

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW269	SCREW, 1/4"-20 × 5/8"	15
2	HW320	FLAT WASHER, 1/4"	15
3	HW322	LOCK WASHER, 1/4"	15
4	HW115	NUT, 1/4"-20	15
5	ST473	EXHAUST TIP, BRUSHED BODY/ BLACK END 3-1/2" × 2-1/4"	2
6	MC225BS	CLAMP, 2-1/4" STAINLESS	2
7	HA1707	DOUBLER, MUFFLER BRACKET	2
8	HS115	OUTER HEAT SHIELD	1
9	HS116	HEAT SHIELD	2
10	842583-479	MUFFLER ASSY	1

REVIEW THE INSTRUCTIONS AND VERIFY THE KIT CONTENTS:

1. Please take a moment to read and understand these instructions before installing your Performance Exhaust System.



2. Use the parts drawing and list (front page) to verify your kit's contents.

In the unlikely event that any parts are missing, please contact Flowmaster Technical Support for replacements.

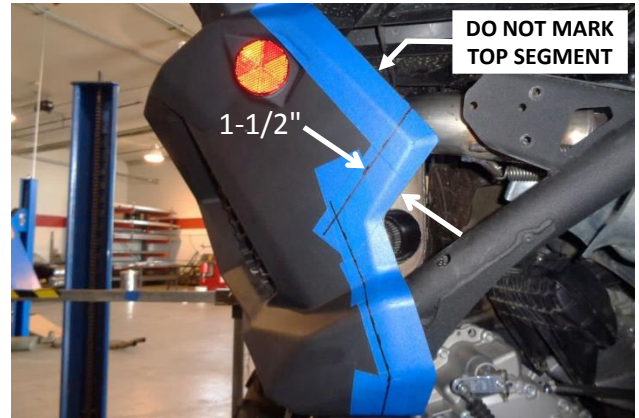
MARK AND REMOVE THE REAR FASCIA:

WARNING

Avoid serious burns! Allow the exhaust system to cool completely before starting work.



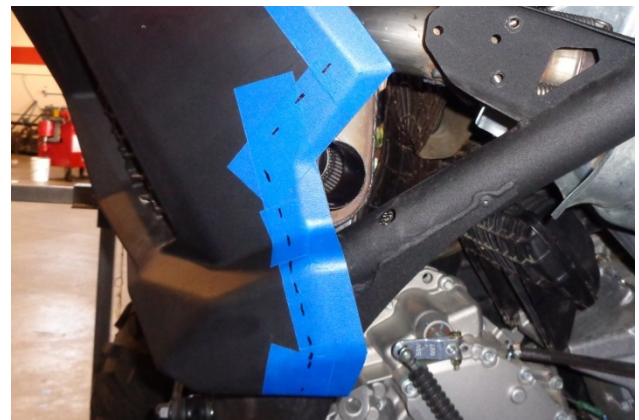
3. The rear fascia will be modified later to accommodate the muffler's dual exhaust. Before removing the fascia, apply 2" wide masking tape to its left and right edges as shown.



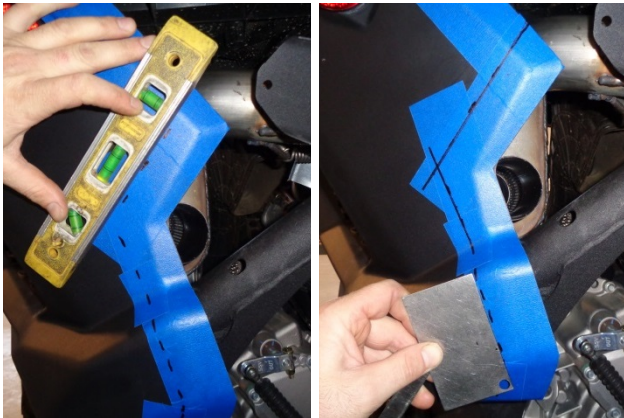
4. On both sides of the fascia, lay out a cut line 1-1/2" from, and parallel to, the edges of the lower three segments, as described below. (Do not mark the top segment; it will not be cut.)



