



FORD PERFORMANCE

M-5200-M2EB/EC/EBV/ECV/SB/SC/SBV/SCV/TBV/TCV
Model 2024+
Mustang 2.3L catback exhaust

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PRIOR TO INSTALLATION READ THESE INSTRUCTION COMPETELY
For questions, Call the FORD PERFORMANCE Techline 1-800-367-3788

Please visit <https://www.performanceparts.ford.com> for warranty information

OVERVIEW:

The use of a floor hoist is recommended for this installation. If you do not have access to one, use a hydraulic floor jack and jack stands to raise the vehicle.

!! CAUTION: JACK STANDS MUST BE USED ON A LEVEL SURFACE AND BE SECURELY SEATED. FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY OR VEHICLE DAMAGE !!

Bill of Materials

1. OEM Quad-Tip rear valence

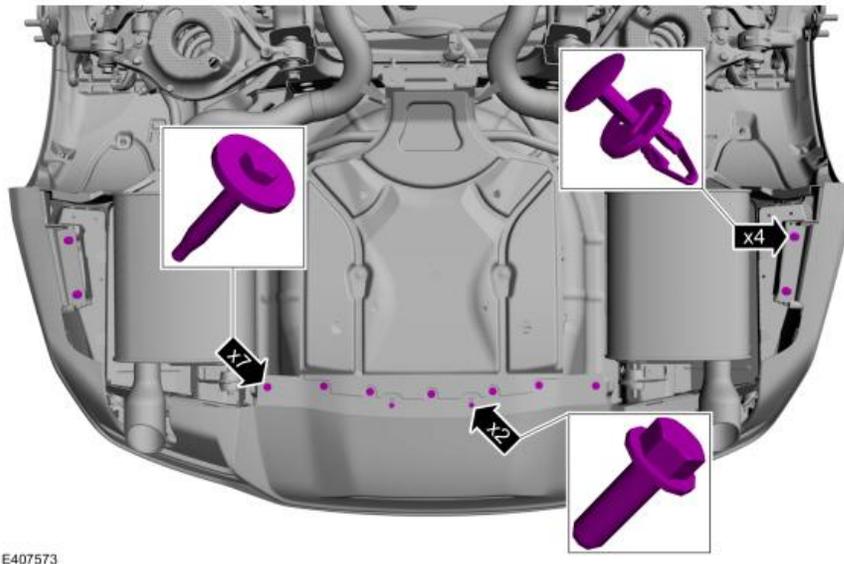


Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356

Removal - All Vehicles

NOTE: Removal steps in this procedure may contain installation details.

1. Remove the rear wheels and tires.
Refer to: Wheel and Tire (204-04A Wheels and Tires, Removal and Installation).
2. Remove the screws, the bolts and the push pins.
Torque: 18 lb.in (2 Nm)

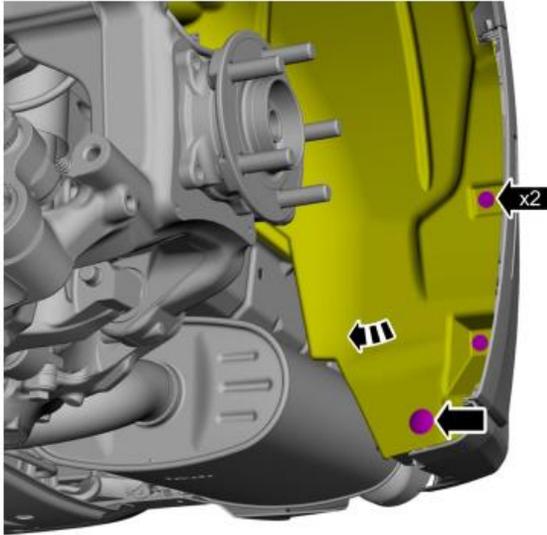


3. On both sides.
Remove the screw, the push pins and position the wheel liner aside.



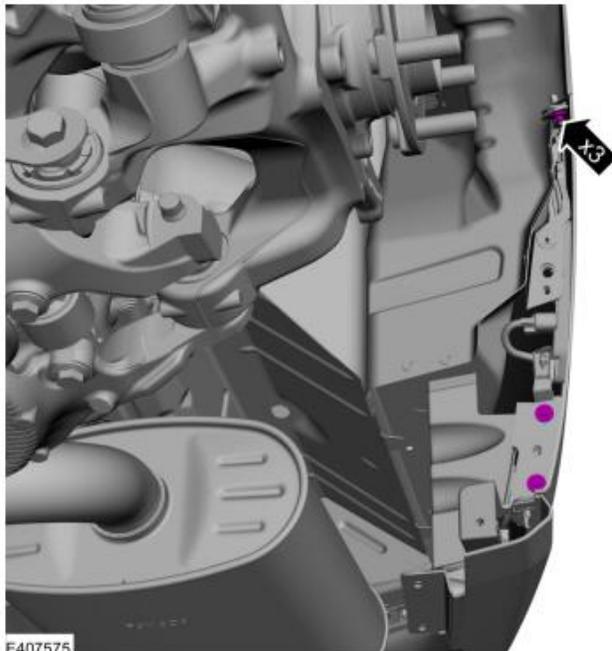
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4. On both sides.
Remove the bumper cover to bracket screws. Save for later
Torque: 17 lb.in (1.9 Nm)



