



A45 AMG

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.



What's in the box

1. ES-A45-C1
2. ES-A45-C2
3. ES-A45-C3
4. ES-A45-VMKR
5. 2 X 2 BOLT FLANGE GASKETS
6. VAREX WIRING HARNESS AND CONTROL BOX
7. 4 X NUTS AND BOLTS (FOR FLANGES)
8. 1 X 3" Clamp



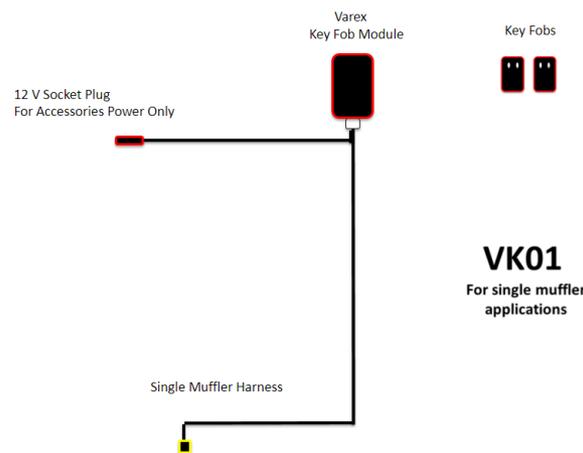
Required Tools and Equipment

1. Spanners and Sockets required 10mm, 12mm, 14mm, 15mm, 16mm
2. 3/8" Ratchet
3. 200mm 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.

