



409S Stainless Steel

Installation Instructions for:
SYSTEM #817719
2016-2019 TOYOTA TACOMA
3.5L V6 ENGINE
ACCESS CAB AND DOUBLE CAB MODELS

01/28/19

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 bolts at the flange connection, just forward of the factory muffler, using a 14mm wrench or socket. Save the bolts and the gasket 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 **#371HA** 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 **#86379S** onto the factory flanged connection using the bolts removed in Step 2 of removal. Be sure to include the gasket, then tighten the two bolts securely. The pipe will rise up and toward the center of the vehicle. 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 and use a supplied 2 1/2" clamp at this connection. Tighten the clamp securely.
- 3) Place the supplied clamp hanger assembly **#386HA** onto the back of the inlet pipe and into the factory rubber mount on the vehicle. Place the muffler inlet thru the hanger assembly and onto the back of the inlet pipe, be sure it's slid on completely and support the muffler with a stand. Be sure the muffler is level and tighten the muffler inlet clamp enough to hold but still allow for adjustment.
- 4) Place a supplied 2 1/2" clamp onto both muffler outlets. Then place right tailpipe **#16843S** into position over the rear axle and into the passenger side muffler outlet. Connect the hangers on the pipe to the rubber mounts on the vehicle. Tighten the clamp enough to hold but still allow for adjustment.

- 5) Slide the left front tailpipe **#16530S** into position and over the rear axle and into the left muffler outlet. Connect the hanger on the pipe to the rubber mount on the vehicle. Tighten the clamp enough to hold but still allow for adjustment. Place a supplied clamp onto the slip-fit of left rear tailpipe **#86380S** then slide into the back of front section **#16530S**. Connect the hanger on the pipe to the rubber mount 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 ends of the tailpipes 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 and 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 ends of the **#371HA** frame hanger and left rear tailpipe hanger. These will prevent the hanger rods from slipping 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	86379S
1	Inlet Extension Pipe	TB472S
1	Right Tailpipe	16843S
1	Left Front Tailpipe	16530S
1	Left Rear Tailpipe	86380S
2	Stainless Tip	ST461
1	Parts Kit	PK816
1	Rear Frame Hanger	371HA
1	Front Clamp Hanger	386HA
4	2-1/2" Clamps	MC250BS
1	Rubber Hanger	HA168
1	3/8" x1-1/4" Bolt	HW209
1	3/8" Nut	HW103
1	3/8" Lock Washer	HW309
2	7/16" Hanger keeper	HW502



Installation diagram for:
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AMERICAN THUNDER

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