



# Toyota Yaris GR (GXPA16R)

## VAREX 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.



## Parts List

1. ES-TY21 C1
2. 1 x 3 1/8" Clamp
3. ES-TY21 C2
4. 2 x 2 bolt Gasket and Nuts and Bolts
5. ES-TY21-VMKR (Rear muffler)



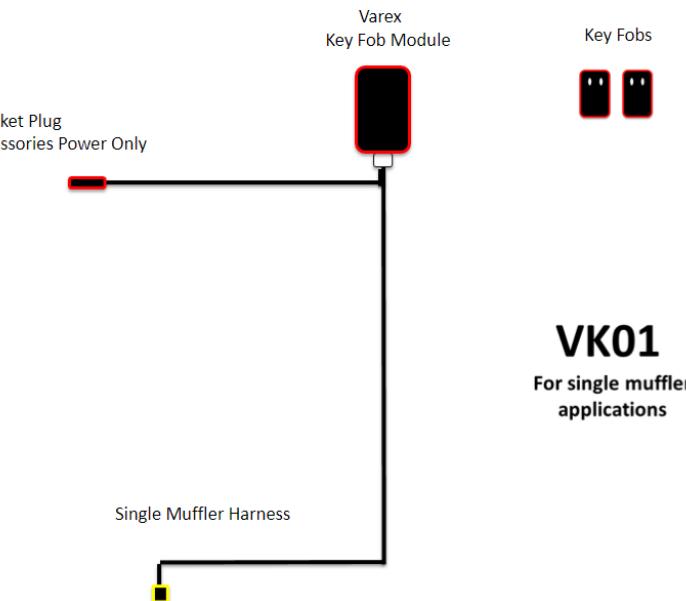
## Required Tools and Equipment

1. Spanners and Sockets required 13mm, 14mm, 15mm, 16mm
2. 3/8" Ratchet
3. 6" long 3/8 Extension bar
4. Can of spray lubricant
5. Tube of O2 Sensor safe sealant for the 2 bolt Gasket and Slip Joints
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 VAREX muffler and control box and power up. Check the operation of all electronics and Muffler valve before installation.

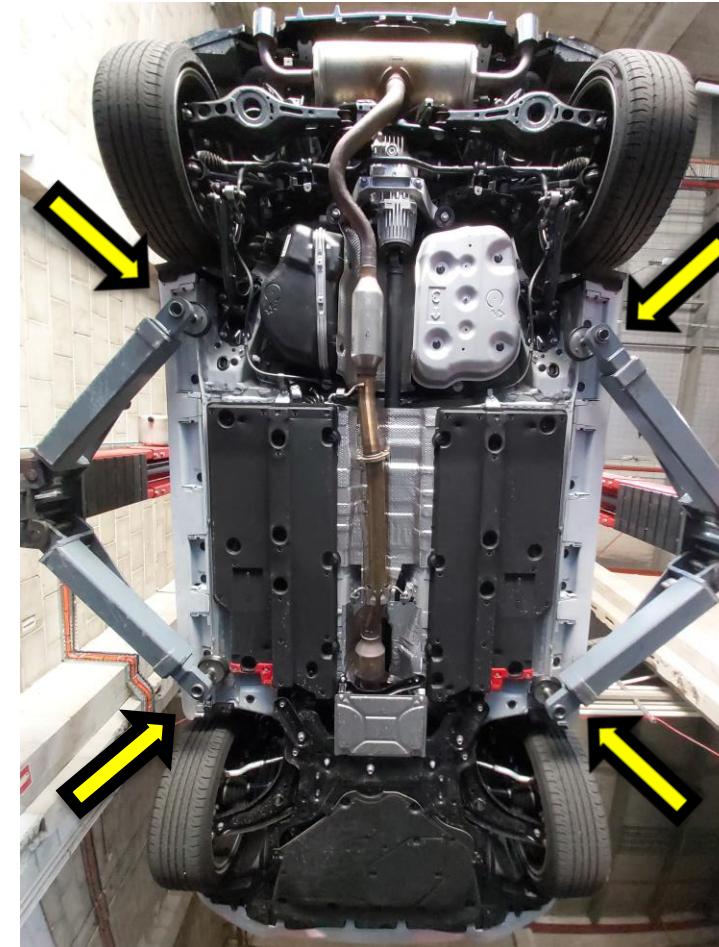




## Step 1

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 **IS NOT** under the vehicle while hoist is moving. Once the Vehicle is at a workable height engage the hoist safety locks.





