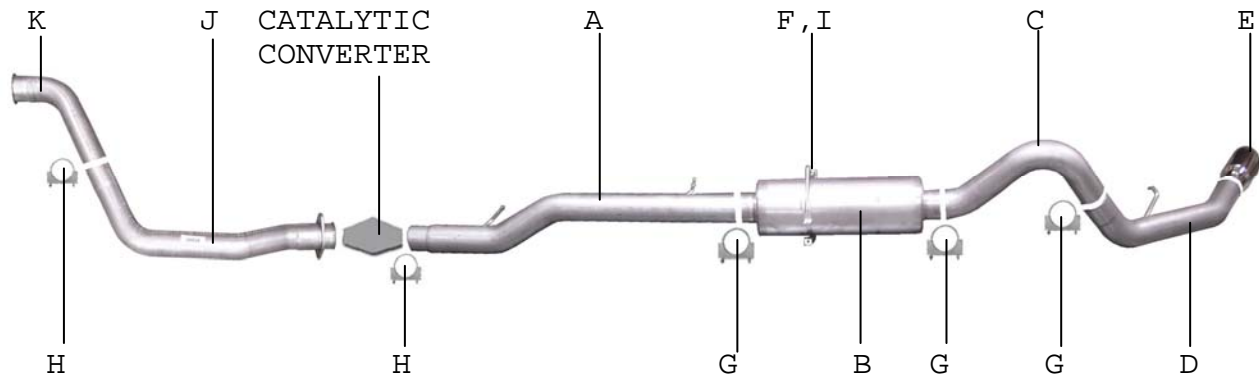




INSTRUCTION MANUAL

CAT-BACK STAINLESS SINGLE 4" EXHAUST WITH DOWN PIPE
 03-06 FORD F250/F350 SUPERDUTY TRUCK
 6.0L POWERSTROKE TURBO DIESEL 2/4WD
 CREW CAB, LONG BED

PART # 619619



ITEM	PART #	QUANTITY	DESCRIPTION
A	657-700523S	1	4" STAINLESS HEADPIPE W/ WELDED HANGERS
B	788040S	1	STAINLESS SUPERFLOW MUFFLER
C	604-700489S	1	4" STAINLESS OVERAXLE TAILPIPE
D	605-700490S	1	4" STAINLESS EXIT PIPE W/WELDED HANGER
E	500401	1	5" STAINLESS TIP
F	4217	1	BAND CLAMP
G	4171	3	4" CLAMP
H	4170	2	3 1/2 CLAMP
I	BO-1015	1	BOLT KIT FOR BAND CLAMP
J	881-700613S	1	3-1/2" STAINLESS PIPE TO CONVERTER W/FLANGE
K	869-700614S	1	3-1/2" STAINLESS PIPE OFF TURBO WITH FLAIR

Thank you for purchasing our GIBSON EXHAUST SYSTEM for your vehicle. If you need any further assistance, please do not hesitate to call our Technical 0905

2ND STEP – EXHAUST INSTALLATION

When installing this exhaust system make sure to use proper safety precautions. Use jack stands when under the truck, set parking brake, block tires and use safety glasses and gloves.

DO NOT WORK WITH HOT PIPES!

SUGGESTED TOOLS:

1/2" , 9/16" , 15mm Socket & Wrench, WD-40, Jack Stand, Hacksaw

Lay out the exhaust on the floor so it looks like the drawing and compare parts with manual



Install the over axle tailpipe # C into the muffler 1-1/2" to 2". Secure to the muffler using clamp # G Do not tighten.



Install head pipe # A on to your existing stock front pipe and line up the notch. Then secure with clamp # H. Insert hangers into rubber grommets. Do not tighten.



Next, remove spare tire. On pass. side there is a bracket that holds the spare tire in place. Remove it and spin it around 180 degrees. Now, re-install your spare tire.



Install band clamp # F into rubber grommets located just above the axle. Do not tighten. And attach with bolt kit # I.



Install exit pipe # D onto overaxle pipe. Then insert welded hanger into rubber grommet. Use clamp # G to secure pipes together.



Install muffler # B onto head pipe # A 1-1/2" to 2" with the louvers facing towards the converter. Use a jack stand to support the muffler. Use clamp # G to secure the muffler to the head pipe. Do not tighten. Muffler inlet is looking into the louvers.



Install stainless steel tip. Clamp down. When you have everything in place, firmly tighten all bolts and clamp down securely starting from the Turbo and work your way back to the rear of the vehicle. To clean stainless steel tip use any stainless steel cleaner and Scotch Brite pad.

MAKE SURE YOU HAVE A 1" CLEARANCE ON ALL RUBBER BRAKE LINES, SHOCK BOOTS, TIRES, FUEL LINES, ETC..

1ST STEP - DOWN PIPE INSTRUCTIONS-

TO INSTALL YOUR GIBSON DOWN PIPE YOU NEED TO REMOVE YOUR STOCK EXHAUST. REMOVE THE STOCK EXHAUST FROM THE CLAMP LOCATED JUST BEHIND THE CATALYTIC CONVERTER. CUT OFF YOUR STOCK TAILPIPE FOR EASIER REMOVAL. LEAVE ALL RUBBER GROMMETS IN PLACE. USE WD-40 TO AID IN REMOVAL OF EXHAUST AND HANGER. AFTER YOUR STOCK EXHAUST IS REMOVED YOU NEED TO REMOVE THE CATALYTIC CONVERTER FROM THE 2-BOLT FLANGE.

NOW CUT YOUR STOCK DOWN PIPE LIKE SEEN IN THE PICTURE.

REMOVE THE REMAINING STOCK DOWN PIPE BY UNCLAMPING IT FROM THE TURBO HOUSING. USE A 11MM SOCKET OR WRENCH. REMOVE YOUR STOCK PIPE THROUGH THE BOTTOM. DO NOT DISCARD THE STOCK CLAMP YOU WILL NEED TO RE-USE IT.

INSTALL PIPE #K ONTO TURBO USING YOUR STOCK CLAMP. DO NOT TIGHTEN.

INSTALL PIPE #J ONTO PIPE #I. USE CLAMP #H TO SECURE PIPES TOGETHER. DO NOT TIGHTEN.

RE-INSTALL YOUR CATALYTIC CONVERTER TO THE NEW DOWN PIPE. USING YOUR FACTORY NUTS.

NOW INSTALL YOUR CAT-BACK EXHAUST ACCORDING TO THE INSTRUCTIONS PROVIDED IN STEP 2.

