



**409S, Stainless Steel**

Installation Instructions for:  
**SYSTEM #817614**  
**2013-2015 TOYOTA TACOMA**  
4.0L V6 ENGINE  
DOES NOT FIT STANDARD CAB OR X-RUNNER

09/22/14

### Removal:

- 1) Raise the vehicle up on a hoist or rack to working height. If you do not have access to a hoist or rack raise the vehicle and support securely with jack stands.
- 2) Remove the two spring loaded bolts at the flange connection behind the catalytic converter using a 14mm wrench or socket. Save the springs as they will be reused.
- 3) Remove the four hangers from their factory rubber mounts on the vehicle. A spray lubricant will make this easier.
- 4) Slide the factory exhaust assembly back and down, then remove it towards the front of the vehicle, sliding the tailpipe over the rear end and set aside.

### Installation:

- 1) Mount the left side rear frame hanger **#344HA** into the large hole on the bottom of the frame next to the spare tire on the driver side, using the supplied 3/8" bolt, nut, lock and flat washers. Once mounted, the hanger rod should face the center of the vehicle. Tighten securely and slide the supplied rubber hanger **#HA168** onto the hanger rod up to the flat washer.
- 2) Secure inlet pipe **#16533S** onto the factory flanged connection using the included M10 x 65MM bolts, flat washers and steel spacers along with the factory springs removed in Step 2 of removal. Tighten the two bolts firmly, but still allow for adjustment. If you have a double cab long bed model you will have to use the supplied inlet extension pipe **#TB472S**. Slide it over the back of the inlet pipe that was just installed and use a supplied 2 1/2" clamp at this connection. Tighten firmly, but still allow for adjustment.
- 3) Place muffler into position, sliding the inlet of the muffler onto the inlet pipe installed in Step 2 of installation and support with a stand. Place the supplied clamp hanger assembly **#386HA** over the muffler inlet connection and into the factory rubber mount on the vehicle. Tighten firmly, but still allow for adjustment.
- 4) Place right tailpipe **#16843S** into position over the rear axle and into the passenger side muffler outlet. The tailpipe hanger should slide into the factory rubber mount on the vehicle. Place a supplied 2-1/2" clamp at this connection. Tighten firmly, but still allow for adjustment.

- 5) Slide the left front tailpipe **#16530S** into position and over the rear axle into the muffler outlet on the driver's side. The tailpipe hanger should slide into the factory rubber mount on the vehicle. Place a supplied 2-1/2" clamp at this connection and tighten firmly, but still allow for adjustment. Place the left rear tailpipe **#16844S** into the back of the left front tailpipe that was just installed. Slide the tailpipe hanger into the supplied rubber hanger installed in Step 1 on Installation. Tighten the clamp enough to hold, but still allow for adjustment.
- 6) Place the two stainless tips onto the exit pipes and tighten the clamps enough to hold, but still allow for adjustment. Adjust the position of the pipes and tips to the desired distance from the fender so that the angle cut on the tips are in the desired location.
- 7) Tighten down all clamped connections securely. After the system is secure, slide the 7/16" hanger keepers onto the hanger rods on the tailpipes to prevent them from sliding out of the rubber mounts.
- 8) For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections. If you live in a geographical area that has harsh winters or sees a great deal of precipitation, the use of high temperature paint over the welded areas can help to prevent surface rust and premature corrosion.

### PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part #</u>
1	Muffler	8525551-Z
1	Inlet Pipe	16533S
1	Inlet Extension Pipe	TB472S
1	Right Tailpipe	16843S
1	Left Front Tailpipe	16530S
1	Left Rear Tailpipe	16844S
2	Stainless Tip	ST461
1	Parts Kit	PK506
1	Frame Hanger	344HA
1	Clamp Hanger	386HA
4	2-1/2" Clamps	MC250BS
1	Rubber Hanger	HA168
2	M10 x 1.25 x 65MM Bolt	HW231
2	1/2" x 1 1/2" Steel Spacer	HW506
1	3/8" x 1-1/4" Bolt	HW209
3	7/16" Hanger keeper	HW502
1	3/8" Nut	HW103
1	3/8" Lock Washer	HW309
3	3/8" Flat Washer	HW303



Installation diagram for:  
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**AMERICAN THUNDER**

**409S. Stainless Steel**

