



INSTALLATION INSTRUCTIONS
FORD RAPTOR
3.5L TWIN TURBO ECOBOOST SUPER CREW 5.6" BED 4WD
SINGLE SIDE EXHAUST KIT

PART # 619701-B



ITEM	Part Number	Quantity	Description
A	999700981S	1	3.0" Headpipe Assembly
B	11244S-1	1	SuperFlow SFT Muffler
C	999700982S	1	3.5" OverAxle Tailpipe
D	500649-B	1	5.0" Rolled Black Ceramic Tip
E	4170	1	3.5" Clamp
F	OHD300	1	3.0" Clamp
G	BO-1020	1	Bolt Kit

CAREFULLY READ INSTRUCTIONS BEFORE INSTALLING PRODUCT

When installing this exhaust system make sure to use proper safety precautions. Use jack stands when working under the vehicle, set parking brake, block tires and use safety glasses and gloves. Allow exhaust to cool before attempting installation. Severe injury or burns could occur if safety measures are not taken.

SUGGESTED TOOLS: 1/2", 9/16" 15mm wrenches & sockets, WD-40, hacksaw, jack stands.

1. First you want to remove your factory exhaust. You will need a 13mm, 15mm and a 10mm socket and wrench. It is easier to remove system by removing the hanger brackets from the vehicle. Be sure you re install them exactly as they were removed.
2. Install your Gibson headpipe assembly #A by using provided bolt kit #G do not tighten all the way until the end of your installation.
3. Install your Gibson Muffler #A. The outlet position will be at 2:00. While the muffler is supported re install the rear OEM hangers's and tighten. Do not tighten exhaust connection.
4. Install your Gibson Over-Axle Tailpipe #B, Re install the OEM hangers and tighten. Use Clamp #E to secure. Do not Tighten
5. Install your Gibson Rolled Tip and adjust it to your liking, place something under it to secure the position and go back to tighten all bolts completely. After each connection is tightened be sure to double check clearance. Drive vehicle for 50-100 miles and re-tighten as necessary.

**"MAKE SURE YOU HAVE A 1" CLEARANCE ON ALL PIPES FROM ALL RUBBER BRAKE LINES, SHOCK BOOTS, TIRES, ETC..."
TORQUE ALL CLAMPS UNTIL USING AN IMPACT WRENCH.**

