



**Holden VE/VF SV6 Sedan
Cat Back System
Installation Guide**

(E4-VE17VMK-CBS & E4-VE172-03-CBS)





XFORCE RECOMMENDS AN AUTHORISED PROFESSIONAL TO INSTALL ALL PRODUCTS

XFORCE PRODUCTS ARE DESIGNED FOR RACE/OFF-ROAD USE ONLY

XFORCE takes pride in its product, and we are dedicated to providing you with a dealer network who can offer you the right advice and information when it comes to your XForce exhaust system or product. Find your local Dealer/Fitter using the link below.

<https://xforce.com.au/find-a-dealer/>

WARNING: When working on any vehicle exercise extreme caution!

Before working on any vehicle, please exercise the following cautions:

- Please allow the vehicles exhaust to be cool enough to the touch before removal! Failing to do so may result in severe burns!
- If working on a hoist, refer to the vehicles owner's manual to check correct lifting specifications!
- Always wear safety glasses, protective equipment (gloves, clothing, etc.) & ensure your working in a safe environment.

Serious injury or death can occur if the correct safety measure ARE NOT FOLLOWED!!

ATTENTION: Please read instructions carefully. XFORCE will only warrant manufacturing faults. This does not extend to damage or breakage due to incorrect fitment. See website for more information!

<https://xforce.com.au/warranty/>



Parts List

- Box 1 (E4-VE172-03-CBS-1):
 - E4-VE17-CL (Left Side Diff Pipe)
 - E4-VE17-CR (Right Side Diff Pipe)
 - E4-VE17-CB (Centre Section)
- Box 2 (E4-VE172-03-CBS-2):
 - ES-VE17-03TIPL (Left Tip)
 - ES-VE17-03TIPR (Right Tip)
 - E4-VE17-03RL (Left Side Muffler)
 - E4-VE17-03RR (Right Side Muffler)

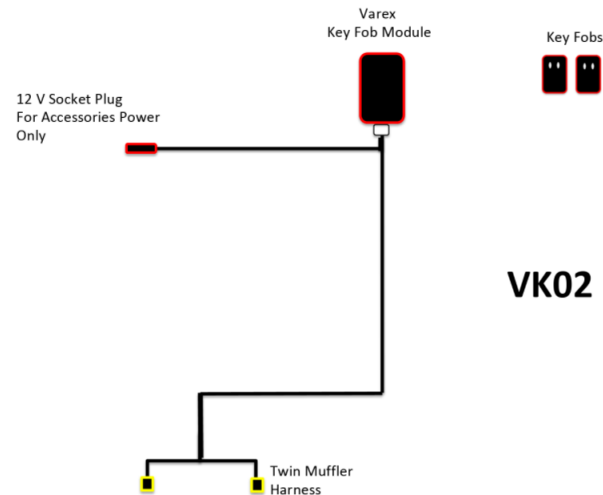
Tools & Equipment Required

1. Spanners & Sockets
 - 10mm, 13mm, 14mm, 15mm & 17mm
2. Extension Bar
3. Can of Spray Lubricant
4. Gasket Maker/Sealant
5. Rags for Excess Sealant
6. Safety Glasses or Goggles
7. Protective Gloves
8. Safety Boots



Important Step (Varex Only!)

Loosely run the wiring for the control box from inside the vehicle to the outside through an open door. Plug the wiring harness into the 12v socket & then into the mufflers and control box, power on the vehicle to test system. Check the operation of all electronics and Varex muffler valve before installation.



Go to page 11 for Varex installation instruction.



Step 1:

Raise vehicle on a 2/4 post hoist making sure the hoist arms are in the correct lifting positions (as per the owner's manual) and that yourself or any other persons are underneath the vehicle while the hoist is in motion.

Once the vehicle is at a workable height, engage the hoist safety locks!





Step 2:

Unbolt factory O2 Sensor from the center pipe & unplug factory O2 Sensor Wiring. Set Aside.

Unbolt the exhaust at the 2-bolt flanges at the back of the catalytic converters & at the 2-bolt flange at the rear mufflers. Leave bolts loose till you are ready to remove system. Use under hoist stands if needed!

Spray the rubbers with lube & removed the center section of the exhaust then remove the rear mufflers.





Step 3:

In the following order, leave firm but DO NOT TIGHTEN!

1. Fit the XForce Diff pipes to the hangers & fit the rear mufflers then bolt together finger tight. Making sure to use gaskets at each flange.
2. Bolt the center section to the diff pipes then to the back of the catalytic converts. Use under hoist stands if needed!

Diff Pipes



Rear Mufflers



Center Section





Step 4:

Check positioning of exhaust & make sure it doesn't hit anywhere that may cause damage or rattle against any part of the vehicle. Also, check tip alignment with the bumper.

Once you are satisfied with positioning, tighten from the rear mufflers forward making sure the alignment is consistent. Remove any hoist stands if used.

Make sure to re-install O2 Sensors!

Start your car, check for any leaks & enjoy your new XFORCE Performance Exhaust!





Step 5:

Drive vehicle for 10-15mins, testing the Varex valve control (if installed). Return to step 4, retention all nut & bolts and enjoy the driving experience your new XForce System provides.

