



INSTALLATION INSTRUCTIONS

FORD RAPTOR

3.5L TWIN TURBO ECOBOOST SUPER CREW, SHORT BED 5.6" 4WD SUPERTRUCK EXHAUST KIT

PART # 69549



ITEM	Part Number	Quantity	Description
A	999700983S	1	3.0" DS Headpipe W/ welded Flange
B	999700984S	1	3.0" PS Headpipe
C	BM0108	2	3.0" M.W.A Superflow Muffler
D	999700985S	1	3.0" X-Pipe
E	999700986S	1	3.0" Driver Side Tailpipe
F	999700987S	1	3.0" Passenger Side Tailpipe
G	800033	1	Rear Tailpipe Hanger
H	BO-1020	1	Bolt Kit
I	BO-907	1	Bolt Kit for Tailpipes
J	500427	2	4.0" Intercooled Clamp on Tips
K	4240	1	Rubber Hanger

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 (800) 528-3044, Monday through Friday, 8:00 am to 5:00 pm PST.

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 first from the Vehicle frame. Be sure you replace the necessary hangers brackets as they were removed.
2. First, install your Gibson headpipes #A and #B using the provided bolt kit #H do not tighten all the way until the end of your installation.
3. Second, you want to install your Gibson SuperFlow mufflers #C and secure their position at by placing something under them to hold them. And something between them to keep them aligned through the process.
4. Next, you want to install your Gibson X pipe #D. This is where you will find the most adjustment for the install. If you find something is not fitting correctly or hitting the frame rail use this point to make minor adjustments buy rotating the X-pipe.
5. After installing your X, use the factory provided clip that's threaded to hold the middle non used rubber grommet. Install the clip on the passenger side frame rail as shown in photo →. Once you have clipped it, you will install your welded hanger #G in the position shown → Do not tighten until everything has been dry fit.
6. Then, you want to install your Gibson Tailpipes, It is suggested you start with the Passenger Side #F, Insert the hangers into the Rubber grommets, then proceed to Install the Driver Side #E. Align the Clips and use provided bolt kits #I to have the correct alignment of your tailpipes. You may need to firmly adjust the kit into placement to allow for proper clearance of the tips.
7. Finally you want to install your Gibson Tips and adjust them to your liking, place something under them to secure the position. Do not tighten until you are satisfied with the fit and finish of the kit. Tighten all bolts completely. Drive vehicle for 50-100 miles and re-tighten as necessary.

