



## Dodge Ram 1500 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.



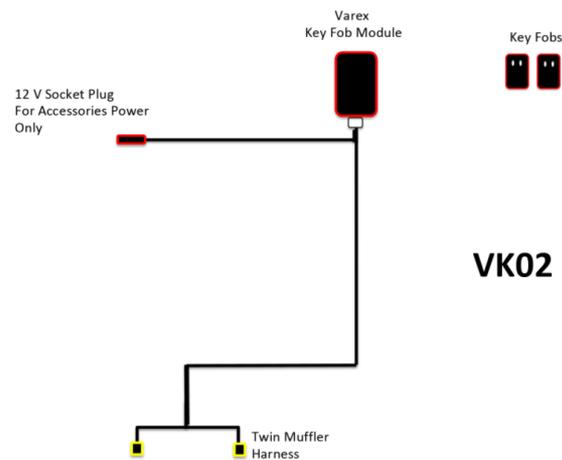
## Required Tools and Equipment

1. Spanners and Sockets required 15mm, 16mm, 19mm
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 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 for Varex ONLY

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).**

Raise vehicle on a 2 post hoist making sure hoist arms are in the correct lifting positions Under Steel Chassis (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

Disconnect the negative battery cable before removal of OEM exhaust. This will allow the ECU to reset for the new Xforce exhaust.



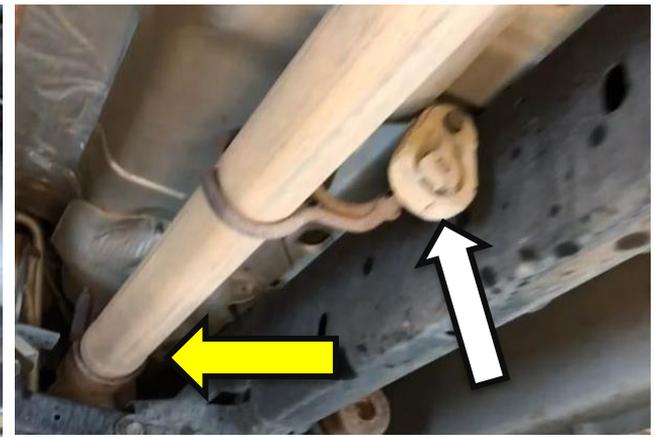
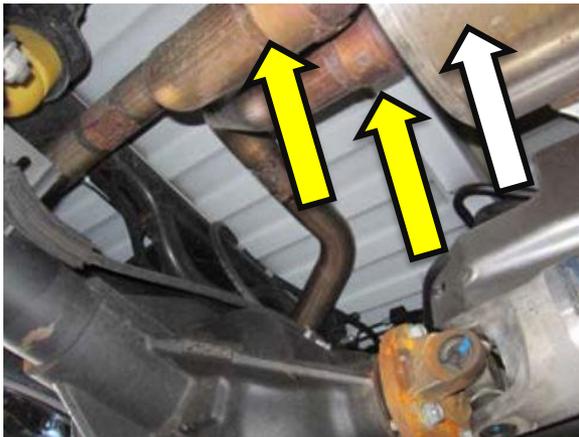


## Step 3

To remove the OEM exhaust, remove all clamps indicated with the yellow arrows.

Spray the hangers (White Arrows) using WD40 and slide out from the OEM rubbers.

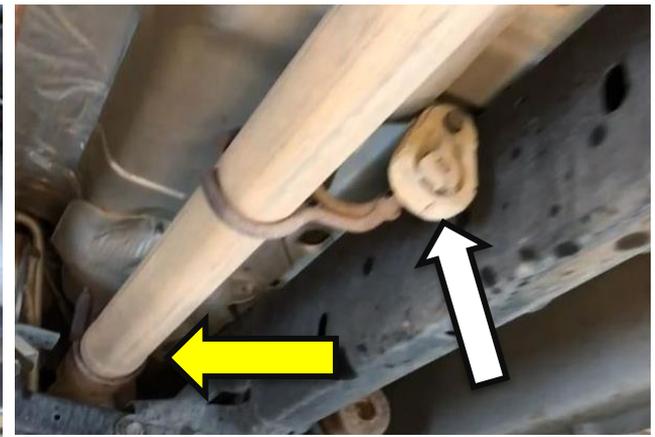
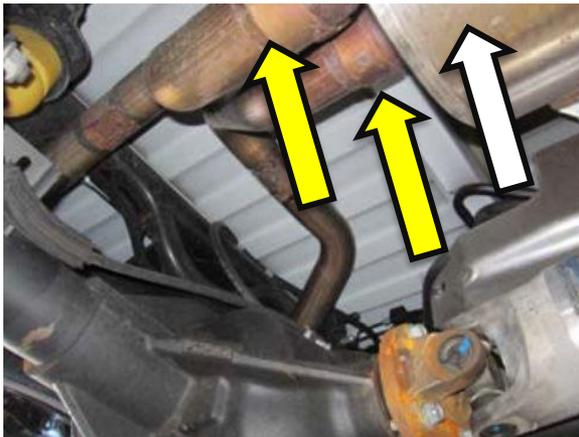
Do not damage or remove the rubbers as you will reuse them to mount your new Xforce system.