5. Use a tape measure to mark evenly-spaced dashes 1-1/2" from the edges of the three lower segments.



6. The three lower segments marked with dashes.



7. On both sides of the fascia, use straightedges to mark the final cut lines by connecting the dashes.



8. The three lower segments marked with cut lines.

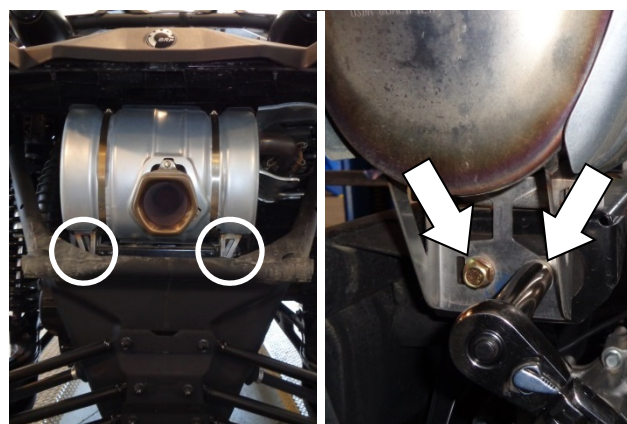


9. Remove the five screws and rear fascia. Set the fascia aside, to be modified later.

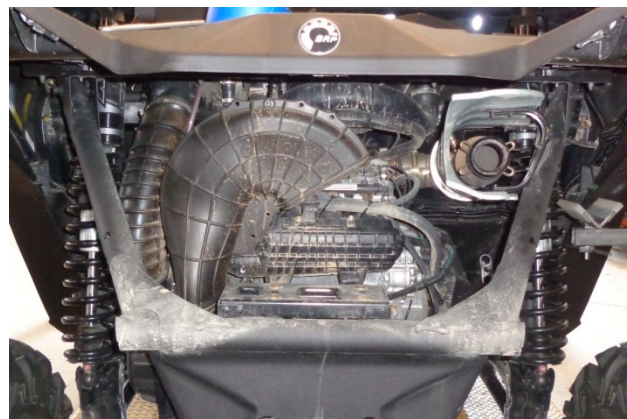
REMOVE THE FACTORY EXHAUST SYSTEM:



10. Use a spring puller to carefully release the four springs around the flange.



11. At the two muffler brackets, remove the four mount bolts (two bolts on each side).



12. Remove the muffler from the vehicle.

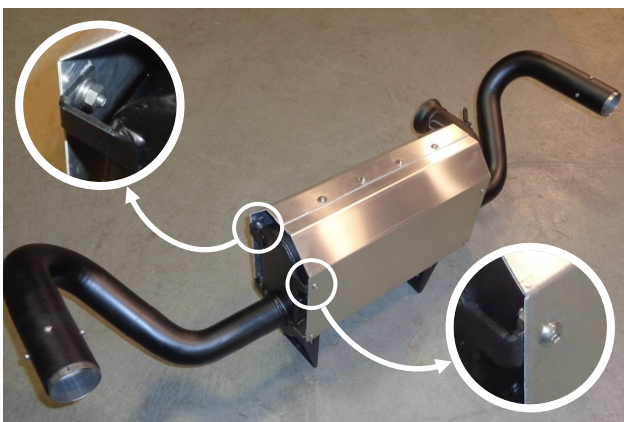


13. Inspect the lead gasket on the end of the exhaust pipe for serviceability. Reinstall or replace the gasket as required.

