



# Installation Instructions

## 738173

2024-2025 Toyota Tacoma

2.4L Turbo 4 cyl

131.9 / 145.1" Wheelbase

Installation requires moderate mechanical skill. If this job is beyond your abilities, seek the services of a qualified technician.

If you do not understand any part of these instructions, please call Flowmaster Technical Support at (866) 464-6553 for assistance.

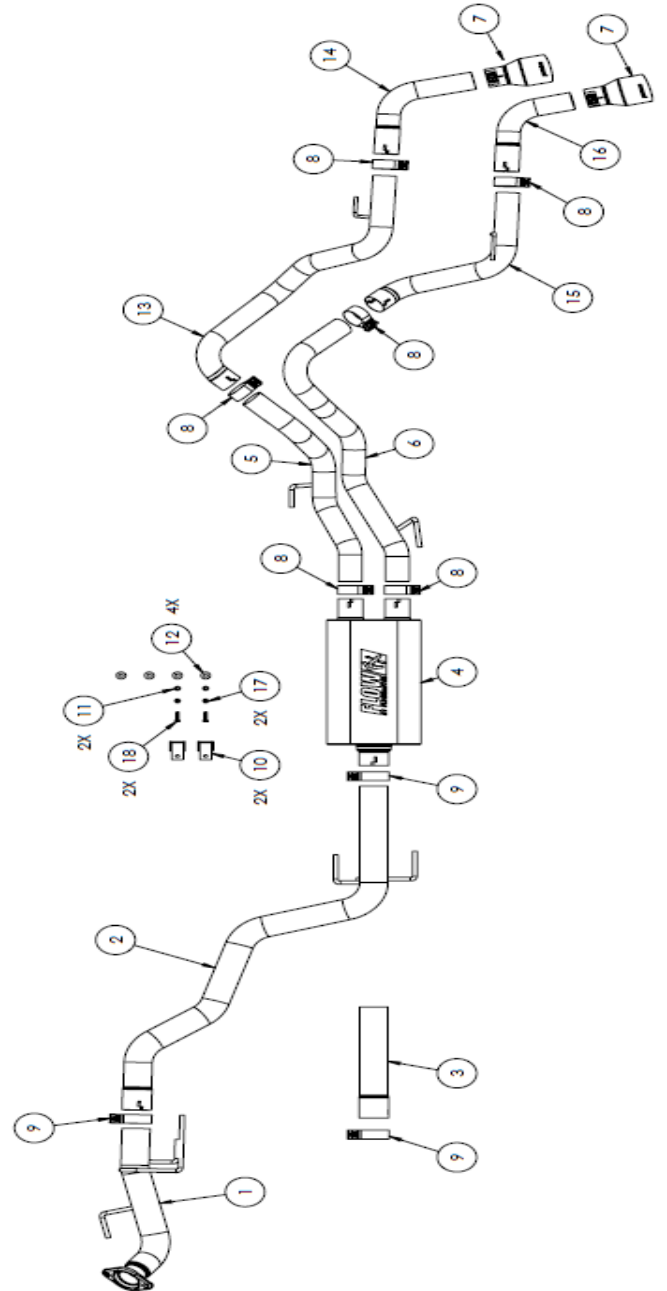
Apply penetrating oil generously to clamps, fasteners, pipes, and hanger rods for ease of disassembly.

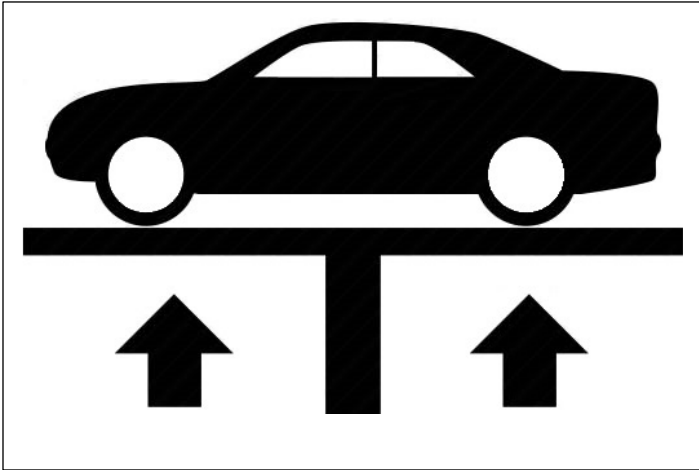
### REVIEW THE INSTRUCTIONS & VERIFY THE KIT CONTENTS

Take a moment to read and understand these instructions before installing your Flowmaster exhaust kit.