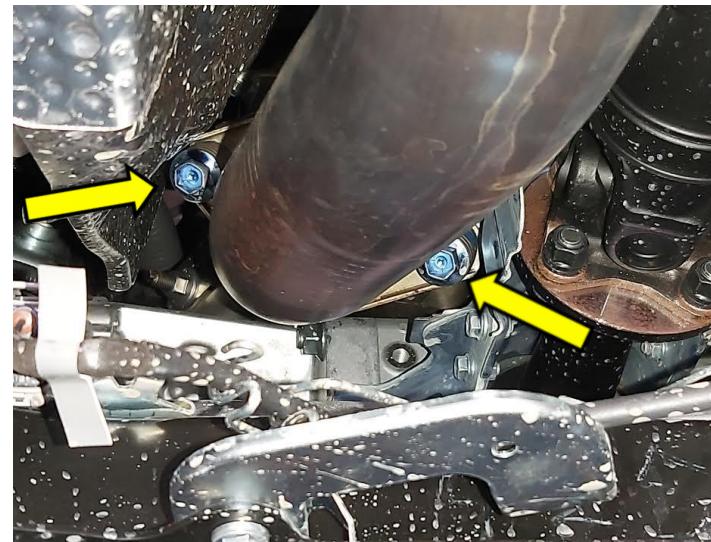
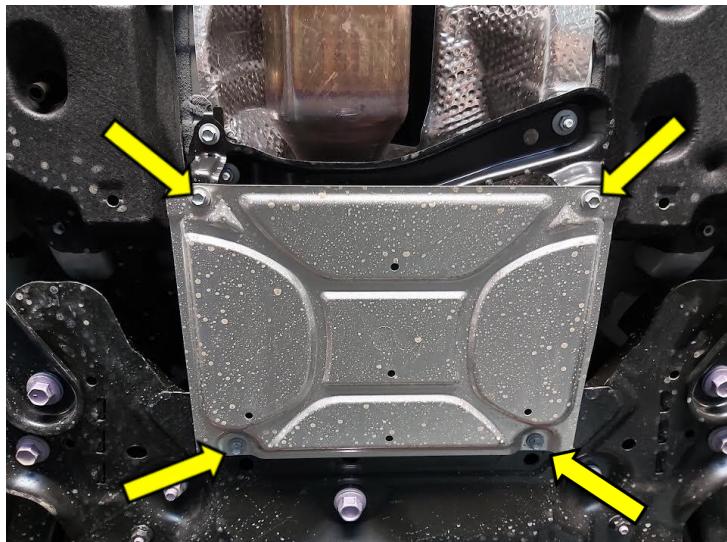
## Step 2

Please make sure you are wearing safety equipment as listed in Required Tools/Equipment.

Unbolt the 4 x 10mm bolts holding the steel cover then remove.

Unbolt the 14mm spring loaded bolts on the ball flare at the base of the cat.