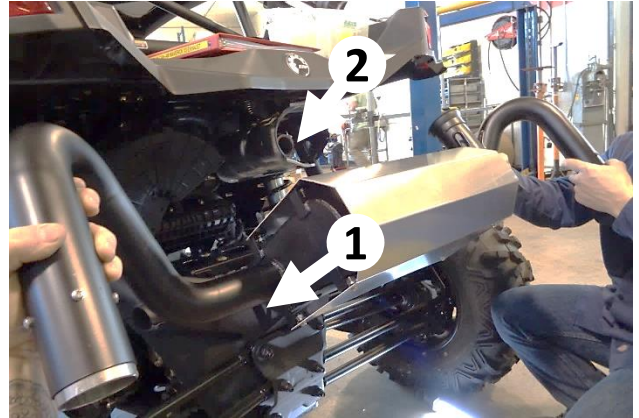
ASSEMBLE AND INSTALL YOUR XDR OFF-ROAD PERFORMANCE EXHAUST:



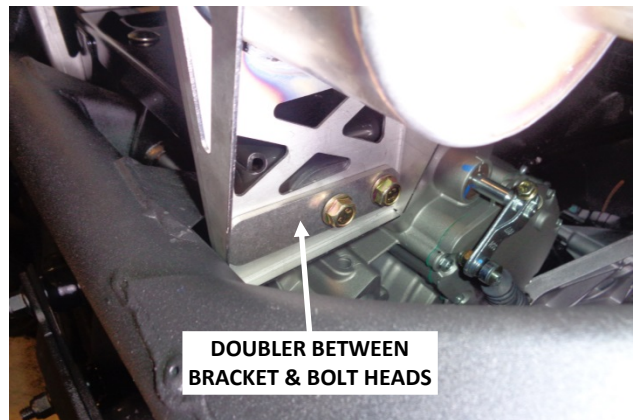
14. Assemble the two heat shield halves (9) at four places, using screws (1) on top, and flat washers (2), lock washers (3) and nuts (4) underneath.



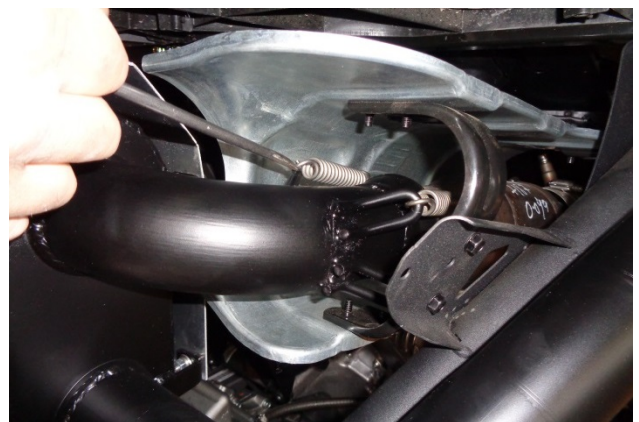
15. Assemble the heat shield to the muffler (10) at eight places, using screws (1) on the heat shield side, and flat washers (2), lock washers (3) and nuts (4) on the bracket side.



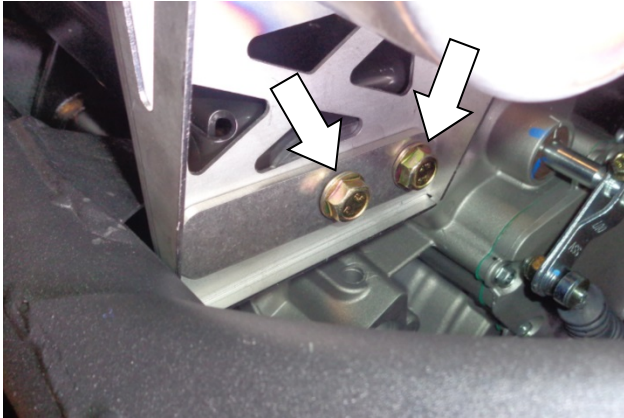
16. Tilt the muffler back and slip its two brackets over their mounts. Then rotate the muffler's inlet pipe toward the stock exhaust pipe.



