



A DIVISION OF SUMMIT INDUSTRIES, INC.

89253 "RACE USE ONLY" Y-PIPE ASSEMBLY

2003-2004 TOYOTA 4RUNNER, LEXUS GX-470, 4.7L



**NOTE: DUE TO VARIATIONS FROM MANUFACTURER DRIVER'S SIDE
FLANGE MUST BE WELDED INTO CORRECT POSSITION**

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LEGALITY NOTE

This y-pipe DOES NOT comply with California air resource Board regulations and is NOT LEGAL for sale or use on pollution controlled vehicles in the state of California. This y-pipe is intended for use on vehicles that are involved in closed course racing applications only. It will be referred to as "RACE USE ONLY" in any other location in this instruction sheet, or any marketing information.

The installation of this y-pipe onto any vehicle must be performed in accordance with all government regulation that pertains to the particular vehicle receiving the y-pipe. Please call your Doug Thorley Headers distributor if there are any questions regarding the legality of the installation.

WARRANTY NOTES

The utmost care is taken at Doug Thorley Headers to maintain the highest standards of quality. However, Doug Thorley Headers cannot control the installation of the product. For this reason, the Doug Thorley Headers warranty covers only the replacement of the components, not the labor for the installation.

1. *The use of any type of "header wrapping" voids the warranty. Using any sort of wrapping material on the headers destroys the tubing's ability to dissipate heat, causing very rapid deterioration of the metal and the subsequent failure of the headers.*
2. *Retain all paperwork pertaining to the purchase of your Doug Thorley Headers product. Save your receipt, your limited life time warranty is not valid without the original proof of purchase.*

PARTS INCLUDED

- Main Y-Pipe Assembly (1)
- Driver Side Y-pipe #1 Assembly (1)
- Band clamp, 2-1/4" (2)

TOOLS REQUIRED

- 3/8" Drive Ratchet
- Assorted Extensions
- 12mm Socket
- 10mm Wrench
- 14mm Socket
- Crescent Wrench
- WD40 or Equivalent
- Welder

INSTALLATION NOTES

1. It is important that you read the entire instruction sheet before initiating any installation.
2. Gather all appropriate tools and secure a clean work space.
3. Do not cut or modify parts unless instructed to do so.
4. Always disconnect the battery when working on your vehicle to avoid any potential problems.
5. Your vehicle should be raised to ease installation. A hoist is ideal, however, installation can be accomplished using a floor jack and jack stands. CAUTION: Never work on a vehicle that is supported by a bumper jack only.

INSTALLATION PROCEDURE NOTES

WARNING! – DO NOT RELY ON BUMPER JACKS OR CHASSIS JACKS FOR SUPPORT DURING HEADER INSTALLATION. THE VEHICLE SHOULD BE RAISED AND SUPPORTED WITH JACKING EQUIPMENT AND JACKSTANDS OR RAMPS INTENDED FOR UNDERCARRIAGE AUTO MAINTENANCE. IT IS EXTREMELY DANGEROUS TO WORK UNDER ANY IMPROPERLY RAISED AND/OR SUPPORTED VEHICLE.

WARNING! – MAKE CERTAIN THERE IS AMPLE CLEARANCE AROUND COMPONENTS SUCH AS BRAKE LINES, BRAKE PROPORTIONING VALVES, FUEL LINES, HOSES AND PUMPS, AND ELECTRICAL COMPONENTS AND WIRES. IN SOME CASES IT MAY BE NECESSARY TO RELOCATE ITEMS THAT MAY BE ADVERSELY AFFECTED BY EXHAUST SYSTEM HEAT.

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INSTALLATION PROCEDURES (**NOTE:** THESE PROCEDURES ARE DOCUMENTED ON FACOTRY STANDARD-EQUIPPED VEHICLES WITH ORIGINAL CONFIGURATION COMPLIANCE. **ANY** MODIFICATION OF THE SUBJECT VEHICLE MAY DICTATE MODIFICATION TO INSTALLATION PROCEEDURES.)

