

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	842583-490	MUFFLER ASSY	1
2	ST473	EXHAUST TIP, BRUSHED BODY/ BLACK END 3-1/2" × 2-1/4"	2
3	MC225BS	CLAMP, 2-1/4" STAINLESS	2
4	HS117	HEATSHIELD	1
5	HW257	SCREW, 1/4"-20 × 1"	4
6	HW528	CLAMP, CUSHIONED LOOP 1-1/4" D × 1/2" W	4
7	HW333	FLAT WASHER, 1/4"	4
8	HW332	LOCK WASHER, 1/4"	4
9	HW124	NUT, 1/4"-20	4
10	HW208	SCREW, HEX 3/8-16 × 1"	2
11	HA602	HANGER, MUFFLER	2
12	HW303	FLAT WASHER, 3/8"	2
13	HW309	LOCK WASHER, 3/8"	2
14	HW103	NUT, 3/8"-16	2
15	MC178BS	CLAMP, 1-7/8"	1

**NOTE: THIS EXHAUST SYSTEM IS INTENDED FOR COMPETITION (CLOSED-COURSE) USE ONLY! IT IS NOT LEGAL FOR USE ON PUBLIC ROADS OR TRAILS.**

## REVIEW THE INSTRUCTIONS AND VERIFY THE KIT CONTENTS:

1. Please take a moment to read and understand these instructions before installing your XDR exhaust kit.



2. Use the parts drawing and list (front page) to verify your kit's contents.

In the unlikely event that any parts are missing, please contact Flowmaster Technical Support for replacements.

## TOOLS REQUIRED

- Jack
- 2 jack stands
- Standard hand tools

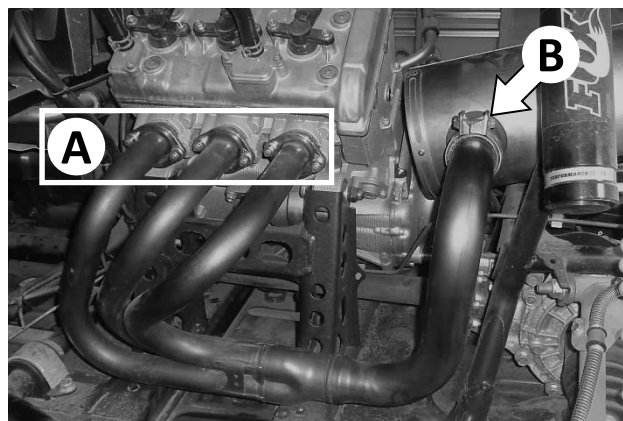
## MATERIALS REQUIRED

- Grease
- Medium-strength thread-locker (Permatex Blue or similar)
- Anti-seize compound (Permatex Nickel or similar)

## REMOVE THE FACTORY EXHAUST SYSTEM:

### WARNING

**Avoid serious burns! Allow the exhaust system to cool completely before removing the factory exhaust system.**



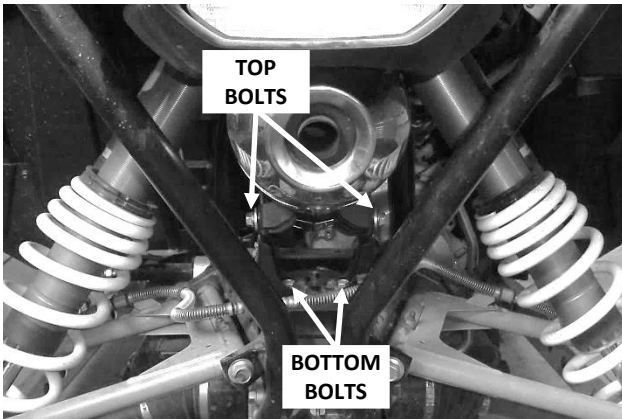
3. Remove the 6 exhaust pipe retainer nuts (A), and loosen the header-muffler clamp (B).