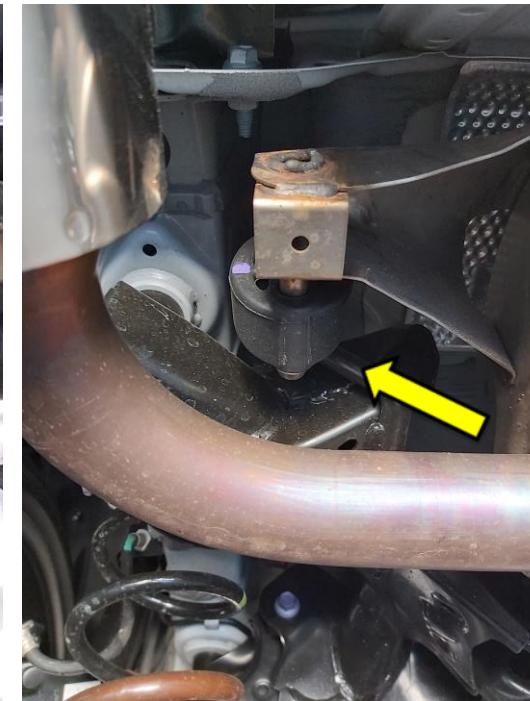
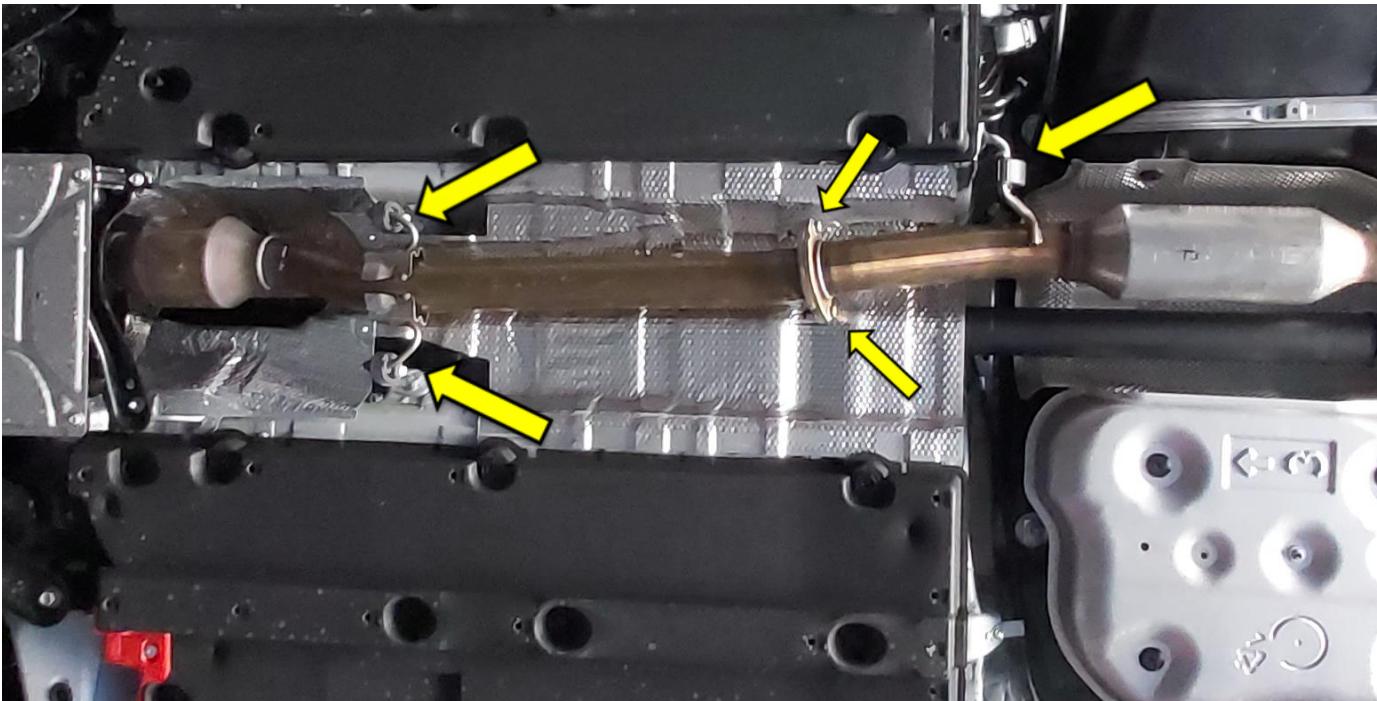
Unbolt the O2 sensor using a 7/8" or 22mm spanner