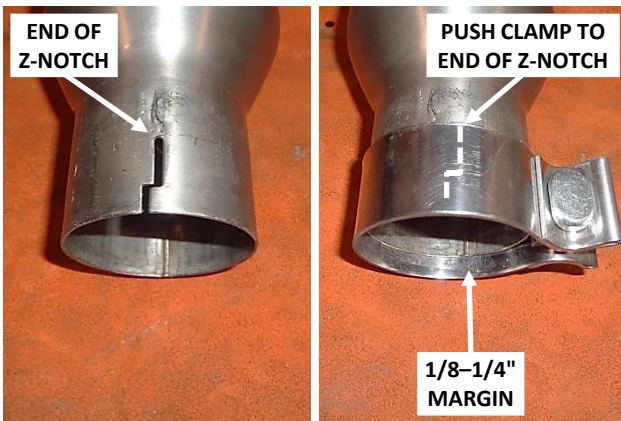
17. Fasten each muffler bracket to its mount using the stock bolts, with a doubler (7) under the bolt heads.
NOTE: Do not tighten the bolts at this time.



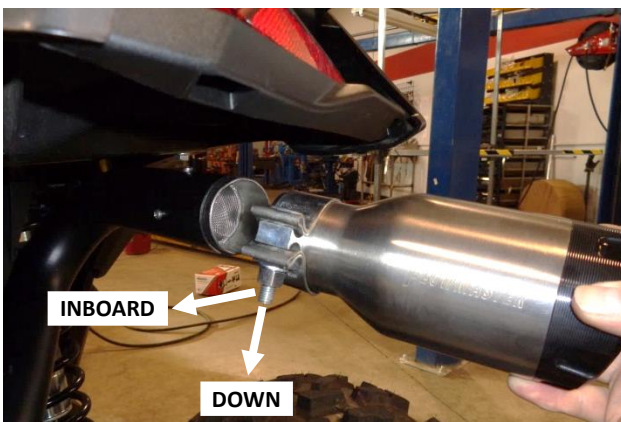
18. Use a spring puller to carefully install the four springs between the stock exhaust pipe and the muffler's inlet pipe.



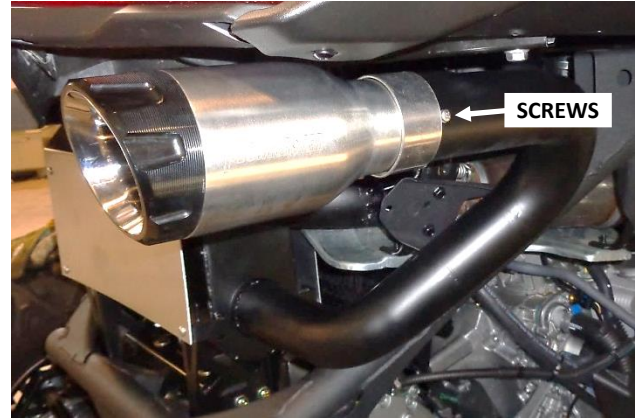
19. After the springs are installed, tighten the four mount bolts (two on each side).



20. Install one clamp (6) on the opening of each exhaust tip (5). For best retention, push the clamp just to the end of the Z-notch, leaving 1/8" to 1/4" of the clamp extending past the tip opening.

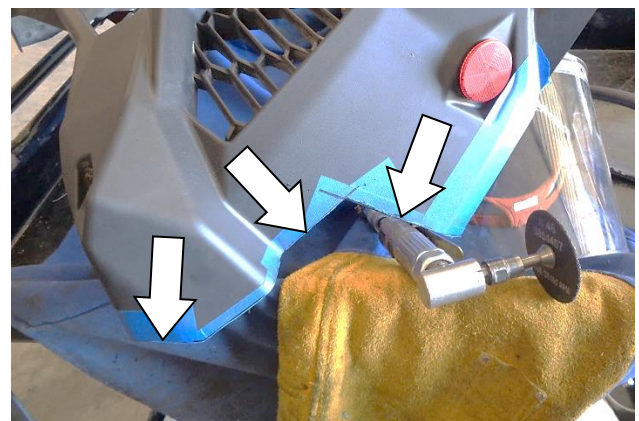


21. Note also that each clamp bolt should be on the inboard side of the tip, with its nut pointing down. Install each tip on its exhaust pipe.

