

Part # 1407040 w/stainless steel blunt cut tips 409 stainless steel kit

Kit fits '99-'01 full-size Ford 3/4 & 1 ton pickup (Super Duty models, F250HD & F350), 2WD & 4WD, all wheel bases, w/5.4L V8 & V10. For vehicles only with 3" exhaust at the converter.

Heartthrob Exhaust--Litchfield, MN [www.heartthroboxhaust.com](http://www.heartthroboxhaust.com)

**DANGER WARNING:** Should the purchaser decide to install this exhaust product at home, be warned that pleasure car or light duty truck/van "bumper" jacks are intended for emergency use only. The use of frame contact jack stands in conjunction with a floor jack as main support is highly recommended to minimize accidental dropping of a vehicle while the installation proceeds.

Limitation of liability--Disclaimers: The regulation of emissions production, noise levels and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns and counties.

The manufacturer makes no warranties of merchantability, of fitness for a particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations or ordinances in the states where they may be sold to the ultimate purchaser, the consumer.

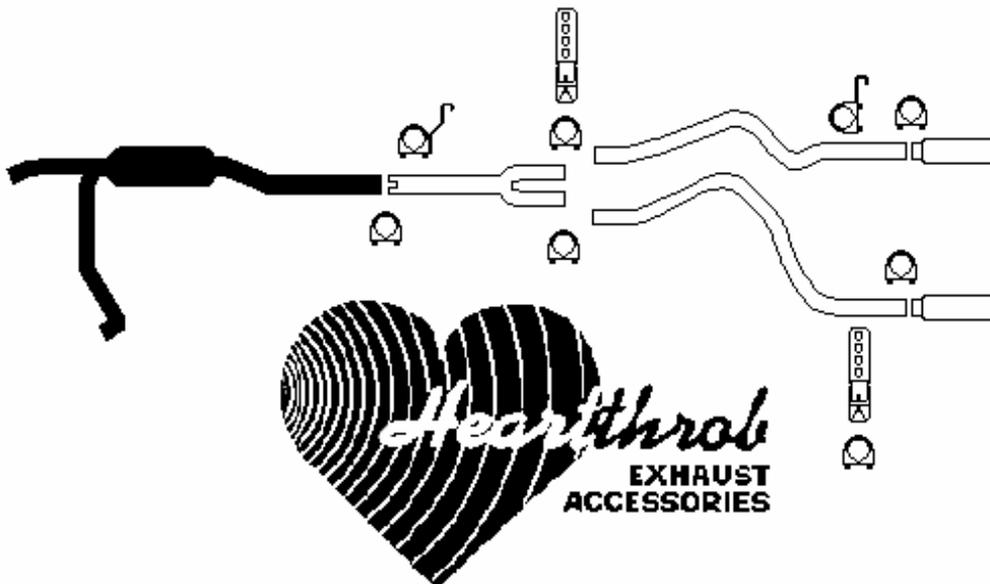
The entire risk as to the conformity of this product in any such state and as to repair, should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer of such product and it is not upon the seller, distributor, or manufacturer.

In this connection, retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, and or repair.

The foregoing statement limits the liability of the manufacturer.

**HARDWARE KIT:**

- |   |                              |                                 |
|---|------------------------------|---------------------------------|
| 2) 5/16" nuts SS                          | 2) 5/16" x 1" bolts SS       | 2) fender washers SS            |
| 2 5/16" lock washers SS                   | 5) 2-1/4" clamps MC9214SS    | 1) 3" clamp MC9300SS            |
| 2) BR91930 swinger hangers                | 1) 3" hanger clamp-# 2959SS  | 1) 2-1/4" hanger clamp-# 2958SS |
| 2) muffler tips—stainless steel--#8493518 | 1) right tail pipe--#1407042 |                                 |
| 1) y-pipe--#0430032                       | 1) left tail pipe--#1407041  |                                 |



## Kit #1407040

### INSTRUCTIONS:

**NOTE:** do not tighten any clamps or nuts and bolts until the last step!! Before cutting any pipes it is a good idea to lay out all the included pipes along side the vehicle and get a good idea of how the pipes will hang on the vehicle. Please read the instructions fully and thoroughly before you begin.

- 1) Remove the old exhaust system at the inlet of the muffler, leaving only the y-pipe, converter, and the extension pipe on the truck. **NOTE:** you will need to re-use the extension pipe after the converter to the muffler. The y-pipe will replace the muffler in the same location.
- 2) Install the y-pipe to the original extension pipe using a 3" clamp. Install the 3" hanger clamp to the y-pipe and connect the hanger to the o.e. rubber mount above the y-pipe.
- 3) Install the right tail pipe (it has 5 bends) making sure that you have at least 1/2" of clearance from the shock. Install the 2-1/4" hanger clamp to the o.e. rubber mount behind the rear axle and above the right tail pipe, and connect to the right tail pipe. Locate a hole in the frame (if one is not present, you will need to drill a hole) near the end of the y-pipe and front of the right tail pipe, and using a fender washer, 5/16" x 1" bolt, nut, and lock washer, mount a BR91930 swinger hanger to the frame. The hanger can be adjusted up or down for clearance. Use a 2-1/4" clamp to connect the right tail pipe and the hanger, but do not tighten at this time. **NOTE:** you may want to trim the right (and later the left) tail pipe to your desired length.
- 4) Mark where you want to cut the right tail pipe by holding up a tip next to the tail pipe. Trim the tail pipe to length. Install the muffler tip onto the right tail pipe. Use a 2-1/4" clamp to secure the tip to the tail pipe and hanger just installed.
- 5) Install the left tail pipe (5 bends) to the y-pipe using a 2-1/4" clamp, making sure that you have clearance between the rear brake line (bend bracket to the front if necessary), shock, and spare tire. **NOTE:** on some vehicles, it may be necessary to trim from, or remove all together, the o.e. muffler heat shield for clearance of the left tail pipe--do so now if necessary. You should end up with a 1/2" of clearance from the shock and the tire. Again, you may want to trim the pipe to length. **NOTE:** the tail pipe crosses over the top and behind the rear differential.
- 6) Locate the mounting hole (or drill if one is not present) directly above the rear of the left tail pipe and mount the hanger as in step 3) for the left tail pipe.
- 7) Repeat step 4) for the left tail pipe.
- 8) Tighten all clamps, nuts, and bolts. Check for leaks and for clearance of all brake and fuel lines, and for clearance of all chassis and frame components. We recommend tack welding the joints (not necessary though).

**BUILD SHEET FOR: DEEP TONE DUALS KITS 409 s/s  
PART # 1407040**

- \_\_\_\_\_ 2) muffler tips— all stainless steel angle --#8439518
- \_\_\_\_\_ 1) stainless steel right tail pipe--#1407042
- \_\_\_\_\_ 1) stainless steel y-pipe--#0430032
- \_\_\_\_\_ 1) stainless steel left tail pipe--#1407041
- \_\_\_\_\_ 1) hardware kit

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_

**BUILD SHEET FOR: DEEP TONE DUALS KITS 409 s/s  
PART # 1407040**

- \_\_\_\_\_ 2) muffler tips— all stainless steel angle --#8439518
- \_\_\_\_\_ 1) stainless steel right tail pipe--#1407042
- \_\_\_\_\_ 1) stainless steel y-pipe--#0430032
- \_\_\_\_\_ 1) stainless steel left tail pipe--#1407041
- \_\_\_\_\_ 1) hardware kit

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_