



**Installation Instructions**  
**817937**  
**1963-66 GM TRUCKS WITH NON**  
**X-FRAME**  
**4.6L, 5.0L, 5.3L, 5.7L ENGINE**  
**2WD & 115"/127" Wheelbases**

This kit fits short & long beds without torsion bar front suspension.

**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.
8	86639S	Right Muffler Exit	1
9	86640S	Left Exit Turndown	1
10	86641S	Right Exit Turndown	1
11	86642S	Left Exit Side	1
12	86643S	Right Exit Side	1
13	86644S	Right/Left Rear Exit	2
N/A	PK1033	Hardware Package includes:	1
14	MC250BS	2½" Stainless Band Clamp	10
15	MC200BS	3" Stainless Band Clamp	1
16	HA572	Universal Bracket	4
17	HW208	⅜"-16 x 1 Screw	8
18	HW103	⅜" Nut	8
19	HW303	⅜" Flat Washer	8
20	HW309	⅜" Lock Washer	8

ITM #	PART #	DESCRIPTION	QTY.
1	86633S	R/L Header Adapter	2
2	86634S	Left H-pipe	1
3	86635S	Right H-pipe	1
4	86636S	Left Muffler Inlet	1
5	86637S	Right Muffler Inlet	1
6	842548-Z	Muffler	2
7	86638S	Left Muffler Exit	1

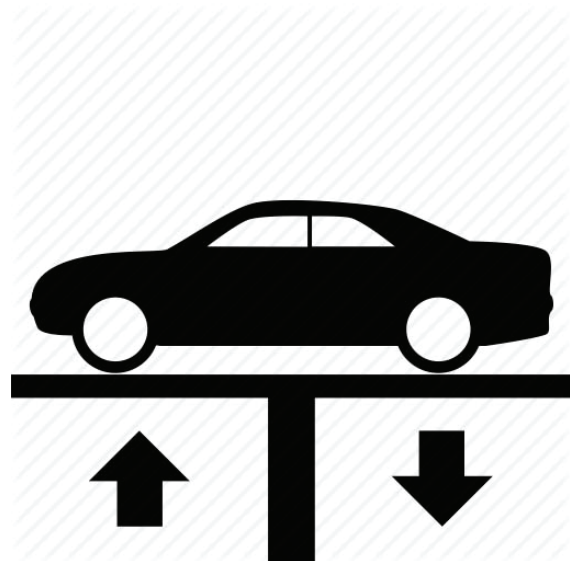
**PREPARE VEHICLE FOR KIT INSTALLATION:**

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. Remove existing system from header collector or manifold down pipes rearward.

### INSTALL FLOWMASTER EXHAUST SYSTEM:

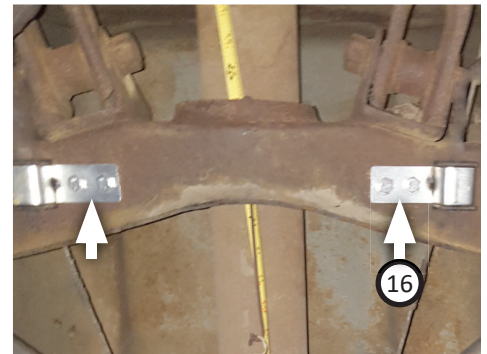
4. Remove nuts from stock and Flowmaster clamps, apply anti-seize compound to bolts and re-install nuts.

**NOTE:** The image in this step is intended for illustrative purposes only and may or may not accurately reflect components included in your kit.



5. Mark center cross member inboard 8¾" from inside frame rail. Now use this mark and **bracket (16)** to create remaining inboard mark. Drill marked (x2) holes.

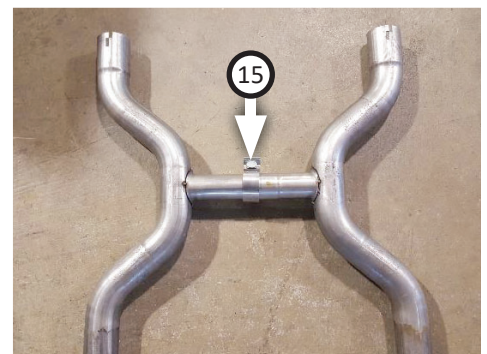
6. Mount (x2) **brackets (16)** oriented as shown with (x2 per bracket) **screws (17)**, **flat washers (19)**, **lock washers (20)** and **nuts (18)**.