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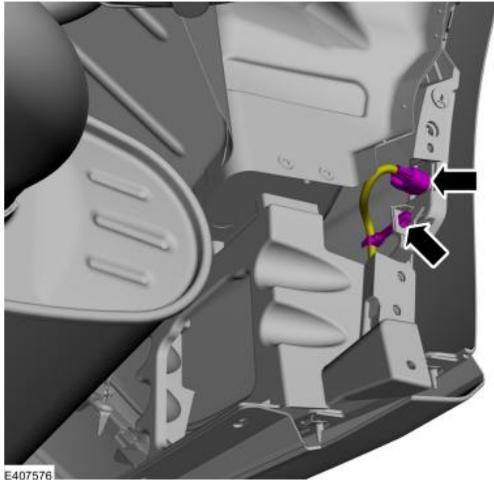
5. On both sides.
Disconnect the electrical connector and detach the wiring retainer.

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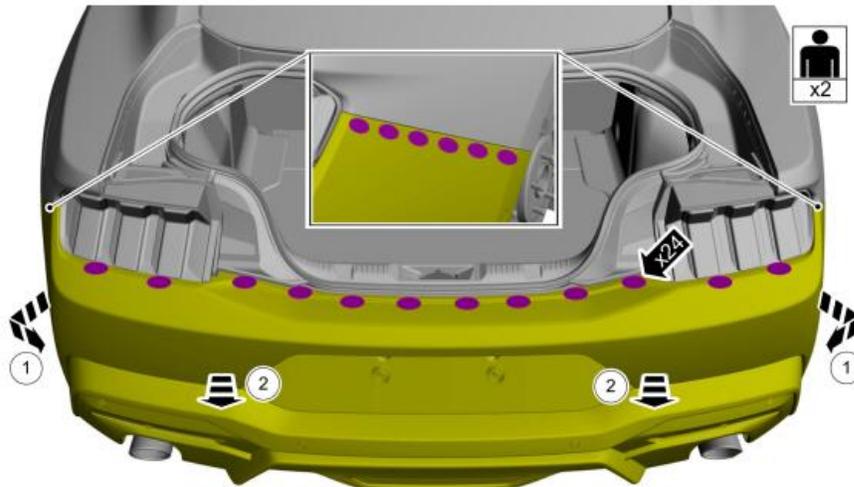
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6. **NOTE:** *This step requires the aid of another technician.*

Position the rear bumper cover aside for access to electrical connector.

1. Release the sides of the rear bumper cover from the side brackets.
2. Release the rear bumper cover from the rear brackets and position aside.



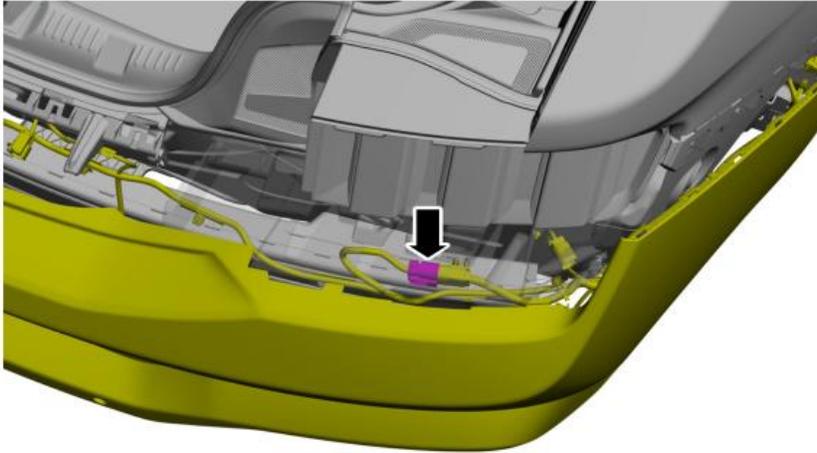
7. Disconnect the rear bumper wiring harness electrical connector.

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8. **NOTE:** *This step requires the aid of another technician.*

Remove the rear bumper cover.



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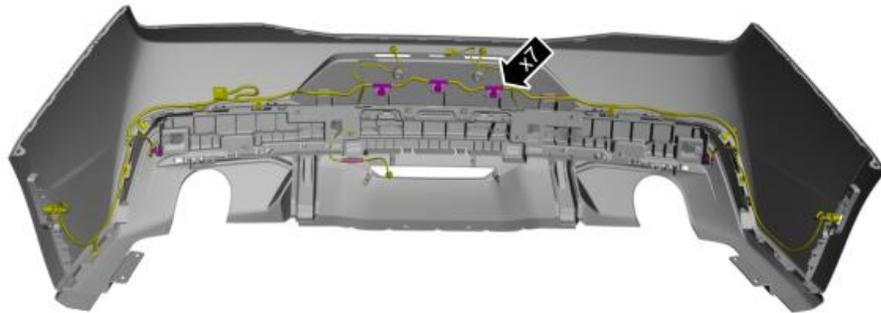
9. Detach the wiring harness guides and position the harness aside.

