



Kia Cerato GT  
Hatch and Sedan  
Cat Back  
Installation Instructions

**XFORCE RECOMMENDS AN AUTHORISED PROFESSIONAL TO INSTALL ALL PRODUCTS**

**WARNING:** When working on any vehicle exercise extreme caution. Please allow the vehicles exhaust system to be cool enough to touch before removal. Failing to do so may result in severe burns. If working without a hoist refer to the vehicles manual to check correct lifting specifications. Always wear safety glasses, protective gloves and ensure your working in a safe area. Serious injury or death can occur if the correct safety measures are not followed.

**Attention:** Please read the instructions carefully. XFORCE will only warrant manufacturing faults. This does not extend to damage or breakage due to incorrect fitment.



## Parts List

1. ES-I30N-C1 (font half of mid pipe with hotdog muffler)
2. 1 x 3" Clamp
3. ES-I30N-C2 (rear half of mid pipe)
4. ES-I30N-H (hanger for mid pipe)
5. ES-I30N-VMKR (Varex rear muffler)
6. 2 x Rear Muffler Rubbers
7. ES-KC19-VMKPL+VMKPR
8. ES-KC19-SED (Sedan Vehicles Only)
9. ES-KC19-TIPR+TIPL
10. 6 x 2 ½"Clamps



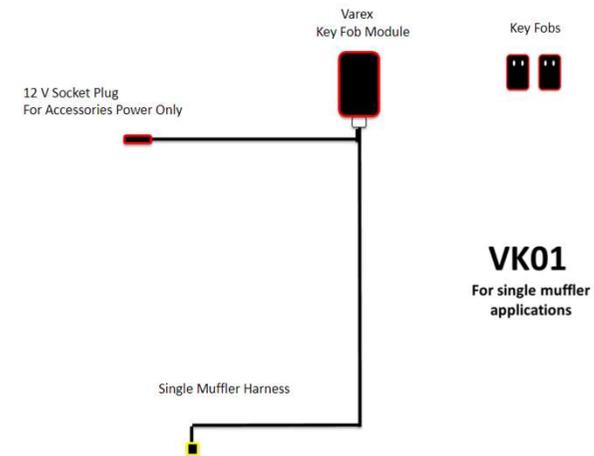
## Required Tools and Equipment

1. Spanners and Sockets required 14mm, 15mm, 16mm, 19mm
2. 3/8" Ratchet
3. 6" long 3/8 Extension bar
4. Can of spray lubricant
5. Tube of O2 Sensor safe sealant for the 2 bolt Gasket and Slip Joint
6. 2-3 Rags for excess sealant
7. 1/2" Tension Wrench with 15mm deep socket, set to 80 Foot Pounds
8. Safety Glasses or Goggles
9. Protective Gloves
10. Safety Boots



## IMPORTANT STEP

Loosely run the wiring from inside the vehicle to the outside through an open door. Plug the wiring harness into the 12V socket and then into the muffler and control box and power up. Check the operation of all electronics and Muffler valve before installation.





## Step 1

**The entire fitting process must be conducted by a professionally trained technician (this also includes hoist operation).**

1 Raise vehicle on a 2 post hoist making sure hoist arms are in the correct lifting positions (as per owners manual) and that you or someone else isn't under the vehicle while hoist is moving. Once the Vehicle is at a workable height engage the hoist safety locks.





