

## 2018+ FORD MUSTANG GT 5.0L

### CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works catback exhaust system for your 2018+ Ford Mustang 5.0L. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



2018+ Ford Mustang GT 5.0L  
M18CB...

**a.**

Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

**b.**

Your exhaust system can be installed by a weekend warrior but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a hard level surface. Jack stands are required for safety reasons.

**c.**

You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.

**d.**

When installing your catback system, make certain that the hangers at the end of the exhaust have at least  $\frac{3}{4}$ " of clearance to the bumper. The exhaust will grow over  $\frac{1}{2}$ " in length and can possibly damage the bumper. If the end of the hangers are too close to the bumper, then you must make sure that you have everything pushed forward onto the slip fit joints more fully.

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## DISASSEMBLY

- 1.**  
Disconnect the battery.
- 2.**  
Raise and support the vehicle.
- 3.**  
Loosen clamps at the factory connection point behind the transmission. Save these clamps if you are installing to the factory manifolds.
- 4.**  
If your vehicle is equipped with Active Exhaust, unplug the wiring from the exhaust valve motor.
- 5.**  
Unbolt the (2) 8mm bolts from the rubber tailpipe hangers and remove them from the rear subframe. Save the bolts and hangers.
- 6.**  
Remove the exhaust from the hangers near the rear bumper and remove from the car. This may take two people.
- 7.**  
If equipped, remove the exhaust valve motors from the stock system, saving the (6) nuts for later.



*Detail 3: Clamps at catback connection*



*Detail 5: Rear subframe hangers*

## ASSEMBLY

- 8.**  
Install your H-pipe or X-pipe. Factory connect systems will use the clamps that were removed in step #3. Performance connect systems will use (2) of the provided 3" clamps.
- 9.**  
Install the (2) mid pipes or (2) mid mufflers to the H-pipe or X-pipe using (2) 3" clamps.
- 10.**  
Install right and left tailpipes using (2) 3" clamps.



*Detail 9: H-pipe and mid pipes installed (factory connect shown)*

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**11.**  
If equipped, assemble the exhaust valve motors onto the muffler assemblies. Make sure the spring aligns into the groove on each valve. Use the provided 6mm bolts and spacers along with the (6) factory nuts.

**12.**  
Install left and right muffler assemblies into rear hangers and onto tailpipes using (2) 3" clamps.

**13.**  
Reinstall the rubber hangers removed in step #5, using the (2) 8mm bolts.

**14.**  
Level the H-pipe or X-pipe and snug the clamps.

**15.**  
Adjust and tighten the system from front to back. Keep the components level from side to side as the tubes are adjusted.

**16.**  
Be sure to have adequate clearance around all wires, hoses and lines. If anything is in contact with the exhaust system, it will melt. Make sure to have at least 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

**17.**  
After double checking for clearance and making sure all lines, wires and hoses are secured, drive the vehicle for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.

If equipped, we recommend disconnecting the exhaust valve motors before performing any welding.



*Detail 12a: Left muffler assembly installed*



*Detail 12b: Tip alignment in valence*



*Detail 15: View from rear of vehicle*

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