



409S Stainless Steel

Installation Instructions for:
SYSTEM #817637
2013-2014 FORD FOCUS ST
2.0L TURBOCHARGED ENGINE · *HATCHBACK ONLY*

07/23/14

1) Raise the vehicle up on a hoist or rack to working height. Spray a penetrating lubricant onto the two front flange bolts as well as the rubber hanger mounts that support the system. This will greatly ease removal of the factory system.



2) To remove the factory exhaust system you will have to cut the system in half. Cutting just before the pipe goes over the rear axle system will allow both halves of the system to be removed easily. After cutting, support the rear muffler with a stand and remove the three hangers on this section from their rubber mounts. You can now lower this section from the vehicle. This section may take some turning and twisting to get the pipe over the rear axle.



3) In front of the large center muffler, remove the two nuts at the flanged connection just behind the flex joint. Then remove the two bolts from the steel body brace behind the large muffler. Once unbolted, remove the hanger on this section from the rubber mount on the vehicle and lower from the vehicle and set aside. Save the gasket from between the two flanges for use with the Flowmaster system.



4) Using the 7/16" bolts, nuts and washers provided, bolt resonator assembly **15174S** to the back of the flex pipe flange. Be sure to replace the gasket. Support with a stand. Then reinstall the steel body brace removed in the previous step and tighten securely.



5) Place a supplied clamp onto the expanded end of pipe **#16738S** and slide onto the back of the resonator. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp just enough to hold, but still allow for adjustment.



6) Place a supplied clamp onto the expanded end of over-axle pipe **#86010S** and slip it onto the back of pipe **#16738S**. Connect the hanger on the pipe to the rubber mount on the vehicle and tighten the clamp enough to hold, but still allow for adjustment.



7) Place a supplied clamp onto the expanded end of exit pipe assembly **#86011S** and slide onto the back of over-axle pipe **#86010S**. Connect the hangers on the pipe to the two rubber mounts on the vehicle. Tighten the clamp enough to hold, but still allow for adjustment.



8) Place the two **#ST459** stainless tips onto the outlets of the exit pipe and adjust to the desired position. Tighten the clamp on the tips enough to hold, but still allow for adjustment.

9) 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.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
1	Resonator Assembly	15174S	
1	Intermediate Pipe	16738S	
1	Over-Axle Pipe	86010S	
1	Exit Pipe	86011S	
2	Stainless Tip	ST459	
1	Parts Kit	PK710	
3	2 1/4" Band Clamp		MC225BS
2	7/16" x 1 1/2" Hex Bolt		HW224
2	7/16" Hex Nut		HW104
2	7/16" Flat Washer		HW304
2	7/16" Lock Washer		HW310
4	7/16" Hanger Keepers		HW502



Installation diagram for:
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AMERICAN THUNDER

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