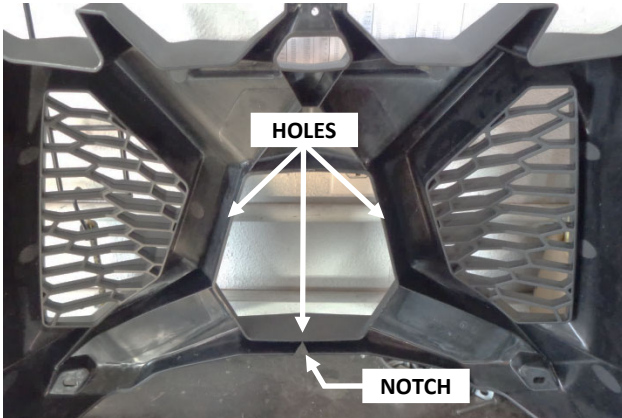


22. Push each tip onto its pipe until its clamp touches the spark arrestor screws. Also be sure to keep the rear edge of the clamp just over the end of the Z-notch (per Step 20). When each tip is in place, tighten the clamp.

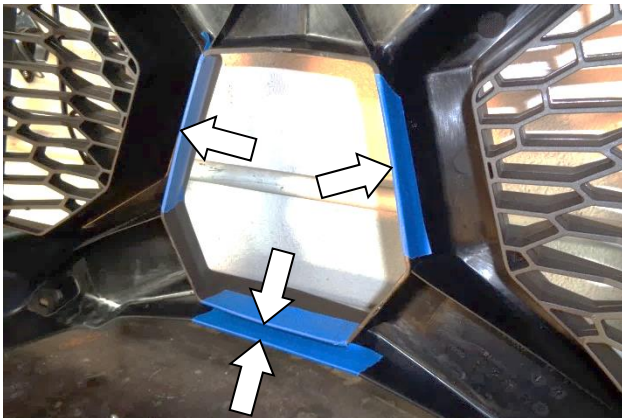
MODIFY, ASSEMBLE AND REINSTALL THE REAR FASCIA:



23. On both sides of the fascia, cut the marked edges using a suitable tool (cutting wheel, shears, etc.). **NOTE: The plastic is relatively soft and pliable. But before cutting along the marked edges, test your cutting tool on the edge of a section that will be removed.**



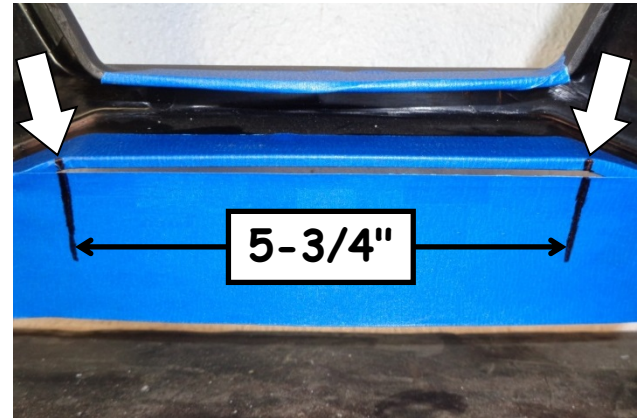
24. To modify the rear fascia to accept the outer heat shield, drill three holes and cut one notch as follows.



