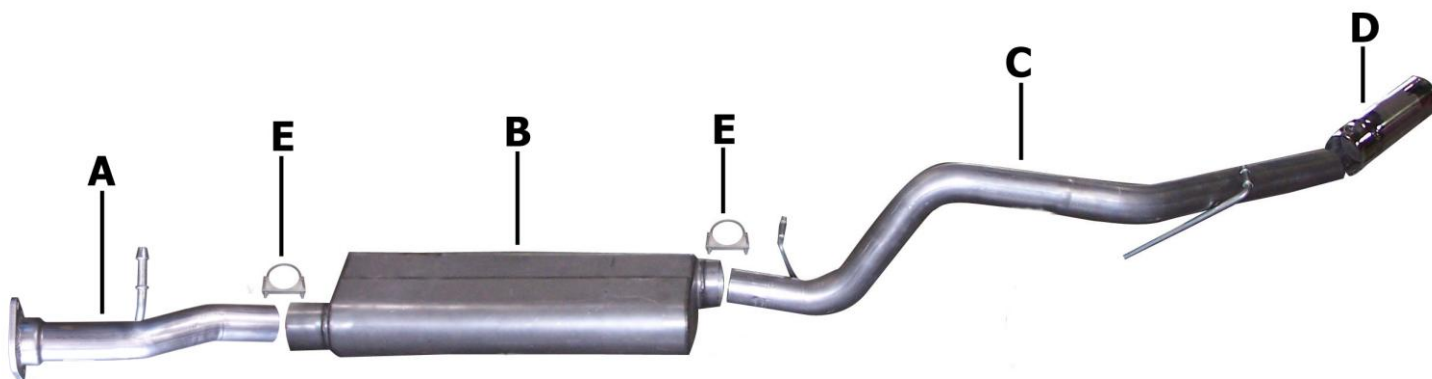




**INSTALLATION INSTRUCTIONS**  
**CAT-BACK STAINLESS SINGLE EXHAUST**  
**CHEVY TRAILBLAZER 4.2L RWD**  
**GMC ENVOY 4.2L RWD**  
**PART #615599**

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ITEM	PART #	QUANTITY	DESCRIPTION
A	1194-700954S	1	2 1/2" STAINLESS HEADPIPE W/WELDED HANGER & FLANGE
B	11223S	1	STAINLESS SUPERFLOW OVAL MUFFLER
C	1112-700875S	1	2 1/2" STAINLESS OVERAXLE TAILPIPE W/WELDED HANGER
D	500374	1	3 1/2" STAINLESS TIP
E	5757	2	2 1/2" CLAMP
F	BO-1028	1	BOLT KIT FOR FLANGE

**Thank you for purchasing our Gibson exhaust system for your vehicle. If you need further assistance, please do not hesitate to call our technical dept at (800) 528-3044 Monday through Friday, 8:00 am to 5:00 pm.**

# INSTALLATION INSTRUCTIONS #615599

## CAREFULLY READ INSTRUCTIONS BEFORE STARTING INSTALLATION

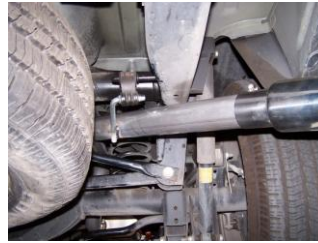
When installing this exhaust system make sure to use proper safety precautions. Use jack stands when working under the vehicle, set parking brake, block tires and use safety glasses and gloves. Allow exhaust to cool before attempting installation. Severe injury or burns could occur if safety measures are not taken.

**SUGGESTED TOOLS:** 1/2", 9/16" 15mm wrenches & sockets, WD-40, hacksaw, jack stands.

**1.** Disconnect the negative battery cable before removal of OEM exhaust. This will allow the computer to reset and recognize the new exhaust. Lay out the exhaust on the floor so it looks like the drawing and compare parts with manual.



**2.** To remove the stock exhaust, remove it from the 2 bolt flange located in front of the muffler. Disengage the welded hangers using WD-40 from the OEM rubber grommets. Do not damage or remove the rubber grommets as you will reuse them to mount your new system. Now, cut off tailpipe before and after rear axle for removal.



**5.** Install tailpipe #C into the muffler 1½-2". Insert welded hangers into rubber grommets use clamp #E to secure to muffler. Do not tighten.



**3.** Install head pipe #A onto your existing stock front pipe and attach with bolt kit #F. Insert welded hanger into rubber grommet.  
\*\*Note -> 06-07 is a flat flange connection.



**4.** Install muffler #B onto head pipe #A. 1½"-2" with the louvers facing towards the converter. Use a jack stand to support the muffler. Use clamp #E to secure the muffler to the headpipe. DO NOT TIGHTEN. Muffler inlet is looking into the louvers. Outlet will be on the drivers side.



**9.** Install stainless steel tip #D. Clamp down. When you have everything in place, firmly tighten all bolts and clamps down securely. Use stainless steel cleaner and a Scotch Brite pad weekly to prevent tip from discoloration. Inspect all fasteners after 25-50 miles of operation and re-tighten as necessary.

GIBSON EXHAUST systems are designed on a factory stock vehicle. Any aftermarket products installed could increase the sound levels of this Exhaust.

**Make sure there is a 1" clearance from ALL rubber brake lines, shock boots, fuel lines, tires, etc to prevent heat related damage or fire.**