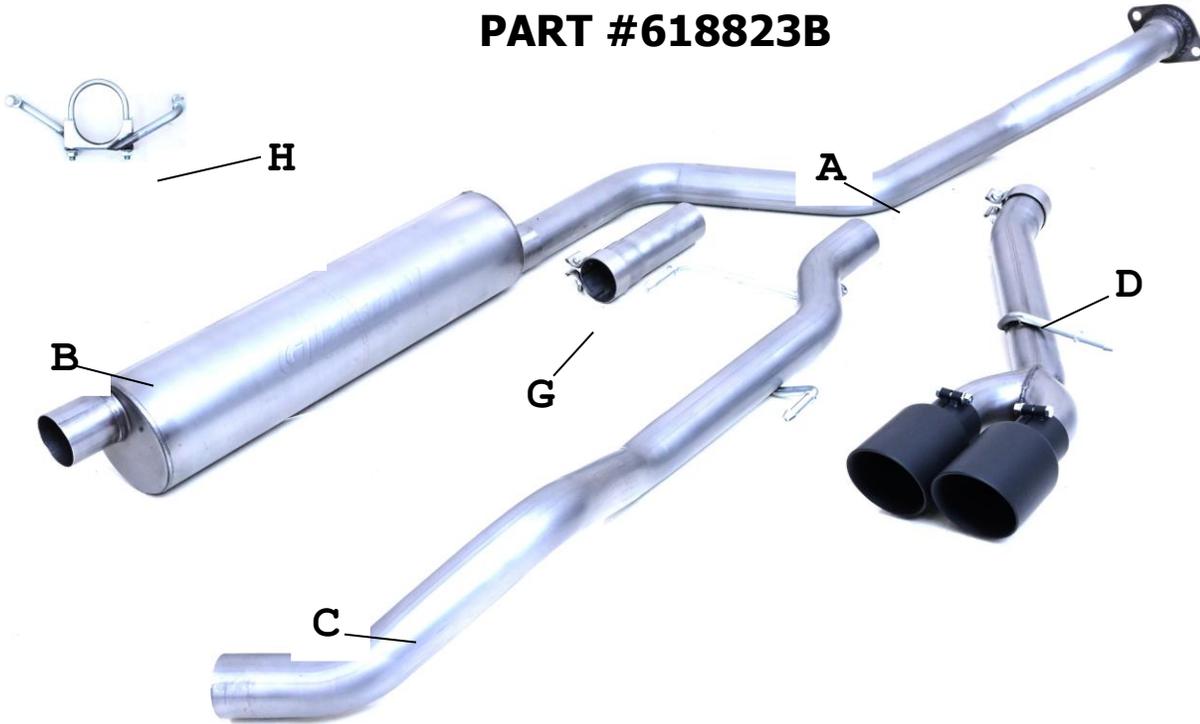




INSTALLATION INSTRUCTIONS

24+ Toyota Tacoma 2.4L 2/4wd
****REAR COIL SPRUNG SUSPENSION ONLY****
 Xtra Cab 6ft Bed, Double Cab 5ft & 6ft Bed

PART #618823B



Item	Part Number	Quantity	Description
A	9997011840S	1	2-1/2" HEADPIPE
B	788500S-10	1	SUPERFLOW MUFFLER
C	999701199S	1	2 1/2" Over Axle Pipe
D	999701201S	1	2 1/2" Exit Pipe
E	500417-B	2	4" STAINLESS BLACK CERAMIC TIP
F	5762	3	2 1/2" BAND CLAMP
G	999701198S	1	Head pipe Extension (Double Cab 6ft Bed)
H	800054	1	Headpipe Clamp Hanger

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 0625

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

1/2", 9/16", 15MM, SOCKET & WRENCH, WD-40, JACK STAND



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** ONTO YOUR EXISTING STOCK 2-BOLT FLANGE AND SECURE. Use clamp hanger **#H** to attach headpipe to rubber grommets (DO NOT TIGHTEN). (DOUBLE CAB LONG BED WILL NEED TO USE HEADPIPE EXTENSION **#G** WITH BAND CLAMP **#F**)



3. INSTALL MUFFLER **#B** ONTO HEAD PIPE 1-1/2" TO 2" WITH THE LOUVERS FACING TOWARDS THE CONVERTER. THEN INSTALL OVERAXLE **#C** USING CLAMP **#F**. USE A JACK STAND TO SUPPORT THE MUFFLER. (DO NOT TIGHTEN)



4. LASTLY, INSTALL EXIT PIPE **#D** USING CLAMP **#F**. INSERT WELDED HANGER INTO RUBBER GROMMET. (ONCE DESIRED LOCATION IS ACHIEVED WITH TIPS **#E** INSTALLED, BEGIN TIGHTENING ALL CLAMPS STARTING FRONT TO 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."