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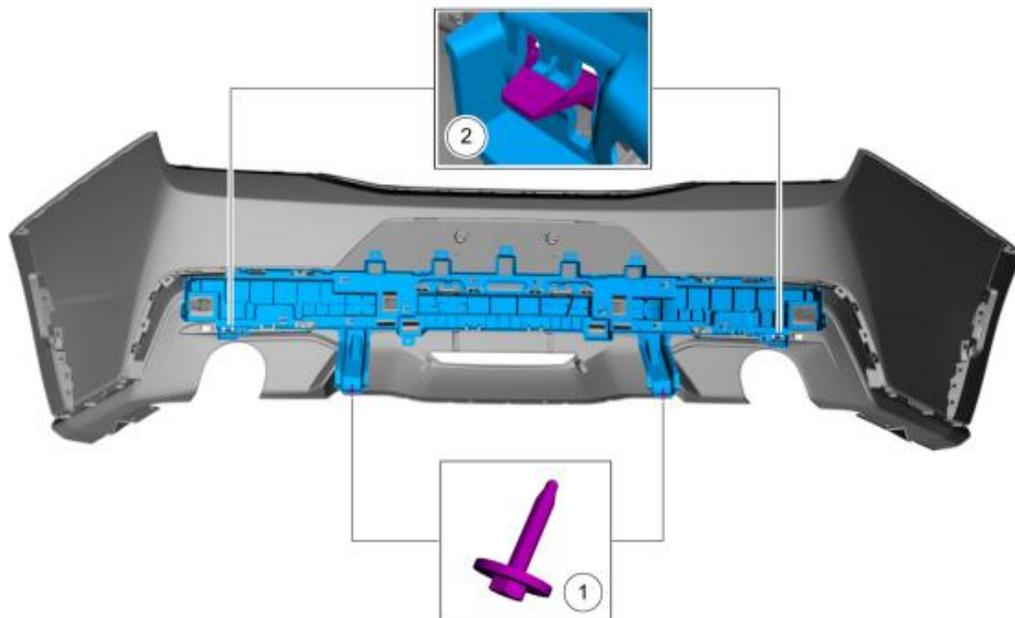
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10. Remove the screws and release the tabs and remove the rear bumper cover reinforcement.



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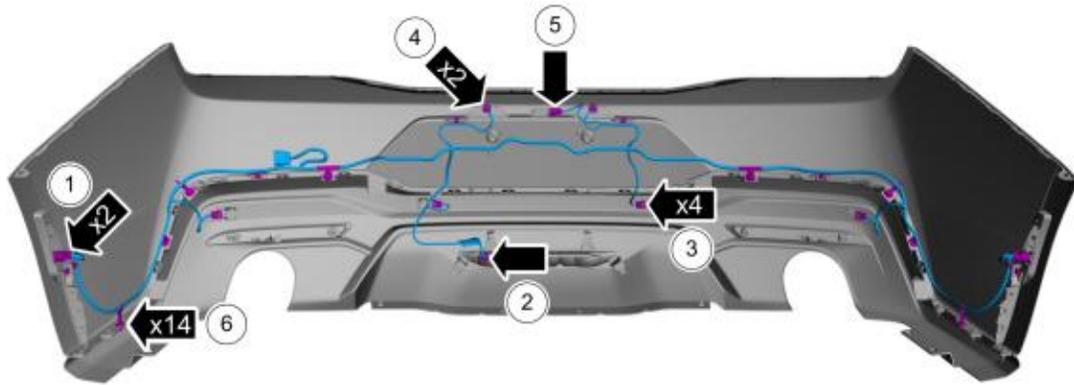
- 11.
1. Disconnect the supplemental rear marker lamp electrical connectors.
 2. Disconnect the supplemental reverse lamp electrical connector.
 3. Disconnect the rear parking aid electrical connectors.
 4. Disconnect the license plate lamp electrical connectors.
 5. Disconnect the decklid release switch electrical connector.
 6. Detach the wiring retainers and remove the rear bumper cover wiring harness

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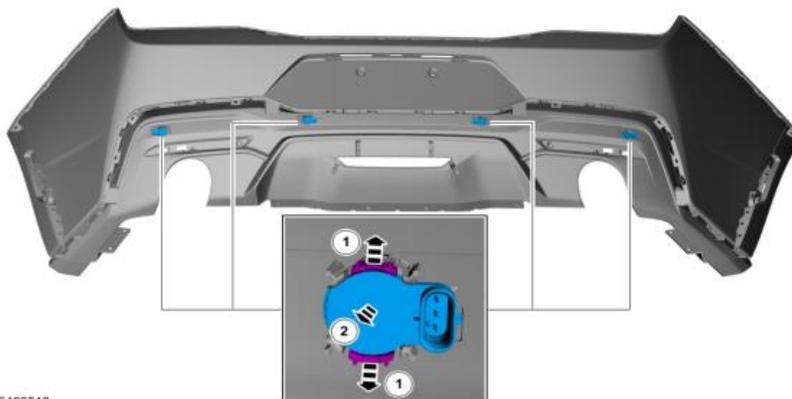
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Vehicles With: Rear Parking Aid

12. NOTE: Make sure that the isolator rings are installed correctly while installing the sensors.
1. Release the tabs.
 2. Remove the rear parking aid sensors from the brackets