ITM#	Part #	Description	Qty.
1	26982H	Down Pipe	1
2	26983H	Muffler Inlet Pipe	1
3	26984H	Extension Pipe	1
4	73688-Z	Signature Series Muffler	1
5	86785H	Right Muffler Outlet Pipe	1
6	86788H	Left Muffler Outlet pipe	1
7	ST460BC	Black Chrome Tip	2
8	MC250BS	2.5" Band Clamp	6
9	MC300BS	3" Band Clamp	3
10	HA602	Tail Pipe Hanger	2
11	HW308	5/16 Lock Washer	4
12	HW303	3/8 Flat Washer	4
13	86791H	Right Tail Pipe	1
14	86792H	Side Exit Pipe "B"	1
15	86793H	Left Tail Pipe	1
16	86794H	Side Exit Pipe "A"	1
17	HW123	M8 X 1.25 Hex Nut	2
18	HW289	M8 x 1.25 x 30mm Bolt	2

Use the parts drawing and list to identify components and verify your kit's contents. In the unlikely event that any parts are missing, please contact Flowmaster Technical Support for replacements.





## Vehicle Compatibility

Model Year: 2024-2025

Make: Toyota

Model: Tacoma

- 131.9" and 145.1" Wheelbase

Engine: 2.4L Turbo 4 cyl

### BEFORE STARTING:

Raise the vehicle to a minimum of eighteen inches. A floor hoist is ideal. If no hoist is available, we strongly urge the use of axle stands as a safety measure. **Please read and understand these instructions and disclaimer in their entirety before attempting installation.**

**CAUTION! WORK ONLY ON A LEVEL SURFACE. USE JACKS /JACK STANDS OF SUFFICIENT CAPACITY TO LIFT AND SUPPORT YOUR VEHICLE. NEVER WORK UNDER A VEHICLE SUPPORTED BY A FLOOR OR BUMPER JACK.**

### Removing the OEM Exhaust:

NOTE: Please read and follow all instructions before attempting to install this exhaust system.

- The OEM muffler and inlet pipe are welded assembly and can be difficult to handle. It is recommended to have a second person available to assist with removing the OEM muffler and inlet pipe assembly.

1. Apply penetrating oil to each rubber Hanger on the exhaust.
2. Support the muffler before disassembly or removing any rubber hangers.
3. Lifting the vehicle to full rear suspension drop or removing the spare tire will be necessary to remove the OEM Tail pipe from the vehicle.
4. Remove the (2x) 14mm nuts from the tail pipe flange connection (A) just after the OEM muffler. Remove the Rubber hanger isolators (B) from the hanger rods and remove the OEM tail pipe. **Fig.1**
5. Remove the spring bolts at the flanged connection between the down pipe and the muffler inlet pipe(C). **Fig.2**
6. Remove the rubber isolators (D) from the muffler hanger rods then remove the muffler assembly.
7. Remove the spring bolts from the flanged connection between the catalytic converter and the down pipe (E), remove the rubber isolators (F) and remove the down pipe. **Fig.2**

