



409S Stainless Steel

Installation Instructions

817174

1955-57 CHEVROLET

V8 ENGINE

Does NOT fit convertibles or wagons.

3/12/2020

Our 1955-1957 Chevy kit is a compilation of many years of development. These cars were built over 50 years ago, in six different assembly plants, and on two different chassis. We have done everything in our power to ensure that this kit fits your vehicle. If you have any fitment issues please contact our tech service line (bottom of page).

Removal:

- 1) Raise the vehicle up on a hoist or rack to working height and support securely with jack stands.
- 2) Remove existing system from the header collector or manifold down pipes back.
- 3) The rear seat of the vehicle will have to be removed in order to install the hangers. (*Described in Step 2 of Installation.*)

Installation:

- 1) Before installing anything, prep the clamps supplied in the hardware kit by removing the nuts, and applying a thick lubricant such as white grease or anti-seize to the threads.
- 2) Remove the back seat and set aside. Look on the underside of the vehicle on the back side of the rear upper seat pan. On both sides you will see two ribs. For the left side place **#229HA** in the middle of the ribs and slide towards the outer rib closest to the frame of the vehicle and measure from the seam down (*see diagram 1.*). Make a mark for your first hole 2 1/4" down and then make a mark for your second hole 5" down. Re-check the marks. Center punch both marks and drill them out to a 3/8" hole (*see diagram 1.*). For the right side place **#230HA** in the middle of the ribs and slide towards the outer rib closest to the frame of the vehicle. Measure and mark your holes to be drilled repeating the left side.
- 3) Install the supplied stud plates **#244HA** from the inside of the vehicle into the holes you have just drilled. Take hanger assembly **#229HA** for the left side, and hanger assembly **#230HA** for the right side and place them over the two bolts protruding through the floor. Secure the hangers to the body using the 3/8" nuts and lock washers provided. (*Note: Once mounted, each hanger will face the outside of the vehicle. See diagram 1.*)
- 4) Slide the supplied rubber hangers **#HA168** onto the hanger rods installed in Step 2. Place clamp hanger **#418HA** for the left side and **#419HA** for the right side into the bottom hole of the rubber hangers. Both clamp hangers will face the inside of the vehicle (*see diagram 2*).

- 5) On the outside of the frame, at the rear of the vehicle, there is a hole punched on either side. Using the supplied **#HA572** hangers for the right and left side, the supplied well nuts and the 5/16" x 1" bolts and lock washers, mount them to the frame with the rubber section facing down and in under the frame. Use the upper hole of the hangers. For extra support when bolting the hangers to the frame, center punch the lower hole on the hanger and drill a 1/4" hole. Use the supplied 5/16" x 3/4" thread cutting bolts to secure into place (*see diagram 3*). (*Note: Use the supplied 5/16" flat washers between the frame and the rubber hanger on the lower hole for support.*)
- 6) If your vehicle does not have existing holes in the rear of the frame you will need to locate and drill these holes. Measure from the rear of the frame rail towards the front of the vehicle 19-5/16" and make a mark, this is your upper hanger hole location. Center punch and drill two 1/4" holes on each side and mount the supplied **#HA572** frame hangers with supplied 5/16" x 3/4" thread cutting bolts. Rubber section will be down and under the frame. Repeat for both sides of the vehicle. (*see diagram 3*.)
- 7) After mounting the rear hangers in place, place the right tailpipe **#16527S** over the rear axle so that the rear of the tailpipe exits between the fuel tank and the leaf spring. Slide the tailpipe hanger through the rubber hanger attached to the frame. Repeat on the left side using tailpipe **#16528S**.
- 8) Install the left muffler by placing the outlet of the muffler into the clamp hanger **#418HA**. Rotate the muffler to get it level and support with a stand. Tighten the clamp enough to hold the muffler in place, but still allow for adjustment.
- 9) Install the right muffler by placing the outlet of the muffler into the clamp of hanger **#419HA**. Rotate the muffler to get it level and support with a stand. Tighten the clamp enough to hold the muffler in place, but still allow for adjustment.
- 10) Slide the front of the right tailpipe **#16527S** through the hanger **#418HA** and into the rear of the muffler. Repeat for the left side using tailpipe **#16528S** and hanger **#419HA**.
- 11) Adjust the rear of the tailpipes so that they are rotated correctly and are centered between the gas tank and the leaf springs. Repeat this step for both sides of the vehicle.
- 12) Place a clamp onto both of the muffler inlets, then install the H-pipe assembly **#16526S** by placing the rear of the assembly into the inlets of both mufflers and centering it in the drive line cavity. Support the front of the assembly with a stand making sure that the muffler and H-pipe assembly are level. Once in place, check the hangers at the rear of each muffler to see if they are hanging straight down. Adjust the H-pipe and the mufflers forward or back as needed to get the correct fit. When the desired fit is achieved, tighten the clamps on each of the muffler inlets enough to hold in place, but still allow for adjustment.
- 13) It will be necessary to adapt from your existing headers or manifold down pipes to the H-pipe assembly installed in Step 12. Due to the many variables in header or manifold downpipe locations, the pieces required to do this will need to be fabricated using the supplied adapter pipes **#86571S**. Some additional miscellaneous tubing may be required.
- 14) Remove temporary support and allow the system to suspend on the hangers.

