



# FORCE II™

## 409S Stainless Steel

### Installation Instructions for:

## SYSTEM #817620

2011-2015 GM 2500HD & 3500HD TRUCKS

6.6L DURAMAX TURBO DIESEL ENGINE

(ALL EXCEPT STANDARD CAB – LONG BED)

08/07/14

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. Spray a penetrating lubricant onto the two rubber hangers that support the stock tailpipe.



2) Locate the Diesel Particulate Filter; it's the last emissions device in the exhaust system. Use the measurements below and measure back from the weld at the back of the DPF and make a mark on the pipe. After making the mark, place the new tailpipe up in place and verify that the cut location is correct. Cut the factory tailpipe off at this mark, after cutting, remove the two hangers on the tailpipe from the rubber mounts on the vehicle and lower the tailpipe from the vehicle. Use a file or die-grinder to remove any burrs from the pipe.

Extended Cab – Standard Bed: Trim 10.00" back from DPF unit.

Extended Cab – Long Bed: Trim 24.00" back from DPF unit.

Crew Cab – Standard Bed: Trim 19.50" back from DPF unit.

Crew Cab – Long Bed: Trim 33.00" back from DPF unit.



3) The tailpipe has been left long enough to properly place the tip on Dually model trucks, if the tailpipe is being installed on a standard wheel vehicle, 4" will need to be trimmed from the back end of the tailpipe. Place a supplied 4" clamp onto the expanded end of tailpipe **#46162S** and place into position over the rear axle and onto the exit of the DPF. Slide the two pipes fully together and connect the hangers on the pipe to the rubber mounts on the vehicle. Tighten the clamp enough to hold but still allow for adjustment.



4) Place a supplied 4" clamp onto the expanded end of stainless tip **#ST475** and slide onto the end of the tailpipe and adjust to the desired location.

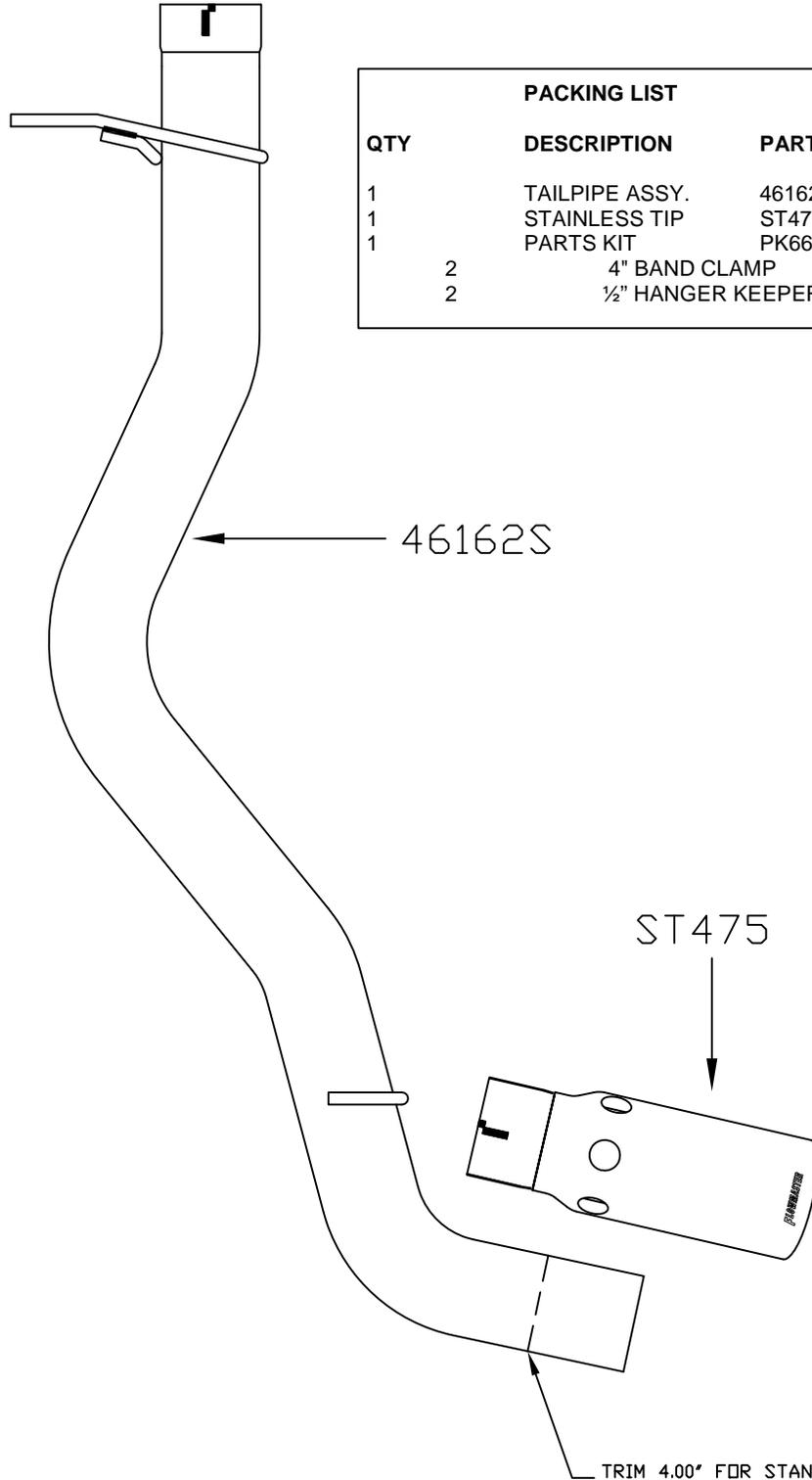
5) Adjust the position of the tailpipe and tip to provide a satisfactory fit. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten the clamps down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. Place the supplied 1/2" hanger keeps onto the end of both of the tailpipe hangers, these will keep the hangers from slipping out of the rubber mounts.



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Installation diagram for:  
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 (ALL EXCEPT STANDRAD CAB – LONG BED)



PACKING LIST			
QTY	DESCRIPTION	PART#	
1	TAILPIPE ASSY.	46162S	
1	STAINLESS TIP	ST475	
1	PARTS KIT	PK666	
2	4" BAND CLAMP		MC400BS
2	½" HANGER KEEPER		HW503