

Part # 1407080 w/stainless steel angle cut tips      409 s/s kit

Kit fits **'04-'07 full-size Ford ½ ton pickup, 2WD & 4WD, all wheel bases, w/4.6L & 5.4L V8, except for Harley Davidson, Lightning, and Super Duty.** For vehicles only with 2-1/2" exhaust at the converter.

Hearthrob exhaust systems are manufactured by Hearthrob Exhaust--Litchfield, MN

For detailed digital installation photos email us at [mike@heartthrobexhaust.com](mailto:mike@heartthrobexhaust.com)

**DANGER WARNING:** Should the purchaser decide to install this exhaust product at home, be warned that pleasure car or light duty truck/van "bumper" jacks are intended for emergency use only. The use of frame contact jack stands in conjunction with a floor jack as main support is highly recommended to minimize accidental dropping of a vehicle while the installation proceeds.

**Limitation of liability--Disclaimers:** The regulation of emissions production, noise levels and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns and counties.

The manufacturer makes no warranties of merchantability, of fitness for a particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations or ordinances in the states where they may be sold to the ultimate purchaser, the consumer.

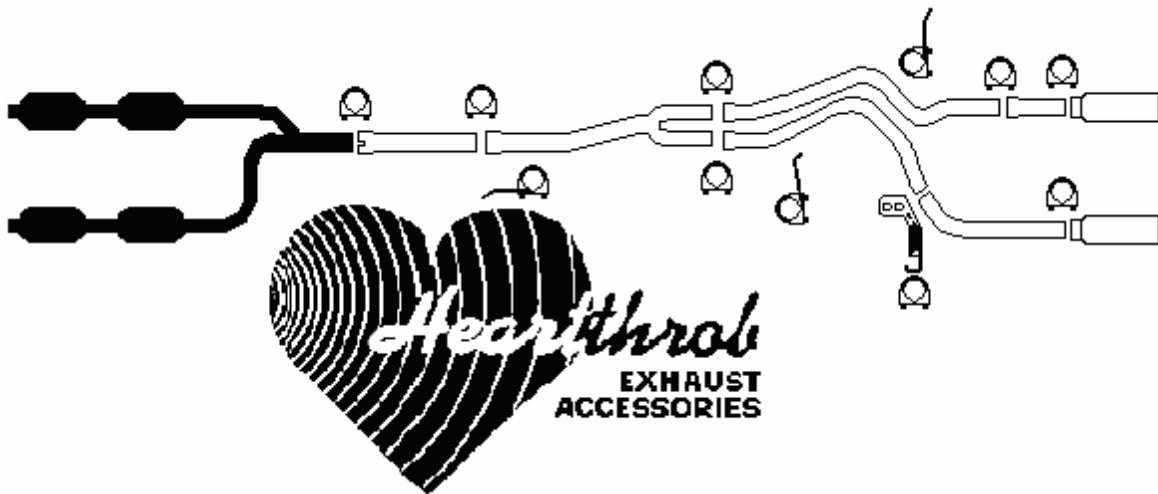
The entire risk as to the conformity of this product in any such state and as to repair, should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer of such product and it is not upon the seller, distributor, or manufacturer.

In this connection, retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, and or repair.

The foregoing statement limits the liability of the manufacturer.

**HARDWARE KIT:**

- |  |                                     |  |
|--|-------------------------------------|--|
| 1) 5/16" nuts SS                           | 1) 5/16" x 1" bolts SS              | 1) fender washers SS                       |
| 1 5/16" lock washers SS                    | 6) 2-1/4" clamps MC9214SS           | 2) 2-1/2" clamps MC9212SS                  |
| 1) rear 2-1/4" hanger clamp--#2862SS       | 1) BR92073SS swinger hanger         | 1) 2-1/2" hanger clamp--# 2864SS           |
| 1) front 2-1/4" hanger clamp--#2863SS      | 1) right tail pipe--#1407090-R      | 1) 2-1/2" x 48" extension pipe--#1407090-1 |
| 2) muffler tips—stainless steel--#8493518  | 1) left front tail pipe--#1407090-L | 1) left rear tail pipe                     |
| 1) y-pipe--#0430017                        |                                     |  |
| 1) right rear tail pipe 2-1/4" id/od x 12" |                                     |  |



**Kit #1407080****INSTRUCTIONS:**

**NOTE:** do not tighten any clamps or nuts and bolts until the last step!! Before cutting any pipes it is a good idea to lay out all the included pipes along side the vehicle and get a good idea of how the pipes will hang on the vehicle. Please read the instructions fully and thoroughly before you begin.