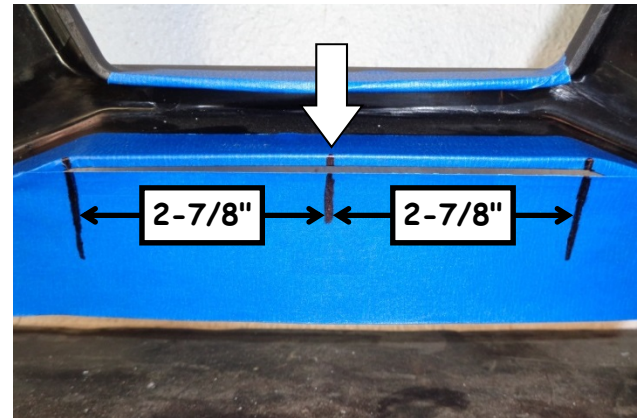
25. Apply 2" masking tape to the four edges as shown (one edge on each side, and two edges on the bottom), with approx. 1" of tape on each face.



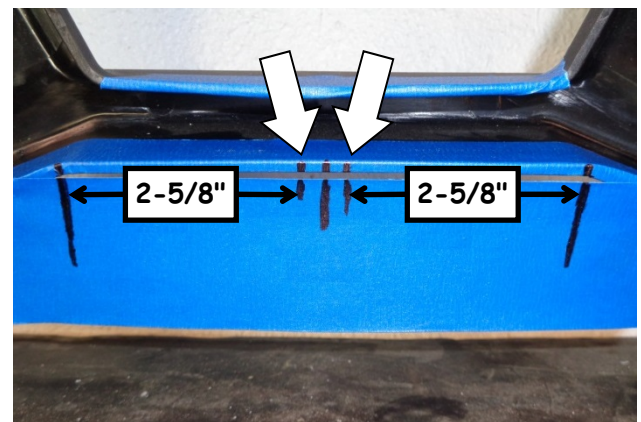
26. Temporarily apply a piece of 2" masking tape parallel to the very bottom edge of the opening, as shown.



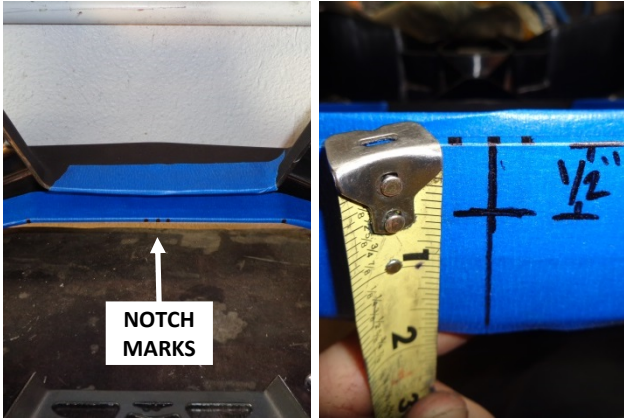
27. On the bottom edge, mark the slight "breaks" (or corners, which are 5-3/4" apart), then transfer the marks down onto the tape below the edge, as shown.



28. Mark the centerline, which is 2-7/8" in from each break, then transfer the center mark up onto the bottom edge, as shown.



29. Mark two cut lines, 2-5/8" in from each break, then transfer the cut marks up onto the bottom edge, as shown.



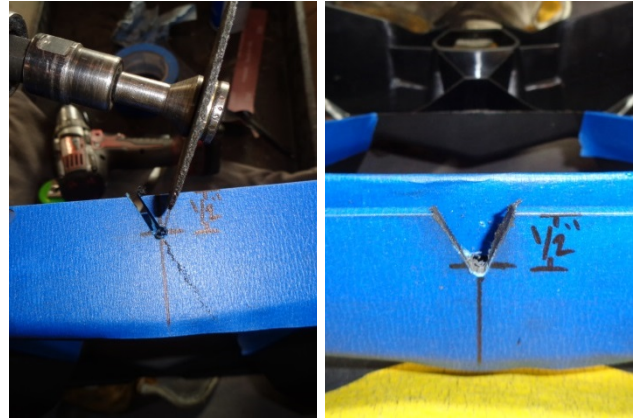
30. Remove the temporary tape. On the bottom face of the lower edge, mark the centerline, then mark 1/2" from the edge.



