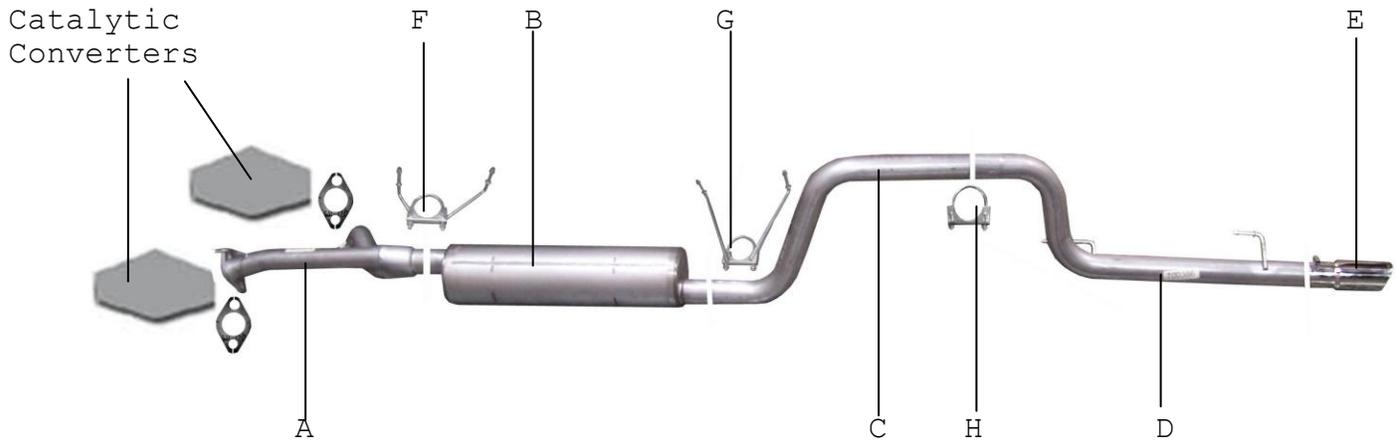




PERFORMANCE EXHAUST SYSTEMS

**INSTRUCTION MANUAL**  
**CAT-BACK STAINLESS SINGLE EXHAUST**  
**TOYOTA SEQUOIA**  
**4.7L 2/4WD, 4 DOOR**  
**PART # 618900**



ITEM	PART #	QTY	DESCRIPTION
A	555-700384S	1	S/S HEADPIPE ASSEMBLY W/FLANGE GP-120
B	788500S	1	STAINLESS SUPERFLOW MUFFLER
C	556-700385S	1	2-1/2" STAINLESS TAILPIPE
D	557-700386S	1	2-1/2" STAINLESS EXIT PIPE W/HANGER
E	500361	1	3" STAINLESS TIP
F	4183	1	FRONT MUFFLER HANGER
G	4184	1	REAR MUFFLER HANGER
H	5757	1	2-1/2" CLAMP

**WILL FIT SR5 AND LIMITED MODELS**

Thank you for purchasing our GIBSON EXHAUST SYSTEM for your vehicle. If you need further assistance, please do not hesitate to call our Technical Department at (800) 528-3044, Monday through Friday, 8:00 am to 5:00 PM.

# INSTALLATION INSTRUCTIONS #618900

WHEN INSTALLING THIS EXHAUST SYSTEM, MAKE SURE TO USE PROPER SAFETY PRECAUTIONS. USE JACK STANDS WHEN UNDER THE TRUCK, SET PARKING BRAKE, BLOCK TIRES AND USE SAFETY GLASSES AND GLOVES. DO NOT DAMAGE STOCK HEADPIPE FLANGE BOLTS AND GASKETS. YOU WILL RE-USE THEM. **DO NOT WORK WITH HOT PIPES!**

## SUGGESTED TOOLS

14MM SOCKET & WRENCH, 9/16" SOCKET & WRENCH, SOCKET & WRENCH, 02 SENSOR GASKET SEALER, JACK STAND, WD-40, HACKSAW



TO REMOVE STOCK EXHAUST UNBOLT THE CLAMP LOCATED BEHIND THE MUFFLER. THE TAILPIPE SHOULD SLIDE OFF. UNBOLT THE STOCK MUFFLER AND HEADPIPES FROM THE 2 FLANGES JUST BEFORE THE MUFFLER. DO NOT DISGARD STOCK NUTS AND BOLTS. LEAVE ALL RUBBER GROMMETS ON THE HANGER. USE WD-40 TO AID IN REMOVAL OF THE EXHAUST AND HANGERS.



INSTALL OVERAXLE TAILPIPE #C INTO MUFFLER 1-1/2" TO 2". INSERT WELDED HANGER INTO RUBBER GROMMET.



INSTALL HEADPIPE ASSEMBLY #A ONTO STOCK FLANGES, RE-USING STOCK NUTS AND BOLTS. DO NOT TIGHTEN. INSERT WELDED HANGER INTO RUBBER GROMMET.



INSTALL HANGER #G INTO RUBBER GROMMET LOCATED JUST ABOVE THE OUTLET OF THE MUFFLER. USE THIS HANGER TO SECURE MUFFLER TO TAILPIPE. DO NOT TIGHTEN.



INSTALL MUFFLER #B ONTO HEADPIPE ASSEMBLY AT LEAST 1-1/2" TO 2". USE A JACK STAND TO SUPPORT THE MUFFLER. THE OUTLET OF THE MUFFLER SHOULD BE AT THE 6 O'CLOCK POSITION.



INSTALL EXITPIPE #D ONTO OVERAXLE TAILPIPE. INSERT WELDED HANGERS INTO RUBBER GROMMETS. USE CLAMP #H TO SECURE TO THE TAILPIPE. DO NOT TIGHTEN.



INSTALL FRONT MUFFLER HANGER #F INTO RUBBER GROMMETS LOCATED JUST ABOVE THE INLET OF THE MUFFLER. USE THIS CLAMP TO SECURE HEADPIPE. DO NOT TIGHTEN.



INSTALL THE STAINLESS TIP #E. TO CLEAN TIP USE ANY STAINLESS OR ALUMINUM CLEANER AND A SCOTCH BRITE PAD. NOW GO BACK AND TIGHTEN ALL NUTS, BOLTS AND CLAMPS STARTING FROM THE FRONT AND WORKING BACK.

**"MAKE SURE YOU HAVE A MINIMUM OF A 1" CLEARANCE ON ALL PIPES FROM ALL RUBBER BRAKE LINES, TIRES, SHOCKS, SPARE TIRE, FUEL LINES, ETC."**