



## Slip-On Muffler Installation Instructions

Thank you for choosing FMF as your performance aftermarket exhaust. We have spent countless hours of R&D and testing to ensure you receive the highest quality product on the market today.

All FMF products are developed using the most current technology available for design and manufacturing. Every exhaust is made 100% at the Flying Machine Factory in Southern California. We use only the highest quality American materials for function and durability.

Since 1973, FMF has been bringing you the very best in bolt on performance. Our products are specifically engineered to broaden your existing powerband and give you an all around power increase with substantial weight savings. Bolt on FMF and **FEEL THE POWER!**

Check out our website at [www.fmfracing.com](http://www.fmfracing.com) for more information.

### Attention

This product is designed for closed course use only unless otherwise stated and not intended to meet emission regulations for use on public lands, roads or access routes – consult with local jurisdictions.

Please read all instructions thoroughly before installation. Failure to follow all installation instructions will void any warranty implied or otherwise. FMF Racing is not responsible for problems due to improper installation and/or improper use.

Before you begin installing this product, we recommend wearing safety glasses and mechanics gloves. You must know how to remove and replace your stock exhaust in order to install this FMF product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new FMF exhaust depending on the application.

### Parts Supplied

(1) Slip-On muffler	045553-045556
(1) spacer	941307
(1) bolt	920655
(1) thermal protection foil	941459

### Tools Required

8mm wrench
spring puller
small screwdriver
WD-40
contact cleaner
high temp silicone

### Removal

1. Make sure the engine is completely cool prior to installation and the vehicle is in a stable position.
2. Using a spring puller tool, remove the spring connecting the front of the muffler to the header.
3. While holding the muffler, loosen and remove the two (2) muffler mounting bolts. Keep for later use.
4. Gently slide the muffler rearward to release it from the header. Use WD-40 in the muffler/header junction to help ease removal.

### Pre - Installation

5. Using contact cleaner, clean the section of the header where the muffler connects and allow to dry.
6. Clean the inside of the side panel using contact cleaner or alcohol, then apply the thermal protection foil (fig. 1).

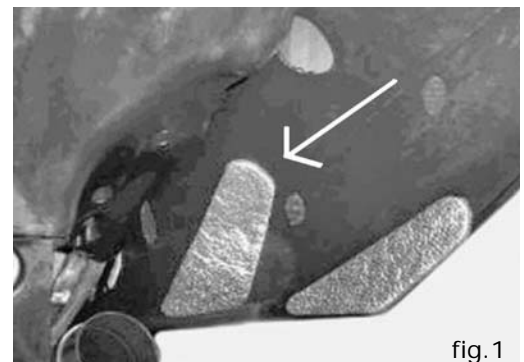


fig.1

### Removal

7. The rubber and aluminum washers from the stock muffler mounts will be used with your new muffler. Remove the inner and outer aluminum washers from each mount and carefully push out the rubber grommet with a small screwdriver using care not to tear the rubber. Use WD-40 to aid in removal and installation of the grommets. With both rubber grommets installed, use the inner and outer aluminum washers for the front muffler mount and for the rear mount unless noted below.

NOTE: 2013-current 250/350 SX-F and XC-F, 2014-current 250/350 XCF-W.

For the rear mount on these models, use only the stock outer aluminum washer and use the supplied spacer (#941307) between the muffler mount and the subframe - do not use the stock inner aluminum washer. You will use the supplied bolt (#920655) on step #10.

### Installation

8. Lightly coat the slip-fit section of the header where the muffler connects with a bead of high temp silicone for an improved seal.
9. Slide the FMF muffler onto the header. Wipe away any excess silicone.
10. Except where noted below, use the stock bolts removed in step #3 to attach the front and rear muffler mounts to the subframe. Do not fully tighten at this time.

NOTE: 2013-current 250/350 SX-F and XC-F, 2014-current 250/350 XCF-W.

For these models, use a stock bolt removed in step #3 to attach the front muffler mount and use the supplied bolt (#920655) to attach the rear muffler mount to the subframe with the supplied spacer (#941307) between the muffler mount and subframe. Do not fully tighten at this time.

11. Make sure the header and muffler are in a neutral position and not binding. Slowly tighten all mounting fasteners to manufacturer's specifications starting at the front muffler mount and finishing at the rear muffler mount.
12. Inspect the complete exhaust to make sure there is no contact with the frame, shock spring, engine, or any cables, hoses or wiring. The exhaust system should only be in contact with the exhaust port and mounting points.
13. Confirm all controls operate in accordance with manufacturer's specifications.

### Post - Installation

14. We recommend using high temp silicone for an improved seal. Please follow instructions for the silicone and allow sufficient time to cure before starting the engine.
15. All FMF exhaust products are designed to use stock fuel settings unless otherwise noted. Our fuel setting recommendations are to be used as a guide only and were derived from operation at sea level at 70 degree ambient air temperature. There are too many variables to provide precise fuel setting specifications; mainly altitude and temperature. If you are not capable of adjusting the fuel settings yourself, please find a mechanic in your area. Refer to our website for additional fuel setting information.
16. Start the engine and bring to operating temperature. Check for exhaust leaks.
17. Allow the engine to cool completely and torque all mounting hardware to manufacturer's specifications.

### Maintenance

To clean your FMF muffler, allow to cool and use mild soap and water. Do not spray water onto a hot exhaust. Mild soap and water is recommended on the muffler canister to reduce streaking and uneven discoloration. Dry completely with a soft cloth.

We recommend repacking your FMF muffler after every 20-30 hours of normal use when properly jetted (more frequently for less than optimal jetting). This will maintain peak performance and keep that race tone. Water will ruin packing. Cover the exhaust outlet when washing your vehicle. Repack your muffler if water enters the chamber and saturates the packing. We offer various repack kits to choose from. If the muffler has a spark arrestor screen, we recommend cleaning it gently with a wire brush after every 30 hours of use.

To repack the muffler, remove the allen screws from the front of the muffler. Do not remove the rear end cap. Grasping the midpipe, work the front end cap out of the canister. Use care not to damage or distort the shape of the canister or end cap. You may need a rubber or plastic mallet to lightly tap the front end cap out of the canister. Unwrap the packing from the core and discard. Clean the core with a wire brush then wrap with new packing and secure with a strip of 1/2" masking tape near each end of the core. Do not pack too tightly as this will hamper performance and increase sound level. Before reinstalling the inner core assembly, apply a thin bead of high temp silicone on the front endcap where it makes contact with the canister. Slide the inner core assembly into the canister making sure the perforated core is fully seated into the rear end cap. Wipe off any excess silicone. Reinstall the allen screws and tighten 1/4 turn after the screw contacts the canister. Allow sufficient time for the silicone to cure before starting the engine.

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