



FORCE II SYSTEM #17211

1994-1997* FORD F250 / F350

7.5L ENGINE · ALL W.B.

*W/3" CATALYTIC CONVERTERS

12/11/12

Removal:

- 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) Apply a penetrating lubricant to muffler clamp nuts at the catalytic converter connection and the three rubber hangers that support the rear of the system. This will greatly ease the removal.
- 3) With an 18mm wrench, remove the muffler clamp at the catalytic converter to muffler connection.
- 4) Put a stand under the rear of the system to support it when the rubber hangers are disconnected.
- 5) Using a pry bar, disconnect the three rubber hangers at the rear of the system.
- 6) Slide the system back to separate the muffler from the catalytic converter. It may be necessary to heat the connection with a torch to loosen it.
- 7) Remove the system from under the vehicle.

Installation:

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) Slip pipe **#TB315** for S.C./L.B. and E.C/S.B. or **#TB231** for E.C./L.B. onto the rear of the catalytic converter and install a 3" clamp. Tighten down securely.
- 3) For Crew Cab place the connector pipe **#TB322** on the back of **#TB231** and install a 3" clamp. Leave slightly loose to allow for adjustment.
- 4) Raise muffler into position and connect it to the rear of the inlet pipe. (Be sure to install inlet forward.) Install the 3" clamp hanger **#179HA** and tighten lightly to allow for adjustment. *Note: The muffler will be rotated at approximately a 45 degree angle with inlet on the bottom and the outlet on top. The top of the muffler will be directed toward the inside of the vehicle.*
- 5) Place pipe **#26041** in position over the rear axle. Slip into the rear of the muffler and install the 3" clamp hanger **#180HA**. Connect the three rubber hangers to support the pipe. Tighten clamp lightly to allow for adjustment.

- 6) Slip pipe **#26042** onto the rear of **#26041**. Install a 3" clamp and tighten just enough to hold, but still allow for adjustment.
- 7) Adjust the position of all muffler, pipes and tips to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the Flowmaster system, the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.
- 8) Using the four bank clamps provided, secure the heatshield to the top of the muffler (between muffler and bed of truck). Tighten the clamps securely using a 8mm socket or standard screwdriver.
- 9) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the end of the over-axle pipe hangers and the clamp hangers. This will prevent the hangers from slipping out of the rubber mounts.
- 10) 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	Short Adapter Pipe	TB315
1	Long Adapter Pipe	TB231
1	Connector Pipe	TB322
1	Muffler	53073
1	Axle Pipe	26041
1	Exit Pipe	26042
1	Heatshield Kit	51022
1	Parts Kit	PK315
2	Clamp Hanger	179HA
1	Clamp Hanger	180HA
5	3" Clamp	MC300G
5	7/16" Hanger Keepers	



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Installation diagram for:
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