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All vehicles

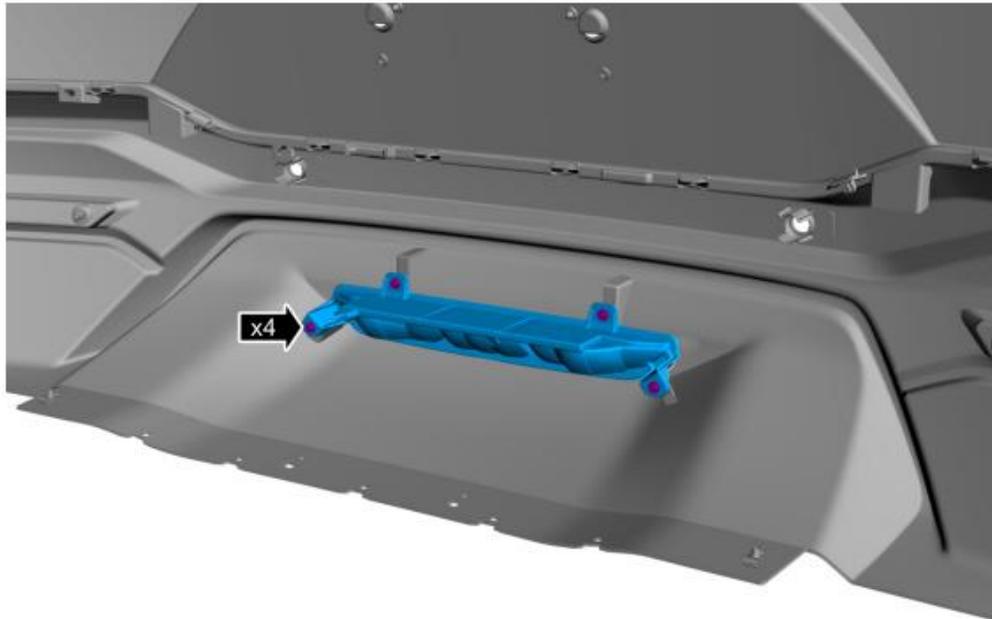
13. Remove the screws and the reversing lamp.
Torque: 18 lb.in (2 Nm)

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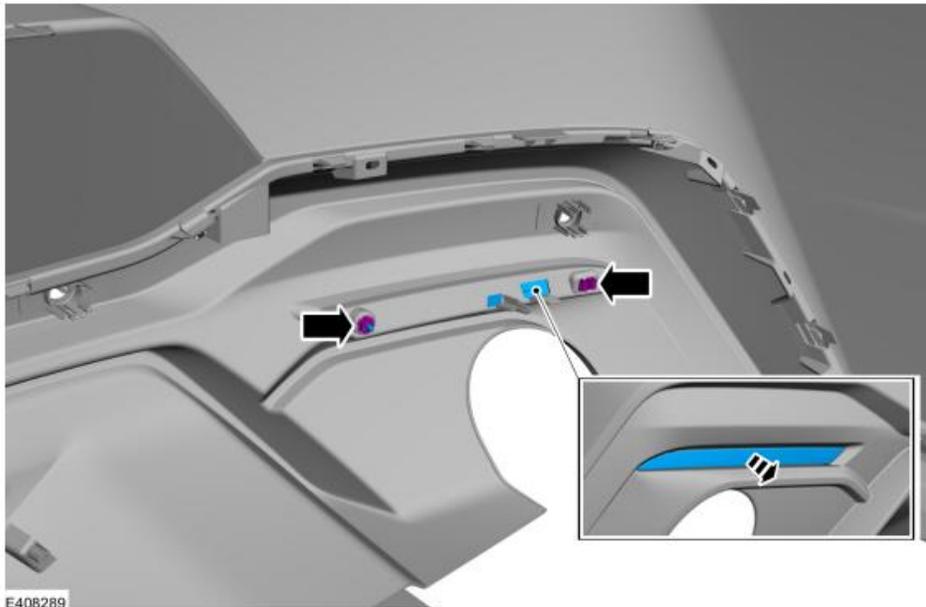
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14. On both sides.
1. Remove the speed nut.
 2. Torque: 13 lb.in (1.5 Nm)



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15. Remove the screws. Torque: 18 lb.in (2 Nm)
1. Remove the push pins.
 2. Release the tabs and remove the upper bumper cover.

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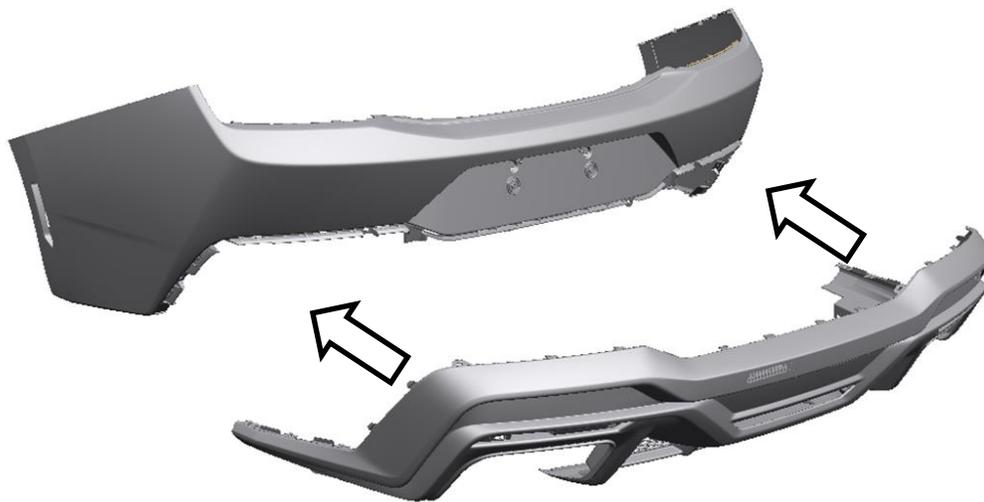
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16. install the provided valance by snapping together clips and reinstalling bolts from step 15
 1. **Do not reinstall rear bumper until Exhaust modification is complete and installed.**



Install Borla exhaust system (PAGE 10) and reinstall valance in reverse order.

