



Ford Mustang FM18 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.



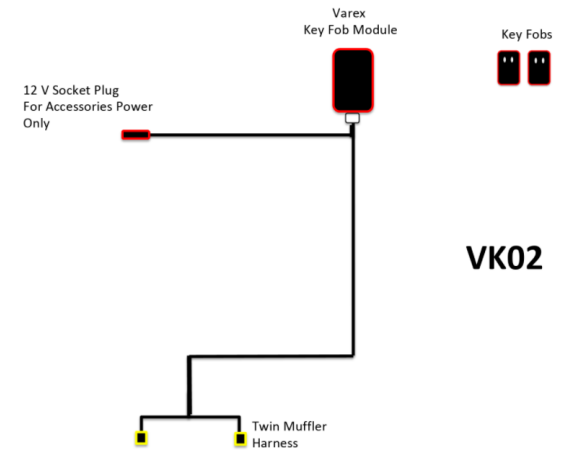
Required Tools

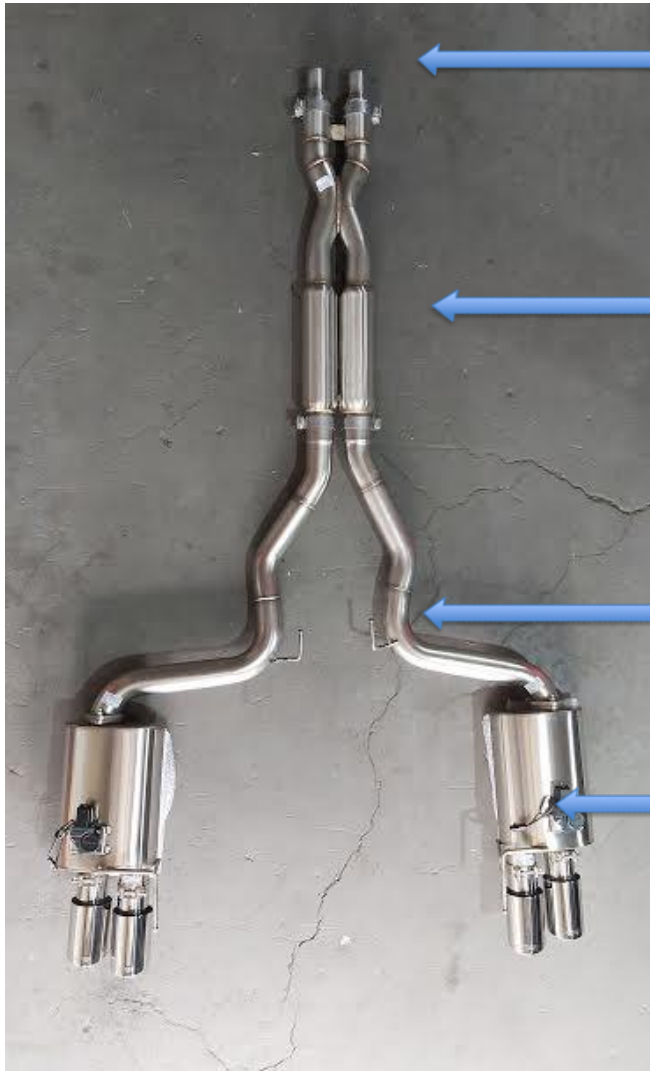
1. Spanners and Sockets required 10mm, 13mm, 14mm, 15mm, 17mm
2. $3/8$ $1/2$ $9/16$ $5/8$ $11/16$
3. Supporting stand
4. Extension bar
5. Can of spray lubricant
6. Tube of O2 Sensor safe sealant for all gaskets



IMPORTANT STEP (Varex ONLY)

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.