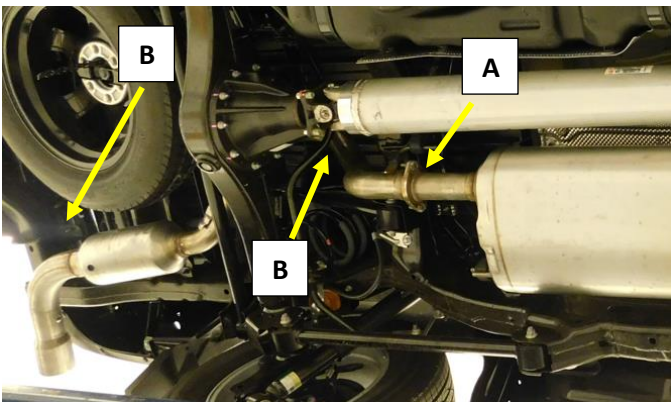


Figure.1

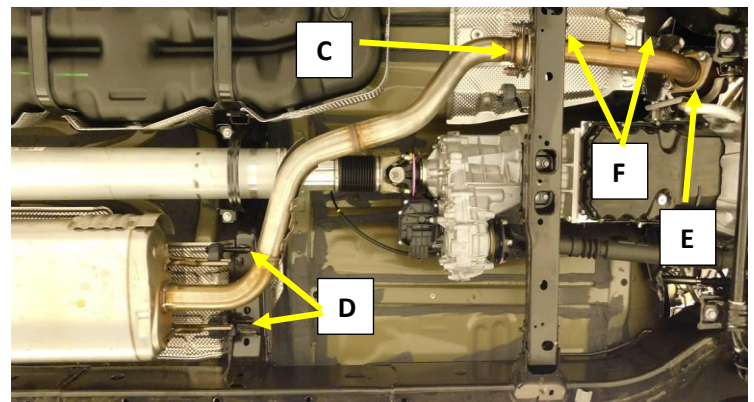


Figure.2

## Installing your 738173 Flowmaster Exhaust

1. Install the supplied Down Pipe (1) on to the catalytic converter using the OEM spring bolts. **Fig.3**

**Important:** Start the bolts by hand using a 6" extension and a ratchet, DO NOT use an impact driver. Be sure the bolts start in the threads easily and do not force the issue if it feels bound or cross threaded. Keep positive pressure on the spring as the bolt is threaded into the nut on the catalytic converter flange. Start both bolts several threads before tightening them evenly until the bolt shoulder passes through the downpipe flange and seats on the flange of the catalytic converter.

\*The flange should not be tight on the gasket when the bolts are tightened. This is designed to be a floating connection with the spring pressure maintaining the flange to gasket seal. **If the flange does not move, something is wrong!**