## Step 3

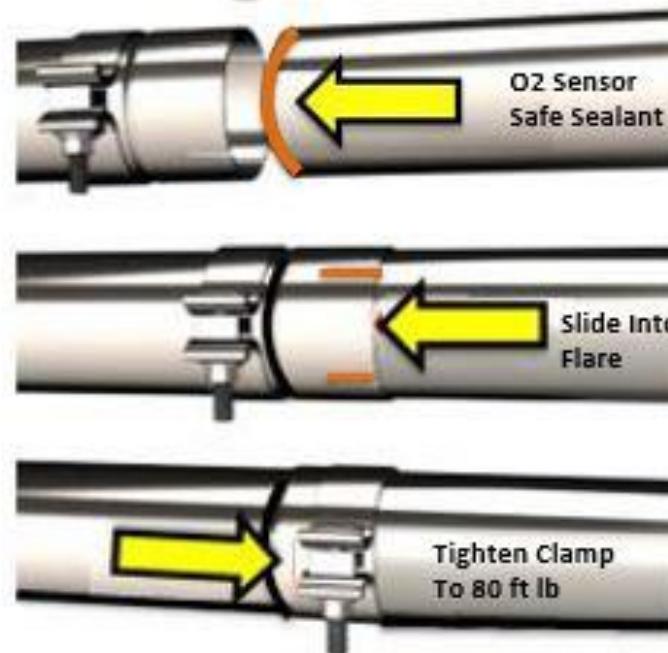
Lubricate the 3 centre rubbers and the 2 rear muffler rubbers the unbolt the 2 x 14mm nuts and bolts at the middle flange then remove the 2 exhaust pieces





## Step 4

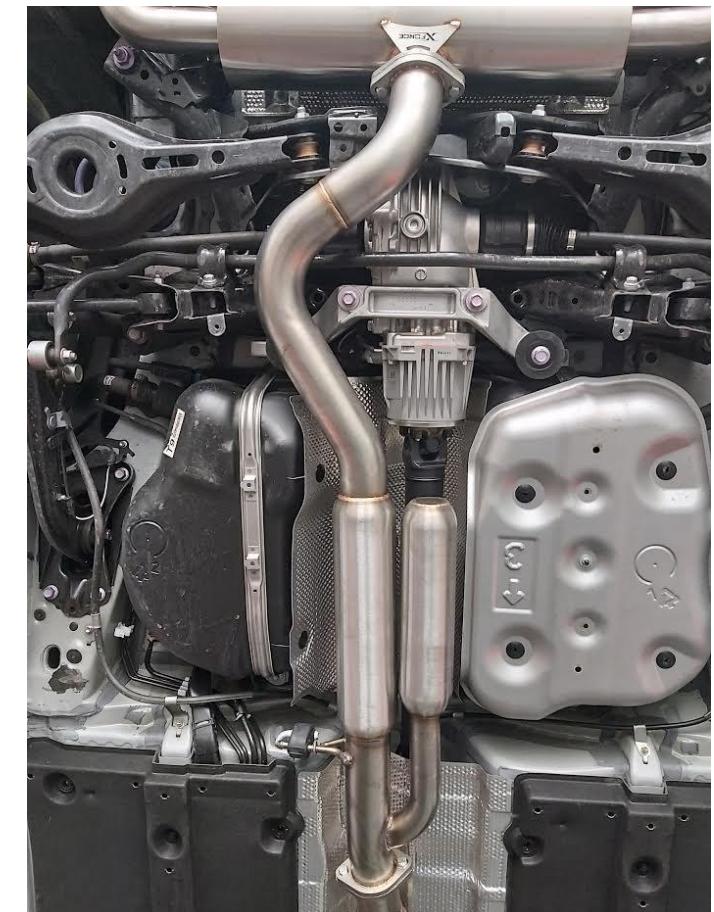
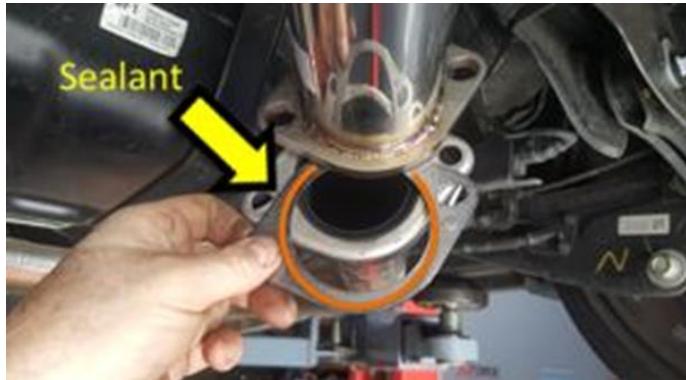
- 1 Fit the TY21 C1 to the base of the cat and replace the 14mm spring loaded bolts
- 2 Refit the O2 sensor and tighten with the 7/8" or 22mm spanner
- 3 Slide the clamp over the slip joint inlet on the TY21 C2 and then slide over the C1 and fit the rubbers then position the clamp and tighten as per diagram.





