



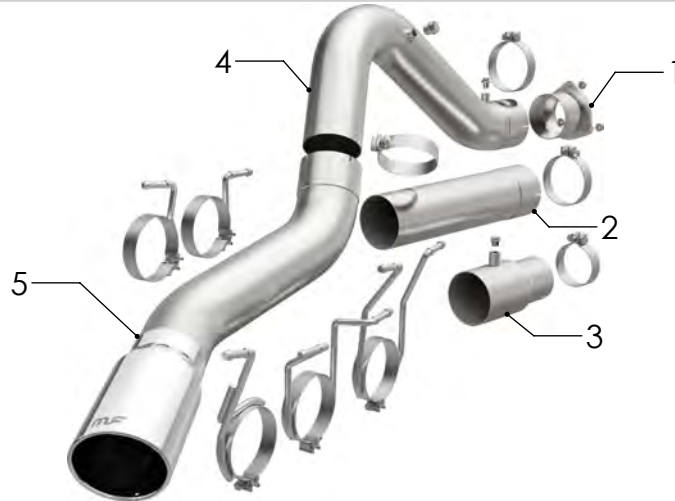
INSTALLATION INSTRUCTIONS



DURAMAX 2500/3500 6.6L

PART NO. 19694

BILL OF MATERIALS:



- 1. INLET NIPPLE
- 2. EXTENSION PIPE
- 3. 4.00"-5.00" NIPPLE
- 4. OVER AXLE PIPE ASSY
- 5. TAIL PIPE ASSY

SHOP SUPPLIES:

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.[1] 4.00" Band Clamp
 - 2.[3] 5.00" Band Clamp
 - 3.[1] Band Clamp Dual Hanger Short Front
 - 4.[1] Band Clamp Dual Hanger Long Front
 - 5.[1] Band Clamp Single Hanger Front
 - 6.[1] Band Clamp Hanger Rear No Bend
 - 7.[1] Band Clamp Hanger Rear w/Bend
 - 8.[1] Hex Plug M16
 - 9.[1] Hex Plug M14
 - 10.[1] Hex Plug M20
 - 11.[3] Hex Bolt 7/16
 - 12.[3] Hex Nut 7/16
- SEE PAGE 3 FOR VISUAL IDENTIFICATION**



WEAR SAFETY GLASSES



READ INSTRUCTIONS THOROUGHLY BEFORE INSTALLING PRODUCT



MINIMUM REQUIRED TOOLS:



SAWZALL, SIMILAR CUTTING TOOL



13mm, 15 mm



Hanger Tool (Or Pry Bar)

MAGNAFLOW RECOMMENDS PROFESSIONAL INSTALLATION ON ALL THEIR PRODUCTS

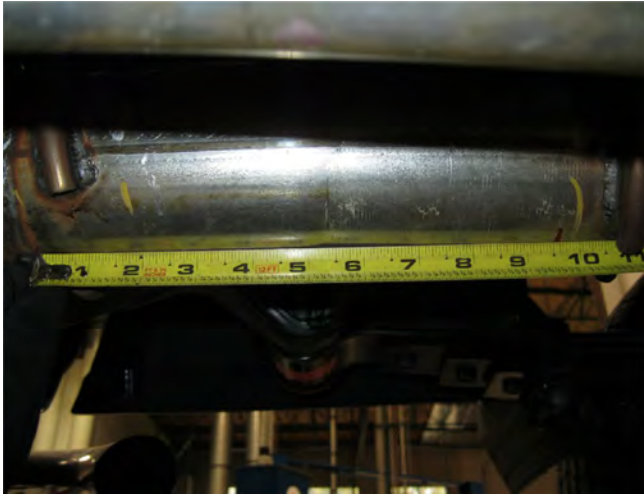


WARNING: When working on, under, or around any vehicle exercise caution. Please allow the vehicle's exhaust system to cool before removal, as exhaust system temperatures may cause severe burns. If working without a lift always consult vehicle manual for correct lifting specifications. Always wear safety 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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INSTALLATION INSTRUCTIONS



Step 1. 2014-2024 Installation: To begin the removal of the OEM system check to see if it has sensor(s) connected to it, if so, remove the sensor(s) and hang it/them out of the way. Next, you will need to cut the exhaust pipe behind the DPF measuring from the rear weld junction to the rear of the vehicle. See **Table 1.** for where to cut for your vehicle. Once cut, you can then disengage the welded hangers from the rubber insulators, working rearward finish removing the system. Do not damage or discard the rubber insulators, as they will be reused to mount the new system.

2007.5-2013 Installation: To remove the OEM system, you will need to cut the tailpipe just behind the OEM muffler. You can then unbolt the muffler at the 3-bolt flange, and disengage the welded tailpipe hangers from the rubber insulators. Do not damage or discard the OEM gasket, fasteners, or rubber insulators, as they will be reused to mount the new system.

**-IMPORTANT-
SEE SHEET 3 OF 3 FOR
CUT AND HANGER
TABLES**



Step 2. 2014-2024 Installation: Begin installation of the Magnaflow system by clamping the 4.00"-5.00" Adaptor Nipple to the newly cut outlet of the DPF using the supplied 4.00" clamp. If your vehicle has any sensor(s) re-install at the appropriate locations. Any boss that doesn't get a sensor installed into it must be closed off with a provided screw in plug, and fitting the hangers in the rubber insulators (leave all clamps loose for final adjustment of the complete system). Next attach the Adaptor Nipple using the supplied 5.00" clamps and fitting the welded hanger clamp into the rubber insulators (leave all clamps loose for final adjustment of the complete system).

2007.5-2013 Installation: Install the new Inlet Nipple using the OEM gasket and the supplied fastener, but leave all clamps and fasteners loose for final adjustment of the complete system. Install the extension pipe using the supplied 5.00" clamps and by fitting the specified welded hanger clamp into the rubber insulator.

INSTALLATION INSTRUCTIONS



Step 3. Complete the installation by sliding the specified Rear Hanger Clamp Assy onto the Tailpipe Assy and attaching the Tailpipe Assy to the Over Axle Pipe. Engage the hangers into OE rubber insulators.



Step 4. Once a final position has been chosen for the new exhaust system, evenly tighten all clamps and fasteners, 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.

TABLE 1.

Vehicle Configuration	2014-2016	2017-2019	'20 - '24
Crew Cab/Long Bed	26.50"	16.25"	31.00"
Crew Cab/Standard Bed	13.25"	3.00"	4.50"
Double Cab/Long Bed	18.40"	8.15"	-
Double Cab/Standard Bed	4.50"	N/A	-

TABLE 2.

Item	Hanger	2007-2013	2014-2019	'20 - '24
1	4.00" Band Clamp	X	X	X
2	5.00" Band Clamp	X	X	X
3	Band Clamp Dual Hanger Short Front			X
4	Band Clamp Dual Hanger Long Front		X	
5	Band Clamp Single Hanger Front	X		
6	Band Clamp Hanger Rear No Bend	X		
7	Band Clamp Hanger Rear w/Bend		X	X

