



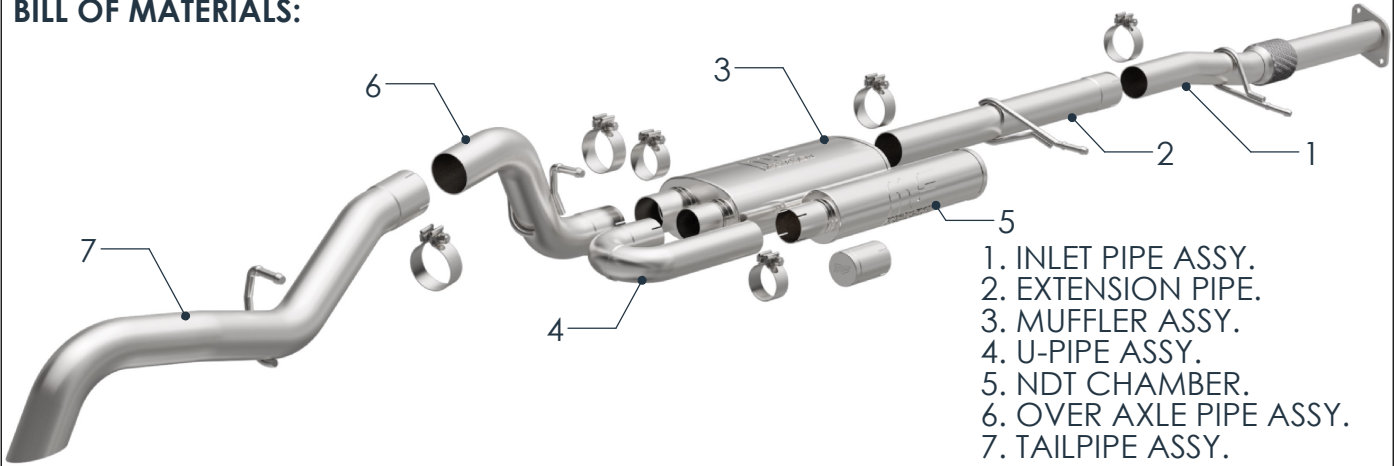
# INSTALLATION INSTRUCTIONS



OVERLAND CAT-BACK

PART NO. 19648

## BILL OF MATERIALS:



WEAR SAFETY GLASSES



READ INSTRUCTIONS THOROUGHLY BEFORE INSTALLING PRODUCT



SPRAY LUBRICANT

To ease removal of existing exhaust components (especially on older vehicles) spray penetrating lubricant on all fasteners and hangers/insulators that will be loosened or removed and let soak before disassembly.

## HARDWARE KIT:

1. [2] 2.50" Torca Clamp
2. [4] 3.00" Torca Clamp
3. [1] MF Block Off Pipe.

## MINIMUM REQUIRED TOOLS:



13mm



Hanger Tool (Or Pry Bar)

## MAGNAFLOW RECOMMENDS PROFESSIONAL INSTALLATION ON ALL THEIR PRODUCTS



**WARNING:** When working on, under, or around any vehicle exercise caution. Please allow the vehicle's exhaust system to cool before removal, as exhaust system temperatures may cause severe burns. If working without a lift always consult vehicle manual for correct lifting specifications. Always wear safety glasses and ensure a safe work area. Serious injury or death could occur if safety measures are not followed.

**ATTENTION:** Always install any supplied band or U-bolt clamps to the proper torque specifications of 40-45 ft-lb for band clamps and 30-35 ft-lb for U-bolt clamps. Over tightening will result in the clamps breaking and will NOT be warranted by MagnaFlow.

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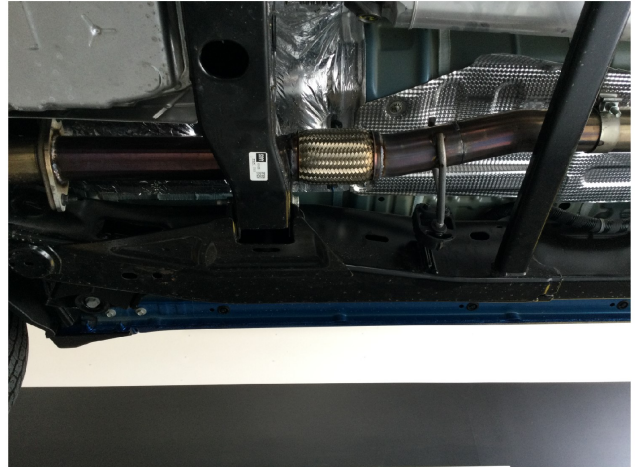
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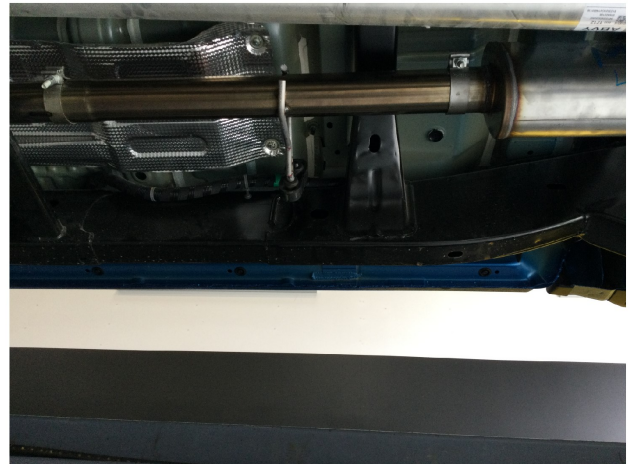
**Step 1:** To remove the OEM exhaust system, unfasten the hardware at the inlet flange (Retain the fasteners they will be used to install the new system).






**Step 2:** Working front to rear, with the exhaust system supported, disengage all welded hangers from the rubber insulators and remove. (Retain the rubber insulators as they will be needed to mount the new MagnaFlow system.)



**Step 3:** Begin installing the new system by attaching the Inlet Pipe assembly to the flanged outlet using the OE hardware.



**Step 4:** Next, attach the Oval Muffler to the Extension Pipe using the supplied 3.00" clamp. This exhaust system is configured to allow the user to tune the sound. For a more moderate exhaust sound install the U-pipe Assy and the 4.00" NDT Chamber (as shown) using the supplied 2.50" clamps. For a more aggressive sound see configuration chart below.

	<b>MODERATE TONE:</b> U-PIPE WITH NDT CHAMBER
	<b>AGGRESSIVE TONE:</b> U-PIPE WITH PIPE CAP
	<b>MOST AGGRESSIVE TONE:</b> ONLY PIPE CAP

## INSTALLATION INSTRUCTIONS



**Step 5:** When using the NDT chamber, mount it above the muffler as shown. Be sure to leave at least 1/2" of clearance between both components.



**Step 6:** Install the Over Axle Pipe to the Muffler outlet using the supplied clamp. Engage both hangers to the OE rubber insulators.



**Step 7:** Finish by Installing the Tail Pipe to the Over Axle Pipe outlet using the supplied clamp. Engage the hanger to the OE rubber insulator. Clearances are very tight, make sure there is adequate room after tightening.



**Step 8:** Once a final position has been chosen for the new exhaust system, evenly tighten all clamps from front to rear using the torque specifications on page one of the instructions. Inspect all fasteners after 25-50 miles of operation and re-tighten if necessary.