## Step 2

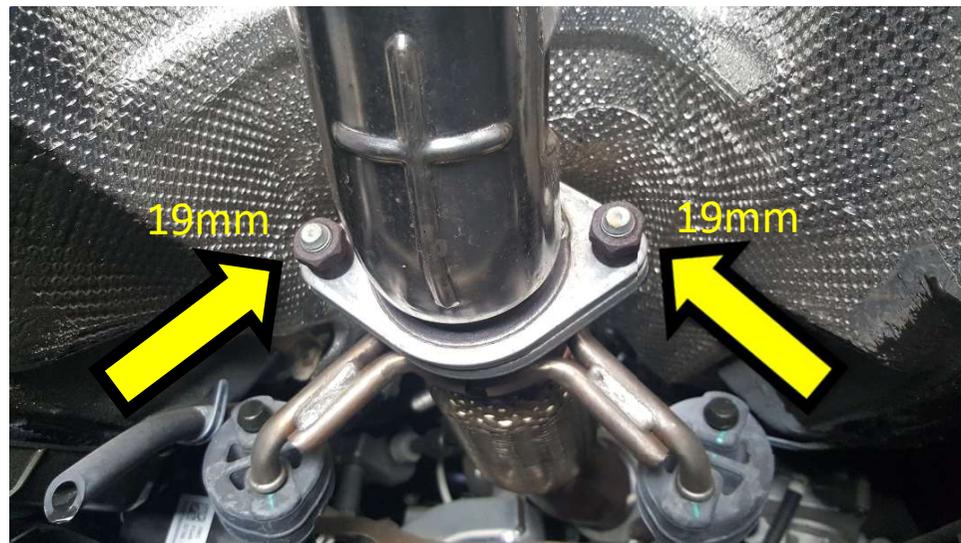
- 1 Please make sure you are wearing safety equipment as listed in Required Tools/Equipment
- 2 Spray lubricant between the Rubber and Exhaust Hanger





## Step 3

Unbolt the 2x19mm nuts at the base of the dump pipe





## Step 4

Unbolt the 2x19mm nuts at the flange near the rear muffler

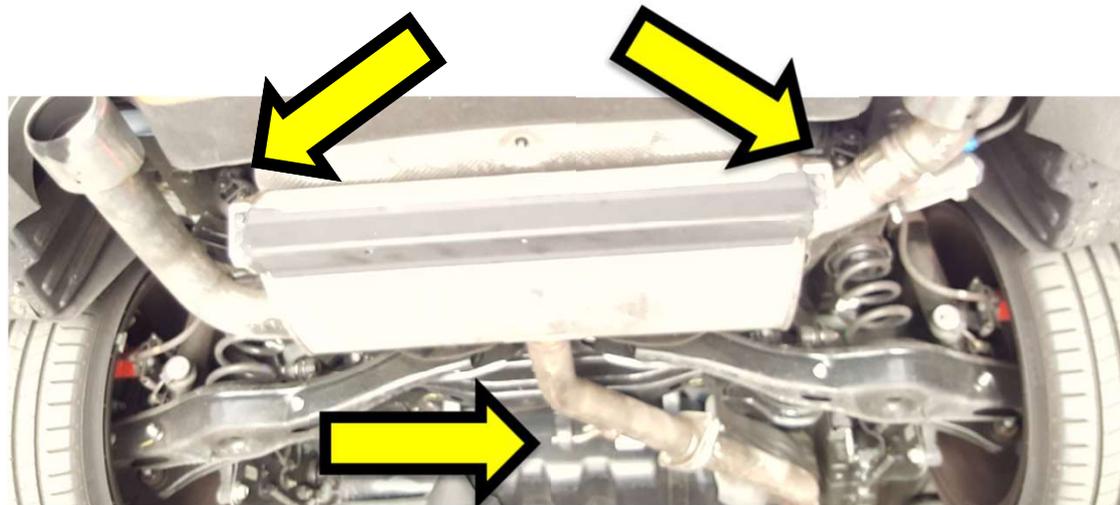
Slide the hanger out of the rubber and remove the centre pipe





## Step 5

- 1 Please make sure you are wearing safety equipment as listed in Required Tools/Equipment
- 2 Spray lubricant between the Rubbers and Exhaust Hangers on the Chassis at the rear of the muffler, between the rubber and hanger on the muffler at the front of the muffler. Remove the muffler from the vehicle leaving the 2 rear rubbers on the muffler and the front rubber on the vehicle.





