

RACE  
APPLICATION  
ONLY

# 631

## 99-03 FORD 7.3L 5" SINGLE WITH HANGERS



- 1-39957(4-7)
- 1-39956(4-7)
- 1-6197
- 1-50040(4-9)
- 1-50024(4-8)
- 1-39952(4-7)
- 1-39910(3-6)
- 1-CH66
- 1-CH67
- 1-LJ400
- 5-LJ500

**FLO~PRO**  
PERFORMANCE EXHAUST

**PICKED BY:** \_\_\_\_\_



**WARNING: BEFORE YOUR BEGIN, VERIFY  
THAT YOU RECEIVED THE RIGHT KIT &  
EACH PART LISTED ON THE REVERSE PAGE**



**KIT #631  
1999-2003 FORD 5" SINGLE  
(Automatic & Manual Transmission)**

**REMOVAL OF ORIGINAL SYSTEM**

1. Starting at turbo, remove the turbo band clamp from the down pipe at the turbo, loosen the bolt enough to unlatch the clamp then pry the clamp away from the flange at three spots with a flathead screwdriver. Remove the clamp. **(Note: keep the stock band clamp, as it will be used with the new system).**
2. Cut the exhaust in two places. First, cut the down pipe next to the transmission and second in front of the muffler. Spray the hangers with WD-40 or Loosen-All and then pry hangers from the rubber and remove the factory exhaust. **(Note: a sawzall or hacksaw is the preferred method of cutting the exhaust).**

**INSTALLATION INSTRUCTIONS**

1. Make sure to place the clamps on all connections before installation of pipes and mufflers.
2. Install #39910 pipe using the factory turbo band clamp. Snug the clamp down so it will hold the pipe but the pipe can still be moved.
3. Install pipe #39952 onto end of the #39910 pipe making sure to put the clamp on connection before installing the pipes and muffler. Install the clamp hanger #CH-66 into the first factory rubber hanger. Snug down the clamp hanger. **(Note: do not fully tighten).**
4. Temporarily hang muffler in factory rubber hangers. Measure from the rear of #39952 to the front connection on muffler, this is the cut length of pipe #50040 or combination of both part numbers (50040 & 50024). **Note: be sure to allow for tubing connections approx. 5", making sure to cut from the non-expanded end of pipe.**
5. Install pipes #50040 & #50024. Install the clamp hanger #CH-67 into the second factory rubber hanger. Snug down the clamp hanger. **(Do not fully tighten).**
6. Install muffler on factory rubber hangers slipping front connection onto rear of pipes #50040 & #50024.
7. Install pipe #39956 into rear of muffler.
8. Install tail pipe #39957 using factory rubber hangers.
9. Snug the clamps down so they will hold the pipe but the pipe can still be moved with some effort. **Check for clearances, i.e. brake line may have to be moved, or e-brake cables as well as axle vent tube.** Also check to make sure that the exit of tail pipe is level with truck.
10. Start with #39910 pipe, tighten the turbo band clamp. Start at the front clamp, work your way to the back connection tightening clamps as you go making sure to tighten clamp hangers as well. **(Note: a mig weld should be applied to the clamped connections of pipe for added security). DO NOT WELD CLAMPS.**

**Kit #631 is for race application only.**

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