1. Starting at the rear of the exhaust, spray WD40 or equivalent lubricant on the rubber hanger to allow easy removal of all hanger rods.
2. Unbolt the flange from behind the catalytic converter. Slide the exhaust system back and out of the way.
3. Unbolt the flanged connection just to the right of the transmission.
4. Remove the bracket from the transmission cross member on the Driver side.
5. Unplug both O2 sensors from the wiring harness.
6. Unbolt and remove the connector popes from the manifolds/headers. Save all hardware and gaskets as they will be reused in the new system.
7. Carefully remove the O2 sensors from the factory head pipes.
8. Then carefully thread the O2 sensors into the Y-pipe.
9. Due to the variations between models, the position of the driver's side flange sometimes differs (this has been an ongoing issue with the fitment). Because of this the included loose flange must be welded on.
10. Install system per usual, DO NOT tighten bolts all the way down, make "snug".
 - Install system to mock up the placement of driver side flange, DO NOT tighten bolts all the way down, make a "snug" fit.
 - Place loose flange on driver's side tube bolting it into place. DO NOT REMOVE the Y-pipe, tack weld flange in place.
 - Remove drivers side, weld the flange all the way around the tube.
 - Reinstall the driver's side.
11. Install the y-pipe assembly up into the manifolds using the stock hardware and crush gaskets. Note: If your crush gaskets are worn, they should be replaced and are a stocked item at most Toyota Dealerships.
12. Using the factory hardware and donut gasket, attach the Y-pipe to the stock exhaust system. Leave the connection loose at this time.
13. Once you are satisfied with the positioning, tighten the connections at the manifold first then tighten the hardware at the exhaust system.
14. Tighten down the supplied band clamps where the three assemblies connect.
15. Plug both O2 sensors back into the wiring harness. (Note: the harness may have to be unclipped from the brackets).
16. Reinstall the bracket to the transition cross member.
17. Reconnect battery and start vehicle, checking for any exhaust leaks or rattles - adjust system as necessary. After several day of driving time, recheck all bolts and retighten as needed.

Enjoy your new headers and thank you for your purchase!

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RETURN POLICY

Returns to Doug Thorley Headers (DTH) will only be accepted from direct sell customers within 30 days of the original invoice date. All returns will require a Return Merchandise Authorization (RMA) number provided by Doug Thorley Headers. Customers are responsible for all shipping charges unless other arrangements with Doug Thorley Headers have been made. Doug Thorley Headers reserves the right to refuse any package returned to our facility without prior authorization. Returned products can be subject to a 20% restocking fee.

Doug Thorley Headers does suggest that when shipping an item back to us, carriers such as UPS and FEDEX, or any providers that offers a signature requirement and insurance coverage be used. Doug Thorley Headers is not responsible for any lost or damaged packages along with the customer will be responsible for all shipping charges and risk of loss during the return shipment.

Doug Thorley Headers does not accept a return of an item that is damaged, used/installed, or special ordered parts. If you receive an item that has been damaged, please inform Doug Thorley Headers within 72 hours of delivery in order for Doug Thorley Headers to begin a claim.

Please keep the original packaging and contents as FEDEX and UPS may require an inspection of the item. If this inspection is required then the carrier in which your item was handled through may contact you to set up a time and date. All claims to sub-component shortages or missing parts must be made within 10 days of delivery. If any you have any questions about returning or missing an item, please contact us at **951-739-5900** or email at **info@doughthorleyheaders.com**

WARRANTY COVERAGE

Unless otherwise specified, Doug Thorley Headers header products are warranted against defective materials and workmanship for as long as the original consumer purchaser owns said header product. Doug Thorley Headers exhaust products defined as any component "downstream" of a Doug Thorley Header product or OE factory exhaust manifold, are warranted against defective material and workmanship for a period of five (5) years from the original consumer purchase date. These limited warranties are offered solely to the original purchaser and are non-transferable. Proof of purchase is required for all warranty claims.

These warranties shall be limited to the repair, adjustment, and/or replacement of defective parts at the discretion of Doug Thorley Headers. Authorized product return will be repaired or replaced at the discretion of Doug Thorley Headers. All warranties become void if any product shows evidence of any modification done without the express consent of Doug Thorley Headers and includes mishandling, bending, welding, mutilation of parts, and insulating wrap products. Doug Thorley Headers is not responsible for any other expenses involved in a warranty claim including any labor costs incurred by the customer in relation to defective parts and/ or shipping cost to or from Doug Thorley Headers. Doug Thorley Headers is not responsible for any damages, whether consequential, special, contingent or otherwise, expenses or injury that may arise from the use of Doug Thorley Headers products.

The bluing and discoloration of chrome exhaust products is considered normal, as is the dulling of ceramic coated products, and as such, coating are not covered under the terms of the warranty. Environmental exposure and rust apparent during the extended life of products is also considered normal and excluded from the warranty. Any Doug Thorley Headers product that has been discontinued from new sales for a period of five (5) years or longer will no longer be eligible for replacement under the terms of warranty, the repair of any defective parts will be the only option. Any non-defective not-installed product may be returned for any reason within thirty (30) calendar days of receipt, and will be subject to a 20% restocking/repackaging fee.