



**Subaru VB/VN WRX Sedan & Wagon  
Secondary Cat Delete Pipe  
Installation Guide**



ESSW29SCRP



**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

- ESSW29SCRP
  - ES-SW29-C1 (Front Section)
    - Bolts up to first catalytic converter.
  - ES-SW29-C2 (Rear Section)
    - Bolts to cat back system.
  - Accessories Pack



## Tools & Equipment Required

1. Spanners & Sockets
  - 14mm
2. Extension Bar
3. Can of Spray Lubricant
4. O2 Sensor Safe Sealant
5. Rags for Excess Sealant
6. Safety Glasses or Goggles
7. Protective Gloves
8. Safety Boots



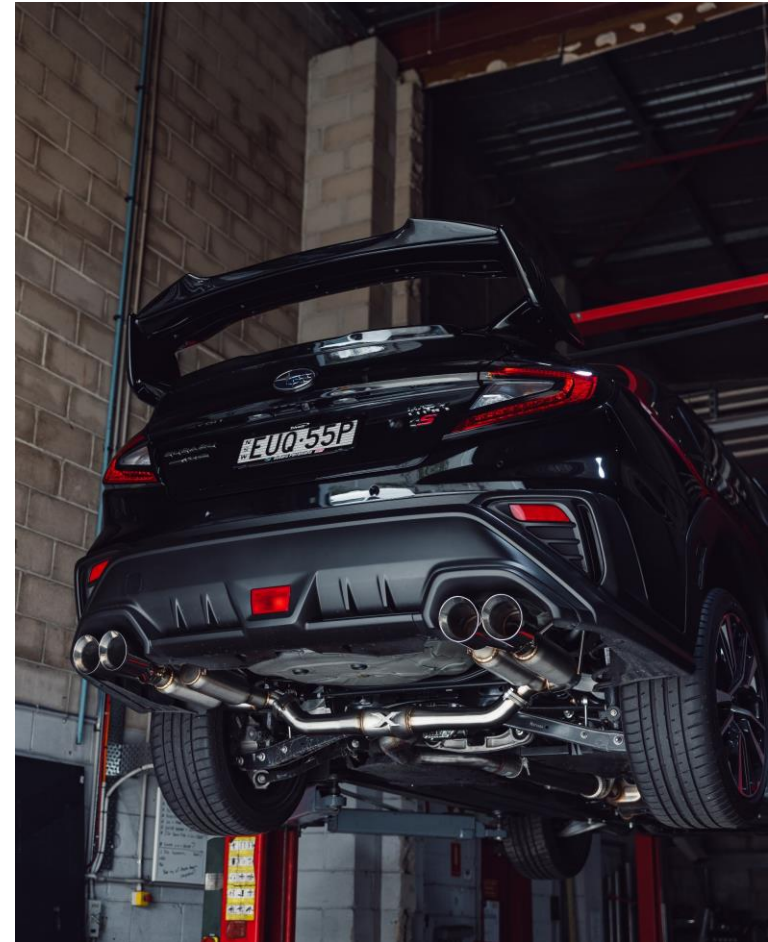


### Step 1:

XFORCE Recommends using a hoist for installation of our systems.

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!





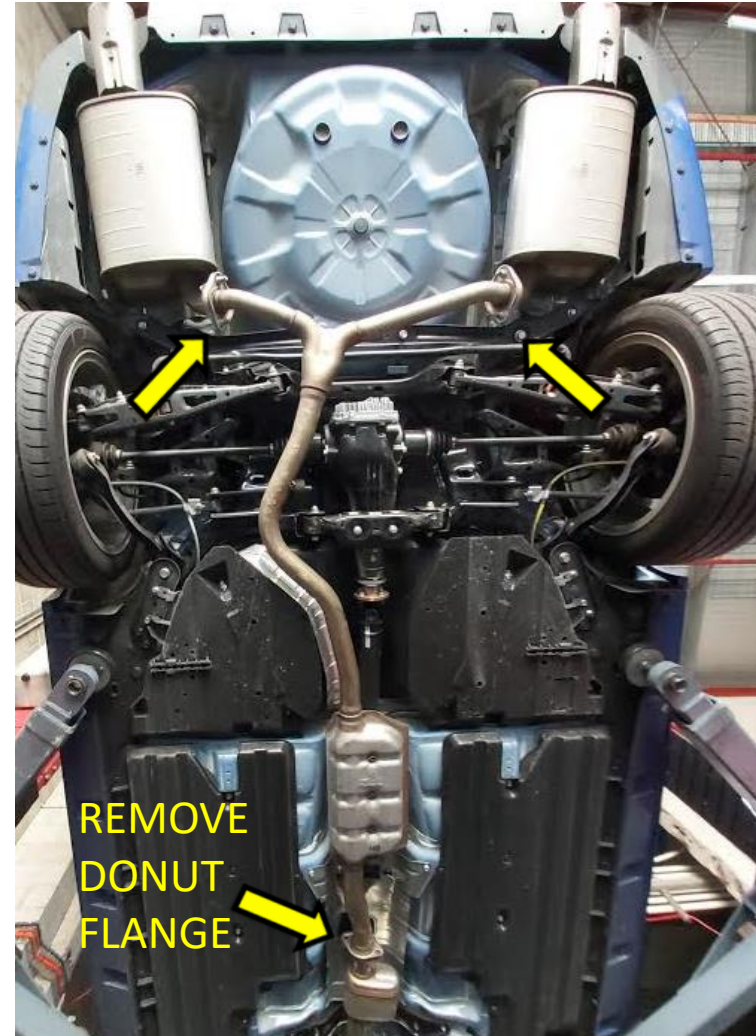
### Step 2:

Lubricate the bolts on the ball flare behind the cat & between the Muffler & Y-Pipe. Loosen bolts but don't remove.

Remove the front of the center pipe first then remove the Y-Pipe.

Now remove factory mufflers from the hangers.

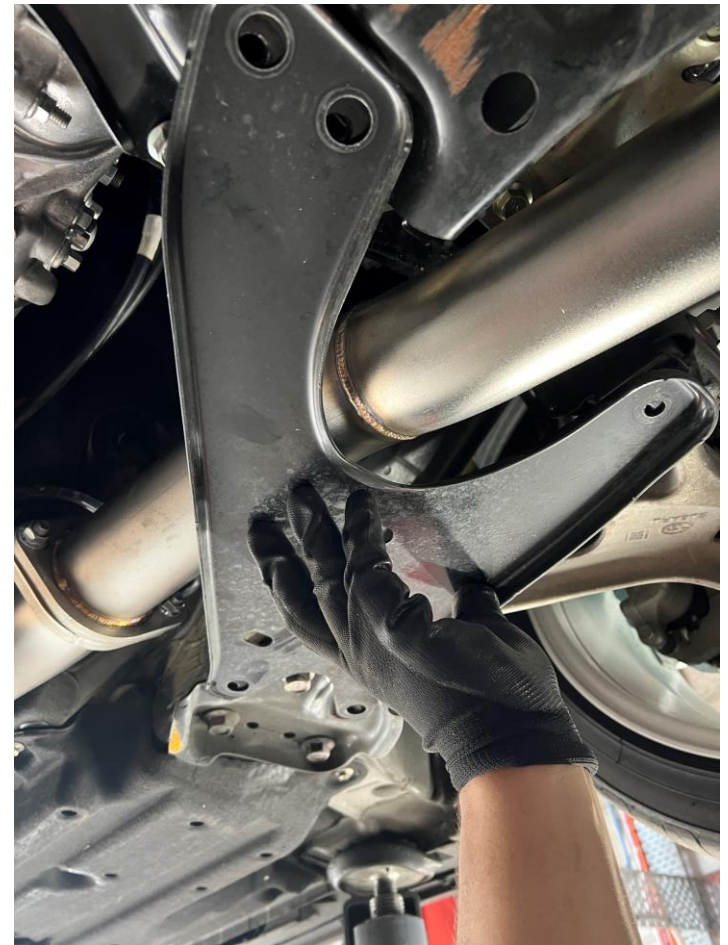
(See Cat Back installation guide if re-installing XFORCE Cat-Back System)





## Step 2:

Remove 14mm bolts for the passenger-side subframe brace.



