



Installation Instructions for:
SYSTEM #17742
1973-1987 GM C10/C20 PICKUP
1/2 & 3/4 TON, 2WD MODELS
2 1/2" CROSSMEMBER BACK SYSTEM

08/05/15

Removal:

1) At the rear of the truck frame locate the oval hole, approximately 9 1/2" forward of the rear leaf spring mount. This hole may be partially obstructed by the factory exhaust hangers. The factory exhaust hangers will need to be removed from the frame in order to mount the **HA602** hangers for the new Flowmaster system. We found that the easiest way to remove the hangers is to center punch and then drill the heads of the rivets off. You can also use a grinder or torch to remove the heads of the rivets. See photos below.



2) Remove the factory pipe hangers from the front and middle exhaust hanger mounts.

Installation:

1) Locate the oval hole described in step one of the removal instructions above, remove the 3/8" hardware from the parts kit and place a 3/8" flat washer onto a 3/8" x 1" bolt, place the bolt thru the HA602 hanger and then into the hole in the frame. Place another flat washer over the bolt on the inside of the frame followed by a lock washer and nut. Make sure that the hanger is straight up and down and tighten securely. Repeat this step on the opposite side of the vehicle. See pictures below.



2) Locate the cross member at the front of the rear leaf spring, on the left side of this cross member, there will be a factory hole 9.00" in from the frame and $\frac{3}{4}$ " up from the bottom, this hole location will need to be duplicated on the right side of the vehicle. Measure over 9.00" from the frame and $\frac{3}{4}$ " up as shown in the photos below, use a center punch to make a mark and drill a $\frac{5}{16}$ " hole on this mark.



3) Remove the $\frac{5}{16}$ " hardware from the parts kit, place a $\frac{5}{16}$ " flat washer over the $\frac{5}{16}$ " bolt and place thru the hole in the **211HA** hanger as shown below. Place the hanger into position with the bolt thru the frame; place a second $\frac{5}{16}$ " flat washer over the bolt followed by a lock washer and nut. Make sure that the hangers are level and tighten securely. Place a **HA168** red exhaust isolator onto the end of each mount.





4) **Note:** For short bed model trucks, 14.00" will need to be trimmed from the front of each tailpipe. Place the right side tailpipe **#86353** up into position over the rear axle, slide the rear hanger on the pipe into the rubber mount on the frame and then connect the front hanger to the red exhaust mount. The red exhaust mount should hang straight up and down. Repeat this step on the left side of the vehicle with tailpipe **#86354**.



5) Place a supplied 2.5" clamp over the outlet of one of the **942545K** mufflers and slide onto the front of the right tailpipe, support the muffler with a stand and tighten the clamp enough to hold but still allow for adjustment. Repeat this step on the left side of the vehicle. Place another supplied 2.5" over the inlet of both mufflers.



6) Take the right and left H-pipe assemblies, **86351** & **86352** and connect them together using cross over pipe **86360**. Place them up into position and connect the non-expanded ends into the muffler inlets. Make sure that they are fully seated. Support the front of the assembly with a stand. Place a provided 2" clamp at both of the cross over connections.



7) Included in the system are 2 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. **Note:** For short bed model trucks, 10.00" will need to be trimmed from the back of the rear exit pipes **#86357** & **#86358**.

8) 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 **#86361** adapter pipes to aid in the fabrication of the connection between these two areas. We have also included a bent adapter pipe **#86362** for the left side of the vehicle; this will allow you to go over or under depending on the style of cross member.

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

10) 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. Place the included 7/16" hanger keepers onto the end of the front tailpipe hangers and slide up to the red isolator, these will prevent the hangers from slipping out of the isolators.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>	
2	Muffler	942545K	
2	Front Adapter Pipe	86361	
1	Bent Adapter Pipe	86362	
1	Right H-pipe Assy.	86351	
1	Left H-pipe Assy.	86352	
1	Crossover Pipe	86360	
1	Right Over-axle Pipe	86353	
1	Left Over-axle Pipe	86354	
1	Rear Exit Pipe, Right	86357	
1	Rear Exit Pipe, Left	86358	
2	Side Exit Pipe (R/L)	86359	
1	Parts kit	PK814	
2	2" Saddle Clamp		MC200S
8	2½" Saddle Clamp		MC250S
2	Red Exhaust Isolator		HA168
2	Front Frame Hanger		211HA
2	Rear Rubber Mount		HA602
2	3/8" x 1" Bolt		HW208
2	3/8" Nut		HW103
4	3/8" Flat Washer		HW303
2	3/8" Lock Washer		HW309
2	5/16" x 1" Bolt		HW204
2	5/16" Nut		HW102
4	5/16" Flat Washer		HW302
2	5/16" Lock Washer		HW308
4	7/16" Hanger Keepers		HW502



Installation diagram for:
SYSTEM #17742
1973-1987 GM C10/C20 PICKUP
1/2 & 3/4 TON, 2WD MODELS
2 1/2" CROSSMEMBER BACK SYSTEM

