



FORCE II®

Installation Instructions

817675

1963-67 CORVETTE STINGRAY
327 SMALL BLOCK ENGINE

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.
1	86200S	X-Pipe Assembly	1
2	86204S	Left Under-Axle Pipe	1
3	86205S	Right Under-Axle Pipe	1
4	842458-345	Right Muffler	1
5	842458-344	Left Muffler	1

ITM #	PART #	DESCRIPTION	QTY.
N/A	PK768	Hardware Package includes:	1
6	MC225BS	2¼" Stainless Band Clamp	6
7	HA602	Universal Bracket	2
8	HA226	Back Up Plate	2
9	HW208	⅜-16 x 1 Hex Cap Bolt	2
10	HW103	⅜-16 Nut	2
11	HW303	⅜" Flat Washer	2
12	HW309	⅜" Lock Washer	2

REMOVE STOCK EXHAUST SYSTEM:

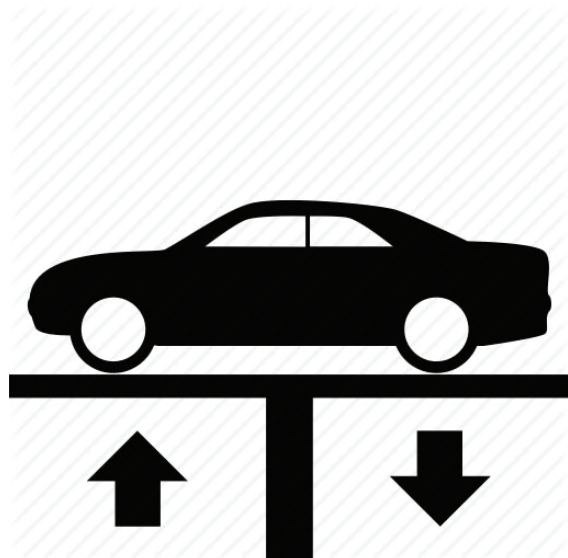
2. Raise vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, support vehicle with jack stands.

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. This system is designed to fit just behind transmission cross member. Remove existing exhaust system from this point back. Unbolt factory hangers at rear of mufflers.



INSTALL FLOWMASTER EXHAUST SYSTEM

4. 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.

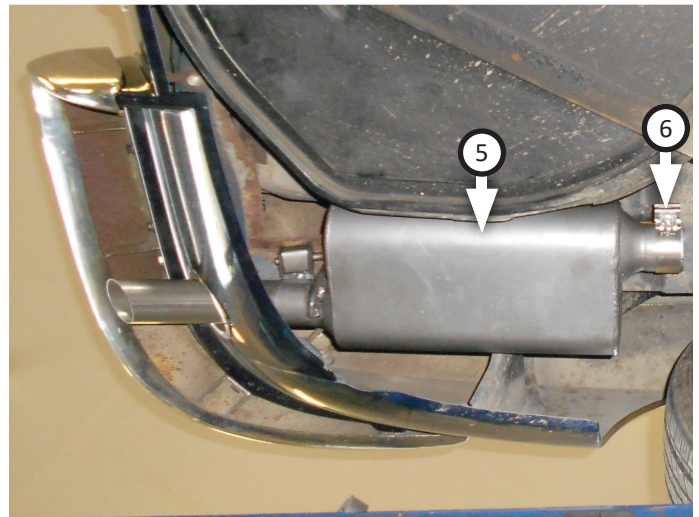


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5. Fasten (x2) **brackets (7)** to holes in vehicle frame above muffler outlets with **bolts (9)**, **back up plates (8)**, **flat washers (11)**, **lock washers (12)** and **nuts (10)**.

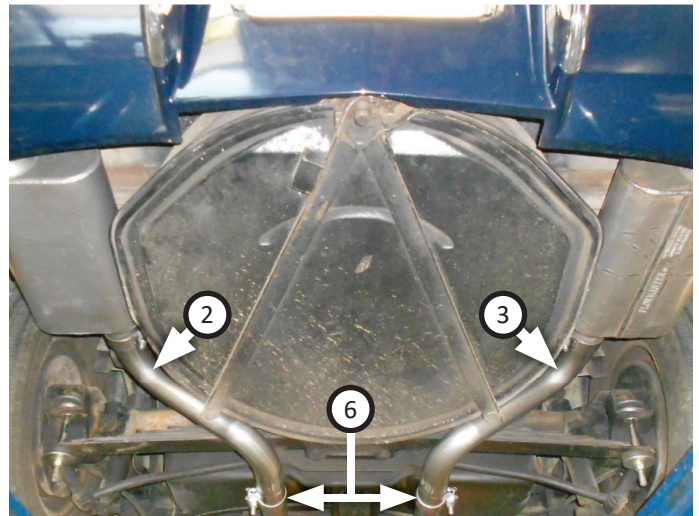
NOTE: The backing plate should be positioned up inside of frame so the bolt can drop down through it.