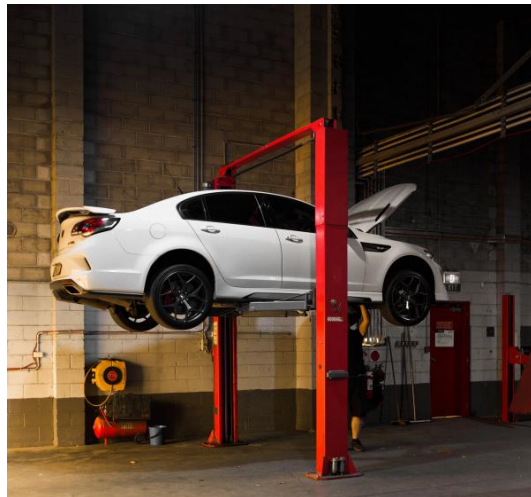


GO TO PAGE 11 for Varex Installation



NOTES:

- When you first start your vehicle after install of your new XFORCE Performance Exhaust System, they may be some smoke or fumes coming from the system. This is a protective oil-based coating used in the manufacturing of the system. This is not a problem & will disappear within a very short period after the exhaust has reached normal operating temperature.
 - This system is designed for the VE/VF SV6 only.
- When trying to install gaskets with flanges, install one bolt on the flange & hang the gasket on the bolt then feed the other part on.
- Muffler hangers do have some adjustment when installing, make sure you are happy with tip placement before tightening bolts up.





**Holden VE/VF SV6 Sedan
Varex Control Module
Installation Guide**

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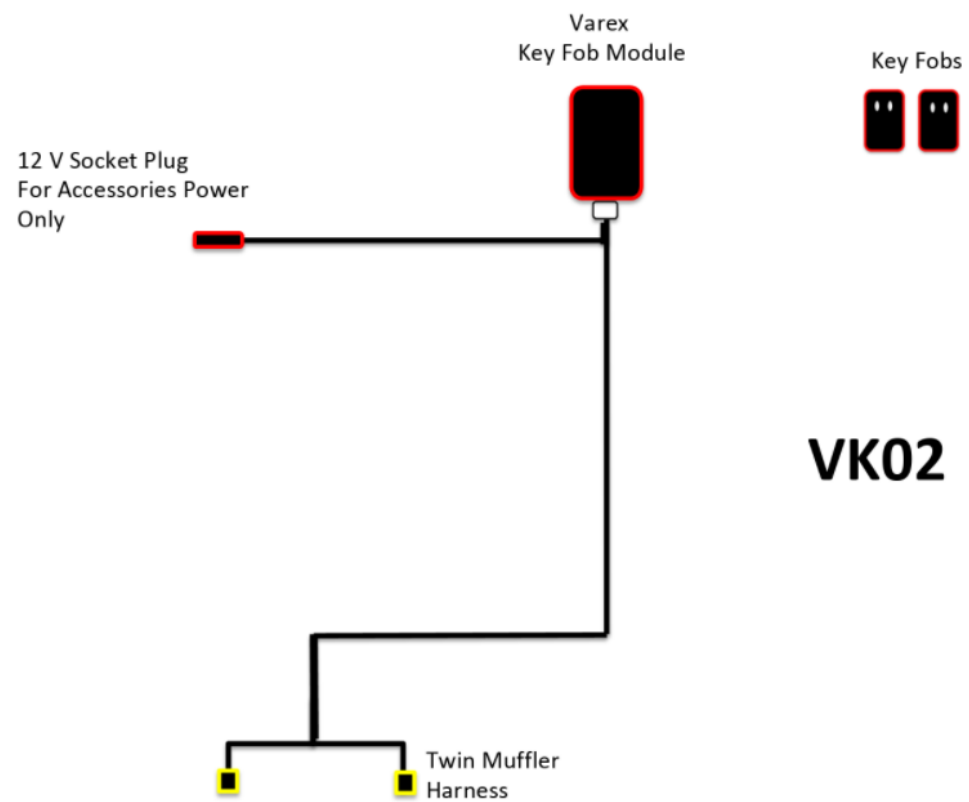
What's in the box

- 1x Varex Control Module
- 1x Wiring Harness (VK01/VK02)
 - 2x Key Fobs





Varex Wiring Diagram





Step 1:

Find a rubber grommet to allow access from the boot area to the underside of the car near the Varex Mufflers

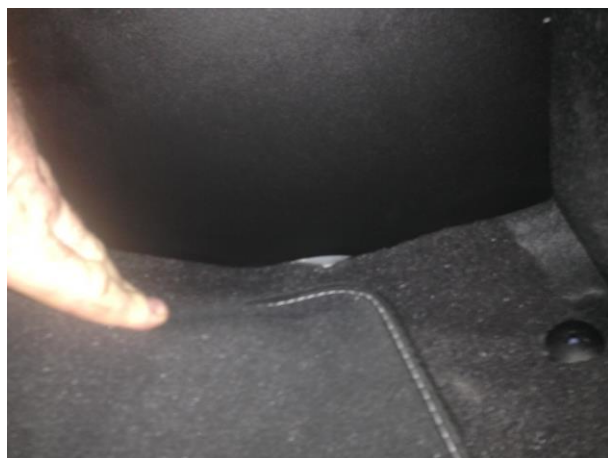
Once located, feed both black 2-pin plugs through the rubber grommet from inside the car to the underside of the car and connect both mufflers.





Step 2:

Feed the white 4-pin & 12v socket from the rear of the car to the front of the car. Making sure to tuck away wiring under the back seat & under any plastic trim till you find a suitable place to store the control box.





Step 3:

Plug the white 4-pin plug into the control box.

Now feed the 12v plug plug to your preferred
to 12v socket is lug in.

Turn on the car on & test the system using
the remote (you should see an LED flash as
you press the remote buttons).

Button A will close the valve & Button B will
open the Varex.

Now enjoy the volume control on your new
Varex System!





NOTES:

- **HARD WIRING:** We do offer a Hard Wiring Kit for your control box (VK16) which is recommended if you do decide to Hardwire your control box. By using this kit, this will bypass the Canbus power restrictor and could result in the control box failing (due to constant power supply) & could also damage electronics in your vehicle.
- XFORCE recommends using the 12v socket provided with your standard wiring kit as this will not affect any vehicle electronics.

