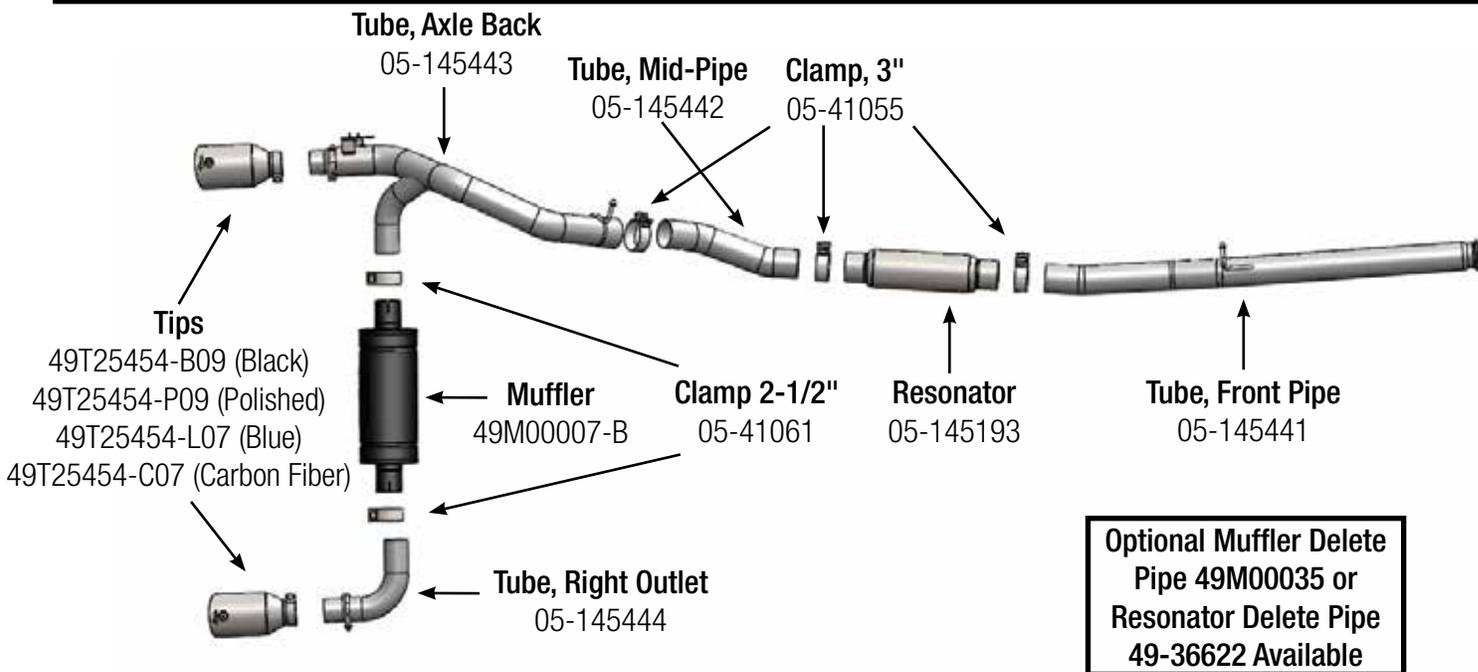


# INSTALLATION INSTRUCTIONS

**MAKE:** Ford  
**MODEL:** Focus RS  
**YEAR:** 2016-2018  
**ENGINE:** L4-2.3L (t)

**Cat-Back Exhaust**  
**304 Stainless Steel**  
 49-33103-B (Black Tips)  
 49-33103-L (Blue Tips)  
 49-33103-P (Polished Tips)  
 49-33103-C (Carbon Fiber Tips)



Professional installation is highly recommended. (Read instructions prior to installation). Make sure to always have at least (2) stands or jacks on hand to support the removal of OE system. Also for the installation of aFe system. Any Removal of rubber isolation mounts may require using a spray lubricant such as WD40 and a pry bar.

**Step 1. (Read Instructions prior to installation)** for faster removal and installation of exhaust a trained professional is recommended for this procedure.

**Step 2.** Secure stock exhaust with jack/stands.

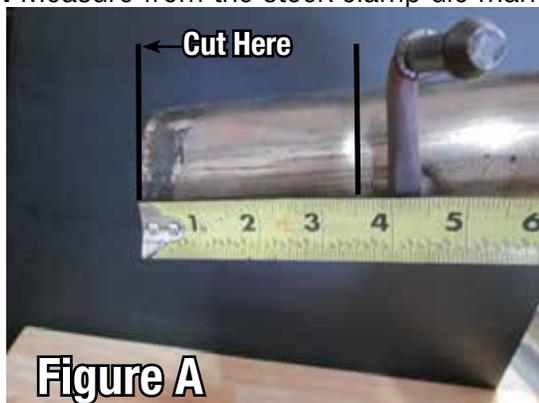
**Step 3.** Disconnect negative battery terminal.

**Step 4.** Unplug the exhaust valve motor connector.

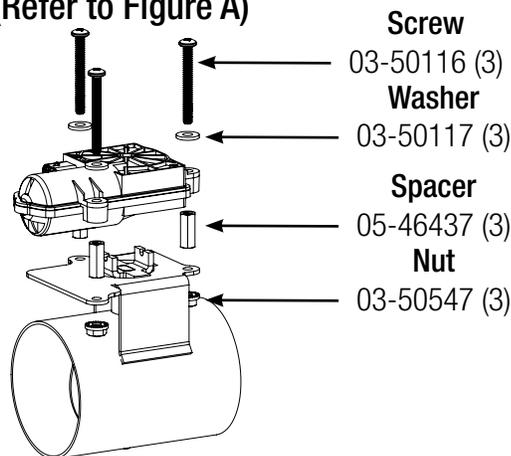
**Step 5.** Loosen the stock v-band clamp from the stock down pipe.

