



FORCE II™

409S Stainless Steel

Installation Instructions for:
SYSTEM #817548
2009-2014 CHEVY SUBURBAN / AVALANCHE
GMC YUKON XL
5.3L · V8 Engine

08/28/13

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) Support the muffler with a stand. Using a hacksaw or sawsall, cut the stock tailpipe in front of the rear end, behind the muffler hangers. Separate the wire hanger on the tailpipe from the rubber mount on the vehicle and remove the tailpipe from the vehicle.



3) Using a 15mm wrench, loosen the bolt on the clamped ball connection behind the catalytic converter. Separate the three wire hangers from the rubber mounts on the vehicle and lower the inlet pipe and muffler from the vehicle.



4) Place inlet pipe assembly **#26366S** in position onto the ball connection behind the catalytic converter. Connect the hanger on the pipe to the rubber mount on the vehicle, then reinstall the clamp onto the ball connection and tighten enough to hold, but still allow for a small amount of adjustment.



5) Place the provided 3" clamp onto the inlet of muffler **#8530562-Z**, then connect the inlet of the muffler to the inlet pipe and support with a stand. Tighten the clamp just enough to hold in position.



6) Look at the top rear shock mount through the wheel well opening on the driver's side of the vehicle. You will see a 1/2" x 3/4" hole through the shock mount. This hole is where hanger **#312HA** will be mounted. Place the provided 3/8" flat washer onto the 3/8" bolt and from the bottom of the shock mount; push the bolt through the hole from the inside out. Place hanger **#312HA**, with the hanger rod facing outward, onto the bolt and secure with the provided washer, lock washer and nut. Make sure the hanger is straight up and down and then tighten securely. Place rubber hanger **#HA168** onto the bottom of frame hanger **#312HA**.



7) Look at the rear end housing at the top; you should see a bracket bolted to it holding the brake lines. Unbolt the brake line from the bracket then unbolt the bracket from the rear end housing. In a vise, straddle the bracket between the jaws and tap the bolt out of the bracket carefully not to damage the threads. It is press fitted and requires some force to remove it; a rubber mallet works best. Take bracket **#HA594** and bolt the longer end to the rear end housing using the original bolt. Using the 5/16" bolt, washer, lock washer and nut, fasten the brake lines to the new bracket. This should move your brake lines forward about 1" to assure clearance from the tailpipe.



8) Place a provided 2 1/2" clamp onto both muffler outlets. Place right side tailpipe **#16758S** into position over the axle and slip into the right side muffler outlet. Connect the hangers on the pipe to the rubber mounts on the vehicle. Tighten the clamp just enough to hold in position.



9) Place the front section of the left side tailpipe **#16508S** into the left side muffler outlet and connect the hanger on the pipe to the rubber mount on the vehicle. Tighten the 2 1/2" clamp on the muffler outlet just enough to hold in position.



10) Install a provided 2 1/2" clamp onto the slip-fit of left side tailpipe **#16510S**, and then connect to the back of the front section by sliding the two sections together at the slip-fit connection over the rear axle. Place the hanger at the rear of the tailpipe into the rubber mount installed in step 4. Tighten just enough to hold in position.



11) Place exit pipes **#16317S** onto the ends of both over-axle pipes. Then slide the stainless tips **#ST396** onto the ends of the exit pipes. Rotate the pipes and tips to the desired distance from the fender. Place a 2 1/2" clamp onto these slip-fit connections and tighten just enough to hold in position. Also, tighten the clamps on the tips.

12) Adjust the position of all pipes and mufflers to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. After the system is secure, slide the 1/2" hanger keepers onto the end of the inlet pipe and the right tailpipe clamp hanger. Slide the 7/16" hanger keepers onto the ends of the hangers at the rear of the vehicle. This will prevent the hangers from slipping out of the rubber mounts.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Inlet Pipe Assy.	26366S
1	Muffler	8530562-Z
1	Right Tailpipe	16758S
1	Left Tailpipe, Front	16508S
1	Left Tailpipe, Rear	16510S
2	Side exit pipe (R/L)	16317S
2	Stainless tips	ST396
1	Parts Kit	PK605
1	Frame Hanger, Rear	312HA
1	Bracket Hanger	HA594
1	Rubber Hanger	HA168
1	3" Clamp	MC300BS
5	2 ½' Clamp	MC250BS
1	5/16" x ¾" Bolt	HW203
1	5/16" Flat Washer	HW302
1	5/16" Lock Washer	HW308
1	5/16" Nut	HW102
1	3/8" x 1" Bolt	HW208
1	3/8" Flat Washer	HW303
1	3/8" Lock Washer	HW309
1	3/8" Nut	HW103
2	1/2" Hanger Keeper	HW503
4	7/16" Hanger Keeper	HW502



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