

INSTRUCTIONS FOR KIT #2404402 DUAL KIT W/HVS MUFFLER/304 S/S TIPS 409 s/s kit

FITS 1980-1996 FULL-SIZE FORD 1/2 & 3/4 TON 2WD & 4WD PICKUPS W/V-8 & 6 CYL. WITH 2-1/4" EXHAUST AT THE CONVERTER. THIS KIT FITS ALL WHEEL BASE MODELS. DOES NOT FIT DIESEL, AND 460 AND 351 C.I. WITH 2-1/2" EXHAUST AT THE CONVERTER.

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

1) REMOVE THE EXHAUST SYSTEM AT THE CLAMP BEHIND THE CONVERTER LEAVING ONLY THE ORIGINAL Y PIPE, RUBBER MOUNTS, AND CATALYTIC CONVERTER ON THE TRUCK.

NOTE: THE EXTENSION PIPE WILL FIT THE LONGER WHEEL BASE TRUCKS WITHOUT CUTTING. ON ALL OTHER VEHICLES THE EXTENSION PIPE WILL NEED TO BE CUT FROM THE 3" **O.D.** END (THE END THAT IS NOT SHRUNK) AS NECESSARY.

2) SLIP THE FRONT PIPE INTO PLACE. WITH THE TAIL PIPES IN THE REAR OF THE MUFFLER, HOLD UP THE MUFFLER AND TAIL PIPES IN A POSITION THAT CLEARS ALL CHASSIS COMPONENTS. MARK THE FRONT PIPE. MAKE SURE TO ACCOUNT FOR AT LEAST 2" OF THE PIPE TO GO INTO THE MUFFLER. CUT THE FRONT PIPE.

3) USE THE 2-1/4" CLAMP TO ATTACH THE EXTENSION PIPE TO THE CONVERTER PIPE.

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

5) INSTALL THE LEFT TAIL PIPE USING A 2-1/2" CLAMP.

6) INSTALL AN I.D/O.D TAIL PIPE EXTENSION TO THE LEFT TAIL PIPE. YOU WILL WANT TO TRIM THE EXTENSION TO YOUR DESIRED LENGTH, AND INSTALL A STAINLESS STEEL TIP USING A 2-1/2" CLAMP.

7) LOCATE OR DRILL A HOLE IN THE FRAME NEAR THE END OF THE OVER THE AXLE SECTION OF THE LEFT TAIL PIPE ABOVE WHERE THE TAIL PIPE AND EXTENSION PIPE JOIN. USING THE 5/16 X 1" BOLT, NUT, LOCK AND FENDER WASHER, INST ALL THE THU-900 (360 SWINGER HANGER) TO THE FRAME AND ATTACH TO THE LEFT TAIL PIPE USING A 2-1/2" CLAMP (YOU WILL USE THIS SAME CLAMP TO CONNECT THE OVER THE AXLE PIPE AND THE REAR EXTENSION PIPE). **NOTE:** BOTH TAIL PIPES ARE ROUTED BETWEEN THE SHOCK AND THE SPARE TIRE. THE LEFT TAIL PIPE HAS A 48 DEG. FIRST BEND AND 65 DEG. LAST BEND, AND THE RIGHT TAIL PIPE HAS A 30 DEG. FIRST BEND AND 65 DEG. LAST BEND. THE OUTLETS OF BOTH TAIL PIPES ARE THE LONG ENDS, AND THE LEFT TAIL PIPE IS THE PIPE WITH THE SHORTER INLET.

8) INSTALL THE RIGHT TAIL PIPE USING A 2-1/2" CLAMP TO THE RIGHT OUTLET OF THE MUFFLER.

9) INSTALL A 30" I.D/O.D TAIL PIPE EXTENSION TO THE RIGHT TAIL PIPE. YOU WILL WANT TO TRIM THE EXTENSION TO YOUR DESIRED LENGTH, AND INSTALL A STAINLESS STEEL TIP USING A 2-1/2" CLAMP.

10) LOCATE OR DRILL A HOLE IN THE FRAME NEAR THE END OF THE OVER THE AXLE SECTION OF THE RIGHT TAIL PIPE ABOVE WHERE THE TAIL PIPE AND EXTENSION PIPE JOIN. USING THE 5/16" X 1" BOLT, NUT, LOCK AND FENDER WASHER, INSTALL THE THU-900 (360 SWINGER HANGER) TO THE FRAME AND CONNECT TO THE JUNCTION OF THE RIGHT TAIL PIPE AND REAR EXTENSION PIPE USING A 2-1/2" CLAMP.

11) INSTALL A THU900 SWINGER HANGER TO EITHER THE FRONT EXTENSION PIPE (AT THE INLET OF THE MUFFLER), OR NEAR THE INLETS OF EITHER OF THE TAIL PIPES. LOCATE OR DRILL A HOLE IN THE FRAME NEAR WHERE YOU WANT TO INSTALL THE HANGER. USING THE 5/16 X 1" BOLT, NUT, LOCK AND FENDER WASHER, INSTALL THE THU-900 (360 SWINGER HANGER) TO THE FRAME AND ATTACH TO THE PIPE USING A 2-1/2" CLAMP.

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

**BUILD SHEET FOR: 2-1/2" S/S DUAL CAT-BACK
PART #'S: 2404402**

- _____ 1) FRONT EXTENSION PIPE--# 2404402-1
- _____ 1) LEFT TAIL PIPE--# 2404402-3
- _____ 1) RIGHT TAIL PIPE--# 2404402-2
- _____ 2) TAIL PIPE EXTENSIONS--# 2404402-4
- _____ 1) MUFFLER # 458442
- _____ 1) HARDWARE KIT
- _____ 2) 9363009 STAINLESS STEEL TIPS

INSPECTED BY: _____

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