



2011+ FORD F-150 RAPTOR 6.2L SUPERCREW (LIGHTNING STYLE SIDE EXIT) CATBACK EXHAUST INSTALLATION INSTRUCTIONS

Thanks for purchasing the Stainless Works Catback Exhaust for your 2011+ Ford F-150 Raptor 6.2L Truck. We have gone to great lengths to make sure that our exhaust systems fit and sound great. Please follow these steps to ensure that your installation goes as planned.

1. Stainless Works recommends the use of Hi-Temp RTV silicon gasket maker as an option to or in conjunction with the use of factory gaskets. The recommended RTV is Valco Sensor Safe Aluminum All in One or Permatex Sensor-Safe P/N 101BR or 27BR, available at NAPA and other retailers.
2. Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.
3. 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 and jack stands are required for safety reasons.
4. Unbolt the factory exhaust at the 2 bolt flange - (2) 10 mm bolts.
5. Remove old exhaust from all hangers then remove from the truck.

INSTALLING THE CATBACK TO MANIFOLDS ONLY

6. Loosen the clamp at the front section of the old exhaust. Disconnect and remove this short section.
7. Mark this pipe section to 7-1/2" from the flanged end for cutting. See picture below.



8. Cut pipe at the above mark with a hacksaw and remove the sharp edges.
9. Reinstall the flanged section cut above, using the (2) 10 mm bolts removed earlier.
10. Install Stainless Works Y-pipe into the new muffler using (2) 3" clamps. Do not fully tighten.
11. Install Y-pipe with muffler to the above factory pipe using (1) 3" clamp. Do not fully tighten.

INSTALLING THE CATBACK TO HEADERS ONLY

12. For installing to Stainless Works headers only - install 30" long muffler (with internal X-pipe) to header lead pipes using (2) 3" clamps. Do not fully tighten.

INSTALLING THE CATBACK TO EITHER HEADERS OR TO MANIFOLDS

13. Install tails into muffler and into OEM rubber hanger using (2) 3" clamps.
14. Adjust all pipes for fitment and tighten clamps. To ensure no movement during extreme driving conditions, you can tack weld each joint together after tightening the clamps. When doing this, you must first disconnect the battery!
15. 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.
16. Lower the vehicle.
17. Reconnect the battery.
18. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the car 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.