4. Remove the header from the vehicle, and remove the muffler clamp from the header.



5. Remove the 3 exhaust pipe gaskets. Inspect them for serviceability, replacing any that are damaged. Then reinstall the gaskets in the exhaust ports.



6. At the rear muffler bracket, remove the top bolts. Then remove the bottom bolts, and **retain them for use at Step 17.**



7. At the lower right corner of the muffler bracket, open the clamp and release the brake line.



8. Rock the top of the rear muffler bracket rearward and remove it from the vehicle.

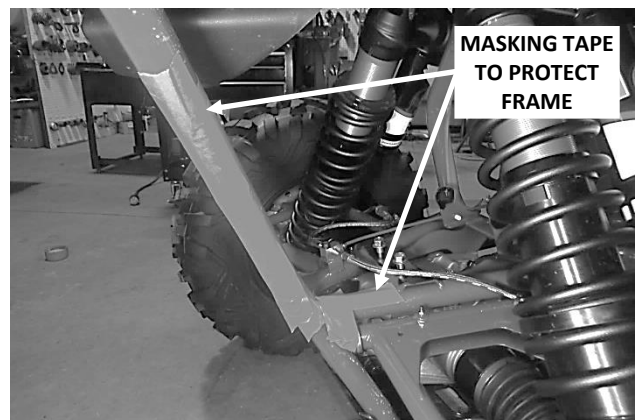


9. Remove the two bolts from the front muffler bracket.



10. Carefully rotate the muffler as required to clear the frame, and remove it from the vehicle.

## ASSEMBLE AND INSTALL YOUR XDR EXHAUST SYSTEM:



11. Apply masking tape to the 2 frame tubes behind the rear shocks, as shown, to protect them from scratching.



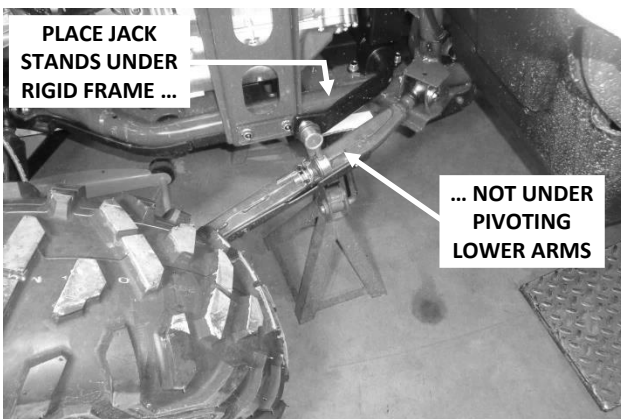
**NOTE:** On vehicles with dual-spring shocks, the rear end **MUST** be jacked up to obtain the necessary clearance to install the muffler. If your vehicle has single-spring shocks, you may be able to install the muffler without jacking up the rear end.



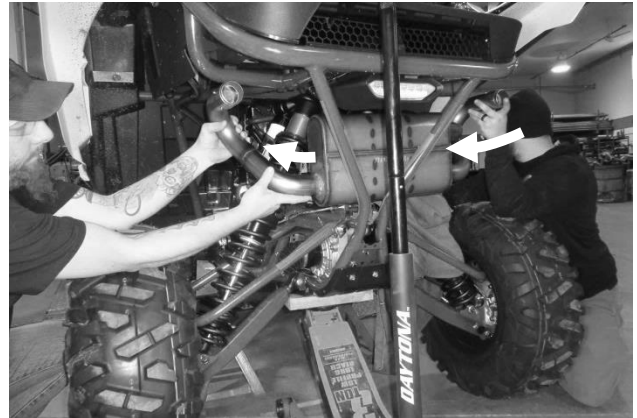
12. Jack up the rear of the vehicle until the tires are well clear of the ground.