← FM18-CBS-C1 x 2

← FM18-C2

← FM18-C3L & C3R

← FM18-VMK-RL & RR

Varex Wiring Kit



Gaskets & Bolts

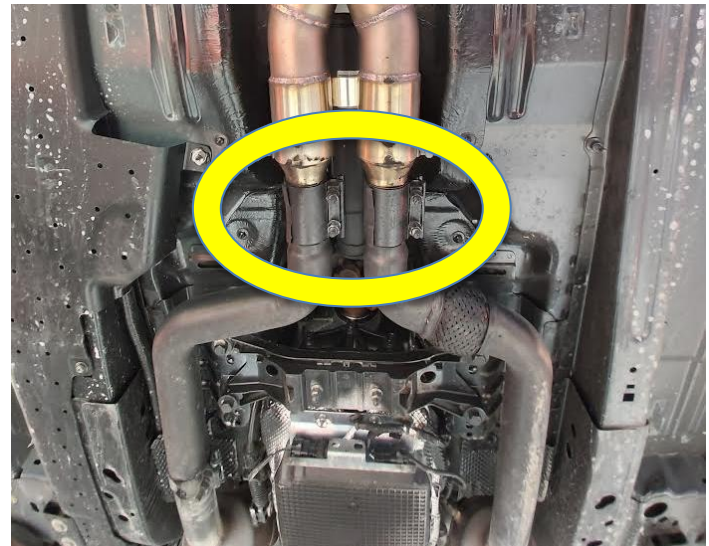




Clamps where
Factory Cat Back
Starts

Step 1

Support the exhaust using a stand and then unbolt the exhaust at the 2 x 2 bolt band clamps (15mm) in the middle of the car





Step 2

Spray the rubbers with lube (WD40) and unbolt the rubber hangers (13mm) from the rear subframe above the diff. Now remove stand and slide the exhaust forwards (towards the engine) until the hangers on the rear mufflers are released from the rubber.

Once the exhaust is on the ground refit the rubber hangers to the subframe but leave loose.





Step 3

If fitting to the factory cats use the Xforce cat back adapters (FM18-CBS-C1 x 2) and factory 2 bolt band clamps.

Fit the centre muffler (FM18-C2) bolting it to the flanges after the cat pipes (or adapters). Put a stand under the muffler to support the system.

Make sure all clamps are on (and have O2 sensor safe sealant in the slip joint)



Cat Back Adapter



CENTRE MUFFLER



Step 4

Slide the diff pipes (FM18-C3L & C3R) hangers into the rubber mounts on the subframe above the diff and slide them onto the back of the centre mufflers.

Fit the rear muffler (FM18-VMK-RL & RR) 1 at a time by sliding the hanger into the rubber and then bolting to the back of the diff pipes.

Make sure all clamps are on (and have O2 sensor safe sealant in the slip joint)

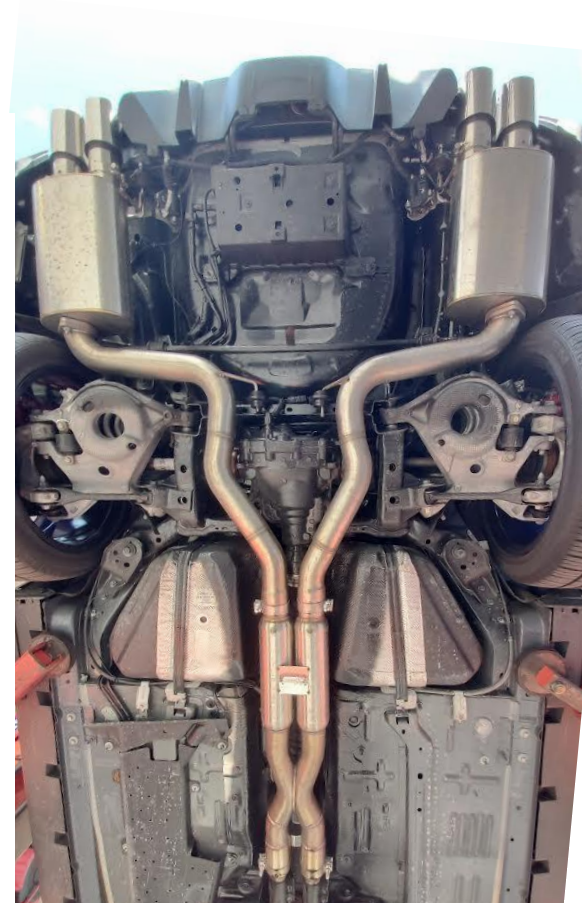




Step 5

Fit the rear muffler (FM18-VMK-RL & RR) 1 at a time by sliding the hanger into the rubber and then bolting to the back of the diff pipes.

Make sure all clamps are on (and have O2 sensor safe sealant in the slip joint)





Step 6

Fit the tips to the muffler, set the length and tighten on both sides. Align the mufflers and tighten the exhaust clamps from the rear to the front.





