

2021+ FORD F-150 5.0L

BUMPER EXIT CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works catback exhaust system for your 2021+ Ford F-150 5.0L. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



2021+ Ford F-150
(FT21CBYUBL, FT21CBYUBR,
FT21CBUBR, FT21CBUBL)

a. Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

b. Your exhaust system can be installed by a weekend warrior but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a level hard surface. Jack stands are required for safety reasons.

c. You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.

d. When installing your catback system, make certain that the hangers at the end of the exhaust have at least $\frac{3}{4}$ " of clearance to the bumper. The exhaust will grow over $\frac{1}{2}$ " in length and can possibly damage the bumper. If the end of the hangers are too close to the bumper, then you must make sure that you have everything pushed forward onto the slip fit joints more fully.

SW102
V001 - 5.13.23

DISASSEMBLY

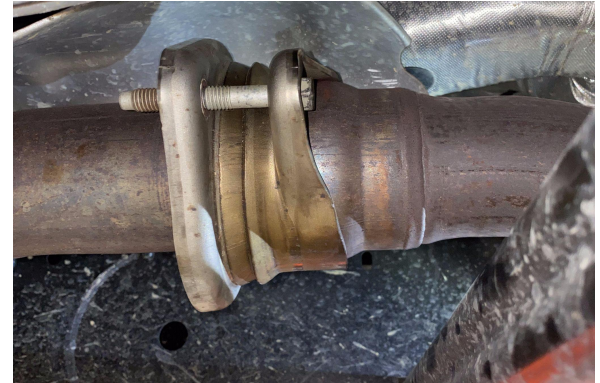
1. Disconnect the battery.
2. Raise and support the vehicle.
3. Unbolt (2) bolts at factory connection point after catalytic converters
4. Unhook exhaust from all hanger locations and remove exhaust from vehicle. If you already have a factory bumper exit remove the existing hanger brackets at the bumper. (x2 24mm nut per side)

ASSEMBLY

5. For factory connect systems only, install to OEM connection using supplied 3/8" bolts washers, and nuts. The straight tube may need trimming depending on your cab/bed configuration. See the chart to the right. Measure from the outlet end, mark tube, and cut. Deburr this tube and install using a 3" clamp. Install Y-pipe using a 3" clamp.
6. For performance connect systems only, install left and right inlet pipes to the X-pipe. The straight tubes may need trimming depending on your cab/bed configuration. See the chart to the right. Measure each from the outlet end, mark tube, and cut. Deburr the tubes and install using (2) 3" clamps.
7. Install muffler inlets using the front hanger assembly and (2) 3" clamps.
8. Install mufflers using (2) 3" clamps.

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Detail 3: OEM flanged connection point

Cab Configuration	Bed Length	Wheelbase	Cut Length
Regular	6.5'	122.8	41.3 (discard)
	8'	141.5	22.6
SuperCab	6.5'	145.4	18.7
	8'	164.1	0.0
SuperCrew	5.5'	145.4	18.7
	6.5'	157.2	6.9

Detail 5 & 6: Straight inlet pipe cut chart



Detail 7: Orientation of front hanger assembly

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9. Install the tailpipe hangers onto tailpipe inlets and install tailpipe inlets to mufflers using (2) 3" clamps.
10. Install the tailpipe outlets using (2) 3" clamps
11. Install the tip hanger brackets using the factory hardware. Leave them loose so the height can be adjusted once the tips are on.
12. Slide the tip hanger clamps over the end of the tail and attach it to the hanger bracket using the black grommets.
13. Install the tips onto the tailpipe and tighten the hanger clamp to secure them in place.
14. Once your tips are installed, adjust the hanger bracket installed in step 11 to the height of your liking and tighten them.
15. Adjust and tighten the system from front to back. Keep the mufflers level from side to side as the tubes are adjusted.
16. Be sure to have adequate clearance around all wires, hoses and lines. If anything is in contact with the exhaust system, it will melt. Make sure to have at least ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.
17. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the truck for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.



Detail 9: Front tailpipe hanger



Detail 13: Tips and hangers installed correctly