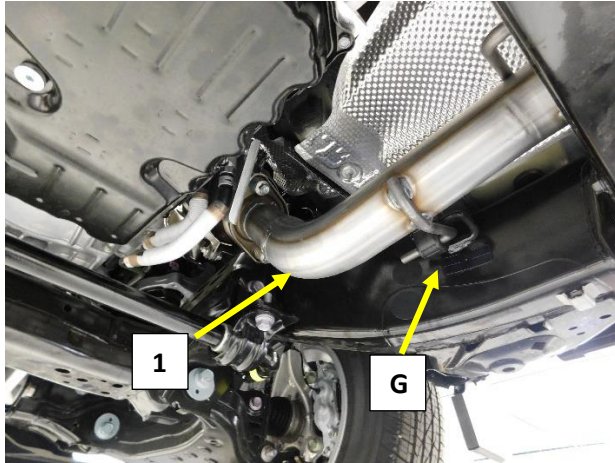


Figure.3

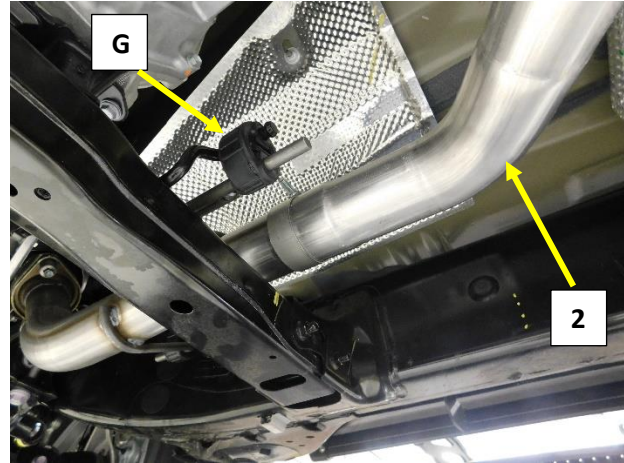


Figure.4

2. Install the rubber Isolators (G) on to the hanger rods. **Fig.3/4**
3. Install a 3" band clamp (9) onto the inlet (expanded section) of the Muffler inlet pipe (2). Position the clamp with the bolt at the top of the expanded section and the nut facing the transmission. **Fig.4/5**

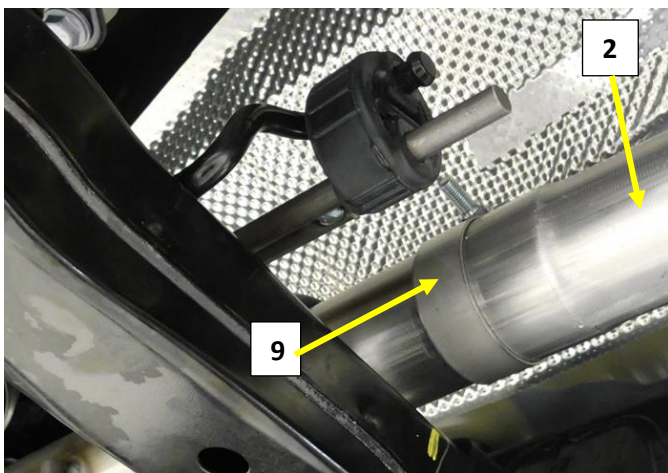


Figure.5

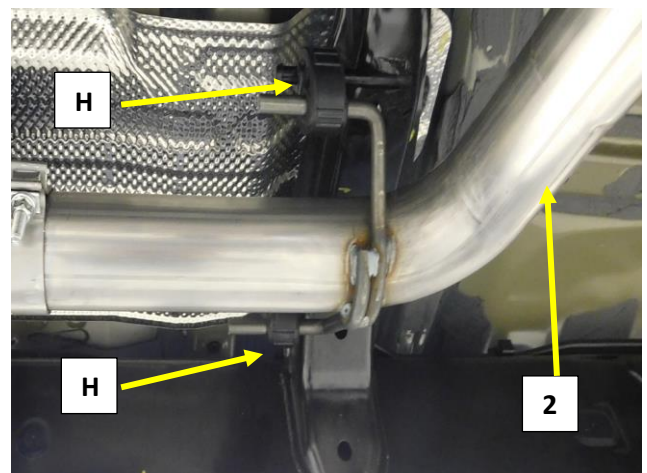


Figure.6

4. Install the muffler inlet pipe (2) on to the down pipe (1), align the hanger rods with the frame hangers and install the rubber isolators. **Fig.4/5/6**

## Installing your 738173 Flowmaster Exhaust

5. Install a 3" band clamp (9) on to the inlet of the 73688-Z muffler (4). Fig. 7
6. Install the muffler (4) on to the muffler inlet pipe (2), align the muffler with the logo down and muffler case level. Tighten the clamp. Fig. 7 **Note: Use extension pipe 26984H (3) between Muffler and inlet pipe for 145.1" wheelbase**
7. Install a supplied 2.5" band clamp (8) on each muffler outlet. Fig.8