- 15) Adjust the position of the mufflers and all pipes to provide a satisfactory fit. Maintain a minimum of 3/4" clearance between the new Flowmaster system and the drivetrain and chassis components, while also keeping suspension travel and vibration in mind.
- 16) Use the supplied plastic zip tie to keep the rubber brake line that runs from the frame to the rear end away from the right tailpipe.
- 17) Tighten down all clamped connections securely. After the system is secure, slide the hanger keepers onto the end of all the hanger rods above the mufflers. This will prevent the hangers from slipping out of the rubber mounts. Place the **#ST396** stainless tips onto the back of the tailpipes and adjust to desired location. Tighten clamped connections firmly.
- 18) For a more secure installation, we recommend welding all slip-fit connections.

Diagram 1.

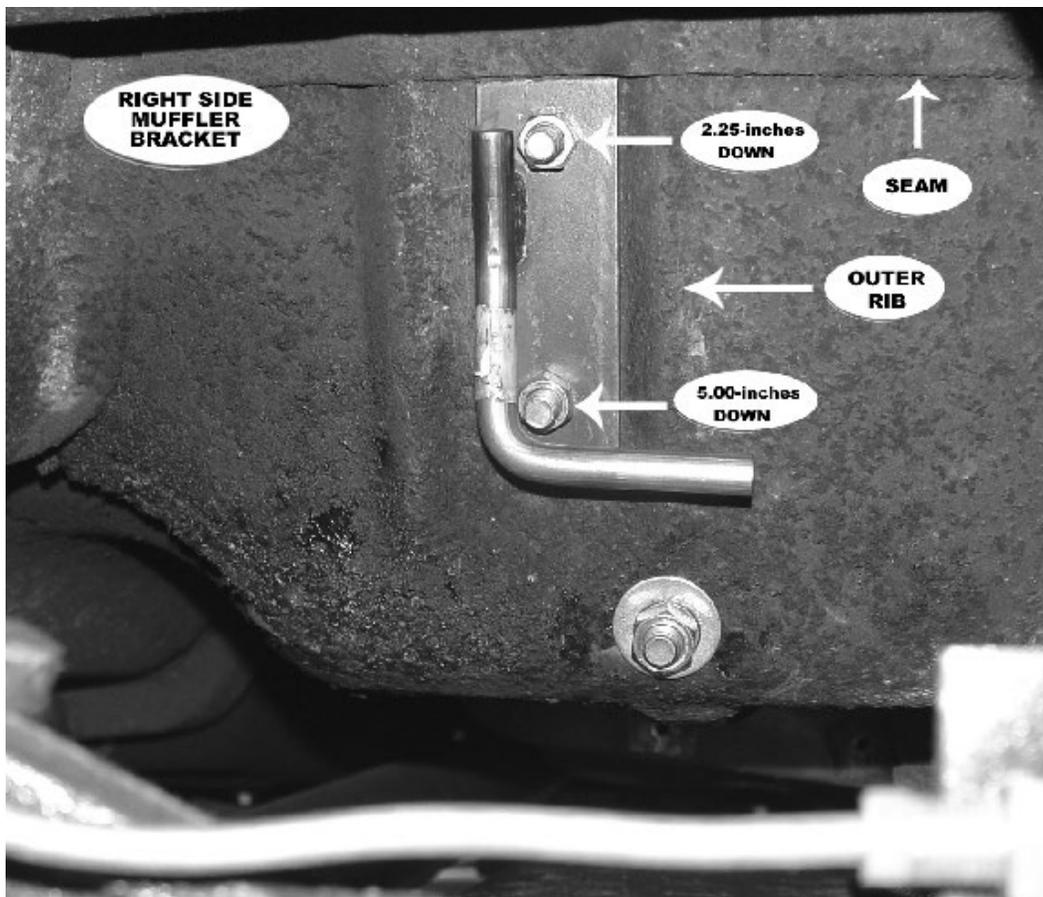


Diagram 2.

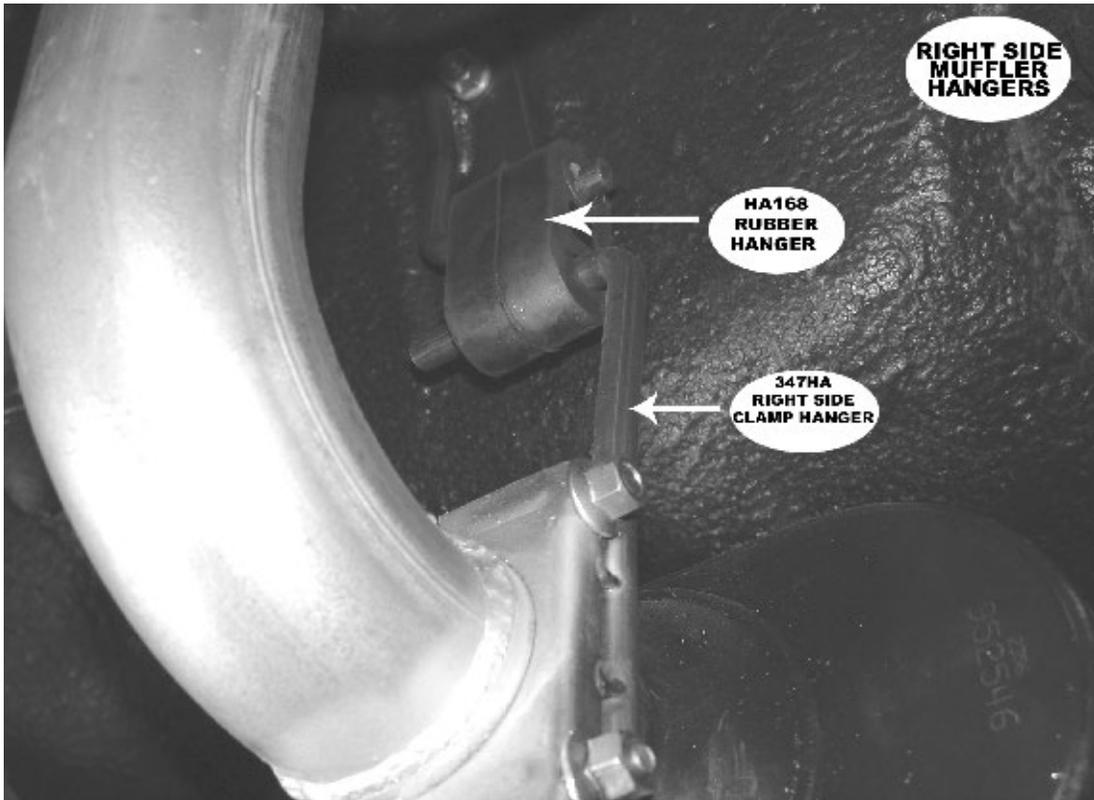
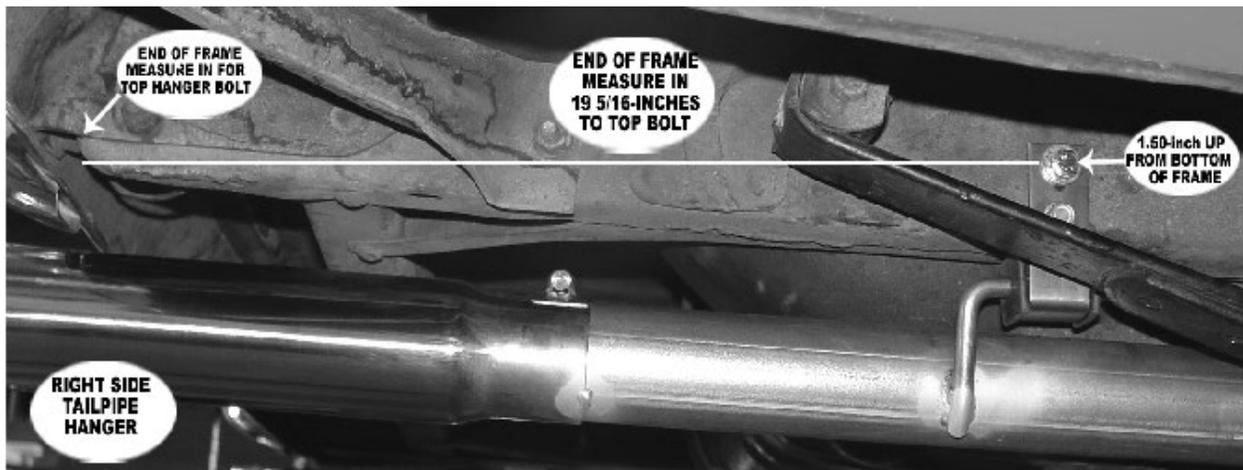


