



FORCE II

Installation Instructions

817486

2009*-21 TOYOTA TUNDRA

4.6L, 4.7L & 5.7L ENGINE

2/4 WD & Wheelbases

This kit does NOT fit regular cab/short bed or double cab/long bed configurations.

*Only fits models built after 08/01/2008.

OVERVIEW:

1. Take a moment to read and understand these instructions before installing your Flowmaster performance system.

NOTE: Please inventory all parts now before continuing and if necessary, report any missing items to our tech line. This will avoid potentially stranding your vehicle until any missing replacement parts arrive.

ITM #	PART #	DESCRIPTION	QTY.
8	16547S	Side Exit Pipes R/L	2
9	ST396	Stainless Tips	2
N/A	PK502	Hardware Pack includes:	1
10	MC250BS	2½" Band Clamp	7
11	384HA	Left Inlet Pipe Clamp Hanger	1
12	353HA	Right Inlet Pipe Clamp Hanger	1
13	354HA	Left Rear Frame Hanger	1
14	HA566	Backing Plate	1
15	HA168	Rubber Hanger	1
16	HW103	¾" Nut	1
17	HW303	¾" Flat Washer	1
18	HW309	¾" Lock Washer	1
19	HW503	½" Hanger Keeper	1

ITM #	PART #	DESCRIPTION	QTY.
1	8525504-181	Muffler	1
2	16634S	Left Inlet Pipe	1
3	16633S	Right Inlet Pipe	1
4	16543S	Right Tailpipe	1
5	16542S	Left Front Tailpipe	1
6	16544S	Left Rear Tailpipe	1
7	16546S	Rear Exit Pipes R/L	2

REMOVE STOCK EXHAUST SYSTEM:

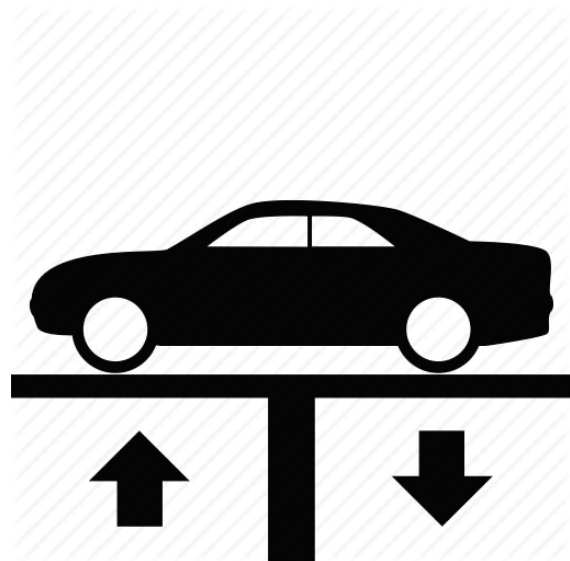
2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

WARNING:

Avoid serious burns! Allow your vehicle time to cool completely before touching any factory engine components.

To ease preparation and installation of your new kit:

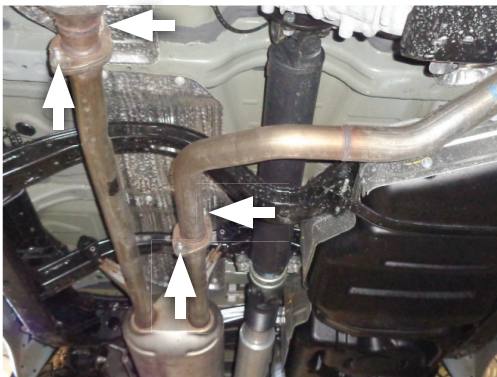
- Apply penetrating lubricant to mounts, bolts and clamps before you remove them.
- Use stands as necessary to support parts as you detach them from your vehicle and again as you install new parts.



3. Unbolt tailpipe connection on muffler exit. Disassemble wire hanger from isolator on vehicle and remove tailpipe.



4. Remove bolts (x4) at front flange connections (x2). Disassemble wire hangers from isolators and remove muffler inlet pipe assembly. Retain bolts for later use.