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KIT INCLUDES:

<u>Description</u>	<u>Qty:</u>
Rear Muffler	2
Front muffler or X-pipe	1
Clamp	4
Left Hand Intermediate Pipe	1
Right Hand Intermediate Pipe	1

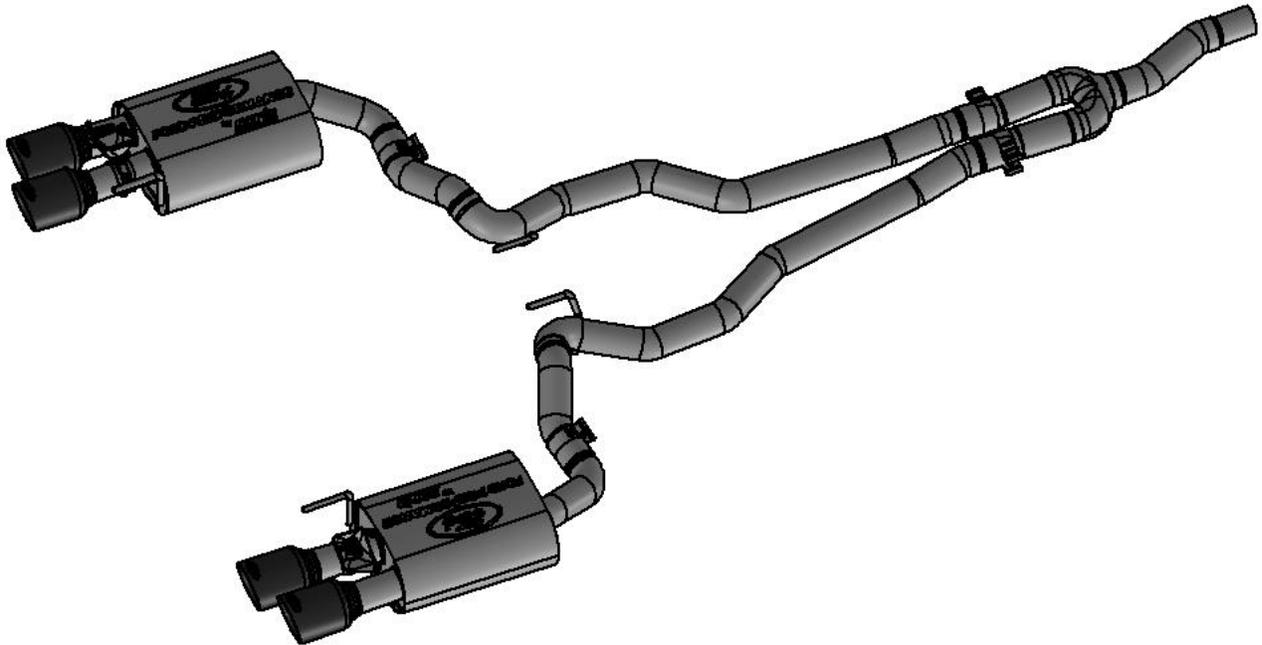
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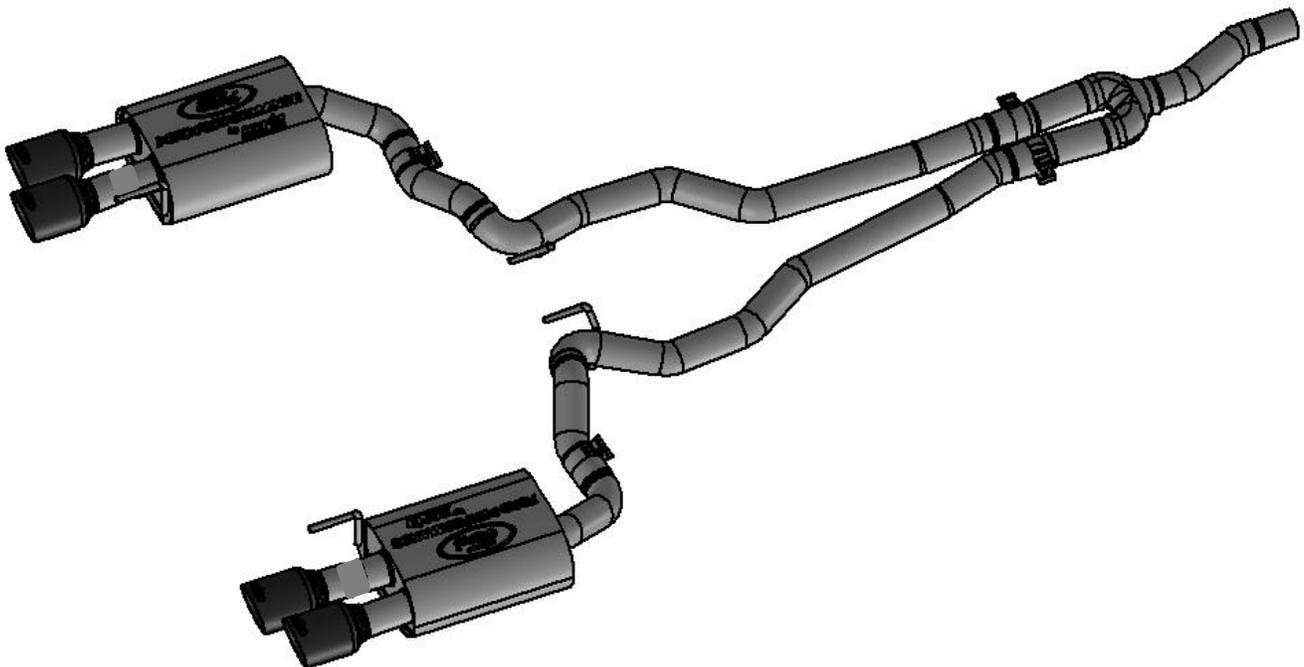
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Representative image for M-5200-M2EB_SB. M-5200-M2EC_SC are chrome tip versions.