**WARNING**

**Avoid serious injury or death by crushing!**  
Securely support the vehicle using rigid jack stands (see next step) before proceeding. **NEVER** work on a raised vehicle that is supported by jacks alone!



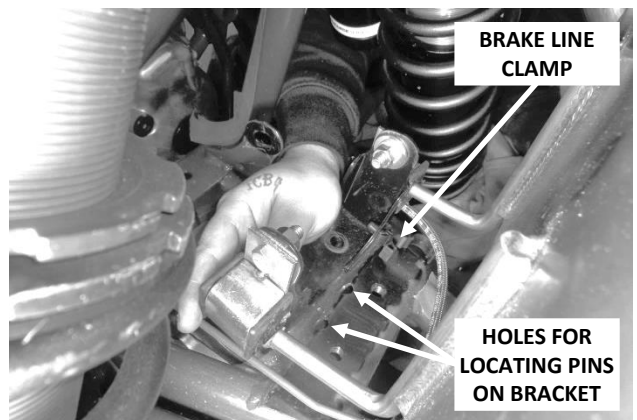
13. Place TWO jack stands (one on each side of the vehicle), under the RIGID FRAME of the vehicle (NOT under the pivoting lower arms). With the vehicle's full weight on the jack stands, the rear wheels must still off the ground.



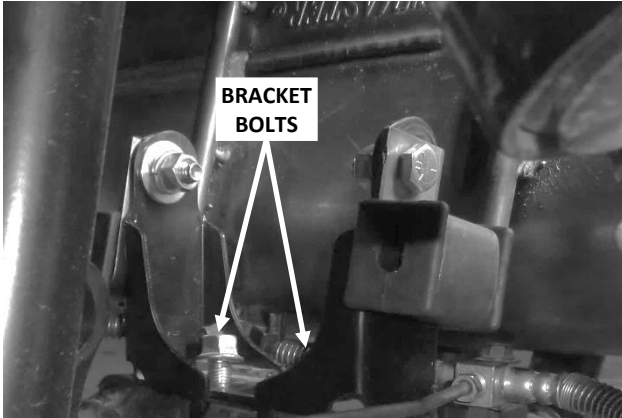
14. Grease the two hanger rods on the front of the muffler (1). Then carefully insert it, from the right side, into the space between the shocks and frame, and gently lay it in the frame.



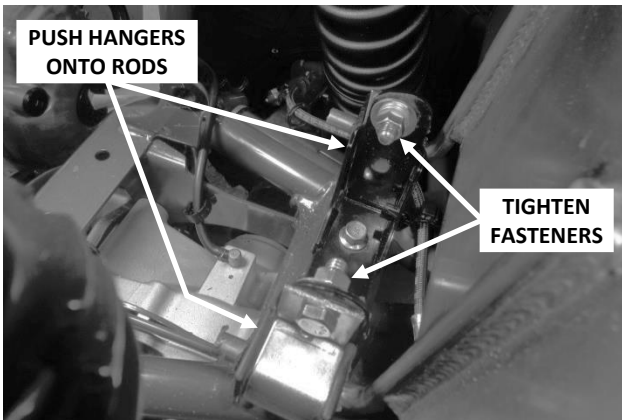
15. Assemble the hangers (11) to the muffler bracket using screws (10) on the hanger side, and flat washers (12), lock washers (13) and nuts (14) on the bracket side. **Leave the hardware loose at this time.**



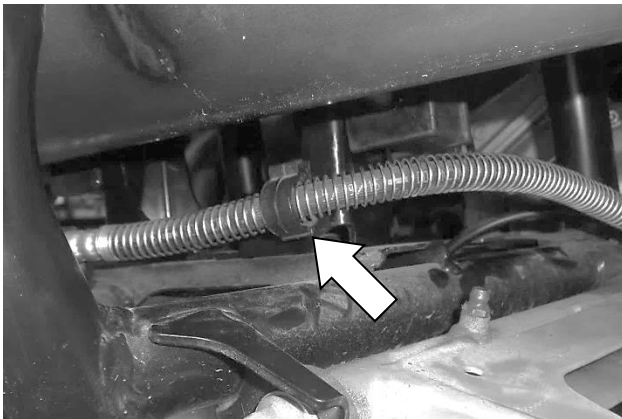
16. Push the assembled bracket and hangers onto the muffler's hanger rods. (Note that the brake line clamp is at the rear of the bracket, and the two locating pins are at the bottom front.)