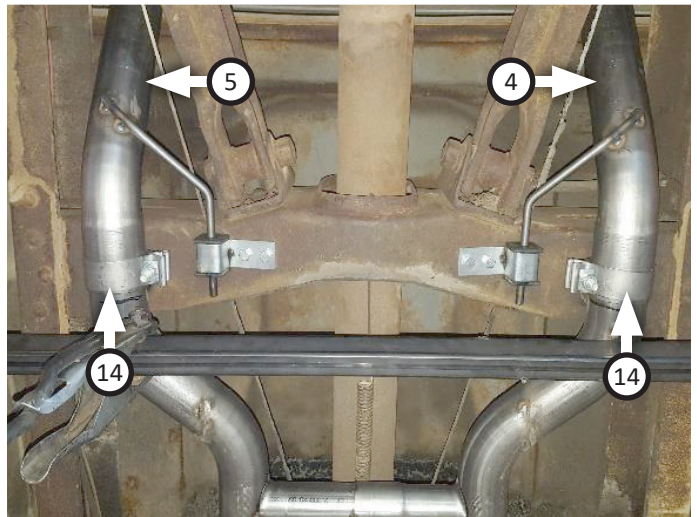
**NOTE:** Step 7 applies only to short bed model vehicles.

7. For short bed model vehicles, trim 12" from rear section of **right (3)** and **left (2)** H-pipes.

8. Connect right and left headpipes with **clamp (15)** but leave it loose.



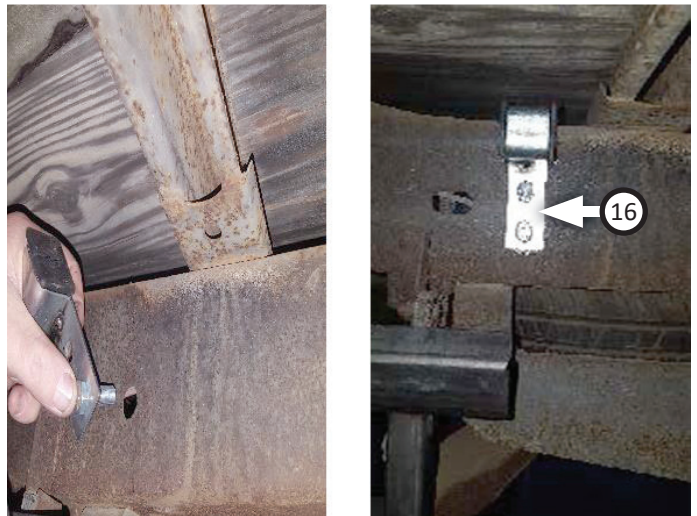
9. Place (x2) **clamps (14)** onto **left (4)** and **right (5)** muffler inlets then connect them to H-pipe assembly.
10. Place assembly into position below center cross member then connect wire hangers to brackets. Tighten clamps just enough to allow for later adjustment.



**NOTE:** If factory holes are not present, skip this step, the hanger will be installed later.

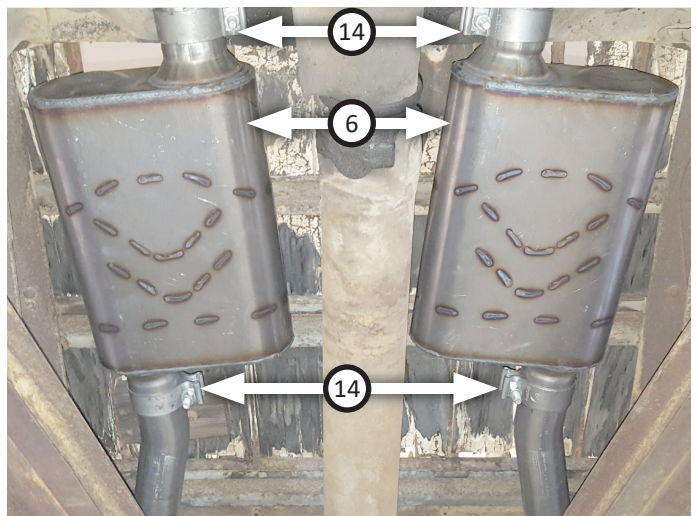
11. At vehicle rear should be an oval slot on side of frame. Place bracket in lower hole with isolator facing up. Square up isolator and drill upper hole then mount **bracket (16)** with (x2 ea.) **screws (17)**, **flat washers (19)**, **lock washers (20)** and **nuts (18)**.