## Step 4

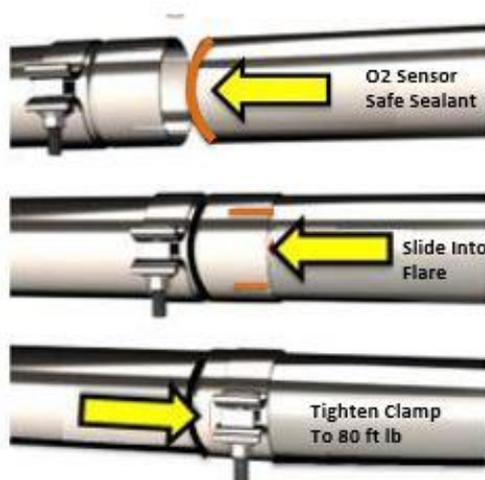
First remove the tailpipes by twisting clockwise and then anticlockwise while pulling away from the centre muffler. Repeat these steps on the muffler and then the front pipe until all the factory parts are removed and your ready to install the Xforce system.





## Step 5

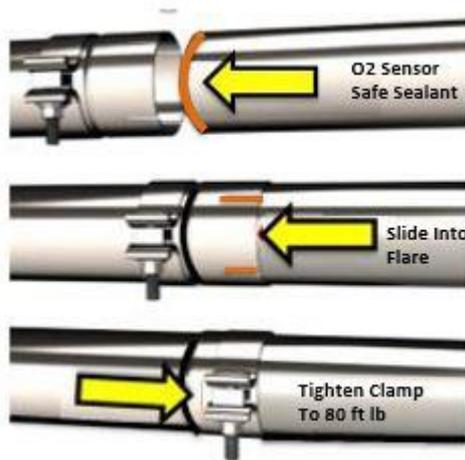
First fit the clamp over the Y pipe inlet, O2 sensor safe sealant into the inlets and then slide the Xforce Y Pipe over the factory engine pipe making sure the flex is closest to the transmission so the hanger will slide into the rubber and leave loose.





## Step 6

Slide the clamps over the C2 inlets, O2 sensor safe sealant into the inlets and then slide the Xforce C2 over the Xforce Y pipe and into the rubber then leave loose.





## Step 7 NON Varex

Bolt the Xforce C2 pipe and mufflers together at the 2 bolt flanges, slide into the rubber then leave loose.





## Step 7 Varex

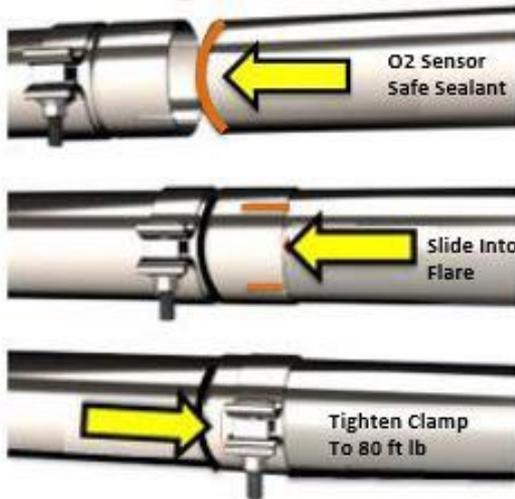
Assemble the hanger onto the 2 Varex VMK41-300 mufflers, making sure the motors are on the top. Lift into place, slide into the rubbers and bolt to the C2. Make sure you have 8-10mm gap between the hanger bolt and Chassis





## Step 8

Slide the clamps over the tailpipe inlets, O2 sensor safe sealant into the inlets and then slide the tailpipes over Xforce mufflers and into the rubbers then fit the tips and leave loose.