INSTALL FLOWMASTER EXHAUST SYSTEM

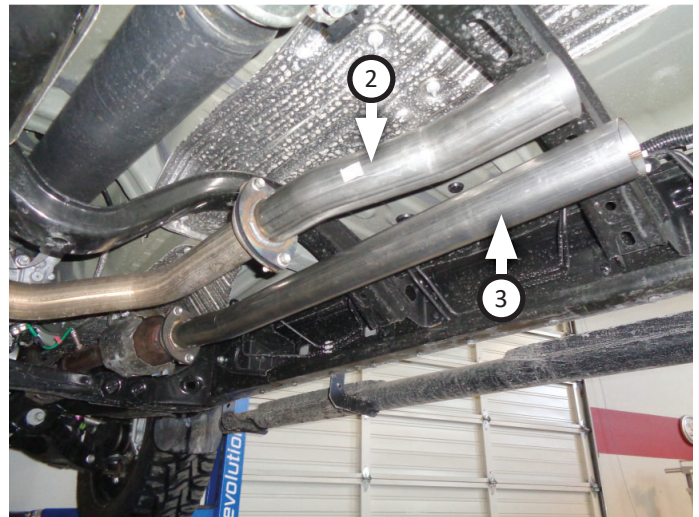
5. Remove nuts from stock and Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.

NOTE: The image in this step is intended for illustrative purposes only and may or may not accurately reflect components included in your kit.

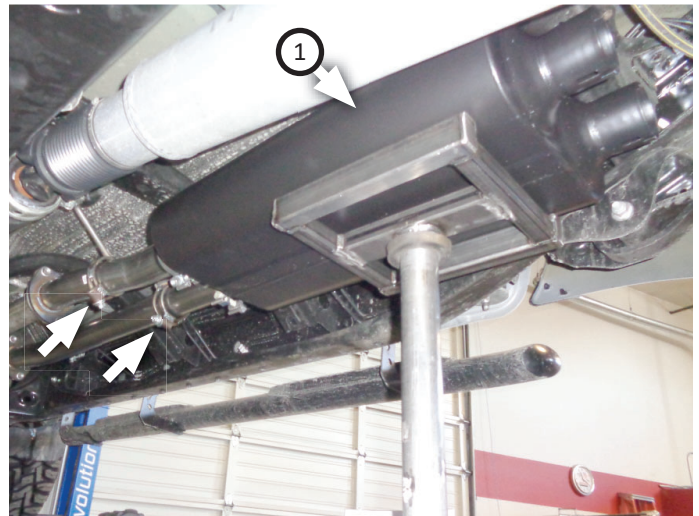
6. Every slip fit connection in this kit must seat 3" deep except for muffler connections which must seat 2" deep. Mark all slip fit components in your kit and mark them accordingly so your Flowmaster exhaust system fits properly onto your vehicle.



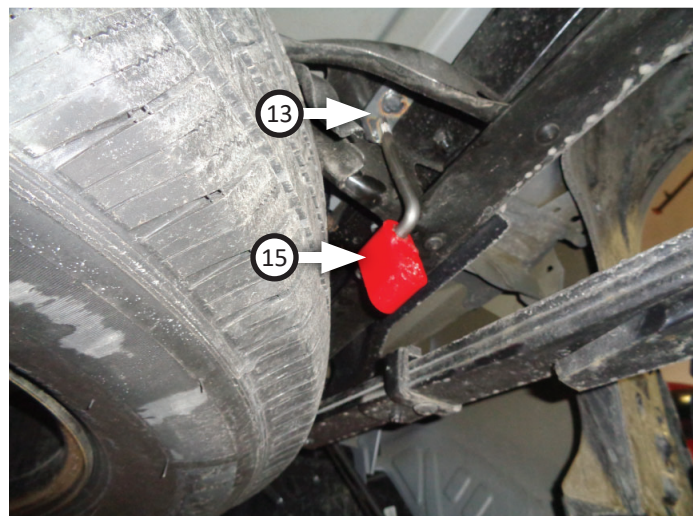
7. Fasten **left (2)** and **right (3)** inlet pipes onto head pipe flanges using bolts (x4) (removed step 4).



