

Exhaust System Installation Procedure

Note: Reference the Vehicle Torque Specification Sheet where applicable

- 1.) Prepare sub-assemblies as needed (i.e., Front Headpipe, CV, and Muffler)
 - Verify Muffler tip is packed with glass material
 - Swiftly hit the Muffler Assy. with your palm and listen for a “rattling” noise. Send “rattling” muffler to R&D for rework.
 - Verify Exhaust Gaskets are installed
 - Install Muffler bracket onto Muffler. Center slots with Muffler weld nuts and torque fasteners to specification
 - Install Frame/Front Headpipe Bracket – Loose
- 2.) Install Front Headpipe Assy.
 - Install Headpipe Bracket onto Headpipe and connect to the Frame Bracket – Loose
 - Install Headpipe/CV Clamp onto Headpipe- Loose
 - Hand tighten Exhaust Flange nuts until they are flush with the exhaust studs
- 3.) Install CV Assy.
 - Install CV/Muffler Clamp onto CV Assy. - Loose
 - Hand tighten Exhaust Flange nuts until they are flush with the exhaust studs
- 4.) Install Muffler Assy.
 - Install protective covering over muffler to help prevent damaging the fender paint
 - Tighten but do not torque Muffler Bracket/Chassis screws (Muffler should have minimal free play with respect to the chassis, CV, and Headpipe Assembly.)
- 5.) Carefully adjust the Exhaust System Assembly to minimize the gap between Front Headpipe and CV Tube. (Fig. 1)

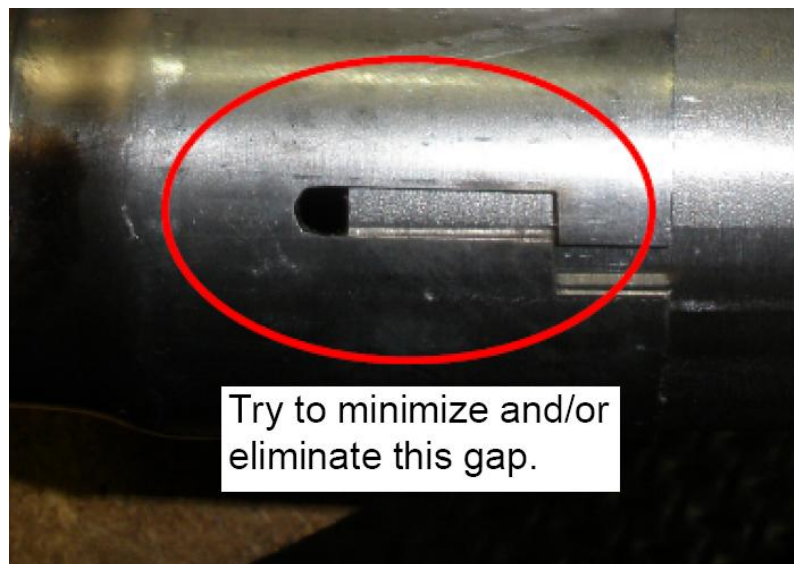


Fig.1: CV/Headpipe Assembly

6.) With the minimum CV/Headpipe gap achieved, align the Front Headpipe until there is a clearance of approx. 3/8 to 1/2in. between the Headpipe O.D. and the nearest edge of the Foot Control Mounting Bracket (Fig. 2)

