

FITS 1994-1995 FULL-SIZE GM 1/2 & 3/4 TON 2WD & 4WD PICKUPS W/4.3L V-6, 5.0 L & 5.7L V-8 WITH 2-3/4" FLANGED EXHAUST AT CONVERTER. THIS KIT FITS ALL WHEEL BASE MODELS.

Heartthrob Exhaust--Litchfield, Mn      [www.heartthrobexhaust.com](http://www.heartthrobexhaust.com) 320-693-0222

**NOTE:** DO NOT TIGHTEN ANY CLAMPS OR BOLTS UNTIL THE LAST STEP!

1) REMOVE THE EXHAUST SYSTEM AT THE FLANGE BEHIND THE CONVERTER LEAVING ONLY THE ORIGINAL Y PIPE, RUBBER MOUNTS FOR HANGERS, AND THE CATALYTIC CONVERTER ON THE TRUCK. YOU WILL NEED TO REUSE THE ORIGINAL NUTS TO FASTEN THE FLANGE TO THE EXHAUST.

**NOTE:** THE FLANGED FRONT PIPE WILL NEED TO BE CUT TO FIT THE REGULAR CAB MODELS. THIS PIPE FITS EXTENDED CAB SHORT BOX MODELS WITHOUT CUTTING. FOR EXTENDED CAB LONG BOX MODELS, AN ADDITIONAL EXTENSION PIPE IS INCLUDED WITH AN EXTRA CLAMP. THESE PIECES ARE NOT NEEDED ON THE OTHER THREE MODELS.

2) SLIP THE FLANGED FRONT PIPE INTO PLACE AND SLIDE THE FLANGE ON THE PIPE (FLAT SIDE FIRST) TO THE CONVERTER FLANGE. INSTALL THE NUTS TO THE BOLTS AT THE FLANGE BUT DON'T TIGHTEN YET.

FOR THOSE WITH REGULAR CAB SHORT BOX MODELS, CUT 23" OFF THE FLANGED FRONT PIPE FROM THE END THAT IS 3" O.D. FOR THOSE WITH REGULAR CAB LONG BOX MODELS, CUT 10" OFF THE FLANGED FRONT PIPE FROM THE END THAT IS 3" O.D.. FOR THOSE WITH EXTENDED CAB SHORT BOX, GO TO STEP 3). FOR THOSE WITH EXTENDED CAB LONG BOX, ADD THE 17" LONG EXTENSION PIPE AND ATTACH TO THE FLANGED FRONT PIPE USING A 3" CLAMP.

3) INSTALL THE 3" HANGER CLAMP TO THE FLANGED FRONT PIPE AT THE FRONT O.E. RUBBER MOUNT.

4) USE A 3" MUFFLER CLAMP TO ATTACH THE INLET OF THE MUFFLER AND THE FRONT FLANGED PIPE TOGETHER.

5) INSTALL THE RIGHT TAIL PIPE TO THE MUFFLER USING A 2-1/2" CLAMP. LOCATE OR DRILL A 5/16" HOLE IN THE FRAME ABOVE THE RIGHT TAIL PIPE AFTER REAR AXLE BUT NEAR THE O.E. RUBBER MOUNT. INSTALL A BR91930 SWINGER HANGER TO THE FRAME USING A 5/16" X 1" BOLT, NUT, LOCK WASHER, AND FENDER WASHER AND USING A 2-1/2" CLAMP, ATTACH TO THE RIGHT TAIL PIPE.

6) INSTALL THE LEFT TAIL PIPE USING A 2-1/2" CLAMP TO THE LEFT OUTLET OF THE MUFFLER. THE LEFT TAIL PIPE GOES UP OVER THE DIFFERENTIAL AND TO THE LEFT OF THE REAR SHOCK. LOCATE OR DRILL A 5/16" HOLE IN THE FRAME ABOVE THE LEFT TAIL PIPE AFTER REAR AXLE BUT NEAR THE O.E. RUBBER MOUNT (DIRECTLY AFTER THE CONNECTING POINT OF THE MUFFLER AND LEFT TAIL PIPE). INSTALL A BR91930 SWINGER HANGER TO THE FRAME USING A 5/16" X 1" BOLT, NUT, LOCK WASHER, AND FENDER WASHER AND USING A 2-1/2" CLAMP, ATTACH TO THE LEFT TAIL PIPE.

7) LOCATE OR DRILL A 5/16" HOLE IN THE FRAME ABOVE THE LEFT TAIL PIPE AFTER THE LAST BEND IN THE TAIL PIPE. INSTALL A THU-900 SWINGER HANGER TO THE FRAME USING A 5/16" X 1" BOLT, NUT, LOCK WASHER, AND FENDER WASHER. CONNECT THE HANGER AND THE LEFT TAIL PIPE USING A 2-1/2" CLAMP.

