



## **FORCE II™**

### **409S Stainless Steel**

Installation Instructions for:  
**SYSTEM #817451**  
**2011-2017 CHEVY/GMC 2500HD/3500HD TRUCKS**  
6.0L · V8 ENGINE · CREW CAB, SHORT BED

04/21/17

#### **Removal:**

- 1) Disconnect the negative side of the battery cable. 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) Loosen the factory flanged connection behind the catalytic converter using a deep 15mm socket and ratchet. Set the two nuts aside, they will be reused in Step #2 of installation.
- 3) Using a pry bar, separate the five hangers on the stock exhaust system from the rubber mounts on the vehicle. A lubricant such as WD40 or lithium grease will ease separation.
- 4) Carefully remove the stock tailpipe and muffler from the vehicle and set aside. The factory exhaust system will come out in one piece, or you can cut the tailpipe just behind the muffler and remove the system in two pieces.

#### **Installation:**

- 1) Remove the factory rubber tailpipe hanger on the passenger rear of the vehicle and set aside, it will not be needed, this may have a small metal clip which is easily removed with a screwdriver. Next slide the supplied **#HA168** rubber hanger onto the factory hanger rod.
- 2) Place inlet pipe **#36044S** into place behind the factory flanged connection and connect both hangers on the pipe to the rubber mounts on the vehicle. Use the included 3/8" x 2" bolts, nuts and washers to secure the two flanges together, tighten enough to hold in place, but still allow for adjustment. **Note:** On 2013-up model trucks, you must trim 4.00" from the back of the **#36044S** inlet pipe, 2011 & 2012 models do not require this trim.
- 3) Place a provided 3 1/2" clamp onto the inlet of muffler **#853550-Z** and place onto the back of inlet pipe **#36044S** and support with a stand. Install clamp/hanger assembly **#214HA** onto the muffler outlet and into the factory rubber hanger mounts. Tighten the clamp on the inlet enough to hold in place, but still allow for adjustment.
- 4) Place tailpipe **#36042S** into the outlet of the muffler and connect the hanger welded to the pipe to the rubber hanger installed in step 2 above. Then tighten clamp hanger **#214HA** at the back of the muffler enough to hold, but still allow for adjustment.
- 5) Adjust the position of the pipes and muffler to provide a satisfactory fit. A minimum 3/4" clearance around all parts of the system must be maintained while keeping suspension travel and vibration in mind.

6) Tighten down all clamped connections securely. After the system is secure, slide the 1/2" hanger keepers onto both the hangers on the inlet pipe, the clamp hanger at the rear of the muffler and the 7/16" hanger keeper on the tailpipe. This will prevent the hangers from slipping out of the rubber mounts.

7) For a more secure installation, we recommend welding all slip-fit connections.

### **PACKING LIST**

<b><u>Qty</u></b>	<b><u>Description</u></b>	<b><u>Part #</u></b>
1	Inlet pipe	36044S
1	Muffler	853550-Z
1	Tailpipe	36042S
1	Part kit	PK585
1	Clamp Hanger	214HA
1	3.5" Clamp	MC350BS
1	Rubber Hanger	HA168
2	3/8" x 2" Bolt	HW211
2	3/8" Flat Washer	HW303
2	3/8" Lock Washer	HW309
2	3/8" Nut	HW103
4	1/2" Hanger Keeper	HW503
1	7/16" Hanger Keeper	HW502



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Installation diagram for:

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