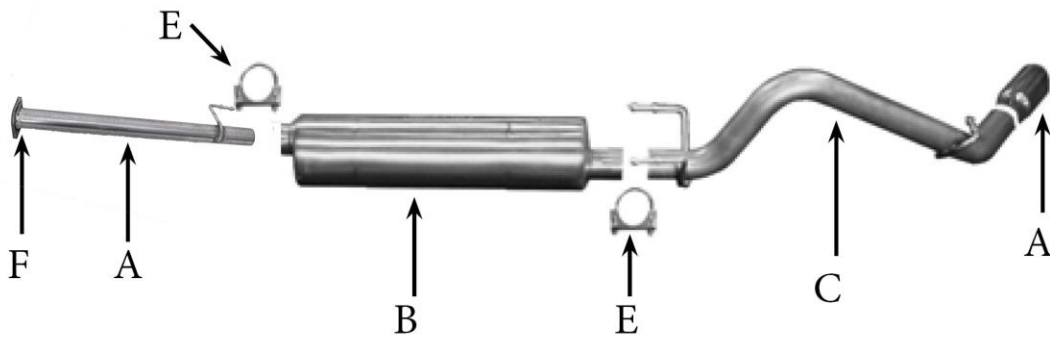




# INSTALLATION INSTRUCTIONS

Black Elite Single Exhaust  
 TOYOTA TACOMA 3.5L V6  
 Double Cab- Crew, Long Bed 73.7" 4 DR 2/4WD  
 PART #618819B



Item	Part Number	Quantity	Description
A	999701047S	1	2-1/2" HEADPIPE W/ FLANGE #GP-110
B	788500S	1	SUPERFLOW MUFFLER
C	999700785S	1	2 1/2" TAILPIPE W/ HANGERS
D	500640-B	1	4IN. Black T304 STAINLESS. ROUND SLASH-CUT TIP. CLAMP ON.
E	5757	2	2 1/2" CLAMP
F	BO-1036	1	BOLT KIT FOR HEADPIPE 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. PST

# INSTALLATION INSTRUCTIONS

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

**SUGGESTED TOOLS:** Sawzall or hack-saw, 1/2", 9/16" socket or wrench, 15mm deep socket or wrench. Hanger removal tool or large channel-lock pliers, WD-40 and 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 before installation.



LAY OUT THE EXHAUST ON THE FLOOR SO IT LOOKS LIKE THE DRAWING AND COMPARE PARTS WITH MANUAL. TO REMOVE THE STOCK EXHAUST. REMOVE IT FROM THE 2-BOLT FLANGE LOCATED IN THE FRONT OF THE MUFFLER. LEAVE ALL RUBBER GROMMETS IN PLACE. USE WD-40 TO AID IN REMOVAL OF EXHAUST AND HANGERS.



INSTALL THE OVERAXLE TAILPIPE #C INTO THE MUFFLER 1-1/2" TO 2". INSERT WELDED HANGERS INTO RUBBER GROMMET. SECURE TO THE MUFFLER USING CLAMP #E. DO NOT TIGHTEN.



INSTALL HEAD PIPE #A ON TO YOUR EXISTING STOCK 2-BOLT FLANGE AND SECURE WITH BOLT KIT #F. INSERT WELDED HANGER INTO RUBBER GROMMET. DO NOT TIGHTEN



INSTALL MUFFLER #B ONTO HEAD PIPE 1-1/2" TO 2" WITH THE LOUVERS FACING TOWARDS THE CONVERTER. THE MUFFLER OUTLET SHOULD BE POSITIONED AT 12:00. USE A JACK STAND TO SUPPORT THE MUFFLER. USE CLAMP #E TO SECURE THE MUFFLER TO THE HEAD PIPE. DO NOT TIGHTEN. MUFFLER INLET IS LOOKING INTO THE LOUVERS.



NEXT, INSTALL YOUR TIP TO YOUR DESIRED LOOK. USE ANY STAINLESS CLEANER TO POLISH YOUR TIP. MAKE SURE YOU HAVE A MINIMUM OF A 1" CLEARANCE ON ALL PIPES FROM ALL RUBBER BRAKE LINES, TIRES, SHOCKS, FUEL LINES, ETC. THEN TIGHTEN ALL CLAMPS AND HANGERS.

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.