Diagram 3.



PACKING LIST

| <u>Qty</u> | <u>Description</u> | <u>Part #</u> |
|------------|-----------------------------|---------------|
| 4 | Adaptor Pipe | 86571S |
| 1 | H-pipe Assembly | 16526S |
| 2 | Muffler | 852546-Z |
| 1 | Right Tailpipe | 16527S |
| 1 | Left Tailpipe | 16528S |
| 2 | Stainless Tip | ST396 |
| 1 | Parts Kit | PK505 |
| 2 | Backing Plate | 244HA |
| 1 | Top Muffler Hanger, Left | 229HA |
| 1 | Top Muffler Hanger, Right | 230HA |
| 1 | Lower Right Muffler Hanger | 419HA |
| 1 | Lower Left Muffler Hanger | 418HA |
| 2 | Right/Left Tailpipe Hanger | HA572 |
| 1 | Plastic Zip Tie (BLK 15") | HW505 |
| 6 | 2 1/2" Clamp | MC250BS |
| 2 | Rubber Hanger | HA168 |
| 4 | 7/16" Hanger Keeper | HW502 |
| 2 | Wellnut | HW108 |
| 2 | 5/16" x 1" Bolt | HW204 |
| 4 | 3/8" Nut | HW103 |
| 4 | 3/8" Lock Washer | HW309 |
| 2 | 5/16" Lock Washer | HW308 |
| 2 | 5/16" Flat Washer | HW302 |
| 4 | 5/16"x 3/4" Cut Thread Bolt | HW225 |



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