Representative image for M-5200-M2EBV_SBV_TBV. M-5200-M2ECV_SCV_TCV are chrome tip versions.



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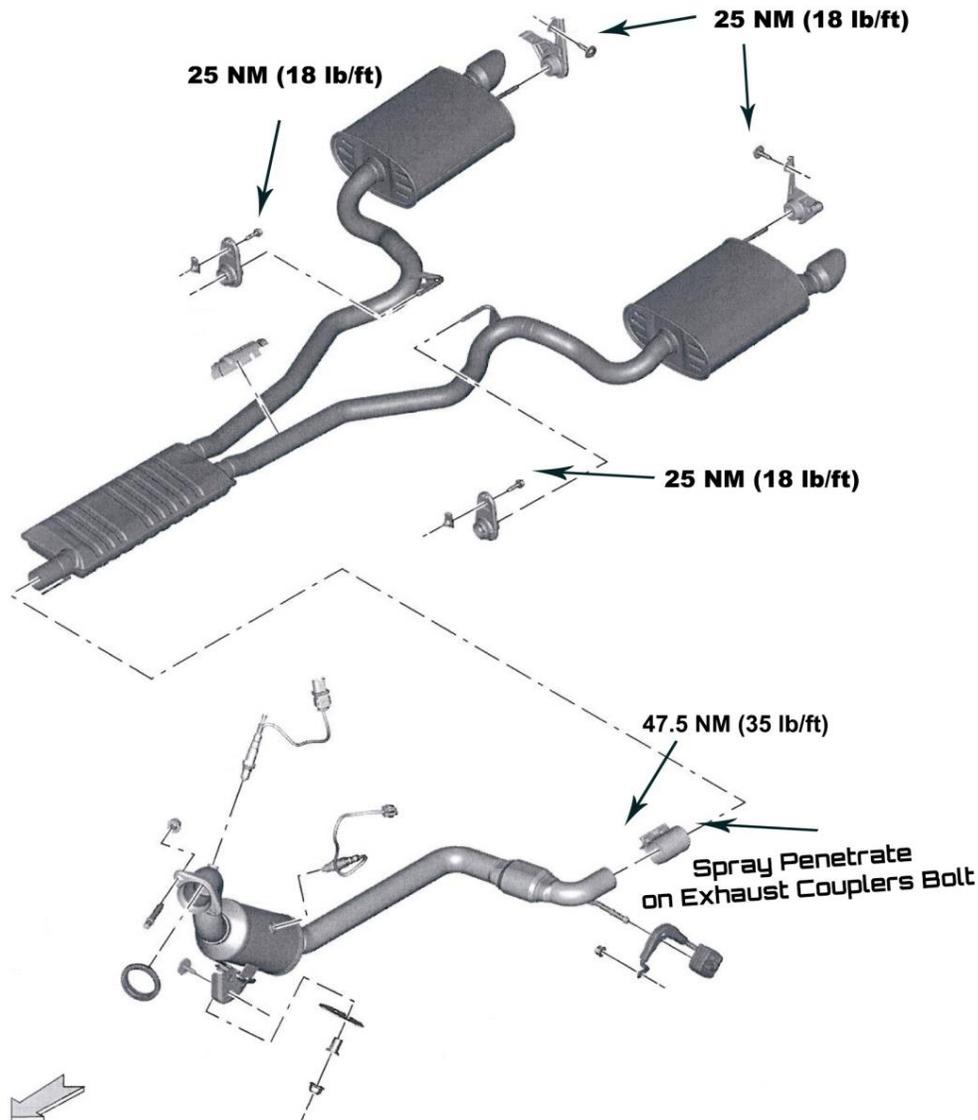
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REMOVAL INSTRUCTIONS:

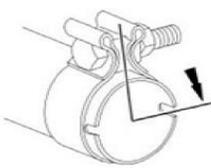
STEP 1: Raise and support vehicle.

STEP 2: Spray penetrate on exhaust coupler bolts. Loosen all Exhaust coupler bolts.