**Step 6.** Un-bolt all rubber hangers from the chassis.

**Step 7.** Measure from the stock clamp die mark 3.5" and mark tube. (Refer to Figure A)



**Figure A**



**Step 8.** Cut exhaust on mark and remove stock exhaust.

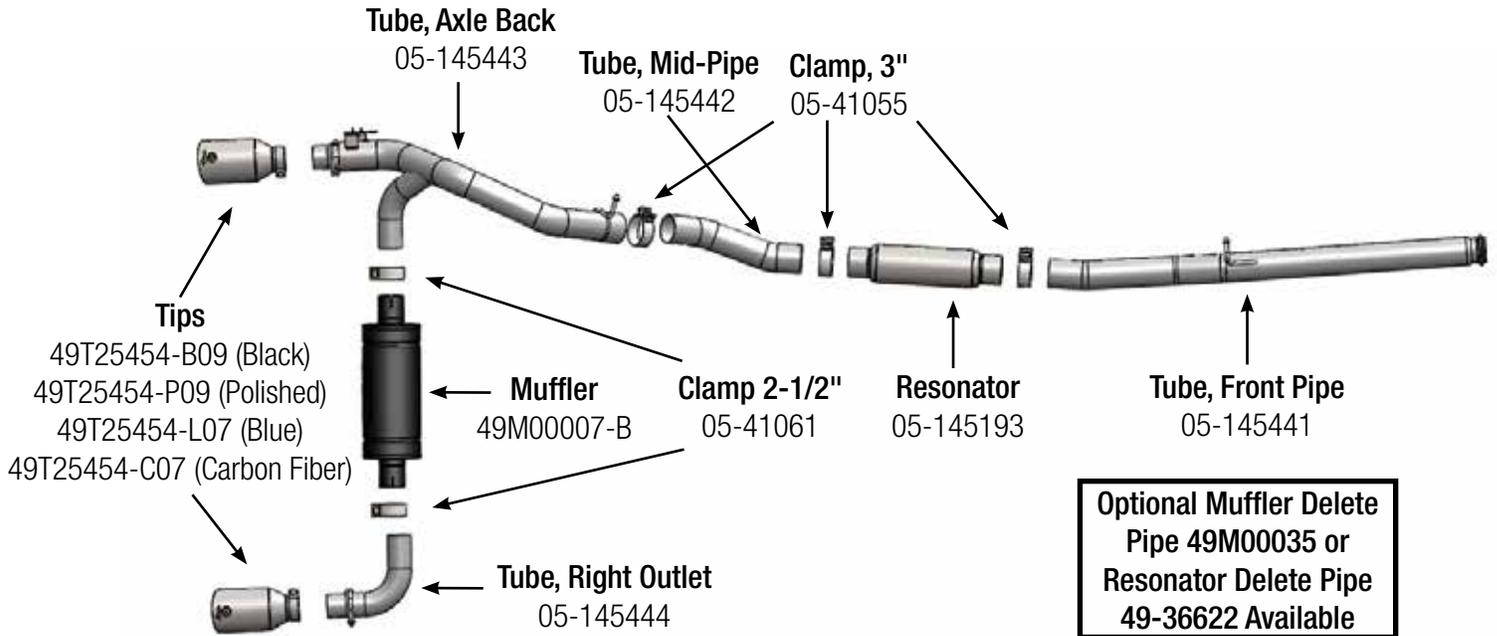
**Step 9.** Remove the motor valve from the stock muffler and install onto the TAKEDA axle back muffler using (x3) supplied nuts, spacers, screws and washers. **Continue Page 2.**

**Caution:** Allow time for your vehicle to cool down prior to installation. When working on or under your vehicle proceed with caution. Exhaust systems reach high temperatures and may cause serious burns. Wear protective safety equipment; eye goggles and gloves to ensure a safe installation. **aFe recommends professional installation on our products.**

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- Step 10.** Remove all rubber hangers' mounts off the stock exhaust section and transfer onto the TAKEDA exhaust system.
- Step 11.** Install the TAKEDA front pipe using stock v-band clamp, **but do not tighten.**
- Step 12.** Using the (x1) supplied 3" band clamp, install the TAKEDA resonator onto the front pipe, **but do not tighten.**
- Step 13.** Using the (x1) supplied 3" band clamp, install the TAKEDA mid pipe #2 onto the resonator, **but do not tighten.**
- Step 14.** Using the (x1) supplied 3" band clamp, install the TAKEDA axle back assembly onto the mid pipe #2, **but do not tighten.**
- Step 15.** Using the (x1) supplied 2.5" band clamp, install the TAKEDA muffler onto the axle back assembly, **but do not tighten.**
- Step 16.** Using the (x1) supplied 2.5" band clamp, install the TAKEDA right side pipe onto the axle back muffler, **but do not tighten.**
- Step 17.** Using the (x1) supplied 2.5" band clamps, install the TAKEDA right and left side clamp on tip onto the right and left side exhaust, **but do not tighten.**
- Step 18.** Adjust TAKEDA exhaust system before tightening.
- Step 19.** Once aligned and you're satisfied, you may now tighten complete system.
- Step 20.** Plug exhaust valve motor connector into valve motor.
- Step 21.** Reconnect battery.
- Step 22.** Start the vehicle and check for any leaks.
- Step 23.** Double check all work and ensure everything is tight. Congratulations, your system is now complete and fully installed! It is recommended to re-tighten all clamps and bolts after 50-100 miles.

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