

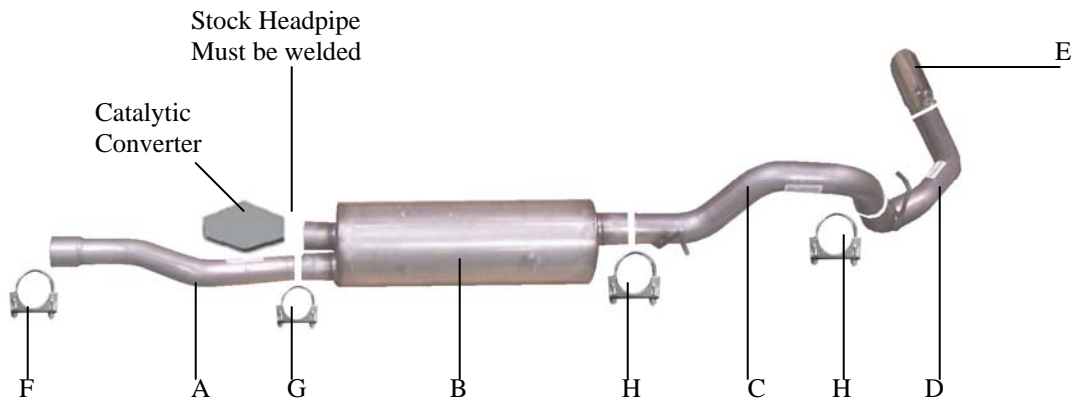


# INSTRUCTION MANUAL

## CAT-BACK STAINLESS SINGLE EXHAUST

00-06 SUBURBAN, YUKON XL 2500 6.0L-8.1L 2/4WD  
02-06 AVALANCHE 2500 CREWCAB, SHORT BED 8.1L 2/4WD

### PART # 615531



ITEM	PART #	QTY	DESCRIPTION
A	427-700272S	1	2.5" S/S DRIVERSIDE HEADPIPE
B	758250S-8	1	S/S SUPERFLOW DUAL INLET MUFFLER
C	301-700158S	1	3" S/S OVERAXLE TAILPIPE
D	428-700273S	1	3" S/S EXIT PIPE
E	500360	1	3-1/2" STAINLESS TIP
F	5758	1	2 3/4" CLAMP
G	5757	1	2 1/2" CLAMP
H	OHD300	2	3" CLAMP

**MIMINUM WELDING REQUIRED**

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 1-800-528-3044 Monday through Friday, 8:00 AM to 5:00 PM. 0106

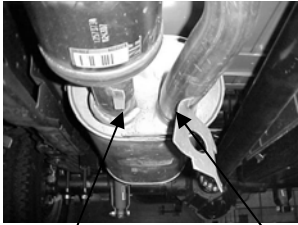
# EXHAUST INSTALLATION

WHEN INSTALLING THE GIBSON EXHAUST SYSTEM MAKE SURE TO USE ALL THE PROPER SAFETY PRECAUTIONS. USE JACKSTANDS WHEN UNDER THE TRUCK, SET PARKING BRAKE, BLOCK TIRES, AND USE SAFETY GOGGLES AND GLOVES. DO NOT WORK WITH HOT PIPES!

## SUGGESTED TOOLS

9/16" SOCKET & WRENCH, 15MM SOCKET, 1/2" SOCKET & WRENCH, HACKSAW, JACKSTAND, WD-40

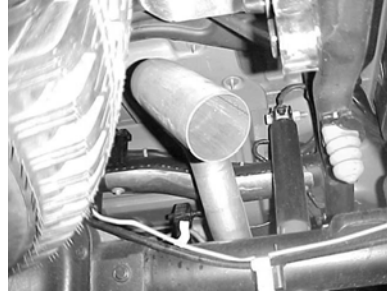
**NOTE: THIS KIT REQUIRES SOME WELDING**



FACTORY EXHAUST BRACKET

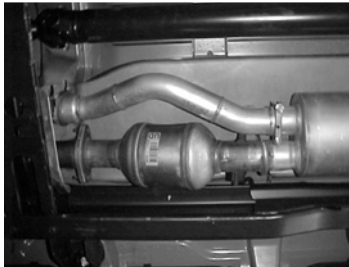
CUT BRACKET AT THIS POINT. THEN CUT 3/4" IN FRONT ON THE MUFFLER ON PASS. SIDE

LAY THE EXHAUST ON THE FLOOR AND COMPARE PART NUMBERS WITH THE MANUAL. REMOVE THE FACTORY EXHAUST BRACKET AT THE FRONT OF THE MUFFLER BY USING A HACKSAW. CUT 3/4" IN FRONT OF THE STOCK MUFFLER ON PASSENGER SIDE. UNBOLT THE DRIVER SIDE 23 1/2" IN FRONT OF THE FACTORY MUFFLER. FOR EASIER REMOVAL CUT TAILPIPE AND REMOVE. NEXT, REMOVE THE STOCK EXHAUST. LEAVE ALL FACTORY RUBBER GROMMETS. USE WD-40 ON ALL RUBBER GROMETS.



INSTALL OVERAXLE TAILPIPE #C INTO THE REAR OF THE MUFFLER. SLIP THE HANGER INTO THE FACTORY RUBBER GROMMET. USE CLAMP #H AT THE REAR OF THE MUFFLER, BUT DO NOT TIGHTEN.

INSTALL THE EXIT PIPE #D. USING CLAMP #H TO ATTACH. DO NOT TIGHTEN. ROTATE ALL PIPES UNTIL YOU HAVE A MINIMUM OF A 1-2" CLEARANCE ON ALL PIPES. SPARE TIRE MAY NEEDED TO BE LOOSENED AND PUSH TOWARD THE DRIVERSIDE INSERT WELDED HANGER INTO RUBBER GROMMET.



MUFFLER MUST BE WELDED ON THE PASSENGER SIDE INLET AND CLAMPED ON THE DRIVER SIDE INLET WITH CLAMP #G. DO NOT WELD UNTIL KIT IS COMPLETELY INSTALLED.



MUST BE WELDED AT THIS POINT

INSTALL HEADPIPE #A ON THE FACTORY DRIVER SIDE HEADPIPE USING CLAMP #F. DO NOT TIGHTEN. INSTALL THE MUFFLER WITH THE OUTLET POSITIONED AT 12 O'CLOCK. USE A JACK STAND TO SUPPORT THE MUFFLER.



WELD PASSENGER INLET OF THE MUFFLER TO THE FACTORY HEADPIPE. THEN TIGHTEN ALL CLAMPS AND HANGERS. INSTALL YOUR STAINLESS STEEL TIP. USE ANY ALUMINUM OR STAINLESS STEEL CLEANER TO POLISH YOUR TIP.

**MAKE SURE YOU HAVE A MINIMUM OF 1" CLEARANCE FROM ALL BRAKE LINES, FUEL LINES, SHOCKS, TIRES, ETC.**