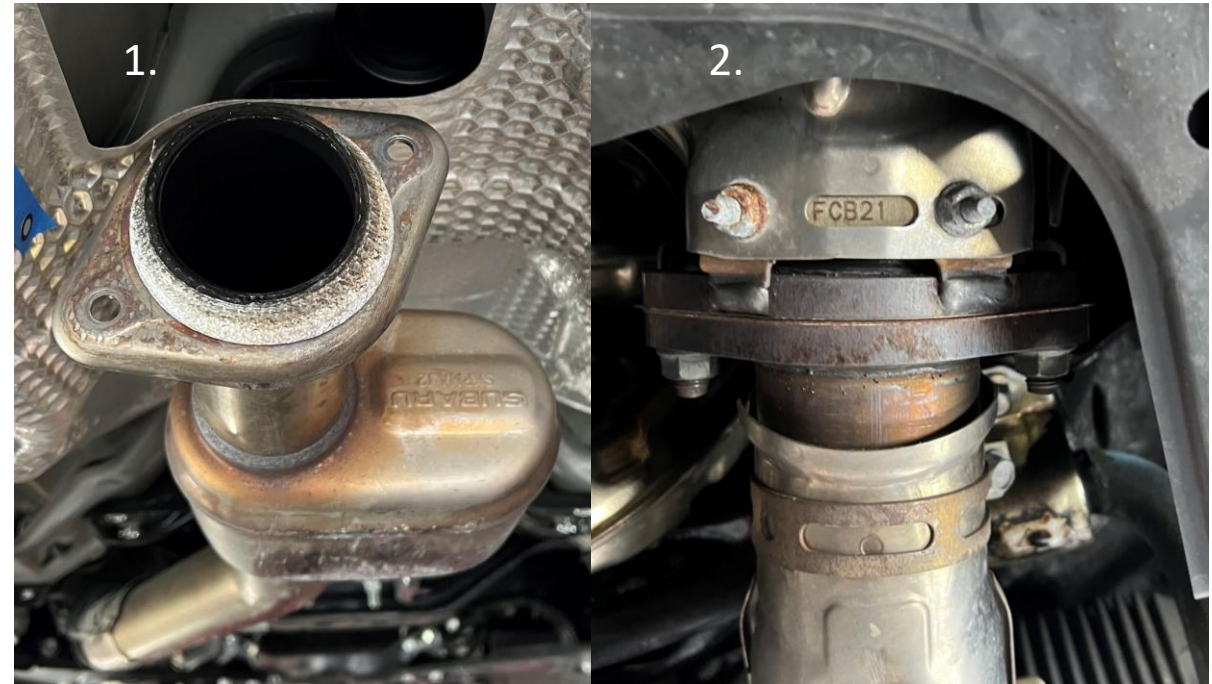




### Step 2:

Lubricate the bolts on the back of the Secondary Cat Pipe (Picture 1) & back of the first cat (Picture 2) & remove.

Un-bolt mount from center of factory pipe (Picture 3) & remove pipe.



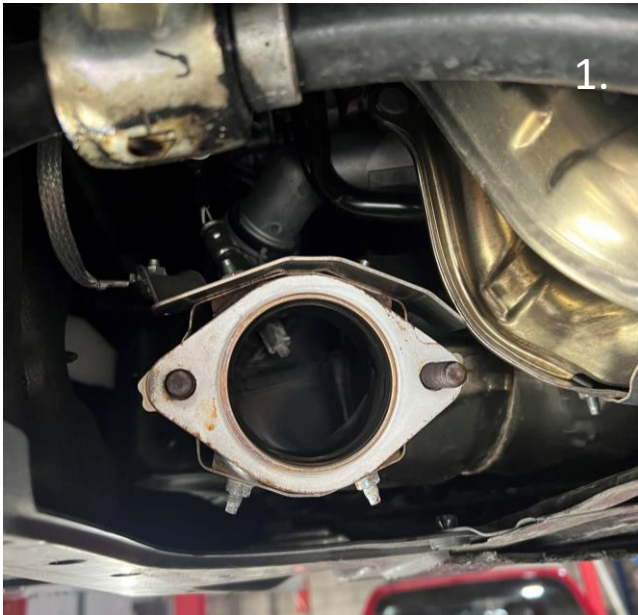


### Step 3:

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

1. Fit the Front Section (E4-SW29-C1) w/ 2-Bolt Gasket to the back of the First Cat.
2. Bolt Rear section (E4-SW29-C2) to the Front section.
3. Use factory bolt to mount bracket on the center of the pipe.
4. Fit subframe brace back onto vehicle using factory bolts.

XFORCE recommends using O2 Safe Sealant on all gaskets & slip on surfaces!







#### Step 4:

Fit Cat-Back system (XFORCE or Factory System) back to vehicle.

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.

Slip Joint Clamp (XFORCE System) needs to be tightened to 80 Foot Pounds.

Remove any hoist stands if used.

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 part is designed for the VB/VN WRX
- 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.