## Step 5

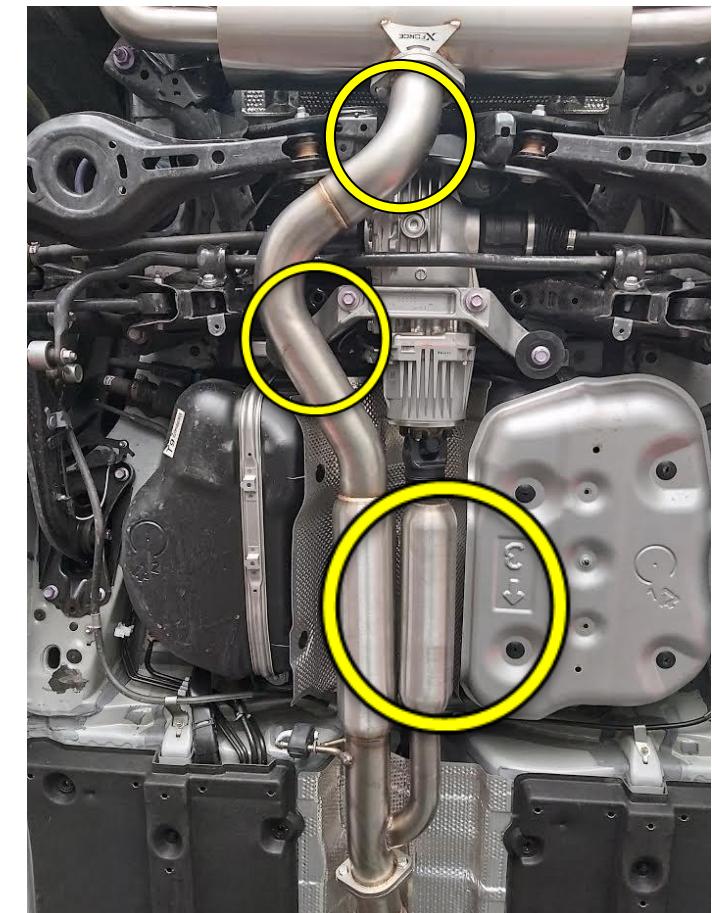
- 1 Hang the rear muffler on the rear rubbers.
- 2 Fit the TY21 C3, the 2 bolt gaskets as per diagram and the 4 x nuts and bolts then tighten.  
**REFER TO DIAGRAM for gasket installation**
- 3 Fit the 2 x tips, position and tighten the 10mm clamps.





## Critical Points to Check

- 1 Check these points before tightening for potential rattle issues.
- 2 If the muffler hanger with the arrow is to close to the chassis hanger where the rubber mounts, you will need to slide (at the slip joint near the engine) the system back towards the rear bar .





## Step 6

1 Check the rear muffler and tips are level and even, check the gaps at all points of the exhaust are enough and haven't moved in the tightening process.



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.



**Your exhaust is now fitted**

Now proceed to installation of the VAREX Key Fob wiring



The VAREX logo, consisting of the word "VAREX" in a large, bold, three-dimensional grey font.