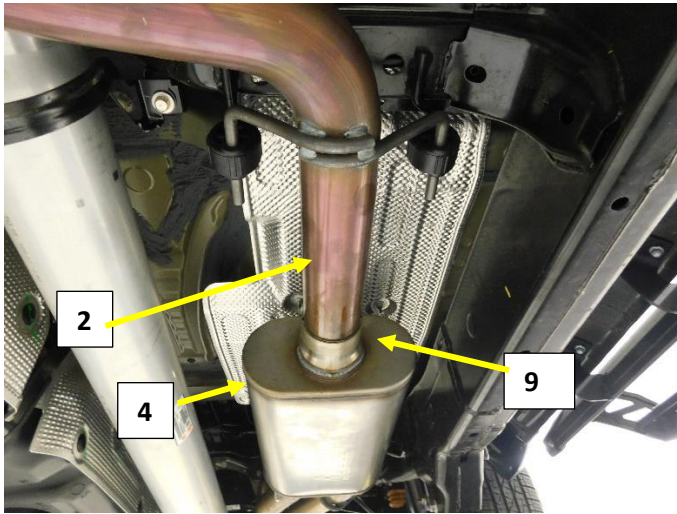


Figure.7

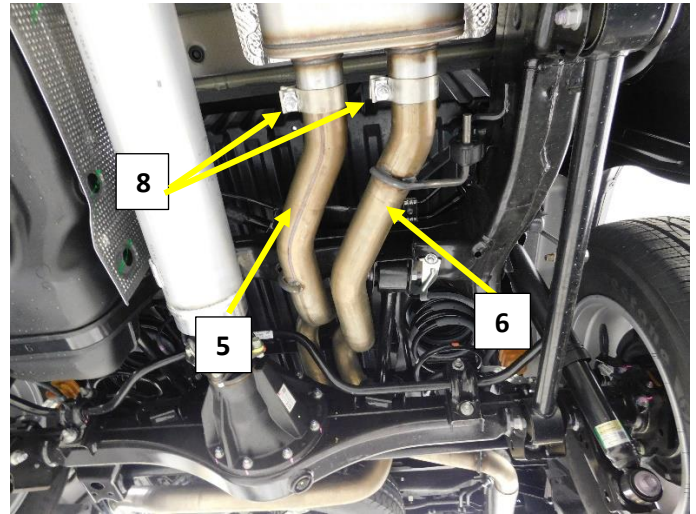


Figure.8

8. Install the Left Muffler Outlet Pipe (6) into the mufflers left (drivers' side) outlet. Install the rubber isolator on to the hanger rod and frame hanger. Rotate the outlet pipe to a  $\frac{1}{2}$  to  $\frac{3}{4}$ " clearance on the upper 4 link bar. Tighten the clamp just enough to prevent movement. Fig.8/9
9. Install the Right Muffler Outlet Pipe (5) into the mufflers right (passenger side) outlet. Rotate the pipe up and install the rubber isolator on to the hanger rod and frame hanger. Adjust the clearance between the two pipes to  $\frac{1}{2}$ " just after the bend up into the chassis. Tighten the clamp just enough to prevent movement. Fig.8/10