6. Fit **left muffler (5)** tip through left side bumper and insert wire hanger through bracket. Place **clamp (6)** onto muffler inlet. Repeat step with **right muffler (4)** and **clamp (6)** on opposite side.

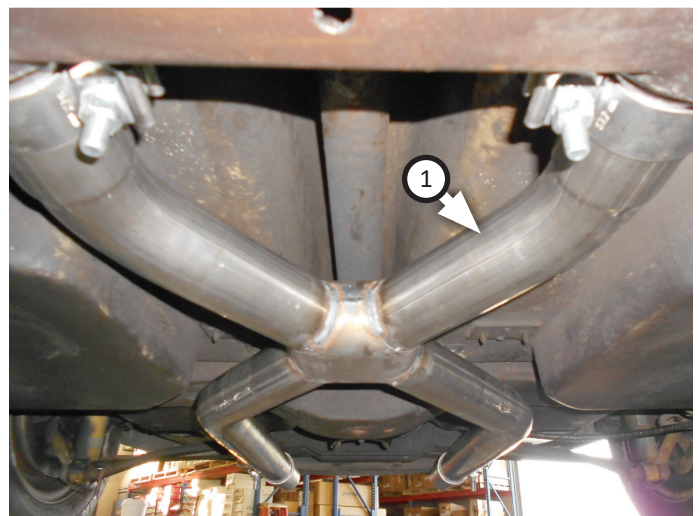
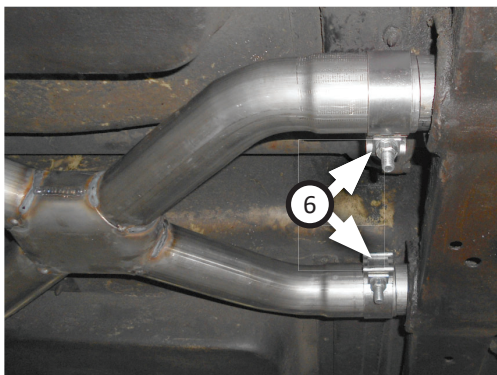


7. Connect **left (2)** and **right (3)** under-axle pipes to muffler inlets, rotated as shown. Tighten clamps just enough to allow for later adjustment. Place (x2) **clamps (6)** onto under-axle pipes.

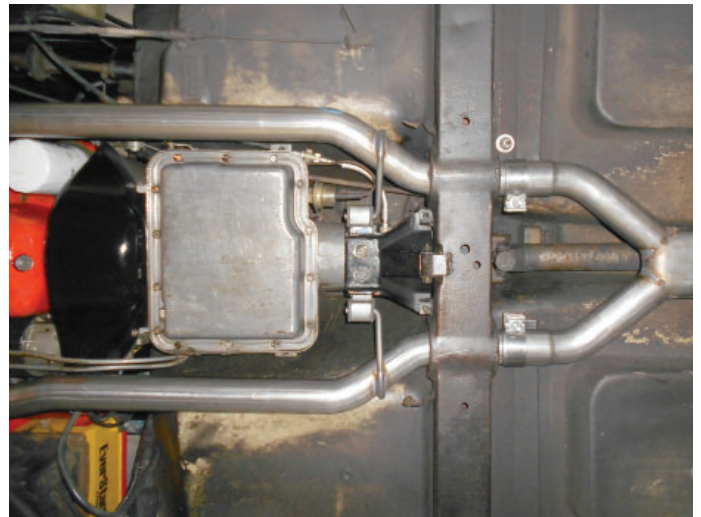


NOTE: The Flowmaster embossing should face the ground.

8. Connect **x-pipe assembly (1)** onto under-axle pipes then support it so inlets are level with vehicle frame exhaust holes as shown. Place **clamps (6)** onto x-pipe inlets.



9. Adjust exhaust components for fit; maintaining $\frac{1}{2}$ " clearance and compensating for suspension, travel and vibration. Then fabricate downpipes down to connect x-pipe to factory exhaust.



10. Remove any support and re-adjust exhaust components to ensure your system is tight-fitting and all connections are stable.
11. Recommended: Secure slip-fit connections with a 1-inch tack weld then spray high-temp paint over each weld to prevent rust and premature corrosion.



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





Installation Diagram
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