

Installation Guide: Ford F150 MR400 Single 4"

Always exercise caution when working on, under or around any vehicles. Serious injury or death could occur if safety measures are not followed.

Warnings and Safety Measures

- Allow the vehicle's exhaust system to cool before removal. Exhaust system temperatures may cause severe burns.
- If working without a lift, always consult vehicle manual for correct lifting specifications.
- Always wear safety glasses and ensure safe work area.
- Catalytic converter are to be used for off road use only.
- Professional installation is recommended.
- Extreme caution must be taken to ensure proper alignment of the exhaust tips. *Do not tighten* any of the four (2 GM & 2 Solo) *band clamps until everything is in place and the tips are aligned perfectly.*

Removing the Stock Exhaust System

1. Remove two 13mm bolts at the two hole flange that connects the converter assembly to the mid pipe.
2. Loosen 15mm nut on the band clamp at the flex pipe.
3. There are two hangers on between the converter and the muffler. Remove the forward most hanger from the truck body using a 10mm socket. This allows the system to drop.
4. There is a 'keyway' connection where the mid-pipe meets the muffler assembly. Drop the exhaust from the flange at the converter and turn the mid-pipe counter clockwise and once the keyway has moved to the "release" position, pull the exhaust pipe out. Heat or lubricant might be necessary to twist the pipe.
5. Slide muffler and tailpipe assembly rearward to remove from hangers.
Note: Squirting soapy water into the rubber hanger (Soapy water does not hurt the rubber like WD40 could) will make removal easier. A large set of channel lock pliers to squeeze the hanger out of the rubber may help.
6. Use care not to damage brake and ABS lines by the rear axle area.
7. If you are not using a hoist you may have to cut the tailpipe by the rear of the muffler to maneuver the pieces out.
8. Reinstall the mid pipe hanger using your 10mm socket.
9. Removal is now complete.

Installing Your New SOLO Single 4" Exhaust Kit

Note: If you snug everything first instead of fully tightening, it will allow for movement and adjustments once the new system is on. Snug, align, snug some more and then do your final tighten.

1. Slide Solo's mid pipe into the two hangers and tighten flanges with the 3" bolts and nuts that are supplied.
2. Slide on muffler assembly. The open end of the louvers point toward the rear (back) of the truck. Louvers are closed toward the front of the truck.
3. Slide on the tailpipe making sure it fits nicely into the hanger brackets.
4. Install band clamps (bolts facing upwards.) Manipulate all parts into proper position with proper clearances. Lightly snug the band

clamps so that you still have room to maneuver.

Solo Clamps: Hold the top nut with a 9/16" wrench and lightly snug the bottom bolt head with a 9/16 socket. *This flat band clamp will form around each layer of pipe. Tighten the bolts evenly.*

5. Check the parts position concentrating on "tip position" and clearances and do a light tighten on all the clamps. Check again and do a harder tighten. Check again and do a final tighten.

6. Make sure the mid pipe hanger that was taken off is tight.

7. Check for rattles. Check that each bolt is tight.

8. Drive away and... Enjoy Going Solo!

For any questions or concerns, please do not hesitate to call:

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