1) Remove the old exhaust system at the outlet after the converter y-pipe, leaving only the y-pipe, converters, and o.e. rubber hanger mounts on the truck.

2) **NOTE:** Do not trim the 48" long extension pipe until you are satisfied that you have the proper measurements. The extension pipe will fit the 163" wheel base models without cutting. For those with shorter wheel base models, you will need to trim as follows from the o.d. end (non-expanded end):

126" w.b. (regular cab 6-1/2' medium box)	cut to 11"
132.5" w.b. (super cab 5-1/2' short box)	cut to 17.5"
138.5" w.b. (supercrew 5-1/2' short box)	cut to 23.5"
144.5" w.b. (regular cab 8' long box, super cab 6-1/2' medium box)	cut to 29.5"
163" w.b. (super cab 8' long box)	no cutting required

3) Install the i.d. end of the extension pipe to the converter y-pipe using a 2-1/2" clamp. Install the y-pipe to the extension pipe, using a 2-1/2" clamp to connect the two pieces. Make sure that the y-pipe is mounted parallel to the ground, the y-pipe has offsetting bends that should raise the exhaust up towards the truck bed.

4) Install the 2-1/2" hanger clamp to the front extension pipe or y-pipe at the o.e. rubber hanger mount along side the extension or y-pipe.

5) Install the i.d. end of the right tail pipe (it has 5 bends) to the outlet of the y-pipe using a 2-1/4" clamp. Install the rear 2-1/4" hanger clamp to the right front tail pipe just after the rear axle, and below the o.e. rubber hanger mount. Install the wire portion of the rear 2-1/4" hanger clamp to the o.e. mount above.

6) Install the right rear tail pipe (2-1/4" id/od straight pipe x 12" long) to the right front tail pipe using a 2-1/4" clamp.

7) Install a muffler tip onto the right rear tail pipe. Use a 2-1/4" clamp to secure the tip to the rear tail pipe.

8) Install the left front tail pipe (4 bends) to the y-pipe using a 2-1/4" clamp, making sure that you have clearance between the rear brake line (bend bracket to the front if necessary) and spare tire.

9) Install the left rear tail pipe (1 bend) to the left front tail pipe using a 2-1/4" clamp. On some models you will need to trim the rear tail pipe to length. Mark where you want to cut the left rear tail pipe by holding up a tip next to the rear tail pipe. Trim the rear tail pipe to length. Install the muffler tip onto the left rear tail pipe. Use a 2-1/4" clamp to secure the tip to the rear tail pipe.

10) Locate the mounting hole (or drill if one is not present) directly above the connecting point of the left front tail pipe and the left rear tail pipe and mount the hanger using the included hardware for the left tail pipe. You will need to put a bend in the hanger to mount it to the bottom of the frame. Attach the hanger to the left front and rear tail pipe using a 2-1/4" clamp.

11) Tighten all clamps, nuts, and bolts. Check for leaks and for clearance of all brake and fuel lines, and for clearance of all chassis and frame components. We recommend tack welding the joints (not necessary though).

**BUILD SHEET FOR: DEEP-TONE DUAL CAT-BACK KIT****PART #(s): 1407080      409 s/s kit**1) HARDWARE KIT2) MUFFLER TIPS, all stainless steel angle cut#84935181) stainless steel Y-PIPE #04300171) stainless steel EXTENSION PIPE #1407090-11) stainless steel LEFT FRONT TAIL PIPE #1407090-L1) stainless steel LEFT REAR TAIL PIPE #1407090-L1) stainless steel RIGHT front tail PIPE #1407090-R1) stainless steel RIGHT rear tail PIPE #1404110

INSPECTED BY: \_\_\_\_\_

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