right Muffler Assembly	852563-285	
1	Left Muffler Assembly	852563-284	
1	Parts Kit	PK509	
2	2 1/2" Stainless Band Clamp	MC250BS	

04/11/13

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height and support securely with jack stands.
- 2) If your vehicle has an automatic transmission, you will need to cut the right side over-axle pipe about 4" away from the factory band clamp toward the muffler. This is not necessary for the left side or standard transmission vehicles.
- 3) Remove all four factory hangers out of the rubber mounts located at the rear of the vehicle using a screwdriver or a pry bar. A spray type lubricant may be used to ease separation of hangers.
- 4) Unbolt the four bolts on the two mounting straps that hold the sway bar using 15mm and 18mm sockets or wrenches. Pull sway bar down and allow it to hang freely.
- 5) Loosen the band clamps at the rear of the factory H-pipe and support with a stand.
- 6) Remove the four nuts at the front cat pipes to the factory H-pipe connection using a 15mm socket or wrench and slide the flanges off the studs.
- 7) Unbolt the two spring loaded hangers located toward the rear of the H-pipe assembly. Remove the H-pipe assembly by tilting the front down, then slide the H-pipe forward off the factory muffler connections and set aside.
- 8) Remove both mufflers by pulling the rear of the mufflers down and out of the vehicle. Some twisting may be necessary to get the inlet pipes over the axle.

Installation:

- 1) Install right muffler **#852563-285** by first routing the inlet pipe up over the half shaft, once the muffler is in its approximate position, support the inlet pipes with a stand and connect the hangers on the muffler to the factory rubber hanger mounts on the vehicle. Repeat this step for the left side using muffler **#852563-284**.

- 2) Install the factory H-pipe by first connecting the slip-fit band clamp connections at the rear of the H-pipe to the muffler inlet pipes. Then, connect the front of H-pipe and secure both flanges to existing studs. Reattach the two spring loaded hangers toward the rear of the H-pipe and tighten. Make sure the H-pipe assembly is level side to side before tightening. Do not overtighten. Tighten the band clamps just enough to hold in position.
- 3) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.
- 4) Tighten down all clamped connections securely. Reinstall the sway bar, reversing the procedure listed in Step 4 of removal.
- 5) For a more secure installation, we recommend welding all slip-fit connections.