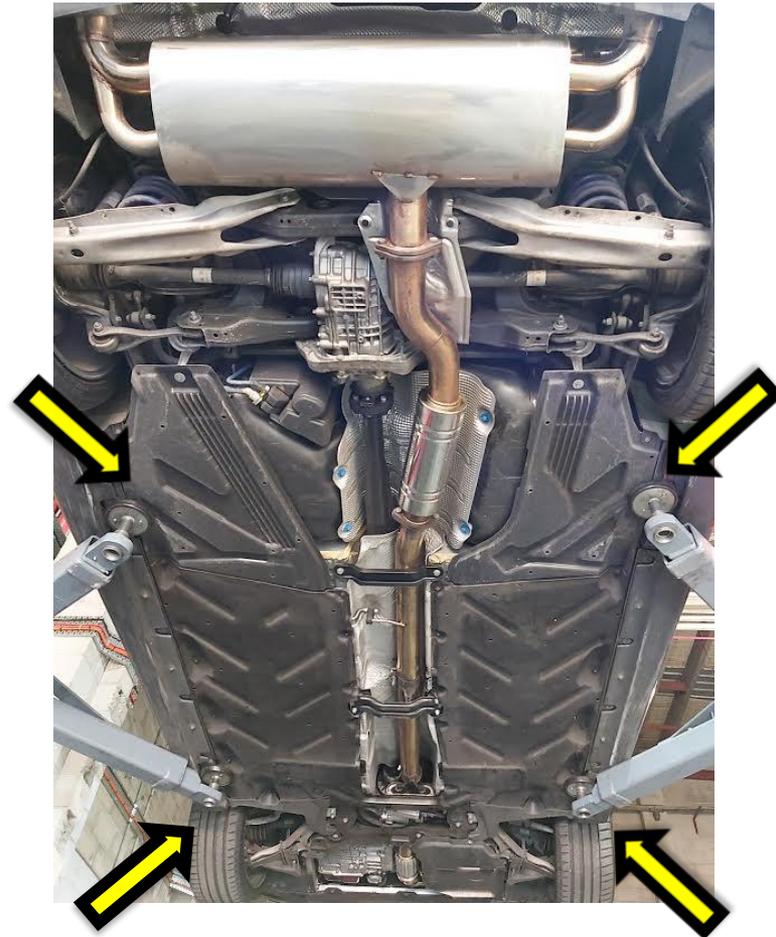




Step 1

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

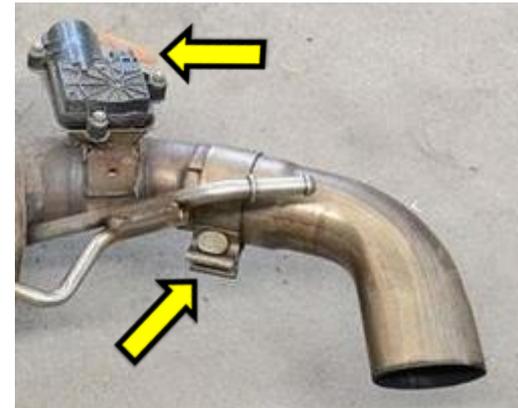
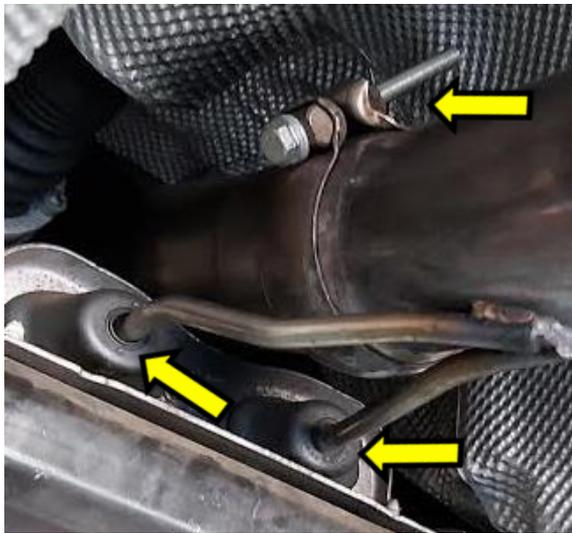
1 Raise vehicle on a 2 post hoist making sure hoist arms are in the correct lifting positions (as per owners manual) and that you or someone else isn't under the vehicle while hoist is moving. Once the Vehicle is at a workable height engage the hoist safety locks.





Step 2

Lubricate the bolts on the ball flare clamp, left and right tailpipe clamps, the centre rubber, rear muffler rubbers, disconnect exhaust valve and slide the tailpipes off the muffler.





Step 3

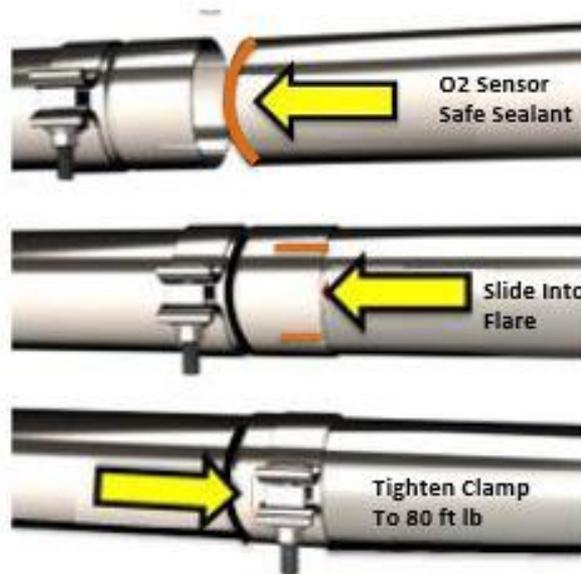
Remove the 2 support braces using a 13mm socket then with someone's help remove the factory exhaust.





Step 4

Fit the Xforce rear Vorex muffler to the car then the C1 to the ball flare and then slide the C2 onto the C1. Make sure you put sealant on the slip joint as per the diagram. Fit the C3 between the muffler and C2 making sure you use sealant on the 2 flanges and gaskets. Leave everything loose until the next step.





Step 5

Once everything is in the correct position, refit the 2 support braces and then tighten from the rear to the front, checking your clearance gaps as you go.





