



409S Stainless Steel

Installation Instructions SYSTEM #817519

2000-2004 TOYOTA TACOMA
Extended Cab and Crew Cab models
With 2.7L I4 and 3.4L V6 Engines
Does not fit S-Runner.

11/30/11

1) Begin by spraying a penetrating lubricant onto the front flange bolts as well as the nuts at the O2 sensor mount just behind the front flange. Also, spray the rubber hangers that support the factory exhaust system. Then, using a hacksaw or sawzall cut the tailpipe just behind the muffler. Remove the hanger at the rear of the tailpipe from the rubber mount on the vehicle and lower the tailpipe from the vehicle. Cutting the tailpipe is not necessary but makes removal of the stock system easier.



2) Using a 15mm socket, loosen the bolts at the front flange connection behind the catalytic converter, be careful not to damage the gasket, it will be reused with the Flowmaster system. Also, loosen the nuts on the O2 sensor mount and remove from the inlet pipe.



3) Support the muffler with a stand and remove the two hangers on the muffler from the rubber mounts on the vehicle. Lower the muffler assembly from the vehicle.



4) Connect the flange on inlet pipe **#16709S** to the flange behind the catalytic converter. Be sure to replace the gasket between the two flanges. Use the included 3/8" bolts, nuts and washers to secure the two flanges together. Use the factory hardware to re-install the O2 sensor to the inlet pipe.

5) Place the provided 2.50" clamp onto the muffler inlet and place the muffler onto the back of the inlet pipe. Support the muffler with a stand and tighten the clamp enough to hold but still allow for adjustment.



6) On the passenger side of the truck at the rear of the frame there are three bolts which bolt the rear cross member to the frame. You will need to remove the center bolt and washer from the frame, once removed place the included **431HA** hanger over the hole and replace the bolt and washer. The hanger will point toward the spare tire. Tighten securely. Place the included **HA168** rubber hanger onto the end of hanger **431HA**.



7) Place the provided 3" clamp onto the muffler outlet. Place tailpipe #26353S into position over the rear axle and connect to the muffler outlet while also connecting the two hangers on the front of the tailpipe to the rubber mounts on the vehicle. Then connect the wire hanger at the rear of the pipe to the rubber mount installed in the previous step. Tighten the clamp enough to hold but still allow for adjustment.



8) Place the ST429 stainless tip onto the end of the tailpipe and adjust to the desired location. Tighten the nut on the clamp to secure the tip in place.

9) Adjust the position of all pipes and muffler to provide a satisfactory fit. Be sure to maintain an adequate clearance around all parts of the system to avoid rattles or damage to heat sensitive components. Once you're happy with the fit, tighten all connections down securely. For a cleaner appearance and more secure installation, we highly recommend welding all slip-fit connections.

PACKING LIST

<u>Qty</u>	<u>Description</u>	<u>Part#</u>
1	Inlet Pipe Assembly	16709S
1	Muffler Assembly	852555-243
1	Tailpipe Assembly	26353S
1	Stainless Tip	ST429
1	Parts Kit	PK599
	1 Rear Frame Hanger	431HA
	1 2½" Band Clamp	MC250BS
	1 3" Band Clamp	MC300BS
	4 7/16" Hanger Keepers	HW502
	1 Rubber Mount	HA168



Installation diagram for:

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**AMERICAN
THUNDER**

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