**NOTE:** Complete step for both driver and passenger sides.



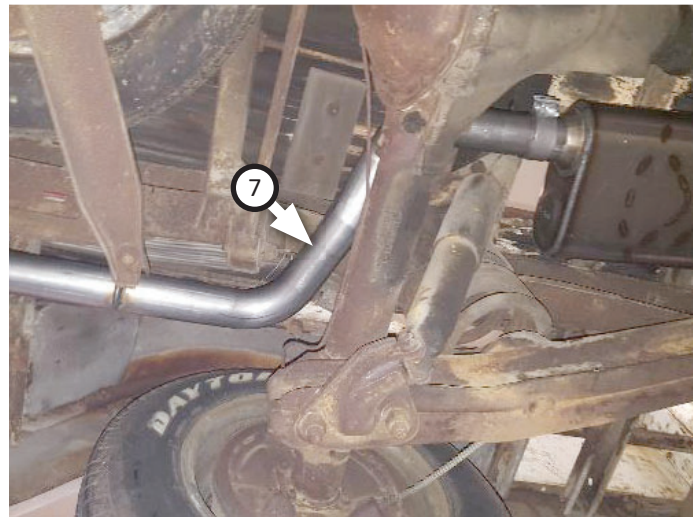
12. Place (x2) **clamps (14)** onto **muffler (6)** then connect it to muffler inlet pipe. Tighten front clamp just enough to allow for adjustment.

**NOTE:** Complete step for both driver and passenger sides.



**NOTE:** For short and long bed vehicle models, trim tailpipes depending on exit pipe placement and preference.

13. Route **left (7)** and **right (8)** muffler exit over axle and connect them to mufflers. If possible, insert wire hangers into brackets. Tighten clamps just enough to allow for adjustment.



**NOTE:** If you skipped step 11, complete this step. Otherwise, skip to step 15.

14. Slide bracket onto muffler exit pipe wire hanger. Adjust pipe as needed to run parallel to frame, then mark and drill mount holes (x2) using bracket as a reference. Mount **bracket (16)** with (x2 ea.) **screws (17)**, **flat washers (19)**, **lock washers (20)** and **nuts (18)**.

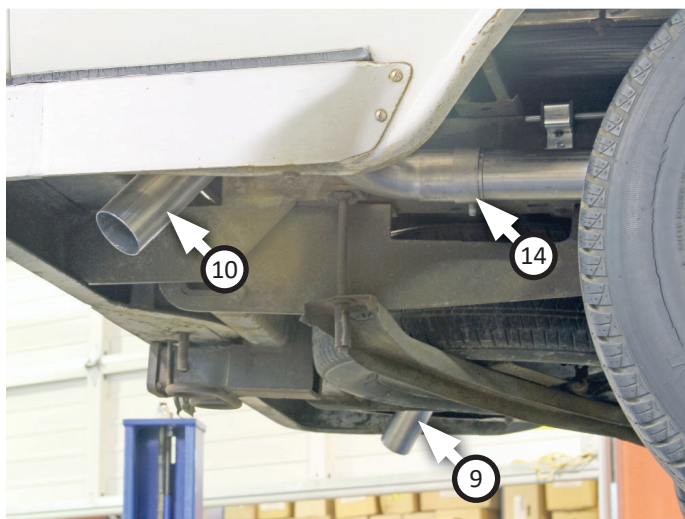
**NOTE:** Complete step for both driver and passenger sides.



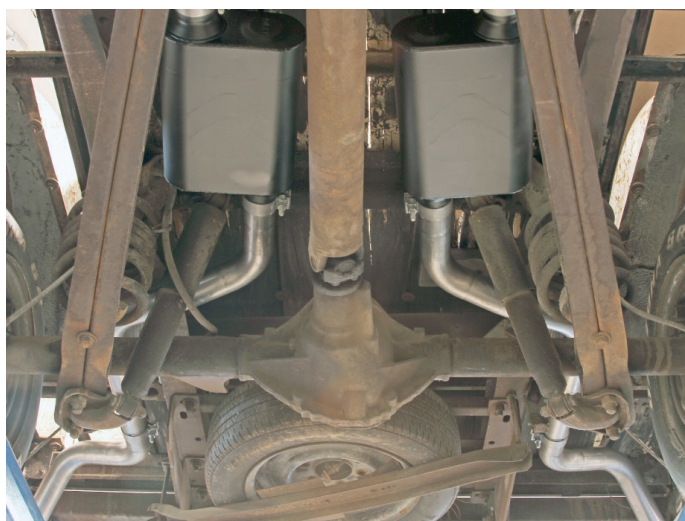
**NOTE:** This kit includes **turndown (9-10)**, **side (11-12)** and **rear (13)** exit pipes. For this installation, we will use the turndown pipes.



15. Place **clamp (14)** onto **left (9)** and **right (10)** exit **turndown** pipes then connect them to muffler exit. Tighten clamps just enough to allow for adjustment.



16. 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 (x2) **header adapters (1)**. Additional fabrication may be necessary to connect exhaust.
17. Adjust exhaust components for fit; maintaining  $\frac{1}{2}$ " clearance and compensating for suspension, travel and vibration.
18. 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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