VAREX

Varex Key Fob Installation Instructions

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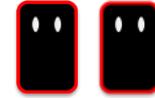
What's inside the box

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

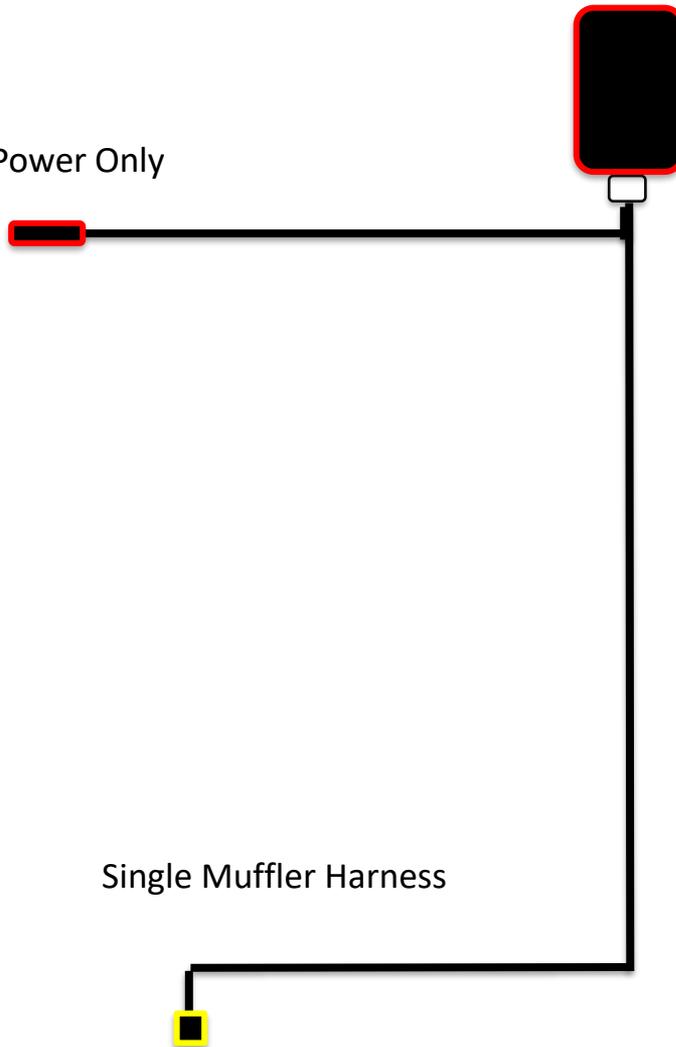


Varex
Key Fob Module

Key Fobs



12 V Socket Plug
For Accessories Power Only



VK01

For single muffler
applications



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

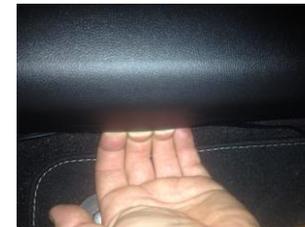
Feed the wiring through the boot towards the back seat, then run the wire into the cabin and under the back seat, towards the plastic cover between the carpet and the doors.

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

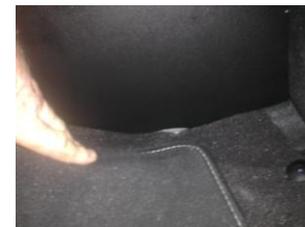
Do this all the way to the front of the cabin and feed the wire behind the kick panel Pic 3 (plastic cover near where your feet would be in the front of the car).



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

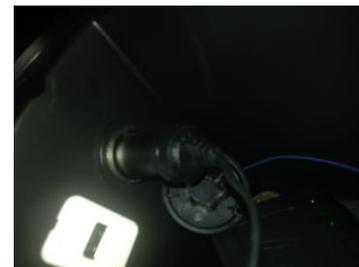
Feed the wiring under the plastic between the centre console and the carpet moving it towards the centre of the car (pic 7 towards the seats) as far as is needed to reach the power socket (pic 8).

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.

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.