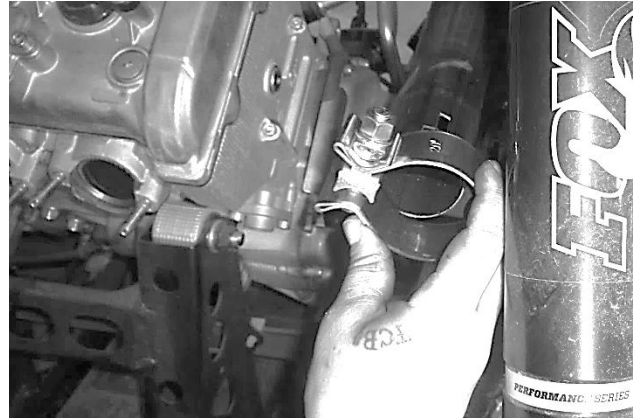
17. Apply medium-strength thread-locker to the stock bracket-to-frame bolts retained at **Step 6**, and install and tighten them.



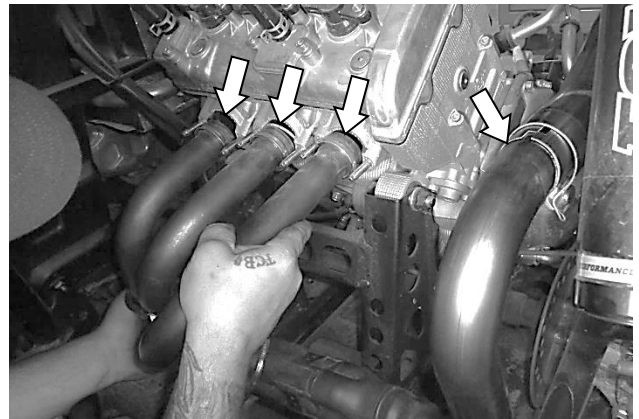
18. Push the hangers fully onto the rods, then tighten their fasteners.



19. Secure the brake line in the clamp.



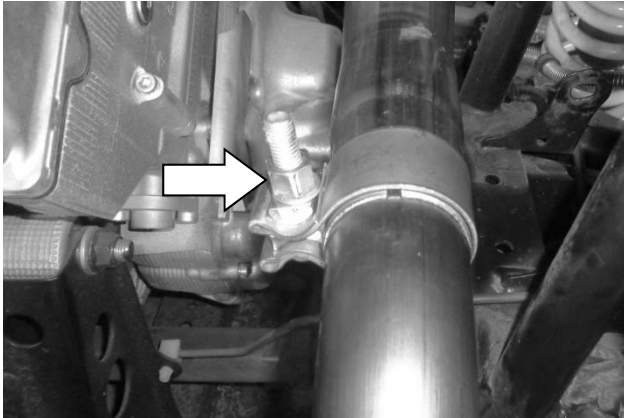
20. On the muffler clamp (15), remove the nut, apply anti-seize compound to the bolt, and loosely reinstall the nut. Then slip the clamp over the muffler intake pipe (bolt to rear, nut on top).



