



409S, Stainless Steel

Installation Instructions

81108

2015-23 FORD
MUSTANG 2.3L
ECOBOOST ENGINE
Coupe & Convertible

NOTE: The steps on pages 1 and 2 are for installing #81108 Y-Pipe assembly with a Flowmaster Axle-back system.

Removal:

Rev. 12/3/2025

1) Raise the vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, raise the vehicle and support securely with jack stands. To ease the removal of the stock system, spray a penetrating lubricant onto the bolts of the two clamp connections just forward of the center resonator as well as the rubber hangers just behind the rear differential and at the rear of the vehicle.



2) Place a stand under the center resonator just forward of the axle-back muffler assemblies. Loosen the clamps at the inlets of the Flowmaster or Hurst axle-back mufflers.



3) Using a 13mm wrench, loosen the two hangers just behind the rear differential from the cross member and the two hanger mounts at the rear of the vehicle from the frame. Slide the muffler assemblies toward the rear of the vehicle to disengage them from the factory system. Leave them hanging in place for re-assembly onto the Flowmaster Y-pipe assembly.



4) Using a 15mm wrench, loosen the two bolts at the clamp connection in the center of the vehicle. Use a small screwdriver to lift the clip and with the help of an assistant, carefully lower the stands at the rear of the resonator and slide the system toward the rear and off of the front pipe. Lower the resonator from the vehicle. The clamp should remain on the factory front pipe as it will be re-used with the new Flowmaster system.

Installation:



1) Be sure that the factory band clamp from the resonator inlet is in place on the front pipe behind the catalytic converters. Place the Y-pipe assembly **#86320S** up into position behind the factory front pipe and slide into the clamp until it stops. Support the rear of the Y-pipe with a stand and tighten the clamp enough to hold, but still allow for adjustment. The Y-pipe outlet with two bends will be oriented to the drivers' side of the vehicle.

2) Place the inlets of the axle-back muffler assemblies onto the back of the Flowmaster Y-pipe, slide them on approx. 2" and tighten the clamps enough to hold, but still allow for adjustment. See steps 4 and 5 on page 5 for final adjustment steps.

SEE IMPORTANT NOTE ON PAGE 5.

NOTE: The steps on pages 3 and 4 are intended for customers replacing the center resonator of their vehicle and retaining the use of the factory Mustang mufflers. (If you are using the new Flowmaster Y-pipe along with a Flowmaster Axle-back system, refer to pages 1 and 2.)

Removal:

1) Raise the vehicle up on a hoist or rack to working height. If you don't have access to a hoist or rack, raise the vehicle and support securely with jack stands. To ease the removal of the stock system, spray a penetrating lubricant onto the bolts of the two clamp connections just forward of the center resonator.



2) Begin by measuring back 2-1/2" from the beginning of the straight area shown in the photo at left and make a mark on both pipes. Support the exhaust system both in front and behind the area to be cut. Check that the marks are correct, then using a reciprocating saw, cut both pipes at the marks. **Note: Due to the closeness of the pipes to the gas tank, use caution when cutting!** Carefully deburr the end of the muffler inlet pipes where cut with a file or die grinder.



3) Using a 15mm wrench, loosen the two nuts at the clamp connection in the center of the vehicle. Use a small screwdriver to lift the clip and with the help of an assistant, carefully lower the stands at the rear of the resonator and slide the system toward the rear and off of the front pipe. Lower the resonator from the vehicle. The clamp should remain on the factory front pipe as it will be re-used with the new Flowmaster system.

Installation:



1) Slide a supplied **TB810S** adapter pipe onto the end of each outlet of the **86320S** Y-pipe assembly. Place a supplied clamp onto the connections and tighten enough to hold.



2) Be sure that the factory band clamp from the resonator inlet is in place on the front pipe behind the catalytic converters. Place the Y-pipe assembly **#86320S** up into position behind the factory front pipe and slide into the clamp until it stops. Support the rear of the Y-pipe with a stand and tighten the clamp enough to hold, but still allow for adjustment. The Y-pipe outlet with two bends will be oriented to the drivers' side of the vehicle.

3) Place a supplied clamp over the inlet pipe of the passenger side stock muffler. Slide the muffler toward the rear of the vehicle and place the inlet into the adapter at the back of the Y-Pipe assembly. Slide the clamp onto the slip connection and tighten enough to hold in place. Repeat this step on the drivers' side of the vehicle.

4) Adjust and level the Y-Pipe and muffler assemblies to provide a satisfactory fit. A minimum of 1/2" clearance around all parts of the system must be maintained; while keeping suspension travel and vibration in mind. After adjustments have been made, you may now securely tighten the clamped connections.

SEE IMPORTANT NOTE ON PAGE 5.

NOTE: For a more secure installation, we highly recommend placing a minimum 1" weld on either side of the inlet slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Y-Pipe Assembly.	86320S
1	Hardware Pack	PK808
2	Adapter Pipes	TB810S
4	2-1/4" Clamp	MC225BS



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