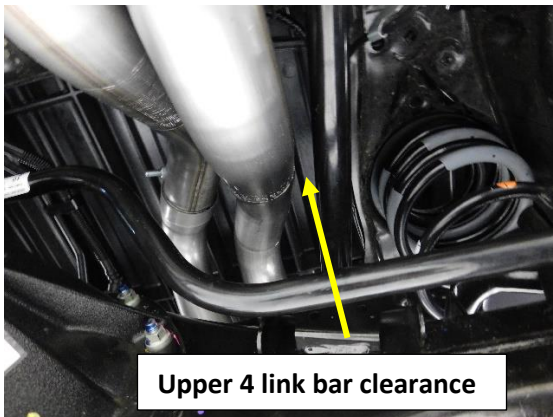


Figure.9

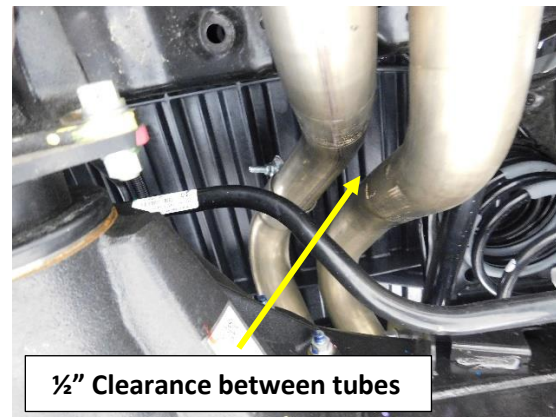


Figure.10

## Installing tail pipes and frame hangers

1. Remove the spare tire
2. Remove the plastic plug from the rear frame rail access holes just behind the Drivers side rear tire **(J)**. **Fig.11**
3. Install a flat washer on to the Supplied M8x 30mm bolt **(18)**.
4. Install the bolt and washer through the access hole and into the square hole in the bottom of the frame rail just below the access hole. This is best accomplished with a small telescoping magnet or magnetic screwdriver that will hold the bolt and washer as they are installed into the frame rail. **Fig.12**
5. Remove the left forward M8 X 20mm mounting bolt for the spare tire carrier **(K)** and loosen the left rear mounting bolt **(L)**. **Fig13**



Figure.11

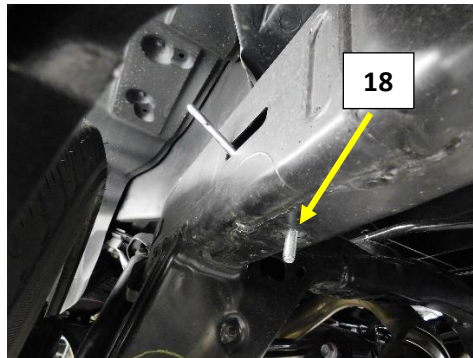


Figure.12

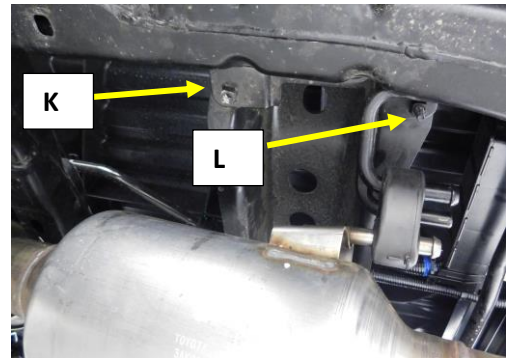


Figure.13

10. Install a 2.5" band clamp **(8)** on to the left tail pipe expanded end **(15)**. Position the clamp with the bolt at the top of the pipe and the nut facing the spare tire when the tube is installed on to the Left muffler outlet pipe **(6)**. **Fig.14**
11. Install the left tail pipe **(15)** on to the left muffler outlet pipe **(6)** just over the Panhard bar and upper 4 link bracket. **Fig.14**
12. Install a supplied tail pipe frame hanger **(10)** on to the left tail pipe hanger rod **(15)**. Rotate the tail pipe up and position the frame hanger on to the bolt **(18)** installed into the frame rail, install a flat washer, lock washer and nut. Use the magnet or screwdriver in place to help hold the bolt as the washers and nuts are installed. **Fig.15**

