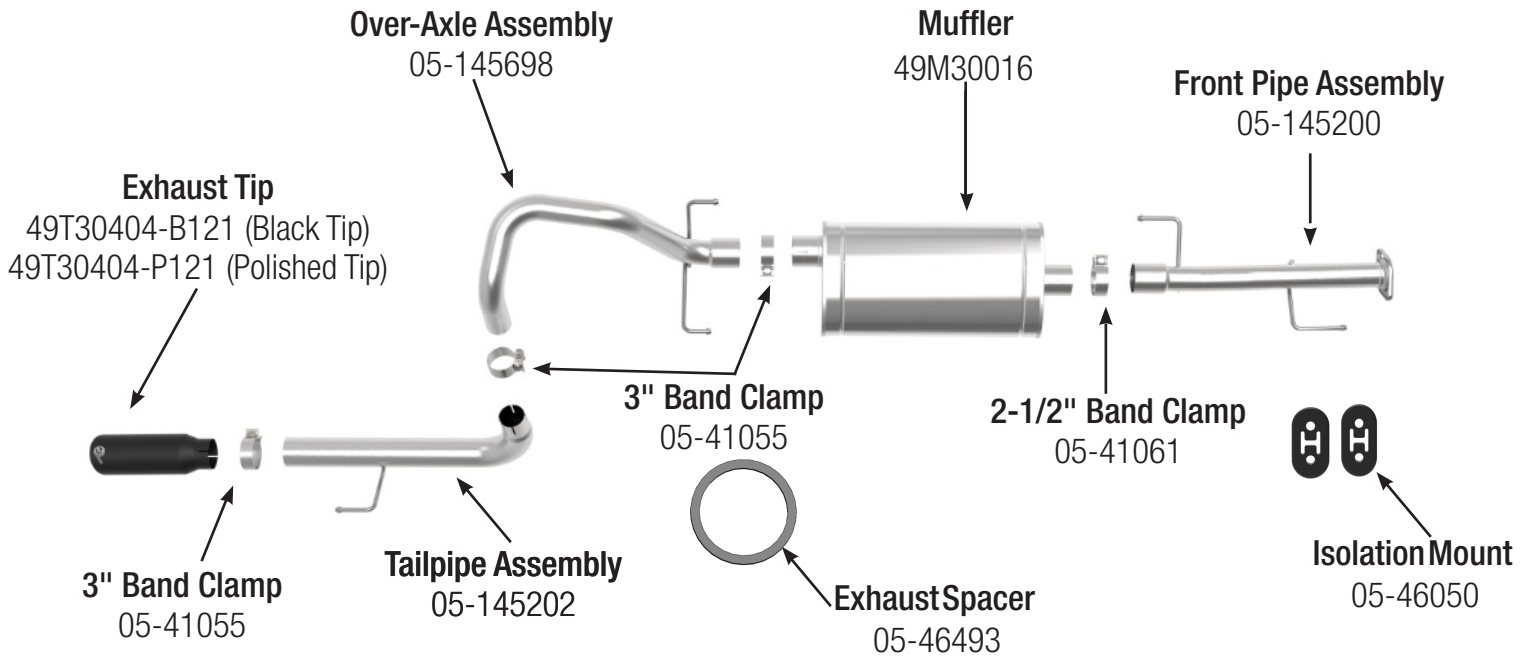




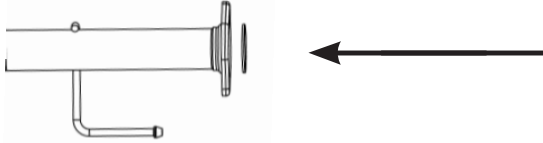
## INSTALLATION INSTRUCTIONS

**MAKE:** Toyota  
**MODEL:** 4Runner  
**YEAR:** 2010-2023  
**ENGINE:** V6-4.0L  
**FITS:** Compatible with Kinetic Dynamic Suspension System (KDSS)

**MACH Force-Xp  
Cat-Back Exhaust**  
49-36040-1B (Black Tip)  
49-36040-1P (Polished Tip)



**Caution:** aFe recommends professional installation on our products. Allow time for your vehicle to cool down prior to installation. When working on or under your vehicle proceed with caution. Exhaust systems reach high temperatures and may cause serious burns. Wear protective safety equipment; eye goggles and gloves to ensure a safe installation.

- Step 1: (Read instructions prior to installation.)** Remove your stock exhaust up to the catalytic converter from the rear of your vehicle, working your way forward. Take caution not to damage the factory hardware and isolation mounts as they will be reused. (It is recommended to not fully tighten the clamps until the entire system has been installed.)
- Step 2:** For faster installation, spread the pieces of the exhaust alongside of your vehicle according to the diagram shown above.
- Step 3:** Remove the OE gasket on the stock y-pipe. Insert the provided spacer (05-46493), then re-install the OE gasket.
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- Step 4:** Install the front pipe onto the stock y-pipe using the stock bolts, gaskets, and factory isolation mounts. Install the muffler assembly. (Use a jack stand to support the muffler assembly), replace the mounts. Install the muffler assembly. (Use a jack stand to support the muffler assembly), replace the factory isolation mounts with the provided mounts (05-46050).
- Step 5:** Install the over axle pipe into the muffler assembly. Adjust the pipe to have clearance between the frame and the floor of the vehicle. Heat shield by spare tire may need to be adjusted.
- Step 6:** Install the tailpipe into the over-axle assembly.
- Step 7:** Place the pipe and the tip at the desired position, do not fully tighten.
- Step 8:** Adjust and straighten out the exhaust. You can now begin to tighten down your exhaust, beginning at the front flange and working your way back.
- Step 9:** Your installation is now complete. It is recommended to re-tighten all exhaust components after 50-100 miles.