## Step 6

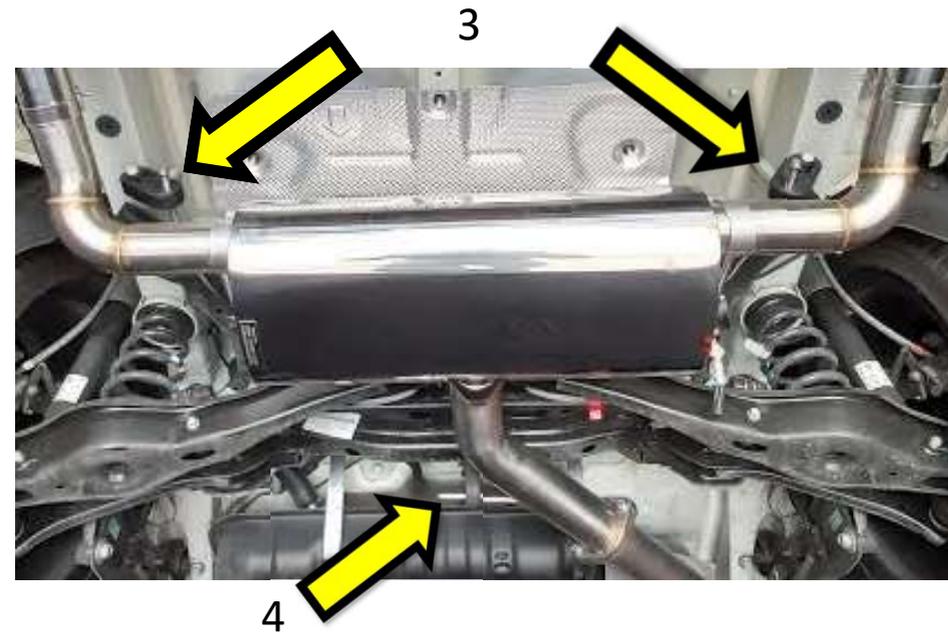
1 Fit the 2 supplied rubbers to the rear hangers on the muffler using the bottom hole.



2 With help from another person raise the Xforce muffler into position on the Vehicle

3 Refit left and right rear exhaust rubbers onto the Chassis hangers

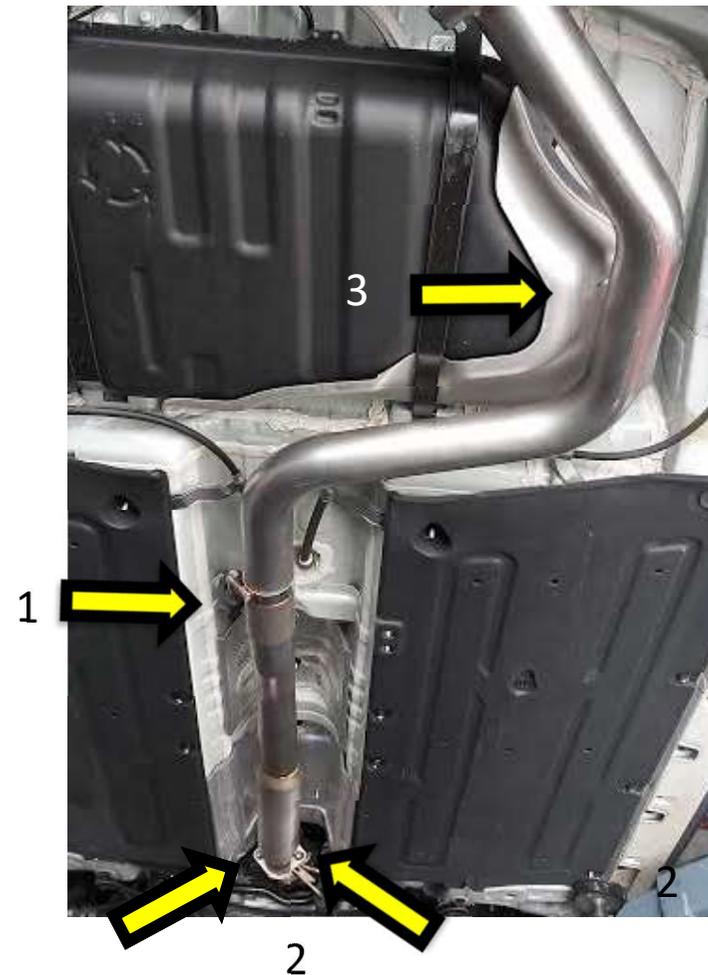
4 Refit the forward muffler Hanger into the Rubber.





