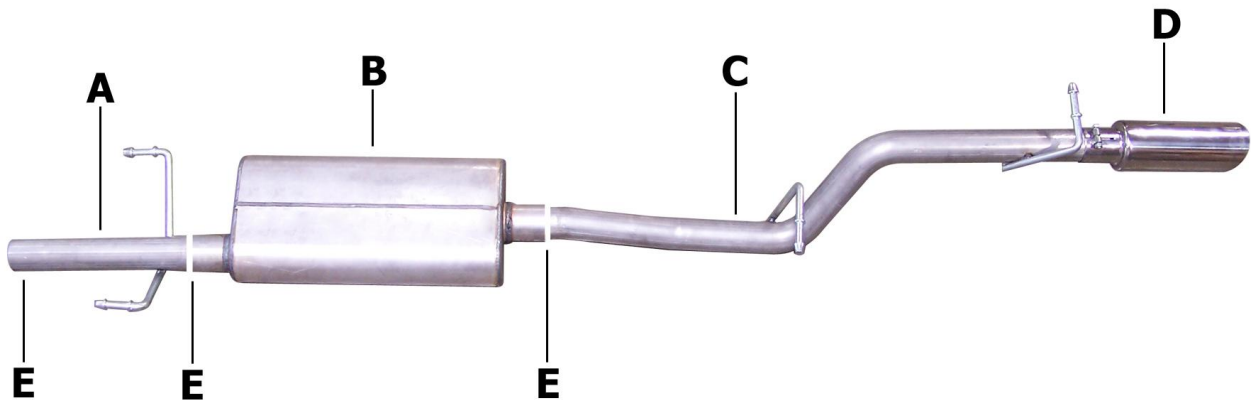




# Installation Instructions

Cat-Back Stainless Single Exhaust  
Toyota Highlander, 3.3L, 2wd, 4dr.

## Part #618901



ITEM	PART	QUANTITY	DESCRIPTION
A	1141-700919S	1	2.25" Stainless Headpipe
B	55161S	1	Stainless Superflow CFT Muffler
C	1142-700920S	1	2.25" Stainless Tailpipe
D	500395	1	3.5" Stainless Tip
E	5756	3	2.25" 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 department at  
(800) 528 -3044 Monday through Friday, 8am to 5 pm.

# Installation Instructions #618901

When installing this exhaust system make sure to use proper safety precautions. Use jack stands when working under the vehicle, set parking brake, block tires and use safety glasses and gloves. Allow exhaust to cool before attempting installation. Severe injury or burns could occur if safety measures are not taken.

**SUGGESTED TOOLS:** 1/2", 9/16", 15mm wrenches & sockets, WD-40, hacksaw, 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 your stock exhaust, measure and cut 8" in front of the muffler. Disengage the welded hangers from the OEM rubber grommets. Use WD-40 to aid in this process. Do not damage or remove the rubber grommets as you will reuse them to mount your new system. Now, cut off tailpipe and remove exhaust.



5. Install the over axle tailpipe #C into the muffler 1.5"-2". Use clamp #E to secure tailpipe to muffler. Do not tighten. Insert welded hangers into rubber grommets.



3. Install headpipe #A onto your existing stock front pipe and attach with clamp #E. Use a jack stand to support the converter. Insert welded hangers into rubber grommets.



4. Install muffler #B onto head pipe #A 1½"-2" with the louvers facing towards the converter. Use a jack stand to support the muffler. Use clamp #E to secure the muffler to the headpipe. Do not tighten. Muffler inlet is looking into the louvers.



8. Install stainless steel tip. Clamp down. When you have everything in place, firmly tighten all bolts and clamps down securely. Use stainless steel cleaner and a Scotch Brite pad weekly to prevent tip from discoloration. Inspect all fasteners after 25-50 miles of operation and re-tighten as necessary.

GIBSON EXHAUST systems are designed on a factory stock vehicle. Any aftermarket products installed could increase the sound levels of the exhaust.

**Make sure there is a 1" clearance from ALL rubber brake lines, shock boots, lines, tires, etc. to prevent heat related damage or fire.**