

2023+ Ford F-150 Raptor R

CATBACK INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works Catback system for your 2023+ Ford F-150 Raptor R. 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.



**2023 Ford F-150 Raptor R
(FTR25CB)**

a.

Prior to turning off the vehicle, if available raise the air suspension all the way up to allow easier removal and assembly of the system

b.

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

c.

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.

d.

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.

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DISASSEMBLY

1. Disconnect the battery.
2. Lower or remove spare tire. (optional)
3. Unplug both valve motors from the muffler. See *photo*
4. Unbolt driver side flange from manifold leads (2x 15mm)
5. Loosen the clamp on the passenger side and slide towards the muffler. (2x15mm)
6. Loosen both clamps holding the midpipes to the muffler and remove midpipes. (3x15mm)
7. Loosen both clamps above the axle after the muffler (2x15mm)
8. Remove factory grommets holding the rear tailpipes and set to the side for later use. There are 2 per side, one on the outside of the frame and one on the back of the rear bumper. (4x10mm/side) See *photo*
9. With the grommets removed and the clamps for the tailpipes loose, you will be able to remove the tailpipes.
10. Remove the hanger from the frame at the front of the muffler. (2x10mm) The muffler section will have two hangers holding it up. For this part it's helpful to have a second person holding the muffler to prevent it from swinging down. Remove the hanger from the frame at the front of the muffler. (2x10mm)

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Step 3: Unplug valve motors from both sides.



Step 8: Remove factory grommet mounts on both sides (2x10mm each)

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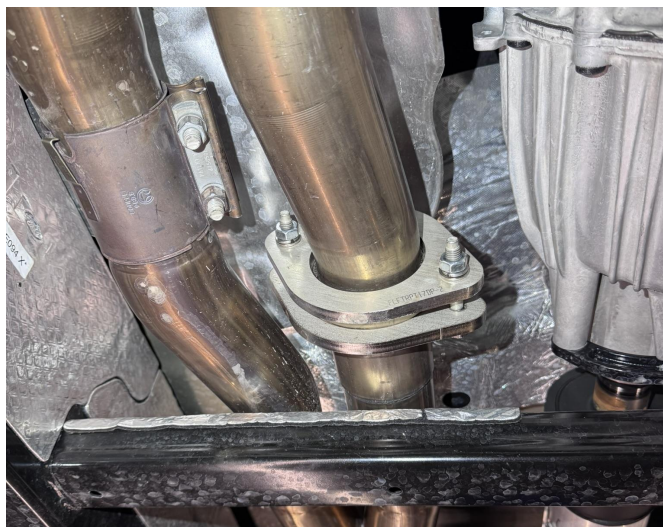


ASSEMBLY

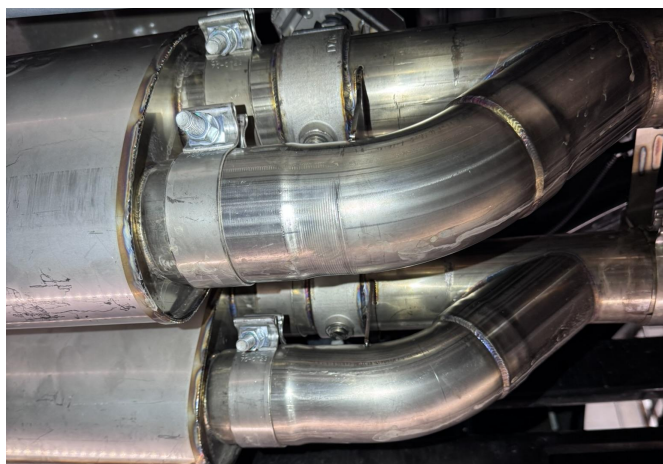
11. Starting with the front, install the lead pipes using the factory clamp on the passenger side and the supplied 2-bolt flange on the driver side. *See photo*
12. Install the x-pipe followed by the muffler lead pipes.
13. Reinstall the front muffler clamp hanger bracket and slide the shorter wire hanger into the grommet.
14. Install the mufflers, starting with the side closest to the frame install the mufflers ensuring that you slide the clamp over the clamp hanger.
15. Before installing the y-pipes, remove the factory valve motor and install the motor with the supplied spring and spring mount by aligning the mount to the motor, pressing towards the valve plate and twisting until it locks into place. You will reuse the screw removed from the factory motors.
16. Install the y-pipes to the mufflers with the valves facing up, at this point you can plug in the supplied valve motor extensions, tuck the excess wire away from hot and moving parts. *See photo*
17. Install the longer clamp bracket hanger into the factory grommet at the rear of the mufflers above the outlet of the y-pipes. .
18. Install the front tail pipes ensuring that you slide the clamp over the clamp hanger.
19. Reinstall the factory grommets that were removed from the back of the bumper, this will help get the tails aligned in place.
20. Sliding the hangers from the tails into the grommet you can now attach them to the front tails and reinstall the grommets that were removed from the outside of the frame onto the tails then bolted to their factory location. *See photo on next page*
21. Tighten down all clamps from front to back once you have everything positioned correctly. Usings spacers in tighter spots while tightening will help retain location during this process.

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Step 11: Factory connection point



Step 16: Y-Pipes installed with valves facing up

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22. 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 ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.
23. 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.

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HEADER INSTALLATION INSTRUCTIONS

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Step 20: Tails installed onto grommet

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