31. Use a straightedge to mark the cut lines for the notch as shown.



32. Drill a 1/8" relief hole at the tip of the notch.



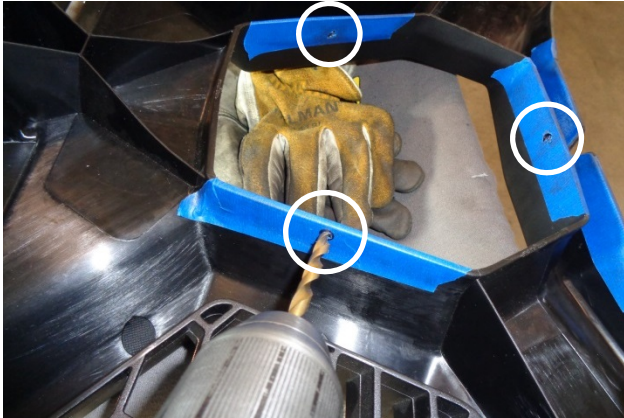
33. Cut the marked notch lines.



34. Lay the outer heat shield (8) over the inside of the center opening.



35. Use the heat shield as a guide to mark the three screw holes.



36. Remove the heat shield and drill the three holes as marked. Start with a small pilot bit (approx. 1/8" diameter), followed by a 9/32" bit.



37. Remove all tape from the fascia, and deburr all drilled holes and cut edges with sand paper.



38. Assemble the outer heat shield to the rear fascia at three places, using screws (1) against the fascia (outside), and flat washers (2), lock washers (3) and nuts (4) against the heat shield (inside).



39. Reinstall the rear fascia using the five stock screws.



Congratulations, the installation of your XDR Off-Road Performance exhaust is now complete!

IMPORTANT: RETAIN THESE INSTRUCTIONS FOR FUTURE REFERENCE



SPARK ARRESTOR MAINTENANCE FOR FLOWMASTER ATV & UTV EXHAUST SYSTEMS

Flowmaster ATV and UTV exhaust systems are equipped with US Forest Service-qualified spark arrestors, which are designed to prevent the discharge of sparks from the exhaust pipes.

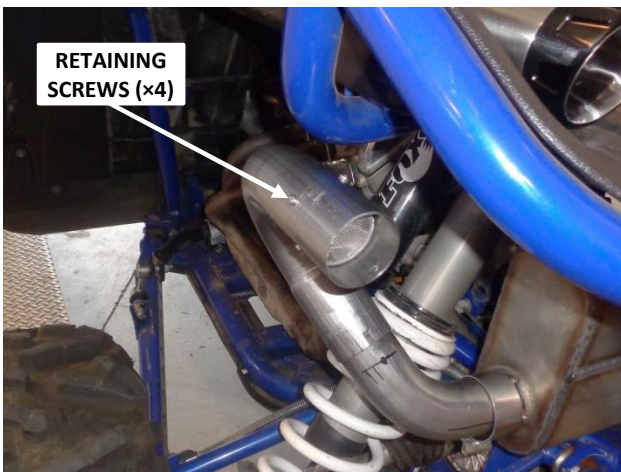
Spark arrestors must be inspected and cleaned periodically to prevent clogging and deterioration, which can adversely affect the performance of both the spark arrestor and the engine.

WARNING

Avoid serious burns! Allow the exhaust system to cool completely before inspecting the spark arrestors.



1. Loosen the exhaust pipe tip clamp and remove the tip.



2. Remove the four retaining screws and washers.



3. Remove the spark arrestor screen.
4. Soak the screen in carburetor cleaner or oven cleaner to loosen carbon buildup.
5. Clean the screen using a wire brush.
6. Inspect the screen for wear or damage.

WARNING

Replace any spark arrestor whose screen is worn or damaged. Call Flowmaster for replacement parts.

7. Reinstall the spark arrestor screen and exhaust pipe tip. (Installation is the reverse of removal.)

NOTE

Do not operate the vehicle unless serviceable spark arrestors are installed.