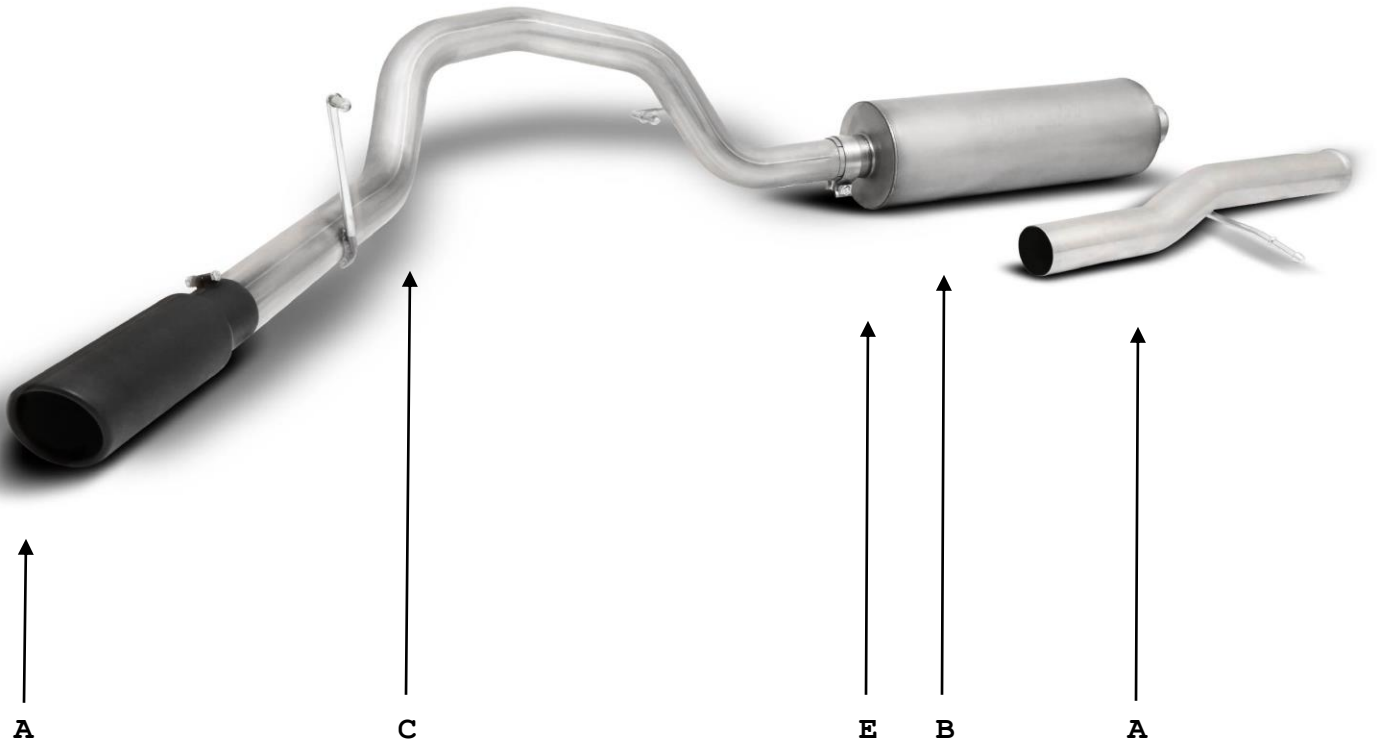


**INSTALLATION INSTRUCTIONS**  
**Black Elite Single Swept Side Exhaust**  
**GMC Yukon/Chevy Tahoe 2/4WD**  
**5.3L V8**  
**“Non Factory Dual Exhaust”**  
**PART # 615638B**



Item	Part Number	Quantity	Description
A	999701090S	1	3.0" Head Pipe
B	420887-V	1	SFT Muffler
C	999701091S	1	3.0" Overaxle Pipe
D	500641-B	2	Stainless Rolled Edge Angle Exhaust Tip
E	5763	2	3.0" band clamp

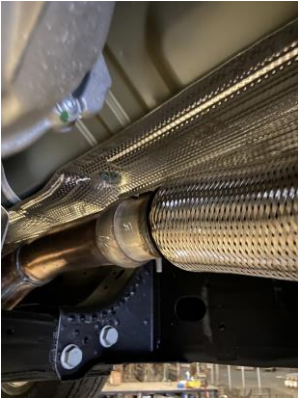
Thank you for purchasing our Gibson exhaust system for your vehicle. If you need further assistance, please do not hesitate to call our technical dept at (800) 528-3044 Monday through Friday, 8:00 am to 5:00 pm. PST

## CAREFULLY READ INSTRUCTIONS BEFORE INSTALLING PRODUCT

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.



2. TO REMOVE YOUR STOCK EXHAUST, Un Bolt the back half from the flange LOCATED above the rear suspension, then loosen the front clamp and remove the remaining exhaust. **(FACTORY RUBBER HANGER GROMMETS WILL BE RE-USED, USE WD-40 TO AID IN REMOVAL.)**

3. INSTALL HEADPIPE #A ONTO STOCK PIPE. INSERT WELDED HANGER INTO RUBBER GROMMET. **(You Will be re-using the factory head pipe clamp.)**

4. INSTALL MUFFLER #B ONTO HEADPIPE, USE CLAMP #D TO SECURE MUFFLER TO HEADPIPE. DO NOT TIGHTEN. USE A JACK STAND TO HOLD UP THE MUFFLER.



5. Finally, over axle pipe #C can be installed using the Band Clamp #D. Install the Tip to help set the over axle pipe height. (Tighten all clamps working from front to back.)



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.