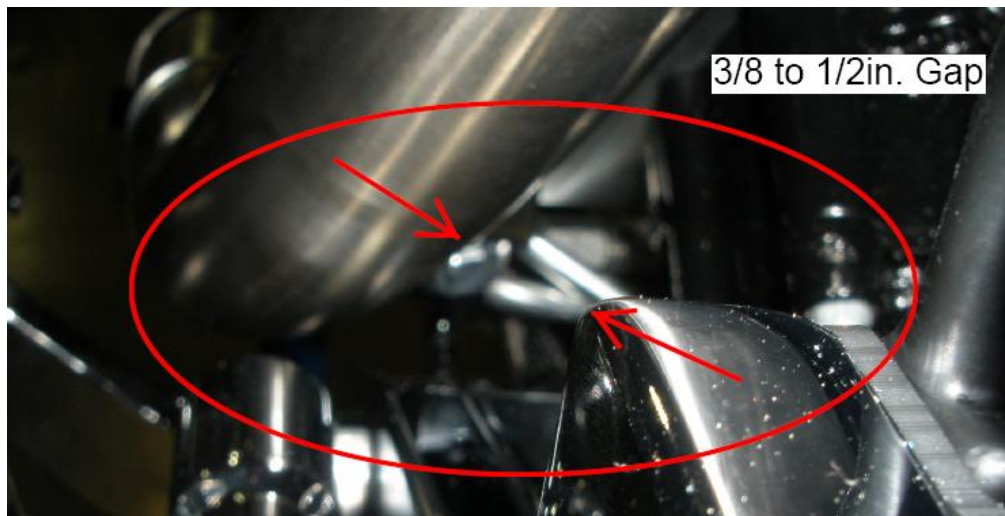


Fig. 2: Headpipe to Foot Control Clearance

7.) Tighten Frame Side Bracket screw to final torque. (Note overlapping of brackets.) (Fig.3)

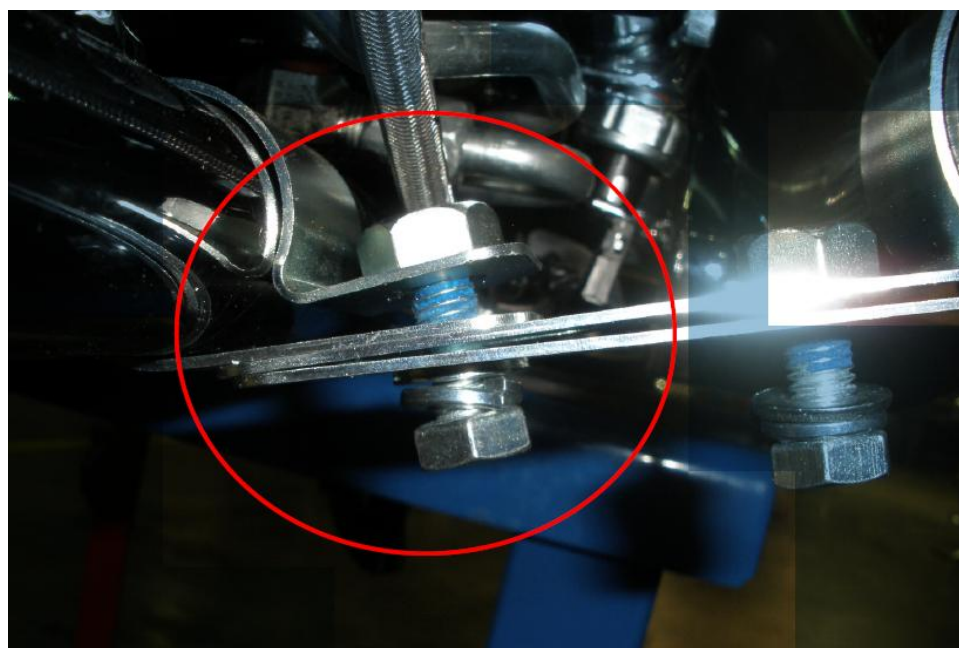


Fig. 3: Headpipe to Frame Bracket

8.) Adjust Exhaust Flange nuts evenly to within one thread pitch. Apply 3 to 5 strokes per each flange nut. Alternate between the Front and Rear Headpipes. Repeat as necessary and slowly until final torque is achieved. (Fig. 4)