8) INSTALL THE 30" I.D/O.D TAIL PIPE EXTENSIONS TO THE LEFT AND RIGHT TAIL PIPE USING 2-1/2" CLAMPS. (YOU WILL WANT TO TRIM THE EXTENSION TO YOUR DESIRED LENGTH.)

9) TIGHTEN ALL CLAMPS AND BOLTS AND CHECK FOR CLEARANCE OF THE FRAME, BODY, AND BRAKE AND FUEL LINES.

10) TRIM TAILPIPE TO LEGNTH, INSTALL S/S TIPS WITH REMAINING CLAMPS.

**HARDWARE KIT FOR KIT #2404353:**

- |                               |                                     |
|-------------------------------|-------------------------------------|
| 2) 3" CLAMPS MC9300SS         | 1) FRONT FLANGED PIPE#2408351-3     |
| 7) 2-1/2" CLAMPS MC9212SS     | 1) LEFT TAIL PIPE #1408351-2        |
| 3) 360 SWINGER HANGER BR91930 | 1) RIGHT TAIL PIPE #1408351-1       |
| 3) 5/16" X 1" BOLTS SS        | 2) TAIL PIPE EXTENSIONS             |
| 3) 5/16" NUTS SS              | 1) MUFFLER #458442                  |
| 3) FENDER WASHERS SS          | 1) 17" LONG EXTENSION PIPE 3" ID/OD |
| 3) 5/16" LOCK WASHERS SS      | 2) S/S TIPS #9363009                |
| 1) 3" HANGER CLAMP-#2954SS    |                                     |
| 1) FORMED FLANGE              |                                     |
| 2) 2-1/2" CLAMPS SS           |                                     |

**DANGER WARNING:** SHOULD THE PURCHASER DECIDE TO INSTALL THIS, OR ANY OTHER 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.

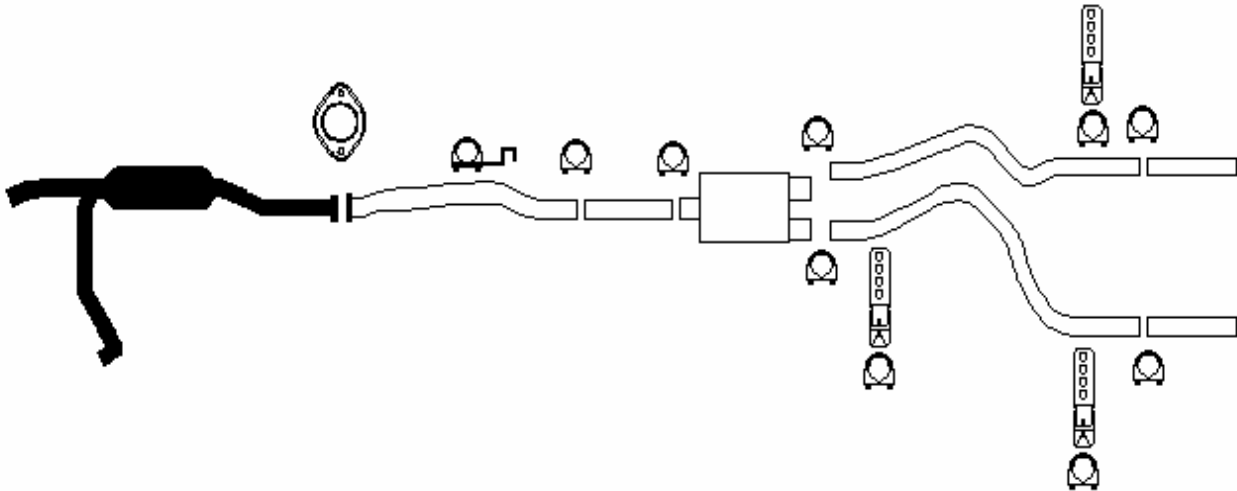
Limitation of liability–Disclaimers: The regulation of emissions production, noise levels and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns and counties.

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.



**BUILD SHEET FOR: SPLIT REAR dual kit 409 s/s**  
**PART #2404353**

- \_\_\_\_\_ 1) FRONT FLANGED PIPE#2408351-3
- \_\_\_\_\_ 1) LEFT TAIL PIPE #1408351-2
- \_\_\_\_\_ 1) RIGHT TAIL PIPE #1408351-1
- \_\_\_\_\_ 2) TAIL PIPE EXTENSIONS
- \_\_\_\_\_ 1) MUFFLER #458442
- \_\_\_\_\_ 1) 17" LONG EXTENSION PIPE 3" ID/OD
- \_\_\_\_\_ 2) S/S TIPS #9363009
- \_\_\_\_\_ 1) HARDWARE KIT

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

DATE: \_\_\_\_\_

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