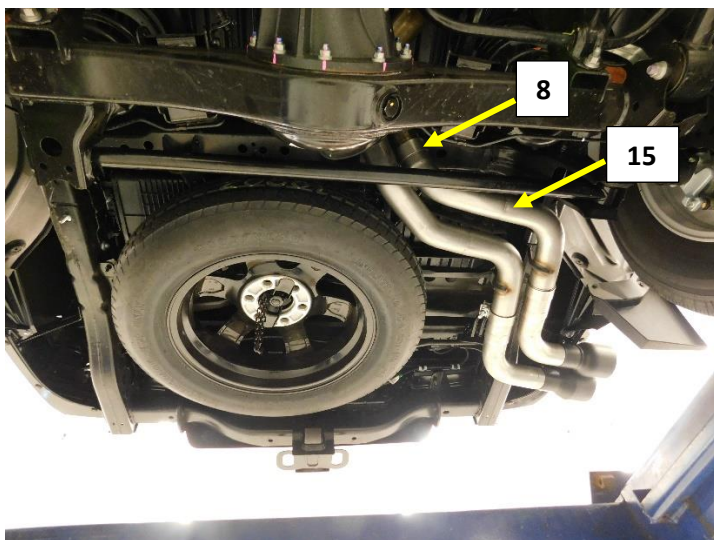


Figure.14

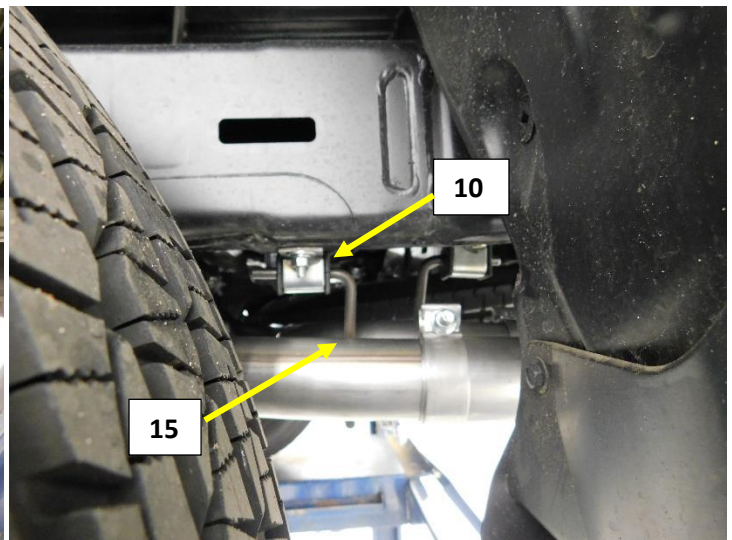


Figure.15

## Installing tail pipes and frame hangers

13. Install a 2.5" band clamp (8) on to the expanded end of the right tail pipe (13). Position the clamp (8) with the bolt at the top of the pipe and the nut facing the right frame rail when installed on to the right muffler outlet pipe (5). Fig.16
14. Install the right tail pipe expanded end on to the right muffler outlet pipe just over the Differential. Position the clamp and tighten to allow adjustment.
15. Install a supplied tail pipe frame hanger (10) on to the right tail pipe hanger rod (14). Rotate the tail pipe up and position the frame hanger (10) at the left forward spare tire mounting bolt location that had the bolt removed in step.5. Fig.17
16. Install a flat washer on to the supplied M8 x30mm bolt.
17. Install the M8 bolt (18) and flat washer (12) into the frame hanger and into the threaded insert. Tighten the bolt. Fig.17
18. Install a flat washer, lock washer and nut on to the bolt from the top and tighten.
19. Tighten the rearward bolt for the spare tire carrier that was loosened in step.5

