



Installation Instructions for:
SYSTEM #817654
1967-1972 GM C10 PICKUPS
2 1/2" HEADER BACK SYSTEM



409S Stainless Steel

06/04/13

Removal:

- 1) Raise the rear of the vehicle and support securely with jack stands.
- 2) Remove the existing system from the header collector or manifold down pipes back.

Installation:

1) Locate the center carrier bearing cross member; this is where the front hangers will be mounted. Measuring in 9-5/8" from the frame toward the center of the cross member there should be a factory hole. Using a drill and bit, open the hole up to 3/8". Then measure in 1.00" toward the center of the vehicle and make a mark. This is where you will drill a second 3/8" hole. Mount one of the HA572 rubber hangers to the bottom of the cross member using the 3/8" hardware provided, do this for both sides of the cross member. See photos below.



2) Take the right and left H-pipe assemblies, **86074S** & **86075S** and connect them together at the center cross-over connection. Place them up into position and connect the hangers on the pipe to the rubber mounts installed above. The hanger rods should stick through the rubber block on the **HA572** hanger approximately 1.00". Support the front of the assembly with a stand. Place the provided 2" clamp at the center H-pipe connection.

3) Locate the rear spring mount cross member, measure in 11 & 12 inches from the edge of the spring mount and make a mark. This will be on the forward channel of the cross member. Once you have verified the measurements are correct, center punch the two holes and drill a 3/8" hole in these locations. Mount one of the **HA572** rubber hangers to the bottom of the cross member using the 3/8" hardware provided. Do this step on both sides of the cross member. See photos below.





4) Take the **86076S** muffler inlet pipes and place a supplied 2½" clamp onto the expanded end, place them onto the back of the H-pipe assembly's **86074S** & **86075S**. Rotate them up into their approximate position and tighten the clamps enough to hold, but still allow for adjustment.



5) Take one of the **842548-Z** mufflers and place a supplied clamp onto the inlet, slide the inlet onto the back of one of the **86076S** inlet pipes with the outlet of the muffler in the center of the vehicle. Support the muffler with a stand and tighten the clamp enough to hold, but still allow for adjustment.



6) Place a supplied clamp onto the right muffler outlet; take the right over-axle tailpipe **#86077S** and slide into the muffler outlet while connecting the front hanger on the pipe to the rubber mount installed in step 3 above. The tailpipes have been left long to work for long bed model trucks, for short bed trucks the rear of the tailpipes will need to be trimmed approximately 12.00". Place a second **HA572** hanger onto the rear hangers in preparation for the two steps below.



7) To mount the rear tailpipe hangers on short bed trucks, measure forward 17¼" from the rear of the frame, there will be a factory hole mid-way up the frame rail. Using the 3/8" hardware provided, and bolting through the bottom hole of the **HA572** hanger installed on the tailpipe hanger, bolt the hanger to the side of the frame. Be sure the **HA572** is straight up and down then drill a 3/8" hole through the top hole in this hanger and secure with a 3/8" bolt, nut and washers.

8) To mount the rear tailpipe hangers on long bed trucks, locate the oval slot in the bottom of the rear frame rail. Measure forward 1¾" and make a mark on the bottom of the frame. Then measure up from the bottom of the frame 1¼" for the bottom hole and 2¼" for top hole and make a mark. Center punch the two marks and then using a drill and 3/8" bit, drill out the holes. Bolt the **HA572** hanger installed on the tailpipe hanger to the side of the frame using the 3/8" bolt, nut and washers provided.



9) Included in the system are 4 different exit pipe styles, determine which of the exit pipes that you would like to use. Place a clamp over the expanded end of your chosen exit pipe and slide them onto the back of the over-axle pipes. Tighten the clamps enough to hold.

10) It will be necessary to adapt from your existing headers or manifold downpipes to the Flowmaster H-pipe assembly. Due to the many different variables in header/manifold down pipe locations, we have included 2 **#86084S** adapter pipes to aid in the fabrication of the connection between these two areas.

11) Remove temporary support and allow the system to suspend on the hangers.

12) Adjust the position of the pipes and mufflers to provide a satisfactory fit. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten the clamps down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
2	Muffler	842548-Z
2	Front Adapter Pipe	86084S
1	Left H-pipe Assy.	86074S
1	Right H-pipe Assy.	86075S
2	Muffler Inlet Pipe	86076S
1	Right Over-axle Pipe	86077S
1	Left Over-axle Pipe	86078S
2	Rear Exit Pipe (R/L)	86079S
2	Side Exit Pipe (R/L)	86080S
2	Turndown Exit Pipe (R/L)	86081S
1	Right Dump Down Exit	86085S
1	Left Dump Down Exit	86086S
1	Parts kit	PK733
10	2½" Clamp	MC250BS
1	2" Clamp	MC200BS
6	Rubber Mount	HA572
12	3/8" x 1" Bolt	HW208
12	3/8" Nut	HW103
4	3/8" Flat Washer	HW303
12	3/8" Lock Washer	HW309



Installation diagram for:
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AMERICAN THUNDER
409S^{SS} Stainless Steel

