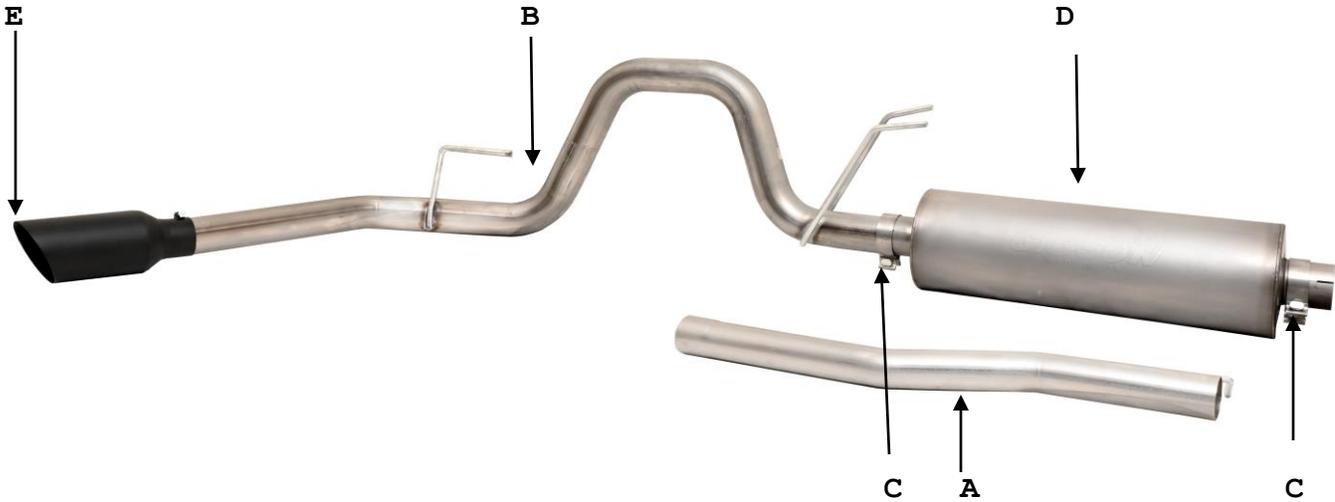




**INSTALLATION INSTRUCTIONS**  
**Black Elite Single Swept Side Exhaust System**  
**2020 Ford F-250/350, 7.3L-V8, Crew Cab, Short Bed 2/4wd**

**PART # 619909B**



Item	Part Number	Quantity	Description
A	999701100S	1	3" Head Pipe
B	999700944S	1	3" Over Axle Pipe
C	OHD300	3	3.0" U-Bolt Clamp
D	420887	1	SFT Round Muffler
E	500661-B	1	5" Black Rolled Round Angle Cut Tip

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 the stock exhaust loosen the clamp from the back of the resonator. Then remove the spare tire and heat shield to aid in removal. Disengage the welded hanger using WD-40 from the OEM rubber grommets. Do not damage or remove the rubber grommets as you will reuse it to mount your new system.



3. Install Head Pipe pipe #A onto your existing stock pipe coming out of the Resonator and attach with clamp # C. Keep the clamp a little loose.

4. Install the Muffler #D onto the new Head Pipe using clamp #C. Leave clamps loose enough to have a little play.



5. Now you may install the Over Axle Pipe #B into the muffler using Clamp #C. Then install the Tip onto the over axle to your desired location and tighten all clamps working 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.