



## INSTALLATION INSTRUCTIONS

MAKE: Toyota  
MODEL: Tacoma  
YEAR: 2012-2015  
ENGINE: V6-4.0L

## Twisted Steel Headers 48-46003-1HC



### Parts Included:

- Bolts x6 (03-50401)
- Flange nut x6 (03-50400)
- Exhaust Flange Gasket x3 (05-60366 )
- Thermo Wrap Heat Tape x2 4" x 4" (05-40110)
- Bolts x7 (03-50421)

### Tools Needed:

- 10mm, 12mm & 14mm socket
- 3/8" drive ratchet
- 3/8" extension
- 12mm, 14mm open end wrench
- O2 sensor wrench
- Philips screwdriver

**CAUTION:** 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. aFe recommends professional installation on our products.

1. Read Instructions prior to installation Secure vehicle on jack stands (refer to your manual for specified jack stand positions).
2. Disconnect the battery before starting work on the exhaust system.
3. Remove the right and left inner fender splash guards.
4. Remove the O2 sensors from the Y-pipe.
5. Remove Y-pipe and right side catalytic converter.
6. Unplug the O2 sensors on the right and left exhaust manifolds.
7. Remove the 10mm bolt on the right side exhaust manifold support bracket.
8. Loosen the X2 10mm bolts securing the right side support bracket to the engine block, so the bracket is loose but do not remove the bolts.
9. Remove the nuts and bolts on the right side air injection tube and set the air injection tube aside as it will be reused later.
10. Remove the X6 nuts on the right side exhaust manifold and remove the exhaust manifold.
11. Remove X2 6mm studs on the OE exhaust manifold that secures the air injection tube and reinstall the on the aFe power header.
12. Remove the X3 top exhaust manifold studs on the cylinder head.
13. Remove the right side O2 sensor from the stock exhaust manifold and install on the right side aFe power header.
14. Install the supplied thermo wrap heat tape to the wire harness next to the dip stick, and the wire harness on frame rail next to the brake line.
15. Clean the Cylinder head exhaust manifold gasket surface area, make sure it is free of debris.
16. Install the right side aFe power header using the original exhaust manifold gasket, nuts and X3, 8 x 1.25 x 25 bolts provided in hardware kit (the original exhaust manifold gasket can be re-used if not damaged, replace if necessary) tighten the x6 header nuts and bolts starting in the middle and working your way to the outside.
17. Reinstall the right side air injection tube using the original nuts and gasket.
18. Reinstall the exhaust support bracket to the header using the supplied 10mm nut and bolt make finger tight only at this time. Tighten the X2 10mm bolts on the exhaust support bracket to engine block and the 10mm bolt on the support bracket to the aFe power header.
19. Remove the right side O2 sensor lead from the bracket on the engine block so it will reach the O2 sensor connector and plug in the O2 sensor.
20. Remove the 10mm bolt on the left side exhaust manifold support bracket.
21. Loosen the X2 10mm bolts securing the left side support bracket to the engine block, so the bracket is loose but do not remove the bolts.
22. Remove the X2 nuts on the left side air injection tube on the exhaust manifold.
23. Remove the X6 nuts on the left side exhaust manifold and remove the exhaust manifold.
24. Remove X2 6mm studs on the OE exhaust manifold that secures the air injection tube and reinstall the on the aFe power header.
25. Remove the top (3) and the (1) bottom rear exhaust manifold studs on the cylinder head.
26. Remove the left side O2 sensor from the stock exhaust manifold and install on the left side aFe power header.
27. Clean the Cylinder head exhaust manifold gasket surface area, make sure it is free of debris.
28. Install the left side aFe power header using the original exhaust manifold gasket, nuts and X4, 8 x 1.25 x 25 bolts provided in hardware kit (the original exhaust manifold gasket can be re-used if not damaged, replace if necessary) tighten the X6 header nuts and bolts starting in the middle and working your way to the outside.
29. Reinstall the left side air injection tube using the original nuts and gasket.
30. Reinstall the exhaust support bracket to the header using the supplied 10mm nut and bolt make finger tight only at this time. Tighten the X2 10mm bolts on the exhaust support bracket to engine block and the 10mm bolt on the support bracket to the aFe power header.
31. Remove the left side O2 sensor lead from the bracket on the engine block so it will reach the O2 sensor connector and plug in the O2 sensor.
32. Reinstall the right side catalytic converter and Y-pipe using the supplied crush gaskets, 10mm nuts and bolts and tighten.
33. Reinstall O2 sensors on Y-pipe.
34. Reinstall spring bolts on Y-pipe to exhaust system and tighten.
35. Reinstall right and left inner fender splash guards.
36. Reconnect connect the battery.
37. Recheck all your work, make sure there is adequate clearance between headers and wire harness.
38. Remove vehicle off jack stands.

**Note:** it is normal for the aFe power headers to emit smoke for the first few minutes upon initial start-up.