# Varex Key Fob wiring Installation Instructions

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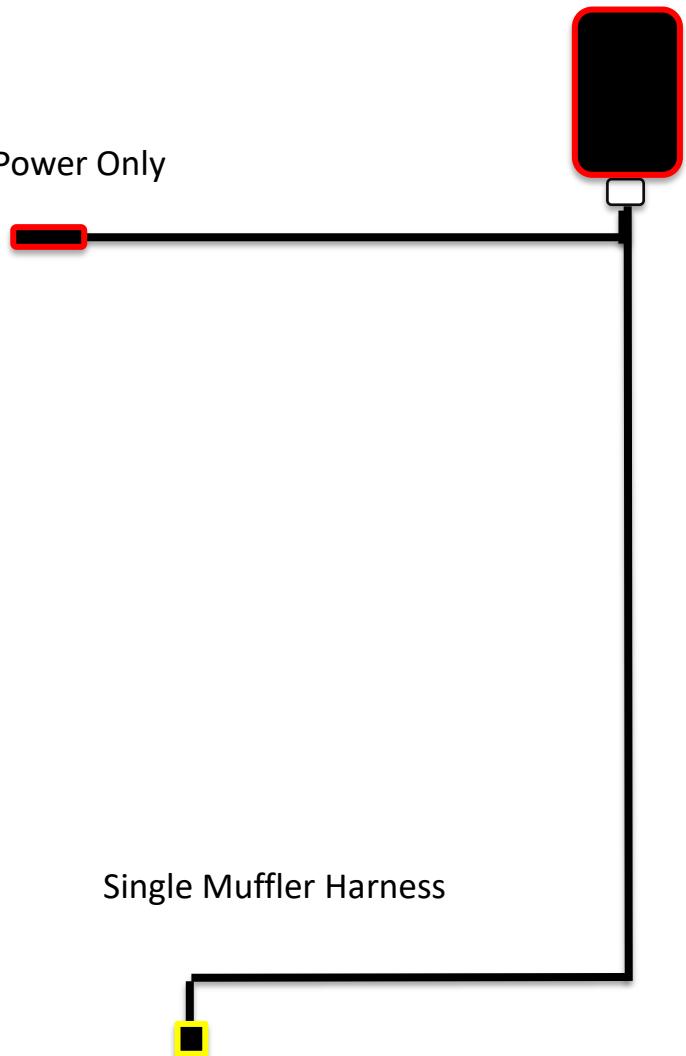
## What's inside the box

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



Varex  
Key Fob Module

Key Fobs



**VK01**

For single muffler  
applications

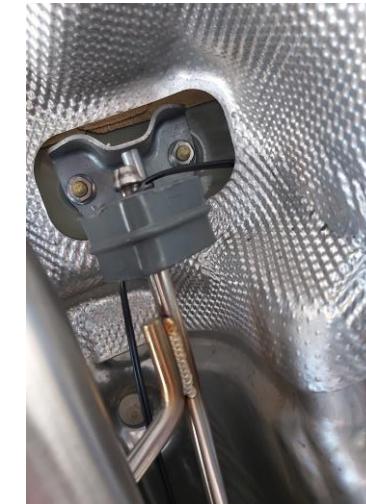


## Step 7

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

Remove the boot floor cover and to the right of the battery there is a plastic grommet. Very carefully make a hole.

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 8

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).

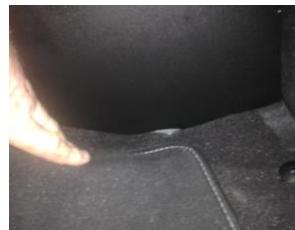
Do this all the way to the front of the cabin and feed the wire behind the kick panel Pic 3 (plastic cover near where your feet would be in the front of the car).



Pic 1



Pic 2



Pic 3



## Step 9

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 10

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).

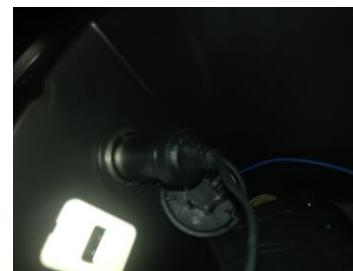
Turn the car on and test the system using the remote

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 11

Drive vehicle for 10mins, Return to **Step 6**, retention all nuts, bolts and enjoy the driving experience your new XFORCE system provides.

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