Step 7

Fit the factory Mustang motor to the Bimodal Bracket and fir the bracket as per the photo (under the rear hanger mount) and clip the wiring back into the motor.





Step 5

Now check that the exhaust doesn't hit anywhere that may cause a rattle or damage to any other part of the car. Once you are satisfied re tighten the bolts and clamps from the rear to the front.

Start the car, check for leaks and now enjoy your new XFORCE PERFORMANCE EXHAUST.

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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What's inside the box

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



12 V Socket Plug
For Accessories Power
Only

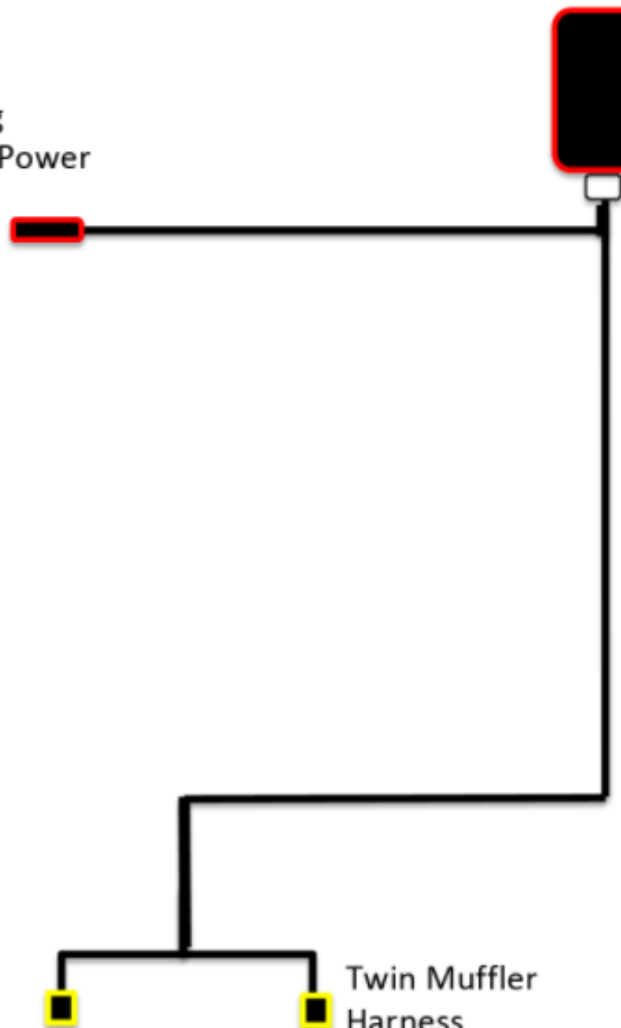
Varex
Key Fob Module

Key Fobs



Twin Muffler
Harness

VK02





Step 6

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 7

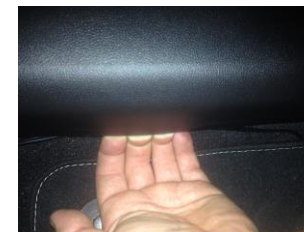
Feed the wiring through the boot towards the back seat, then run the wire into the cabin and under the back seat, towards the plastic cover between the carpet and the doors.

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

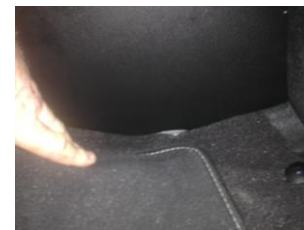
Do this all the way to the front of the cabin and feed the wire behind the kick panel Pic 3 (plastic cover near where your feet would be in the front of the car).



Pic 1



Pic 2



Pic 3



Step 8

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 9

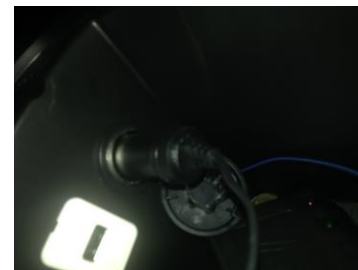
Feed the wiring under the plastic between the centre console and the carpet moving it towards the centre of the car (pic 7 towards the seats) as far as is needed to reach the power socket (pic 8).

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 10

Drive vehicle for 10mins, Return to **Step 5**, retention all nuts, bolts and enjoy the driving experience your new Xforce System provides.

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