To tighten the exhaust clamp.

- The exhaust clamp should be installed to within a 1/16" of the edge of the expanded and notched pipe.
- The Bolt section should not be over either of the notches. Perpendicular to the notches is preferred.
- Tighten to 48 Nm (35 lb./Ft.)



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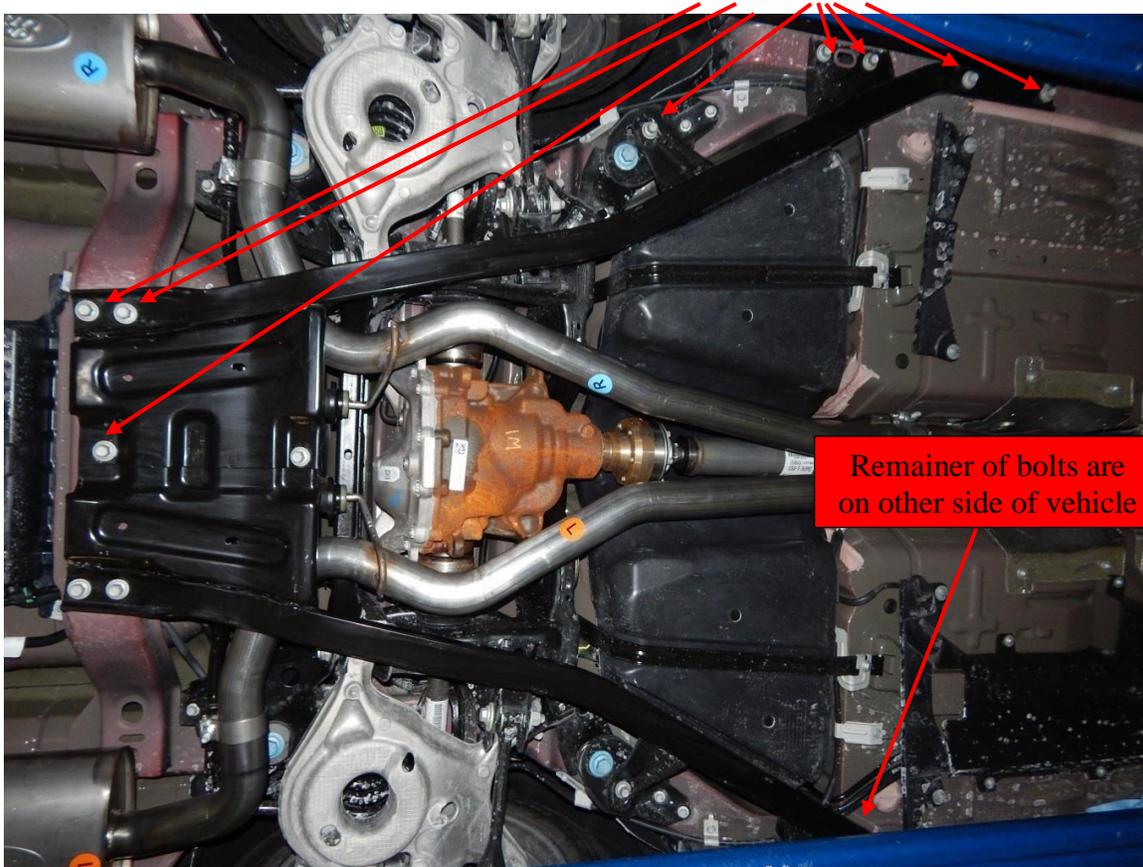
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If vehicle is a convertible, remove the extra bracing by removing 15 bolts using a 15mm socket.



STEP 3: If the system has valves, disconnect the valves at the rear mufflers (LH and RH). Pull the pin holding the connector in, slide it out of the valve actuator assy.



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STEP 4: Using a 15mm socket loosen nuts on the clamp at the front of the Factory system.



STEP 5: Using a 13mm socket to remove bolts from exhaust hangers in rear Sub frame near the rear axle, LH and RH sides.



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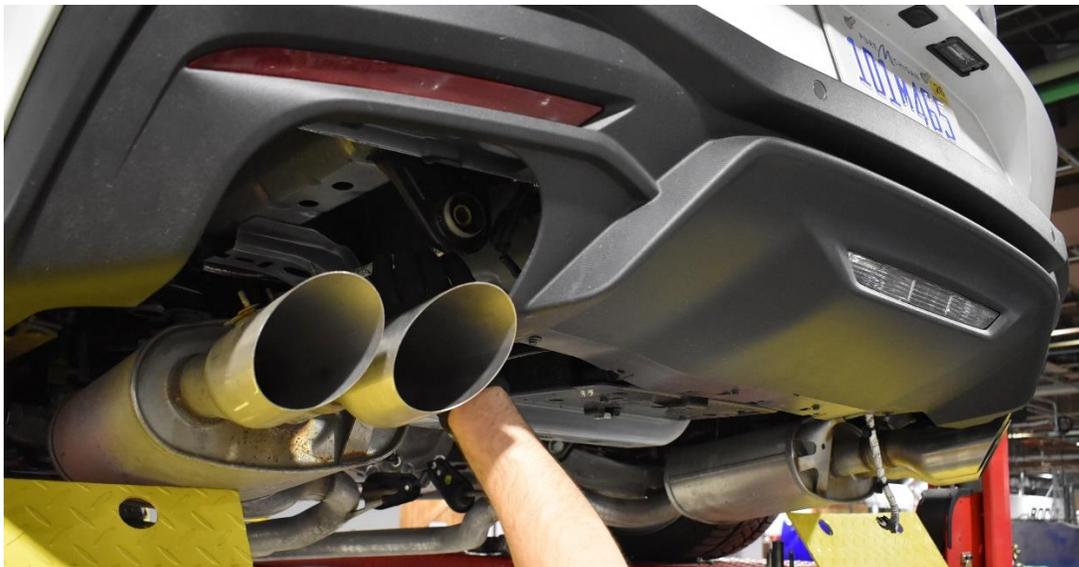
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STEP 6: After loosening exhaust clamps, slide clamps back on exhaust pipe releasing it from the down pipes. Remove clamp from exhaust and slide back onto the downpipe.