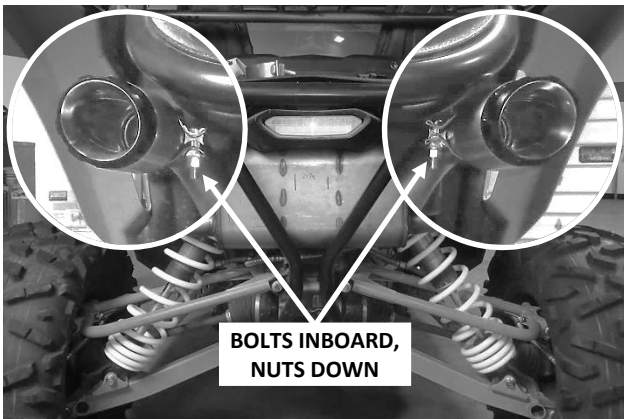
21. Apply anti-seize compound to the 6 exhaust port studs. Then install the header in the exhaust ports and muffler intake pipe.



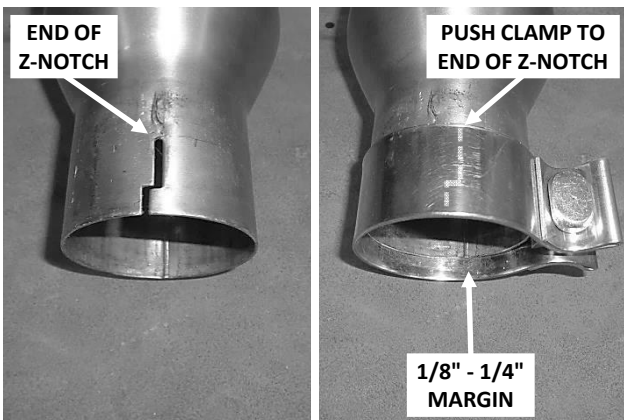
22. Install the 3 exhaust port retainers and the 6 nuts. Tighten the nuts evenly (alternating from pipe to pipe), to 14 ft-lbs.



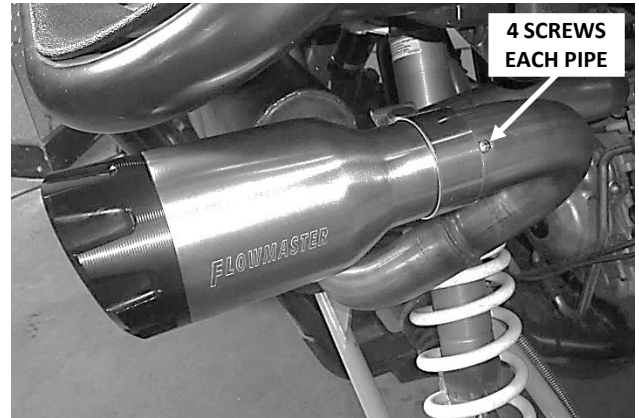
23. Tighten the muffler clamp nut to 14 ft-lbs.  
Remove the masking tape from the frame.



**NOTE:** The bolts on both tip clamps (3) will be oriented inboard, with the nuts pointed down.



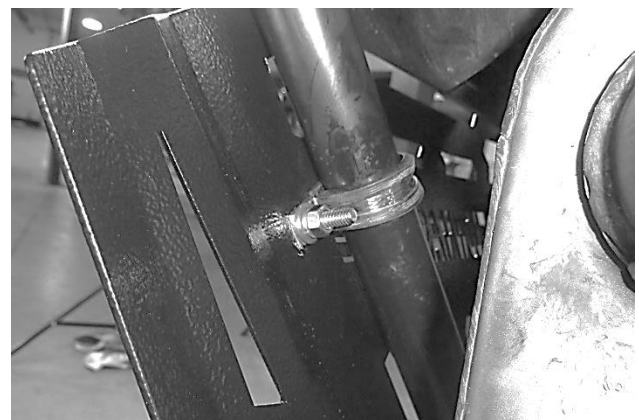
24. With the above note in mind, install a clamp on each exhaust tip (2). For best retention, push the clamp just to the end of the Z-notch, leaving 1/8" - 1/4" of the clamp extending past the tip opening.