## Step 7

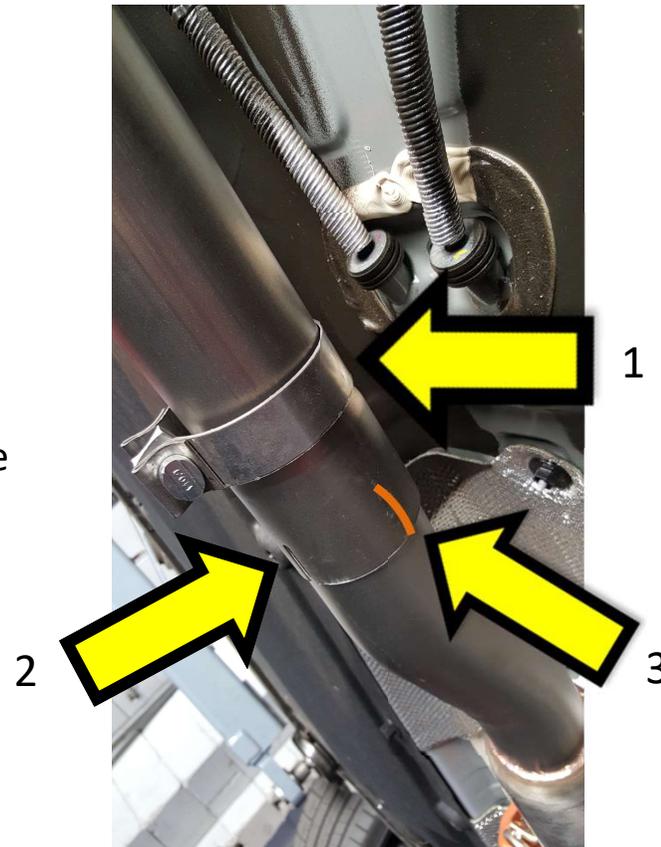
- 1 Fit the front half of the Xforce Centre Pipe (I30N-C1)
- 2 Then fit the 19mm nuts and tighten
- 3 Slide the rear half of the centre pipe (I30N-C2) over the C1 making sure the hanger (1<sup>st</sup>) and Clamp (2<sup>nd</sup>) are over the flare and a generous bead of O2 Sensor safe sealant is inside the slip joint. Slide the hanger into position.





## Step 8

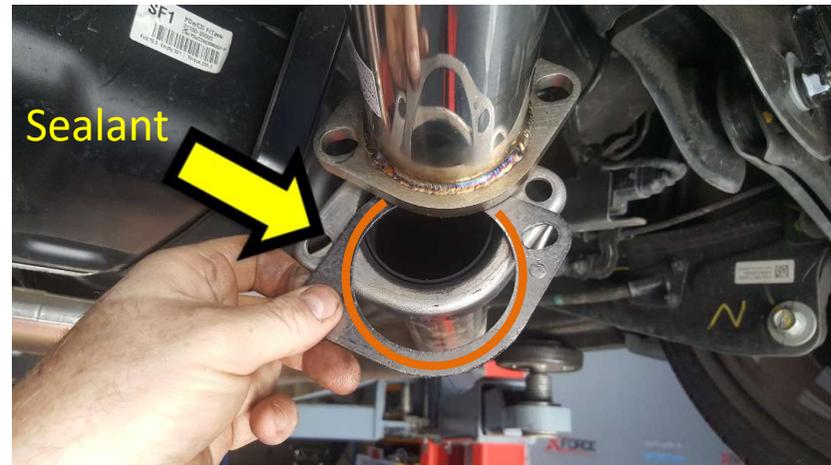
- 1 Slide the clamp over the slip joint
- 2 Slide the second half of the Xforce Centre Pipe over the first half.
- 3 Make sure the sealant covers the slots.





