



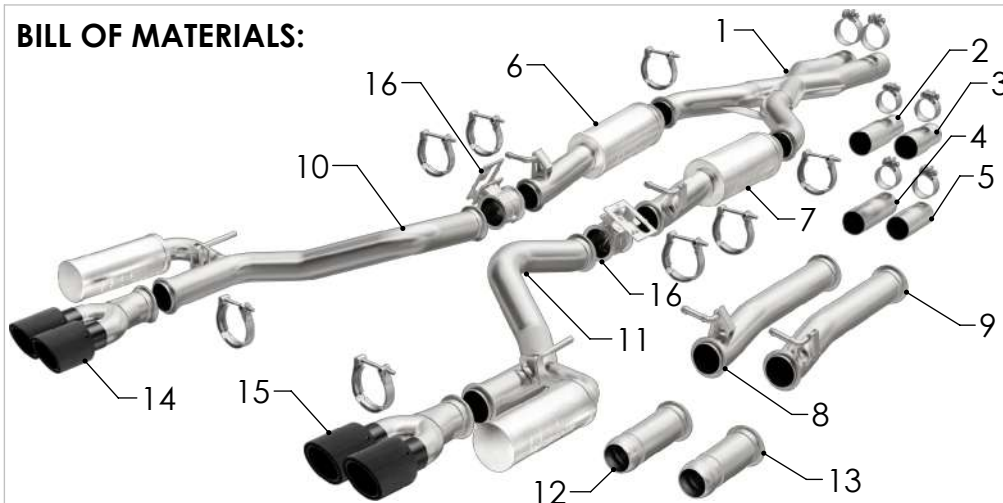
INSTALLATION INSTRUCTIONS



DODGE CHALLENGER HEMI

PART NO. 19536

BILL OF MATERIALS:



1. X-Pipe Assy
2. D/S 2.50 Inl Pipe
3. P/S 2.50 Inl Pipe
4. D/S 2.75 Inl Pipe
5. P/S 2.75 Inl Pipe
6. D/S Reso Sub Assy
7. P/S Reso Sub Assy
8. D/S Delete Pipe Assy
9. P/S Delete Pipe Assy
10. D/S Mid Pipe Assy
11. P/S Mid Pipe Assy
12. D/S Tail Pipe Assy OEM
13. P/S Tail Pipe Assy OEM
14. D/S Tip Assy
15. P/S Tip Assy
16. MF Valve Assy



**WEAR SAFETY
GLASSES**



**READ INSTRUCTIONS
THOROUGHLY BEFORE
INSTALLING PRODUCT**



SPRAY LUBRICANT

To ease removal of existing exhaust components (especially on older vehicles) spray penetrating lubricant on all fasteners and hangers/insulators that will be loosened or removed and let soak before disassembly.

HARDWARE KIT:

1. [10] 3.00" V-Clamp
2. [2] 3.00" Torca Clamp
3. [2] 2.75" Torca Clamp
4. [2] 2.50" Torca Clamp
5. [6] Bolt M5-0.8 x 20mm

MINIMUM REQUIRED TOOLS:



11mm, 13mm,
15 mm



Hanger Tool
(Or Pry Bar)

MAGNAFLOW RECOMMENDS PROFESSIONAL INSTALLATION ON ALL THEIR PRODUCTS



WARNING: When working on, under, or around any vehicle exercise caution. Please allow the vehicle's exhaust system to cool before removal, as exhaust system temperatures may cause severe burns. If working without a lift always consult vehicle manual for correct lifting specifications. Always wear safety glasses and ensure a safe work area. Serious injury or death could occur if safety measures are not followed.

ATTENTION: Always install any supplied band or U-bolt clamps to the proper torque specifications of 40-45 ft-lb for band clamps and 30-35 ft-lb for U-bolt clamps. Over tightening will result in the clamps breaking and will NOT be warranted by MagnaFlow.

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NOTICE. The Dodge Challenger can be purchased with an "Active Exhaust" system including exhaust valves (image above). This MagnaFlow kit can be used with "Active Exhaust" by using the provided MagnaFlow valves.

Skip Step 1 and Step 3 for vehicles not equipped with Active Exhaust

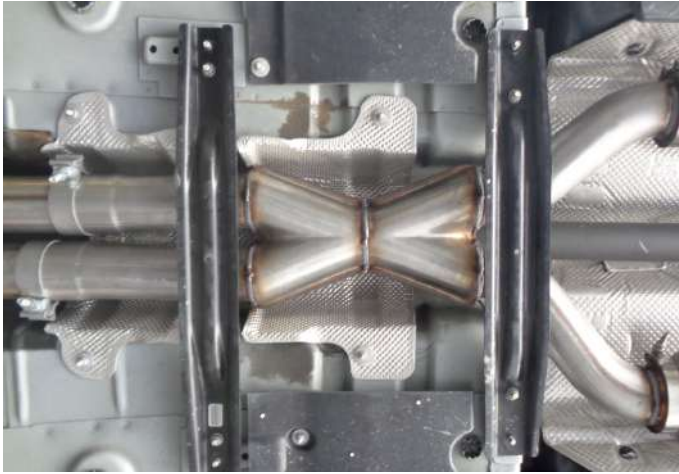


Step 1. To remove the OEM system first unplug the electrical connector at the exhaust valves.

Step 2. Begin by loosening the clamps at the exhaust inlet. Remove all four welded hangers from the rubber insulators and remove the exhaust. Do not damage the fasteners or rubber insulators as they will be used to install the new MagnaFlow system.

Step 3. Once the exhaust is off of the vehicle remove the valve motors from the muffler assembly and transfer it over to the new MagnaFlow exhaust valve assembly using the factory hardware.

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Step 4. *MagnaFlow xMOD exhausts are designed with multiple build options giving the ability to use different components depending on sound and performance preference.*

Begin installation of the MagnaFlow system by attaching the X-Pipe Assembly. Next, select the Extension Pipes. The 5.7L utilizes the 2.52" slips, and the 6.2L/6.4L utilize the 2.77" slips. Slide the supplied Torca clamps over the Extension Pipes and install them into the X-Pipe Assembly. (Leave all clamps and fasteners loose for final adjustment of the complete system.)



Step 5. *MagnaFlow xMOD exhausts are designed with multiple build options giving the ability to use different components depending on sound and performance preference.*

Determine the best configuration for your preference. Install either the Muffler Delete Pipes or the Muffler Sub Assemblies by sliding the hanger into the OE hanger bushing. After, loosely install the supplied V-Band clamps on to the rear of the X-Pipe Assembly.

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Step 6. Next install the driver and passenger side valve assemblies, with the OE motors already attached. Loosely install the V-Band clamp on the Muffler Assembly/Delete Pipe side.



Step 7. Next, remove the OEM hanger brackets (Driver & Passenger) attached to the vehicle near the tip. Move the brackets towards the front of the vehicle by approximately 12 inches, into the secondary set of holes. Resecure the hanger bracket to the vehicle's chassis.



Note: Hanger was moved to correct location

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Step 8. Next install the driver and passenger side Helmholtz Tail Pipe Assemblies. Start by sliding the hanger into the relocated hanger bracket and bushings, and then use a supplied V-Band clamp at the valve. Then loosely install the V-Band clamp on the tip side.



Step 9. Finally, select either the provided dual Carbon Fiber tips, or the factory tip and MagnaFlow extension pipe. Align the tip and tighten the clamps. Lastly, tighten all clamps in the entire kit from back to front.