## Step 9

Make sure the system is aligned correctly, that there is at least a 25mm (1") clearance from ALL rubber brake lines, shock boots, fuel lines, tires, etc to prevent heat related damage or fire. Then tighten the clamps to 80 ft lbs from the rear to the front constantly checking the gaps and clearance as you go.





# VAREX

## Varex Key Fob wiring Installation Instructions

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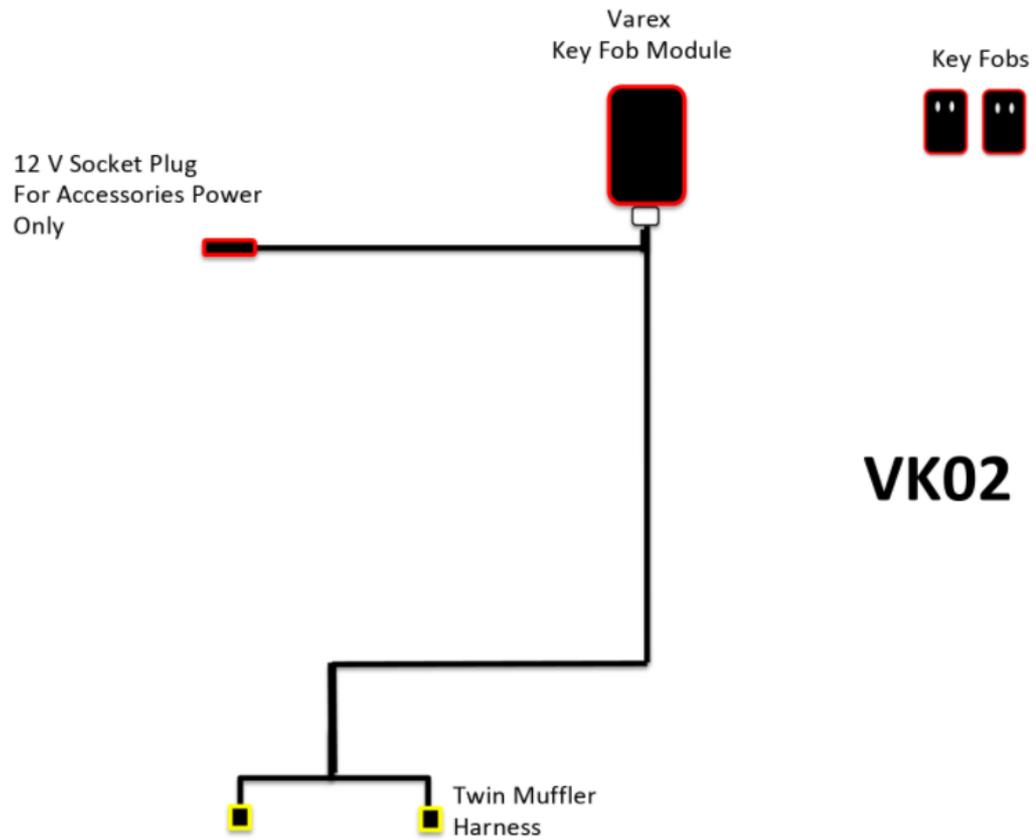
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## What's inside the box

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







## Step 10

Access the underside of the car through the storage box under the floor on the right between the front and rear seats. Drill a hole in the plastic box to allow the wiring through. Feed the black 2 pin plugs through the hole and into the underside of the car and connect to the mufflers.



## Step 11

Feed the wiring through the box towards the front seat, then run the wire between the right front seat and the centre console then into the 12V socket in the dash.



## Step 12

Plug the Key Fob box into the white 4 pin plug and the (pic 4) and place in the storage box and check Valve operation again.



Pic 4



## Step 13

- 1 Check the tips are level and even
- 2 If it's uneven loosen the clamps in **Step 8** rotate the tailpipes so the tips are level and even then retighten as per **Step 8** and check again.
- 3 Disengage safety locks and lower the vehicle



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.



## Step 11

Drive vehicle for 10mins, Return to **Step 5**, retention all nuts, bolts and enjoy the driving experience your new Xforce System provides.