## Step 9

Use the gasket supplied by Xforce and apply a bead of O2 sensor safe sealant





## Step 10

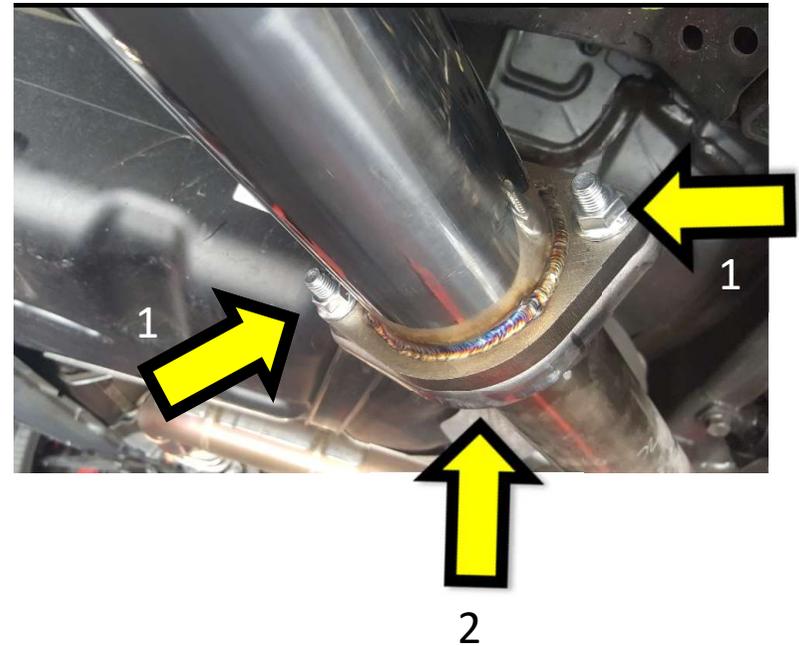
1 Rotate the second pipe up to align with rear muffler flange





## Step 11

- 1 Use the 2 x bolts with the 16mm head and the 2 x nuts with the 15mm head and place through the flange bolt holes
- 2 Align the 2 Flanges so the match evenly
- 3 Tighten the 15mm nuts and 16mm bolts
- 4 Wipe off excess sealant with a rag





## Step 12

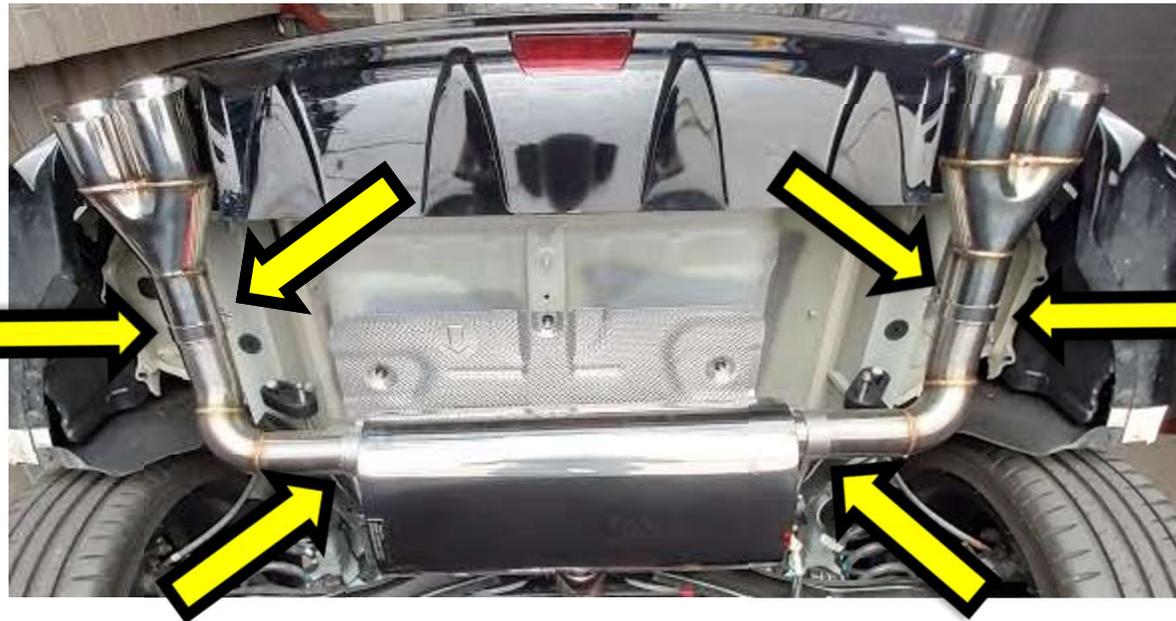
Tighten the clamp to 80 Foot Pound using a Tension Wrench with 15mm deep socket.





