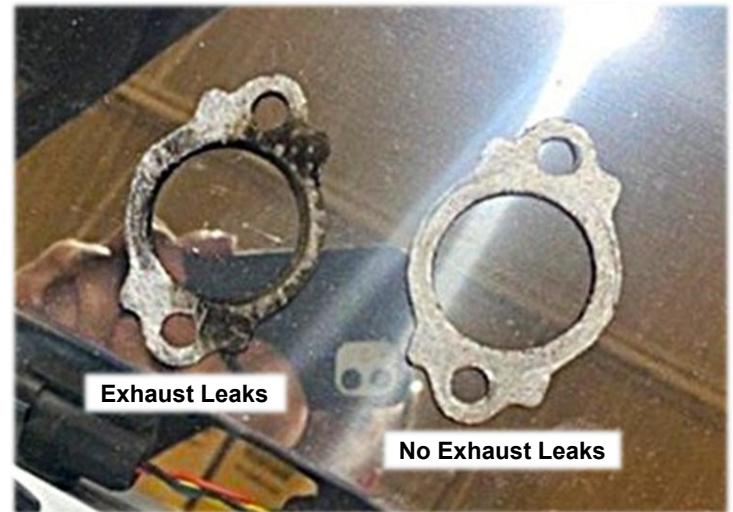


MD80 MUFFLER KIT INSTALLATION INSTRUCTIONS

Units requiring installation of 48374-SK (MD80 Muffler Kit) must follow the specified tightening sequence to properly relieve stress on the flex joint and ISO mounts. Failure to follow this procedure may result in mechanical stress, misalignment, or premature component wear. For optimal performance and reliability, refer to the detailed installation procedure provided below.

Important Notes:

- Ensure exhaust flanges are welded flat and properly aligned. Crooked flanges will not seal correctly, allowing exhaust leaks and creating downstream tension on the muffler and isolators.
- Production variances may result in slightly incorrect pipe lengths. If installation steps are followed carefully, this should not present an issue. - Refer to the attached print to confirm critical dimensions if necessary.



Installation Procedure:

1. Apply anti-seize compound to threads of 4 fasteners then install to fasten muffler manifolds to cylinder head and tighten fasteners to **195 lb-in (22 Nm)**.

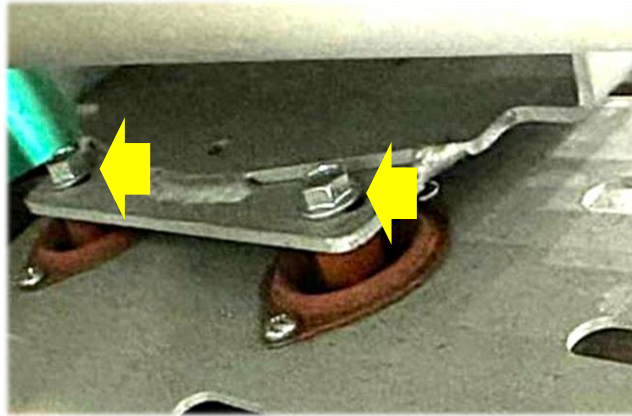


MD80 MUFFLER KIT INSTALLATION INSTRUCTIONS

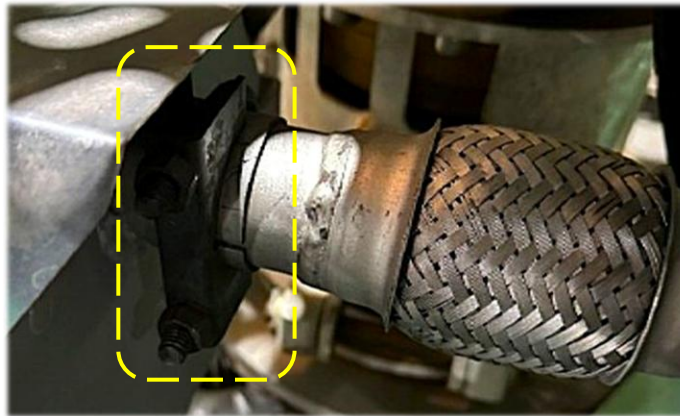
Installation Procedure Continued:

2. Install and tighten the isolators to the step mount using the hardware provided.

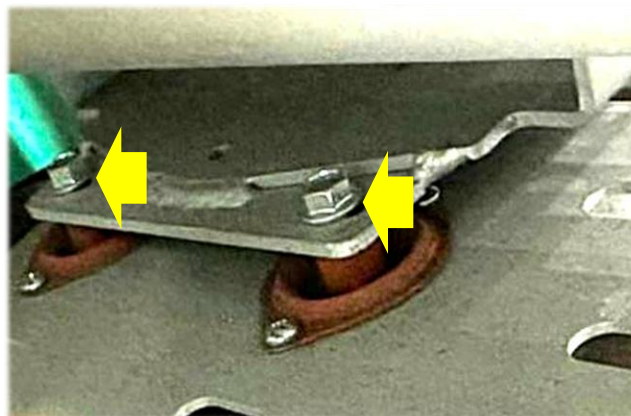
Note: Screw in the 6M bolts securing the muffler to the isolators (**DO NOT TIGHTEN**).



3. Attach the mid pipe with the flex coupler loosely to the muffler. Do NOT tighten the clamp at this stage.



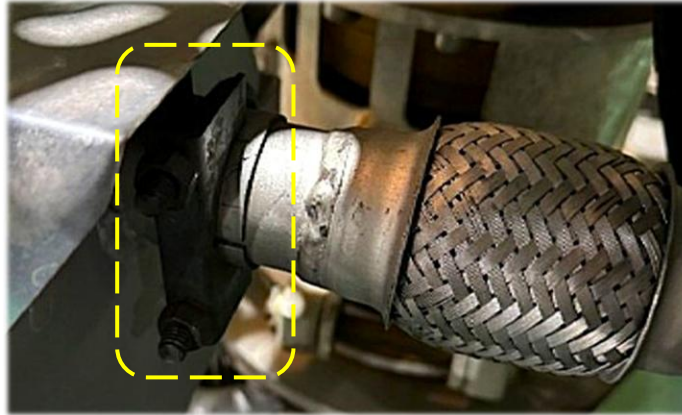
4. Secure the muffler to the isolators, by tightening the 6M bolts, ensuring it sits flat and is not twisted to avoid preload on the isolators.



MD80 MUFFLER KIT INSTALLATION INSTRUCTIONS

Installation Procedure Continued:

5. Tighten the mid pipe last, confirming that tightening does not twist the muffler on its mounts.



**Post-Installation Perform a functional check to confirm proper fit and operation.
Do this at operation temperature.**