



Installation Instructions for:  
**SYSTEM #817493**  
1997-1999 Jeep Wrangler  
2.5L & 4.0L Engines

# FORCE II™

## 409S Stainless Steel

05/24/12

- 1) Raise the vehicle up on a hoist or rack to working height.



- 2) Using a hacksaw or sawsall, cut the stock tailpipe off where it exits the muffler. (This step is not mandatory, but it makes removal a little easier.)



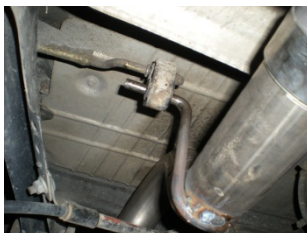
- 3) Separate the wire hangers on the tailpipe from the rubber mounts on the vehicle. Remove the tailpipe and set aside.



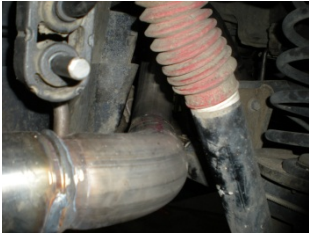
- 4) Support the muffler with a stand. Using a 15mm wrench, remove the muffler clamp at the catalytic converter to muffler connection. Remove the muffler assembly from under the vehicle.



- 5) Place the provided 2¼" clamp onto the muffler inlet and then slide the muffler onto the back of the catalytic converter and support with a stand. Tighten the clamp enough to hold, but still allow for adjustment.



- 6) Place a provided 2½" clamp onto the muffler outlet and then place tailpipe **#16770S** into position over the rear axle. Slide the hangers on the pipe into the rubber mounts on the vehicle and then into the muffler outlet. Tighten the clamp enough to hold, but still allow adjustment.



7) Adjust the position of all pipes and mufflers to provide a satisfactory fit. This is a tight fitting system, so take your time and be patient, tightening and adjusting a little bit at a time. 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 all connections 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>
1	Muffler Assembly	852462-268
1	Tailpipe	16770S
1	Parts Kit	PK631
	1 2¼" Band Clamp	MC225BS
	1 2½" Band Clamp	MC250BS
	2 7/16" Hanger Keeper	HW502



Installation diagram for:  
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