## Step 13

Fit left and right rear tailpipes and exhaust tips.  
Align and tighten the 2 x clamps with 15mm nut on  
the tailpipe and 2 x 10mm clamp on each tip



For sedan add the  
KC19-SED between  
the tailpipes and tips

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## Step 14

- 1 Check the rear muffler and tips are level and even
- 2 If it's uneven loosen the clamps in **Step 13** raise or lower the Tailpipes and rotate the tips so they are level and even then retighten and check again.
- 3 Disengage safety locks and lower the vehicle



**Note:** When you first start your vehicle after the installation of your new XFORCE Performance Exhaust System, there may be some smoke and fumes coming from the system. This is a protective oil based coating used in the manufacturing of mandrel bent performance exhaust tubing. This is not a problem and will disappear within a very short period of time after the exhaust has reached normal operating temperatures.



# VAREX

## Varex Key Fob Installation Instructions

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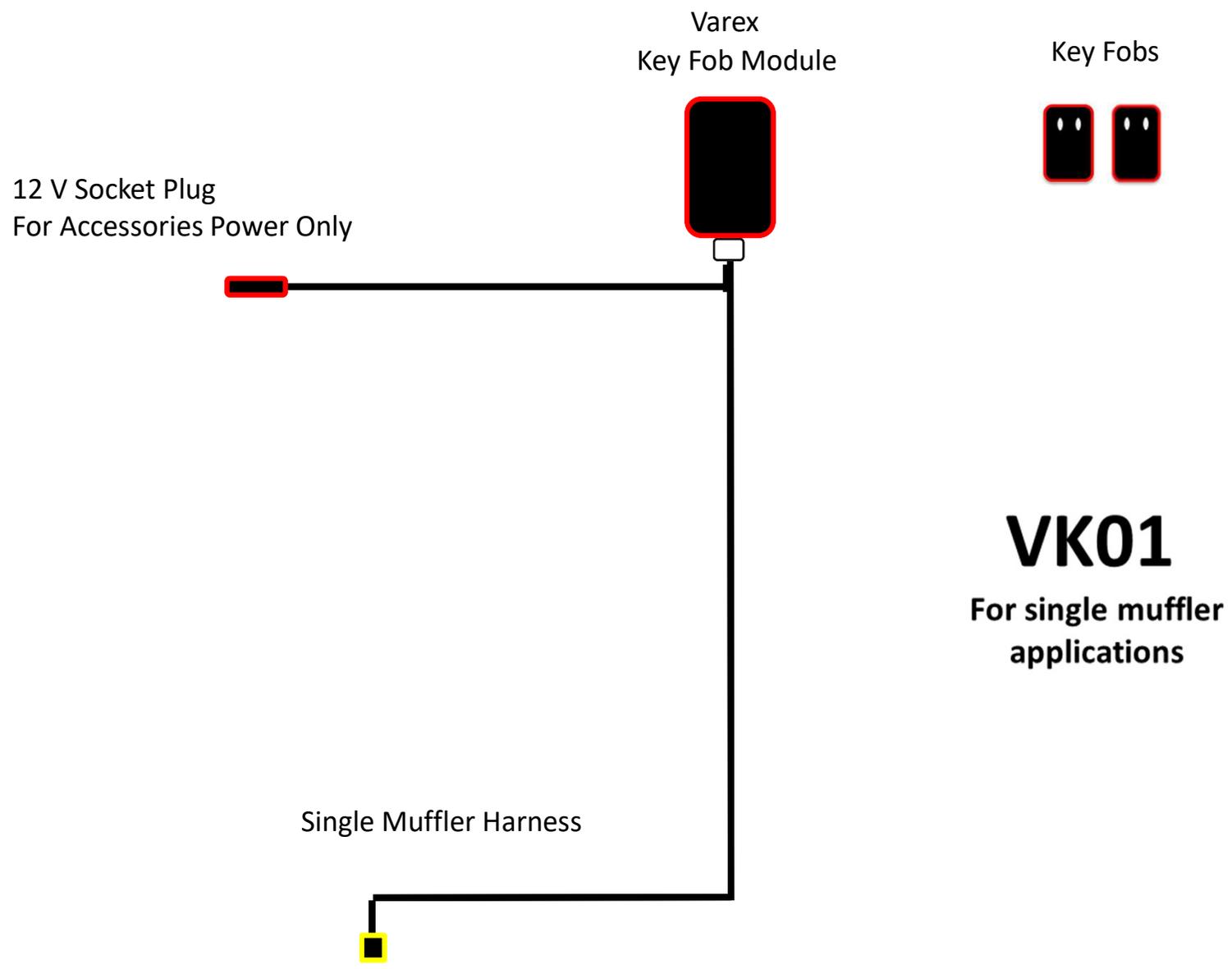
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## What's inside the box