Step 7: Allowing exhaust to hang down, remove rear mufflers from hangers by moving the exhaust system towards front of vehicle.
Note: Have someone help with this step.



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INSTALLATION INSTRUCTIONS:

Step 1: Install y-pipe by placing in the clamp on the downpipe. Snug but do not Tighten.



Step 2: Install factory hangers (previously removed) onto under axle pipes.



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Step 3: Install supplied clamps onto the expanded inlet of under axle pipes, slide pipes/clamps onto y-pipe. Using a 13mm socket install bolts in exhaust hangers in rear sub frame.



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Step 4: Using a 13mm socket tighten bolts to 25 nm (18 lb-ft) in rear Sub frame exhaust hangers.



NOTE: For systems with valves, the actuator will have to be removed from the factory system by removing 3 nuts as shown and attached to the valve on the new exhaust. The Factory bracket also needs to be installed in the factory location.



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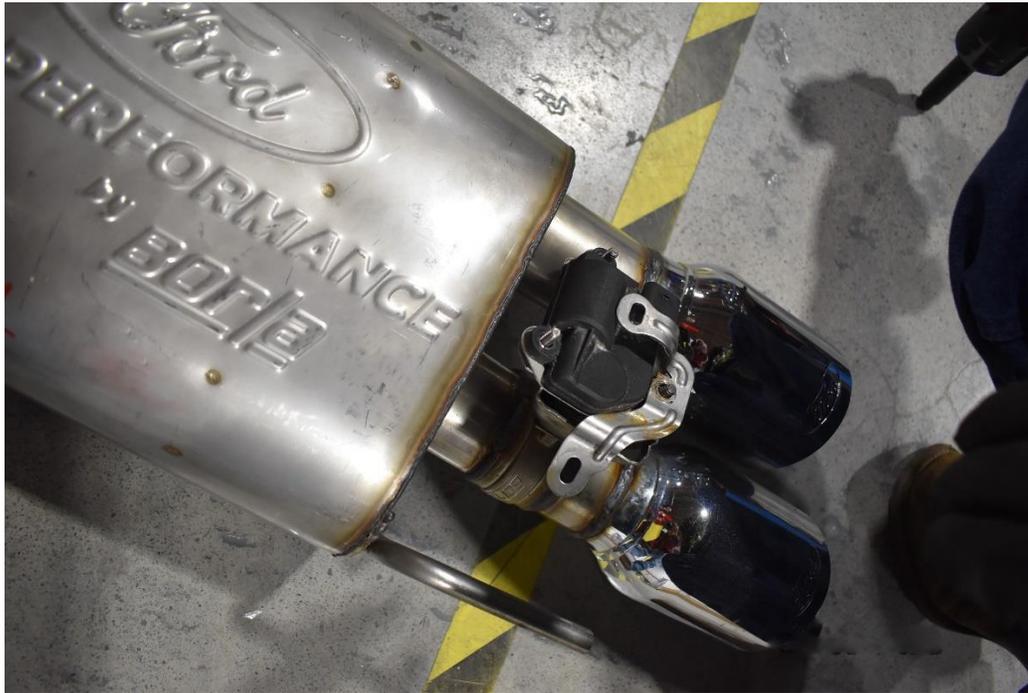


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Step 5: Install supplied clamps onto the new muffler inlets and slide muffler hangers into factory exhaust hangers. Next slide the mufflers over the under axle pipes, centering tips in rear bumper opening. Attach the wiring harness to the valves if applicable.



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Step 6: Check your exhaust system for proper clearance under the vehicle and also for tip alignment, tighten the clamps to 32-35 ft. lbs, checking tip alignment and clearances as you do. There should be a minimum gap of 25mm from the tips to the edge of the car, and the tips should be in 25mm from the outermost edge of the rear bumper.

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STEP 6: (cont'd) For the convertible, replace the brace and torque the fasteners to 47.5 nm (35 ft-lbs). Ref. picture on page 4. Check for clearance of the exhaust to the brace, differential housing, and body rail.



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STEP 7: Lower vehicle. Start vehicle and check for any leaks. If any leaks are found, determine cause (such as loose or incorrectly positioned clamp) and repair as necessary.

Congratulations!!! You have completed the installation of your new Ford Performance Parts Exhaust Kit.

Note: When you first start your vehicle after the installation of your new Ford Performance Parts Exhaust System, there may be some smoke and fumes coming from the system. This is a protective water 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 operating temperatures.

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