



409S_s Stainless Steel

Installation Instructions for:
SYSTEM #817104
1967-1974 V8 CAMARO/FIREBIRD
1968-1974 V8 NOVA
(EXCEPT CONVERTIBLE)

07/31/14

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height and support securely with jack stands.
- 2) Remove existing system from the header collector or manifold down pipes back.

Installation:

- 1) Place a supplied clamp onto the inlets of muffler **#842585-Z** and position the muffler behind the axle in the stock location. Temporarily support the muffler with a floor jack, jack stands or a sturdy box.
- 2) Slide the intermediate pipes, **#86267S** and **#86268S**, into the muffler inlets and tighten the clamps enough to hold but still allow for adjustments. *NOTE: For 1967-1969 vehicles only, cut 2 1/4" off of the muffler inlet end of the intermediate pipes (See Figure A).*
- 3) Place a supplied clamp onto the slip-fit of intermediate pipes **#86267S** and **#86268S**. Install the H-pipe assembly **#16267S** into the intermediate pipes and tighten the clamps enough to hold but still allow for adjustments and pipe alignment.
- 4) Place a supplied clamp onto the slip-fits of H-pipe assembly **#86265S**, then install the connector pipes **#TB754S** from the H-pipe assembly to the headers or downpipes. It may be necessary to cut these pipes due to variation of header lengths (*see drawing*). *Note: It will be necessary to either weld a standard flange (not supplied) or connect to header cone or manifold down pipes.* Align the front pipe assembly with header collector outlets or manifold down pipes. Temporarily support these pipes with stands.
- 5) Adjust the position of the muffler so it is centered in the muffler cavity behind the axle and between the rear springs. Be as accurate as possible. This step may require the help of an assistant.
- 6) Slide the intermediate pipe hanger assemblies, **#HA109**, with bolts removed, onto the intermediate pipe hanger brackets. (See diagram)
- 7) Raise muffler and pipe assembly and allow hanger to make contact with the floorboards. Be certain the muffler and pipes are aligned properly. Use the holes in the hanger assembly to make marks on the floorboard for the assembly bolt holes. Repeat for both sides. There will be a total of 4 holes, 2 on each side of the system for each hanger.
- 8) Drill out marked holes with 5/16" drill, through the floorboard. *Note: Remove the rear seat before drilling to avoid damaging it.*

- 9) Bolt hangers to floorboard. (See Figure B)
- 10) Remove temporary support and allow system to suspend on the hangers.
- 11) Place a supplied clamp onto the muffler outlets, then insert tailpipes **#16035S** and **#16036S** into the muffler outlets and adjust for desired position; clamp tightly enough to hold in position but allow for adjustment. It may be necessary to trim the muffler end of the tailpipes to obtain proper fit between the leaf springs and the quarter panel.
- 12) Support the muffler just enough to hold its weight.
- 13) Install the **#HA122** rubber hangers onto tail pipes **#16035S** and **#16036S** (non-metal brushed end of hanger connects to wire tailpipe mount.) Position the tailpipes in the desired location.
- 14) Use the hangers to locate the hanger bolt-hole location and mark on the frame rail. Use a 3/16" bit to drill hanger bolt hole. Install the included lag screw and washer to bolt the tailpipe hangers to the frame rail. Be sure lag screw is installed in the metal bushed end of the rubber hanger. *Note: Make sure tail pipes are aligned properly before holes are drilled.*
- 15) Remove temporary support and allow system to suspend on hangers.
- 16) Adjust and align all pipes; maintain a minimum of 1/2" clearance between the new exhaust system, the drivetrain and all chassis components. Also, keep suspension in mind.
- 17) For a cleaner appearance and more secure installation, we recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Muffler	842585-Z
2	Connector pipe	TB754S
1	H-pipe assembly	86265S
1	Intermediate Pipe (Right)	86267S
1	Intermediate Pipe (Left)	86268S
1	Tailpipe (Right)	16035S
1	Tailpipe (Left)	16036S
1	Parts Kit	PK568
8	2½" Band Clamp	MC250BS
2	Intermediate Pipe Hangers	HA572
2	Rubber Tailpipe Hangers	HA122
2	Back-up Plates	HW1408
2	5/16" X 1½" Lag Bolts	HW217
2	5/16" Fender Washers	HW305
2	3/8" hanger keepers	HW501
4	5/16" x 1" Bolt	HW204
4	5/16" Hex Nut	HW102
4	5/16" Flat Washer	HW302
4	5/16" Lock Washer	HW308



Installation diagram for:
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