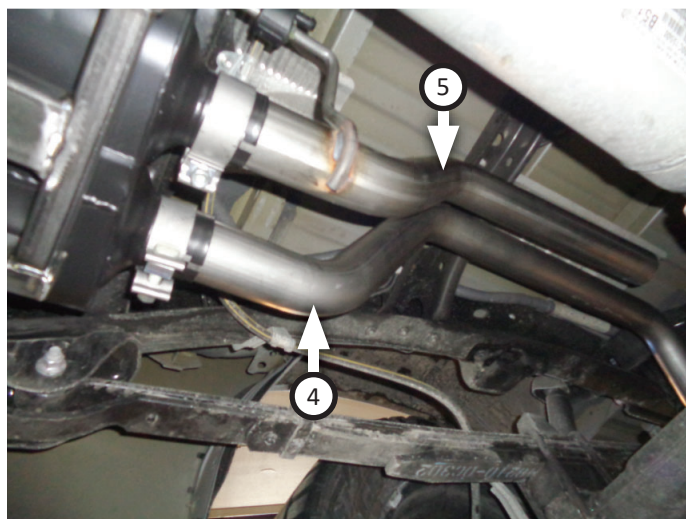
8. Place **left (11)** and **right (12)** inlet pipe clamp hangers onto inlet pipes and hang them on vehicle frame hanger mounts. Place (x2) **clamps (10)** onto **muffler (1)** then connect it to inlet pipes. Tighten clamps enough to allow for adjustment.



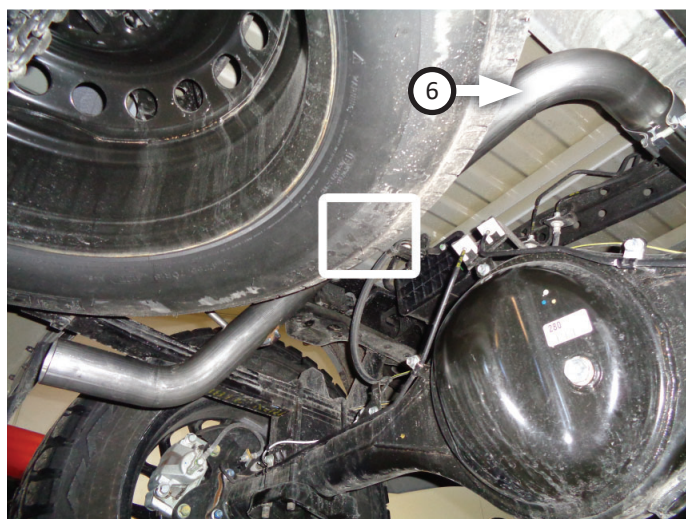
9. Secure **left rear frame hanger (13)** to vehicle frame using **backing plate (14)**, **flat washer (17)**, **lock washer (18)** and **nut (16)**. Then slide **rubber hanger (15)** on the end.



10. Place (x2) **clamps (10)** onto muffler outlets. Connect **right tailpipe (4)** and **left front tailpipe (5)** while inserting wire hangers into isolators. Tighten clamps enough to allow for adjustment.



11. Place **clamp (10)** onto **left rear tailpipe (6)** and connect it to left front tailpipe. Insert wire hanger into rubber hanger and tighten clamps just enough to hold parts.



NOTE: This kit includes both side and rear exit pipes. If you wish to equip your vehicle with a rear exit exhaust, use rear exit pipes now in place of side exit pipes.

12. Place **clamp (10)** onto right tailpipe then connect **side exit pipe (8)**. Repeat this on left side tailpipe.



13. Install (x2) **stainless tips (9)** onto exit pipes then tighten inlets.



14. Adjust exhaust components to provide a satisfactory fit. Maintain a minimum of $\frac{1}{2}$ " clearance around all components of exhaust system, keeping in mind suspension, travel and vibration. After making any required adjustments, securely tighten all clamps.
15. Slide **hanger keeper (19)** onto sideways hanger.
16. We recommend applying a one inch tack weld to all slip-fit connections for a more secure installation. You may also apply high temperature paint over welded areas to prevent rust and premature corrosion.



Congratulations, the installation of your FLOWMASTER performance exhaust system is now complete!





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Installation Diagram
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