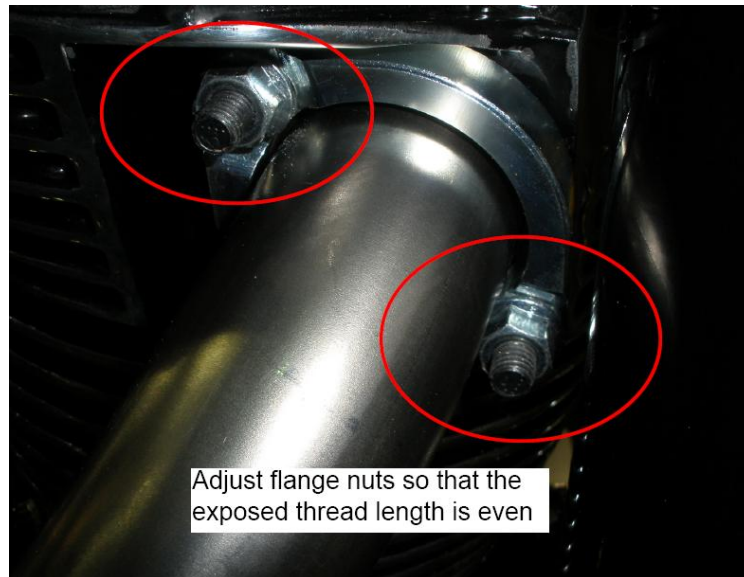


Fig. 4: Flange Nut Detail

9.) Check for a gap between CV Tube slot Headpipe (figure 1). If a gap exists between the Headpipe and CV Tube then apply “Catalyst Friendly” Exhaust Sealant to both inboard and outboard slots as shown in figure 5. Wipe excess sealant from slots. **Sealant is not required if there is no gap.**

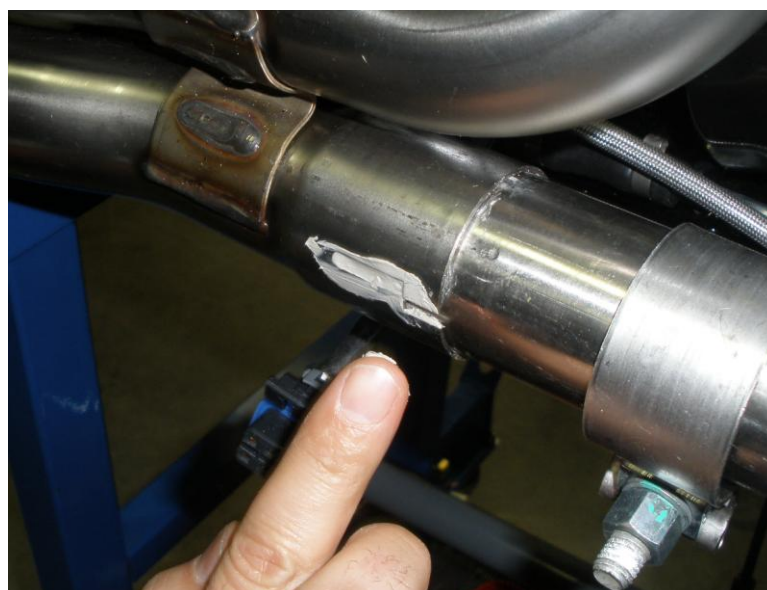


Fig. 5: Application of Headpipe/CV sealant

10.) Adjust then tighten Headpipe/CV Clamp to final torque. Align the Clamp so that it is flush with the edge of the CV Tube and it completely covers the inboard side seal slot profile. (Fig. 6)



Fig. 6: Headpipe Clamp covers inboard seal slot profile

11.) Adjust then tighten Muffler/CV Clamp to final torque. Align the clamp so that it is even with the edge of the Muffler and it completely covers the inboard side seal slot profile. **Sealant is not required for this joint.** (Fig. 7)



Fig. 7: Muffler Clamp covers inboard seal slot profile

12.) Tighten Muffler Bracket/Chassis screws to final torque

13.) Tighten Headpipe/Chassis Bracket screw to final torque (Fig. 8)

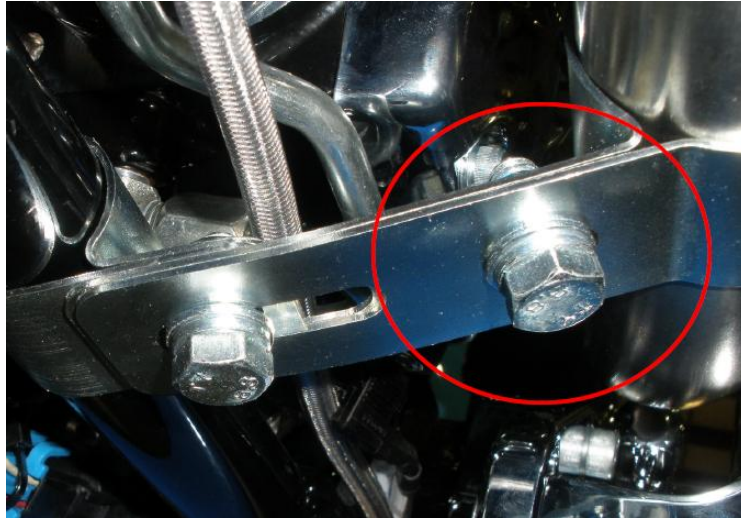


Fig. 8: Headpipe/Chassis Clamp detail

14.) Install Heat Shields