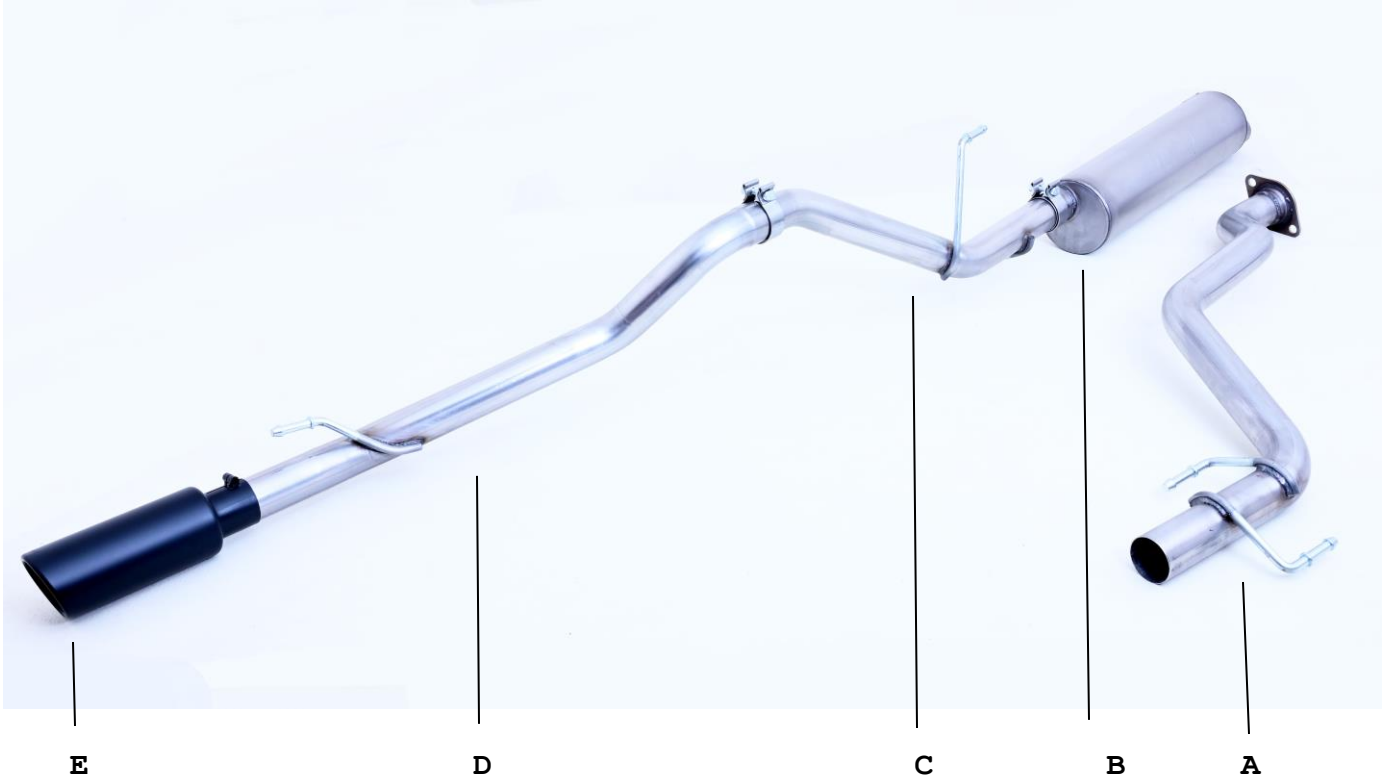




Black Elite Single Exhaust Installation Instructions

**24+ Toyota Tacoma Pickup 2.4L 2/4wd
Rear Leaf Spring Suspension Only
Xtra Cab 6ft Bed, Double Cab 5ft & 6ft Bed
PART #618821B**



Item	Part Number	Quantity	Description
A	9997011840S	1	2-1/2" HEADPIPE
B	788500S -10	1	SUPERFLOW MUFFLER W/ SLIT NOTCH)
C	9997011841S	1	2 ½" Over Axle Pipe
D	9997011842S	1	2 ½" Exit Pipe
E	500640-B	1	4" STAINLESS ROLLED EDGE TIP
F	999701198S	1	Head pipe Extension (Double Cab 6ft Bed)
G	800054	1	2.5" Clamp Hanger
H	5762	3	2 ½" 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

INSTALLATION INSTRUCTIONS

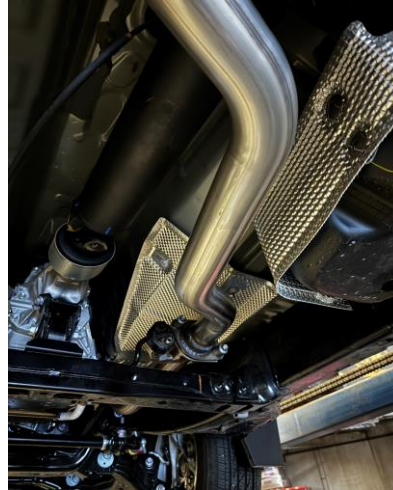
WHEN INSTALLING THIS EXHAUST SYSTEM, MAKE SURE TO USE PROPER SAFETY PRECAUTIONS. USE JACK STANDS WHEN UNDER THE TRUCK, BLOCK TIRES, AND USE SAFETY GLASSES AND GLOVES.
DO NOT WORK WITH HOT PIPES!

SUGGESTED TOOLS

HACKSAW, JACKSTAND, 1/2" WRENCH & SOCKET, 9/16" SOCKET & WRENCH, WD-40, MEASURING TAPE



1. 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 BEHIND THE MUFFLER THEN THE 2-BOLT FLANGE ON THE HEADPIPE (KEEP HARDWARE). LEAVE ALL RUBBER GROMMETS IN PLACE. USE WD-40 TO AID IN REMOVAL OF EXHAUST AND HANGERS.



2. INSTALL HEAD PIPE **#A** ON TO YOUR EXISTING STOCK 2-BOLT FLANGE AND SECURE. INSTALL CLAMP HANGER G ONTO HEADPIPE. INSTALL EXTENSION PIPE IF REQUIRED. DO NOT TIGHTEN UNTIL THE END



3. 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 6:00, THEN INSTALL OVERAXLE **#C** USING CLAMP **#F** ON BOTH ENDS OF THE MUFFLER. USE A JACK STAND TO SUPPORT THE MUFFLER. PIPE. DO NOT TIGHTEN.



4. LASTLY, INSTALL EXIT PIPE **#D** USING CLAMP **#F**. INSERT WELDED HANGER INTO RUBBER GROMMET. (ONCE DESIRED LOCATION IS ACHIEVED WITH TIP **#E** INSTALLED, BEGIN TIGHTENING ALL CLAMPS STARTING 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. Ensure a 1" clearance from all rubber brake lines, shock boots, fuel lines, and tires to prevent heat-related damage or fire.