

# 2021+ FORD F150 5.0L

## CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works catback exhaust system for your 2021+ Ford F150 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+ F150 5.0L**  
**(FT21CBFT)**

**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 nearby components. 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 nearby components, then you must make sure that you have everything pushed forward onto the slip fit joints more fully.

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## DISASSEMBLY

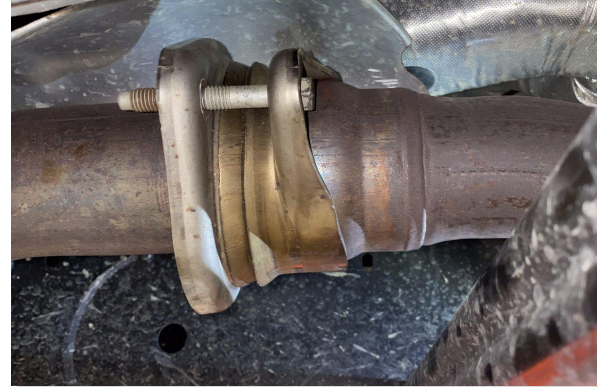
1. Disconnect the battery.
2. Raise and support the vehicle. It may help to have the vehicle supported by the frame, so that the rear suspension is free hanging.
3. Use a 13mm socket to remove (2) bolts from the factory 2-bolt flange after the converters.
4. Remove the exhaust from the hangers and remove from vehicle.

## ASSEMBLY

5. Use the chart to the right to determine your wheelbase and cut length. Measure from the side without the flare to the distance shown. Mark the tube and cut to remove the length shown. Deburr the cut end.
6. Tighten the connection point using the supplied (2) M10 x 1.5 x 55 long bolts, (4) washers, and (2) lock nuts.
7. Install the muffler using (1) 3" clamp. Keep the muffler loose enough to rotate when the tails are installed.
8. Install (2) 10mm speed nuts in frame. Use the existing holes above the leaf spring bracket in front of the passenger rear tire.
9. Install hanger to the speed nuts using (2) M10 x 1.5 x 35mm bolts and (2) lock washers. Assemble grommet (8180) onto the hanger.

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Detail 3: OEM catback connection point

Cab Configuration	Bed Length	Wheelbase	Cut Length
Regular	6.5'	122.8	41.3
	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: Inlet pipe cut chart



Detail 9: Frame hanger and grommet installed.

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**10.** Install the tailpipes using (2) 3" clamps and installing to the grommets at both the inside and outside of the frame. Make sure to put the hanger for the rear pipe above the hanger for the front pipe. Bolt together using (1) M10 x 1.5 x 35 long bolt, (2) washers, and (1) lock nut provided.

**11.** Install tips using (2) 3" clamps. The tips should be rolled so that the slash cut aligns with the bed.

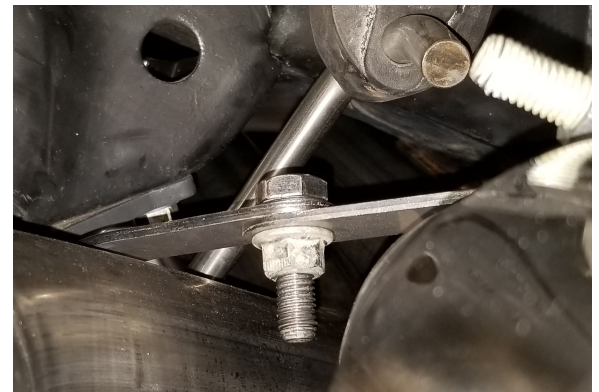
**12.** Adjust and tighten the system from front to back. Keep the mufflers level from side to side as the tubes are adjusted.

**13.** 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 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

**14.** 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 10a: Tailpipes installed to muffler.*



*Detail 10b: Rear pipe hanger above front pipe hanger*



*Detail 11: Tips installed.*

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