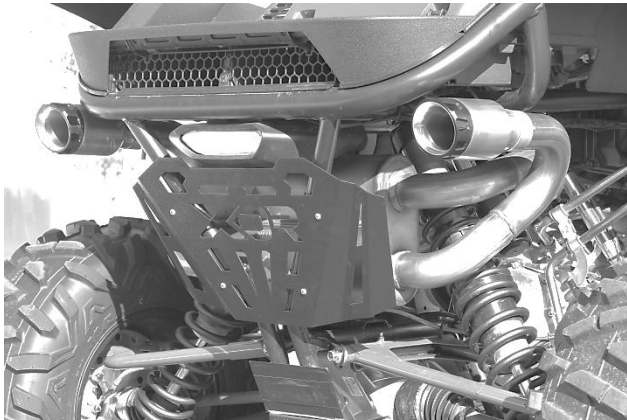
25. Push each tip onto its pipe until its clamp touches the 4 spark arrestor screws. Orient the clamp bolts inboard and the nuts down (per previous note). Also, keep the rear edge of the clamp just over the end of the Z-notch (per Step 24). When each tip is in place, tighten its clamp.



26. On each diagonal frame tube behind the muffler, install 2 loop clamps (6) as shown (bolt holes outboard, flat legs rearward).



27. Fasten the heat shield (4) to the clamps using screws (5) (on the heat shield side), and flat washers (7), lock washers (8) and nuts (9) (on the clamp side). Start all 4 nuts before tightening.



**Congratulations, the installation of your XDR  
exhaust kit is now complete!**

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**IMPORTANT: RETAIN THESE INSTRUCTIONS FOR  
FUTURE REFERENCE**







# SPARK ARRESTOR MAINTENANCE for FLOWMASTER / XDR ATV & UTV EXHAUST SYSTEMS

Flowmaster ATV and UTV exhaust systems are equipped with US Forest Service-qualified spark arrestors, which are designed to prevent the discharge of sparks from the exhaust pipes.

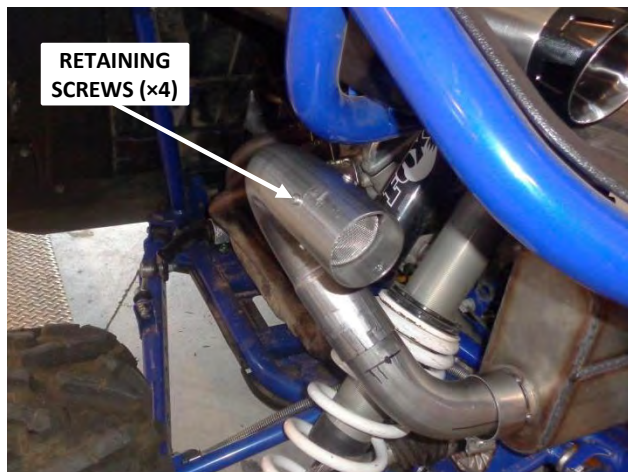
Spark arrestors must be inspected and cleaned periodically to prevent clogging and deterioration, which can adversely affect the performance of both the spark arrestor and the engine.

## WARNING

**Avoid serious burns! Allow the exhaust system to cool completely before inspecting the spark arrestors.**



1. Loosen the exhaust pipe tip clamp and remove the tip.



2. Remove the four retaining screws and washers.



3. Remove the spark arrestor screen.
4. Soak the screen in carburetor cleaner or oven cleaner to loosen carbon buildup.
5. Clean the screen using a wire brush.
6. Inspect the screen for wear or damage.

## WARNING

**Replace any spark arrestor whose screen is worn or damaged. Call Flowmaster for replacement parts.**

7. Reinstall the spark arrestor screen and exhaust pipe tip. (Installation is the reverse of removal.)

## NOTE

**Do not operate the vehicle unless serviceable spark arrestors are installed.**