

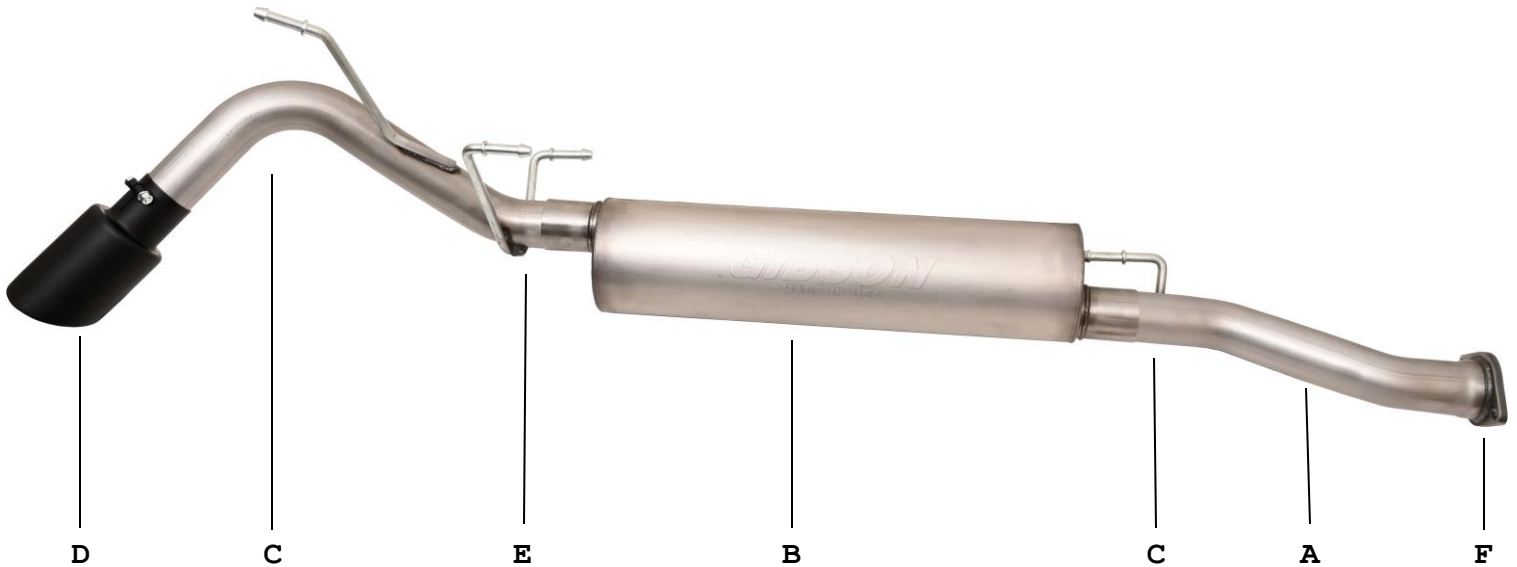


INSTALLATION INSTRUCTIONS

Black Elite Trail Kit

2016-2021 TOYOTA TACOMA 3.5L V6
 Double Cab- Crew, Short Bed 60.5" 4 DR 2/4WD
 Access Cab-Extended, Standard Bed 73.7" 2/4WD

PART #618820B



ITEM	PART #	QTY	DESCRIPTION
A	999700905S	1	2-1/2" HEADPIPE W/ FLANGE #GP-110
B	788500S	1	SUPERFLOW MUFFLER
C	999701102S	1	2 1/2" TAILPIPE W/ HANGERS
D	500417-B	1	BLACK CERAMIC TIP
E	5757	2	2 1/2" CLAMP
F	BO-1036	1	BOLT KIT FOR HEADPIPE FLANGE
G	800046	1	Tailpipe Hanger
H	BO-906	1	Tailpipe Hanger Bolt Kit (800046)

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.

EXHAUST INSTALLATION

WHEN INSTALLING THIS EXHAUST SYSTEM MAKE SURE TO USE ALL THE PROPER SAFETY PRECAUTIONS. USE JACK STANDS WHEN UNDER TRUCK, SET PARKING BRAKE, BLOCK TIRES AND USE SAFETY GLASSES.

DO NOT WORK WITH HOT PIPES!!!

1. Disconnect the negative battery cable before removal of the 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. Remove the factory exhaust by cutting behind the factory muffler. Once the tail pipe has been removed un-bolt the muffler and head pipe at the flanges located behind the catalytic converters. Use wd-40 or another type of penetrating oil to remove the rubber grommets. Do not damage these they will be re used.



2. Install Head pipe Item # A onto the factory flange. Install hanger into rubber grommet and loosely tighten down the flange. You will re-use the factory Gasket.



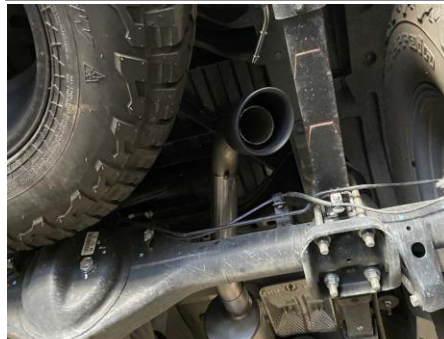
3. Install the muffler onto your head pipe. Be sure all slip joints are in a minimum of 1.5". The muffler inlet will have the louvers facing forward. Do not tighten.



4. Install the over axle pipe into the muffler outlet a minimum of 1.5" and insert the hangers into the rubber grommets. The muffler outlet will be positioned closely to 2:00 o clock. Do not tighten down.



5. Install your tailpipe hanger in to the existing frame holes shown in the photo. Use the provided bolt kit and do not tighten.



6. With proper clearance from spare tire, install the exhaust tip onto the tailpipe. With the tip in your desired position begin to tighten down all clamp connections from the front head pipe back.



7. Be sure to check all clearance after each section has been tightened to be sure there is proper clearance. It may take 4-500 miles for your vehicle to fully adjust to the changes in exhaust flow.

"MAKE SURE YOU HAVE A 1" CLEARANCE ON ALL PIPES FROM ALL RUBBER BRAKE LINES, SHOCK BOOTS, TIRES, ETC..." TORQUE ALL CLAMPS TO APPROX. 100 TO 150 FT LBS.