



FORCE II™

409S Stainless Steel

Installation Instructions for: **SYSTEM #817667** 1980-1981 CHEVROLET CORVETTE 5.7L · V8 ENGINE

11/14/13

Removal:

1) Remove the four bolts at the rear of the catalytic converter and remove the existing exhaust system from the vehicle from this point back. Unbolt the factory hangers at the rear of the mufflers; these will not be used with the Flowmaster system.

Installation:

1) Place the provided **HA572** rubber hanger onto the wire hanger of Y-pipe assembly **86156S** as shown in photo 2 below. Place the **86156S** into position behind the catalytic converter and support with a stand. Using four of the 3/8" nuts, bolts and lock washers provided, secure the two flanges together. Be sure to place the **GA132** gasket between the two flanges before securing. Secure the **HA572** rubber hanger to the oval hole in the bottom of the cross member by first placing a flat washer onto two of the 3/8" bolts, then place them up into the cross member through the hole next to the mounting hole and then down into the mounting hole as shown below. Rotate the **HA572** hanger into position and then secure using two 3/8" nuts and lock washers provided.



2) Place a provided clamp onto both outlets of Y-pipe assembly **#86156S**. Place one of the supplied **HA602** rubber mounts onto the wire hanger of right muffler assembly **#842550-323**. Place the muffler assembly onto the back of the Y-pipe and slide the two pipes full together, support the muffler with a stand. Secure the **HA602** rubber hanger to the oval hole in the bottom of the frame by first placing a **HA226** backing plate onto a 3/8" bolt, and then place the bolt down thru the hole above the muffler outlet. Rotate the **HA602** hanger into position and then secure using two 3/8" nuts and lock washers provided.



3) Place one of the supplied **HA602** rubber mounts onto the wire hanger of left muffler assembly **#842550-324**. Place the muffler assembly onto the back of the Y-pipe and slide the two pipes fully together, support the muffler with a stand. Using a supplied 3/8" bolt, nut, washer and lock washer, bolt the **HA602** hanger to the hole in the frame above the muffler outlet.



4) Adjust the position of the pipes and mufflers to provide a satisfactory fit. A minimum of 3/4" clearance around all parts of the system must be maintained; while also keeping suspension travel and vibration in mind. Tighten all clamped connections down securely.

5) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Y-Pipe Assembly	86156S
1	Right Muffler	842550-323
1	Left Muffler	842550-324
1	Parts kit	PK760
2	2 1/2" Clamp	MC250BS
1	Gasket	GA132
1	Rubber Hanger	HA572
2	Rubber Hanger	HA602
2	Backup Plate	HA226
4	3/8" x 1" Bolt	HW208
4	3/8" Lock Washer	HW309
2	3/8" Flat Washer	HW303
4	3/8" Nut	HW103



Installation diagram for:
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