- 1 Varex Control Module
- 2 Main Wiring Harness (VK1 or VK2)
- 3 Key Fobs

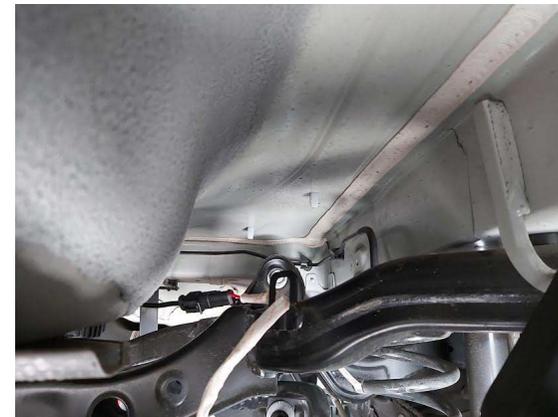
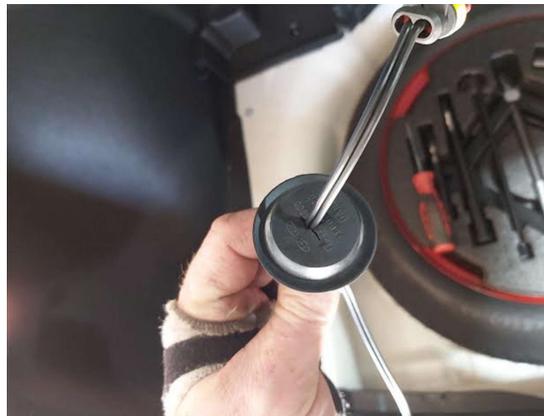






## Step 15

Find a rubber grommet to allow access from the boot area to the underside of the car near the Varex Mufflers. Once located feed the black 2 pin plug through the rubber grommet and into the boot area to the underside of the car and connect to the muffler





## Step 16

Feed the wiring through the boot towards the back seat, then run the wire into the cabin and under the back seat, towards the plastic cover between the carpet and the doors.

Put your fingers under the cover (pic 1) then push the wiring up under the cover (pic 2).

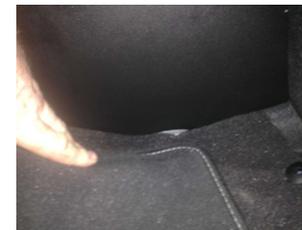
Do this all the way to the front of the cabin and feed the wire behind the kick panel Pic 3 (plastic cover near where your feet would be in the front of the car).



Pic 1



Pic 2



Pic 3



## Step 17

Plug the Key Fob box into the white 4 pin plug and the (pic 4)

Remove the panel under the glovebox (pic 5) and place the wiring and box on the panel (pic 6), run the wire (with the 12V Socket Plug) towards the 12V Socket.



Pic 4



Pic 5



Pic 6



## Step 18

Feed the wiring under the plastic between the centre console and the carpet moving it towards the centre of the car (pic 7 towards the seats) as far as is needed to reach the power socket (pic 8).

Turn the car on and test the system using the remote  
Button A will close the Varex and button B will open the Varex

Now enjoy the volume controllability of your new Varex System



Pic 7



Pic 8



## Step 19

Drive vehicle for 10mins, Return to **Step 7**, retention all nuts, bolts and enjoy the driving experience your new Xforce System provides.

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