



# Focus RS

## KIT B

### 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.



## Part Number List

1. ES-FRS16-F1
2. ES-FRS16-F1H
3. ES-CRP21-300
4. ES-CATB21-300
5. ES-FRS16-F2
6. BNG-08
7. 3 X GASKETS
8. 4 X 10MM BOLTS AND NUTS



# Step 1

Remove Air Box

Remove Battery

Remove Battery Box

Disconnect Front and Rear O2 Sensors

Remove Front O2 Sensor

Undo 2 x 15mm Nuts On Dump Pipe Turbo Flange

Raise Car On Vehicle Lift



## Step 2

Remove Under Tray

Remove Steel Brace

Remove Rear O2 Sensor

Unbolt Dump Pipe Support Bracket

Unbolt V Band between Exhaust and Dump Pipe

Remove Dump Pipe From Engine Bay



## Step 3

On a bench assemble the dump pipe (ES-FRS16-F1) to the High Flow Cat (CATB21-300 or tuning pipe CRP21-300) and to the lower dump pipe (ES-FRS16-F2) making sure that the gaskets are between the flanges and the flange with the oval holes on the F1 goes to the turbo.

Tighten all nuts and bolts and install the BNG-08 into the **SECOND** O2 sensor hole and fit the rear sensor into the BNG-08 (make sure it points towards the F1 following the tube)

Slide the assembled XForce dump pipe into the engine bay from underneath, fit hanger hooks on the F2 into the rubber on sub frame and F1 flange onto the turbo then lower the Vehicle.



## Step 4

Tighten Dump Pipe at the Turbo.

Refit front O2 Sensor and plug both Front and Rear Sensors into the Wiring Harness.

Refit Battery Box.

Refit Battery.

Refit Air Box.

Raise Vehicle.



## Step 5

Fit ES-FRS16-F1H to the dump pipe and factory support on the Gearbox

Refit Steel Brace

Before Refitting the under tray check that all bolts, brackets, fittings and wiring plugs are in the correct place and tight.

Once your happy everything is correct Refit the Under Tray.

Final Step is to connect the Dump Pipe Assembly to the XForce Cat Back (ES-FRS16VMKSB-CBS).

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.