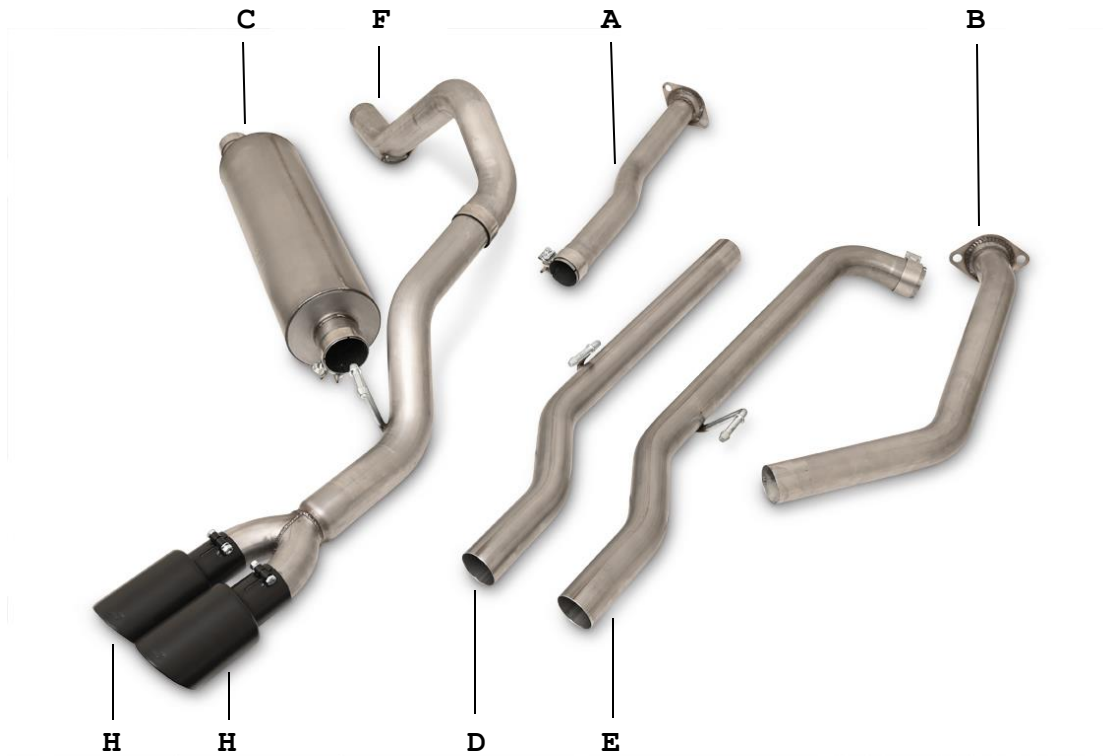


# INSTALLATION INSTRUCTIONS

**Black Elite Stainless Steel Dual Sport Cat-Back Exhaust**  
**22-24 Toyota Tundra Crew Max, Standard Bed 6.6" 3.5L-T V-6 2/4wd**

## PART #67105B



ITEM	PART #	QTY	DESCRIPTION
A	999701140S	1	Driver Side Headpipe
B	999701157S	1	Passenger Side Headpipe
C	789800SV	1	SFT Muffler Assembly
D	999701175S	1	Driver Side Mid-Pipe
E	999701176S	1	Passenger Side Mid-Pipe
F	999701144S	1	Overaxle Pipe
G	999701145S	1	Exit Pipe Assembly
H	500417-B	2	4.0" Intercooled Black Ceramic Stainless Tip
I	5762	4	2.50" Stainless Band Clamp
J	5763	2	3.0" Stainless 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. 0524**

# EXHAUST INSTALLATION

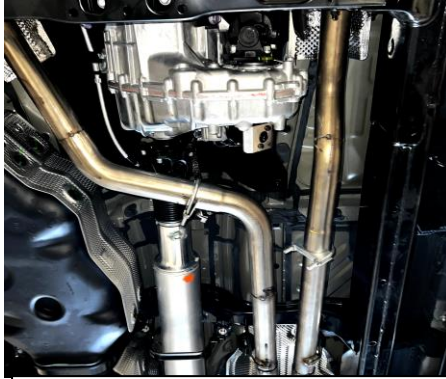
WHEN INSTALLING THIS EXHAUST SYSTEM MAKE SURE TO USE ALL THE PROPER SAFETY PRECAUTIONS. USE JACK STANDS WHEN UNDER TRUCK, SET PARKING BRAKE, BLOCK TIRES AND USE SAFETY GLASSES.

**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.



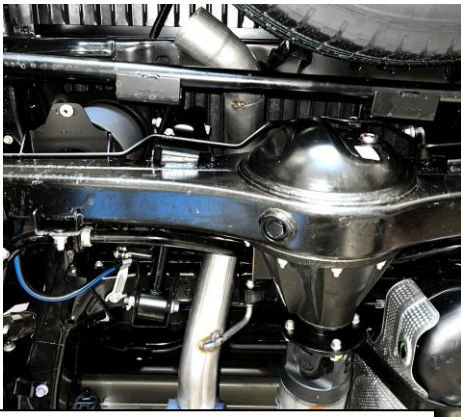
2. Install Driver side and Passenger side Head pipe onto the factory flanges. loosely tighten down the flange with the factory springs on the rear side of the Gibson Flange.



3. Install Passenger and driver Mid-pipe. Insert the hangers into the rubber grommets. Loosely tighten down because you will need to make final adjustments to find the right fit for your vehicle with the right clearance.



4. Using a jack or something to support the muffler install the muffler onto the head pipe. The muffler was designed to have all slip joints instated at 1.5". This can vary on each install but is a good starting point.



5. Install your over axle pipe and insert the hanger in to grommet and remove muffler support. Do not tighten



6. Install your exit pipe and exhaust tips. Now go back and adjust the kit so you have proper clearance and the muffler sits level with the frame rail, the tips were designed to have the tips 1" below the ¼ panel. Begin to tighten from the front to the back. Check clearance as parts will move.



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.**