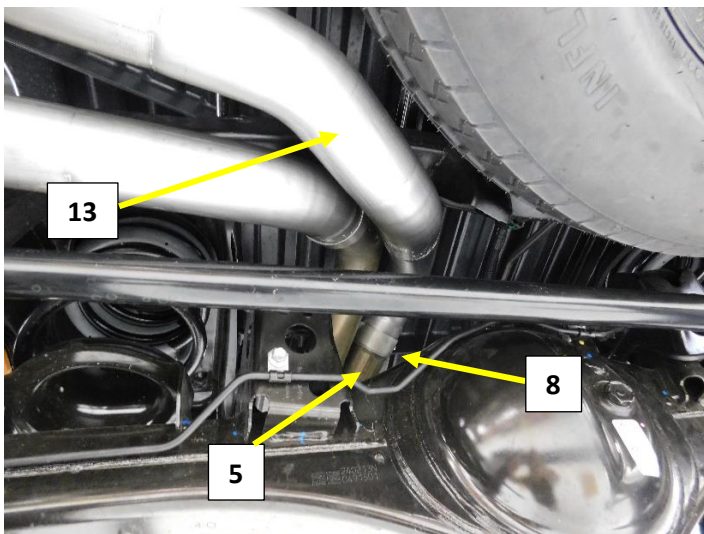


Figure.16

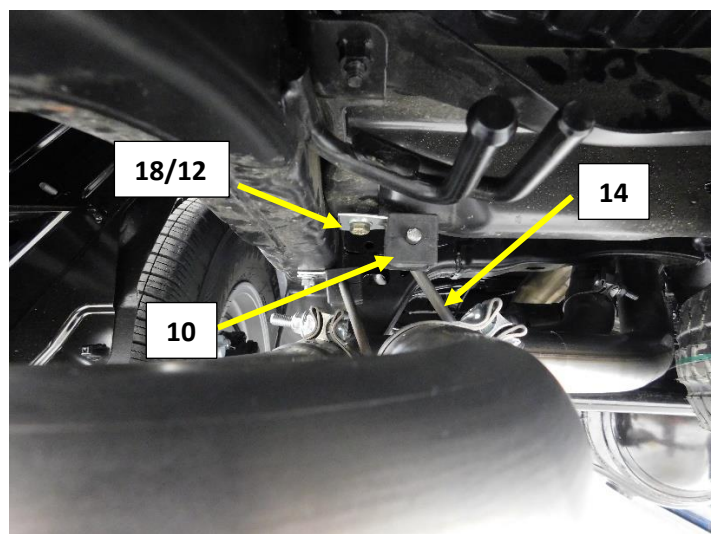


Figure.17

20. Install a 2.5" band clamp on to the Side Exit Pipe "A" (16) with the clamp at the top of the pipe and bolt facing out.
21. Install Side Exit Pipe "A" pipe on to the left tail pipe and tighten the clamp to allow for adjustment. Fig.18
22. Install a 2.5" band clamp on to the Side Exit Pipe "B" (14) with the clamp at the top of the pipe and bolt facing in.
23. Install Side Exit Pipe "B" pipe on to the right tail pipe and tighten the clamp to allow for adjustment. Fig.19

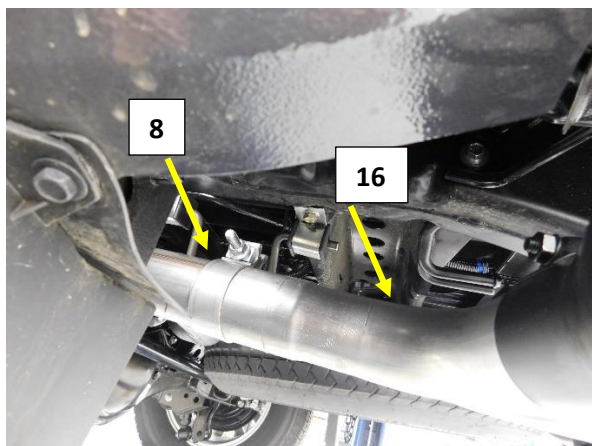


Figure.18

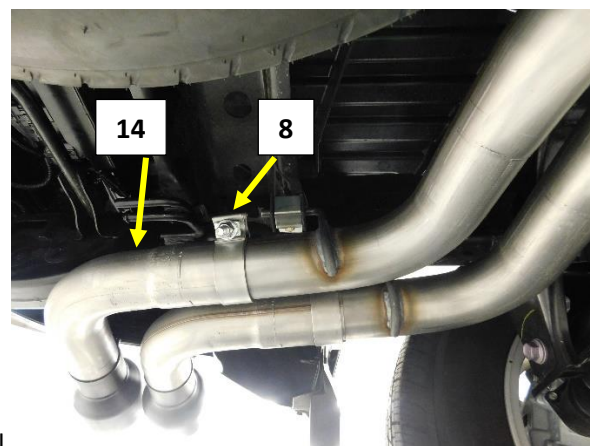


Figure.19

## Final Adjustment

24. Install the Black Chrome tips (7). Adjust to personal preference and tighten the clamp bolts.
25. Start at the front of the exhaust and adjust the components for best alignment and component clearance. Tighten the clamps as you go.
26. Install the spare tire and pull it toward the trailer hitch and to the right side as far as it will go for maximum clearance around the tail pipes and tighten the hold down.



Enjoy Your Flowmaster Exhaust!