

2018-2025 Roush Mustang 5.0L GT Axle-Back Exhaust Kit

Installation Instructions

P/N: 422097 (1318-52310RR)



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P/N: 422097 (1318-5231ORR)



Application: 2018-2025 Mustang 5.0L

Important Note: IF VEHICLE IS EQUIPPED WITH FACTORY FORD ACTIVE EXHAUST, INSTALLATION OF THIS KIT REMOVES THAT FEATURE FROM THE VEHICLE, THE ACTIVE EXHAUST MODES WILL NOT FUNCTION

Before installing your ROUSH Extreme Exhaust, please read through the entire installation procedure and check to make sure all items are present. Contact ROUSH Customer Service at 1-800-59-ROUSH, 9:00 AM to 5:00 PM weekdays, for any questions regarding fit or instructions that are unclear to you.

NOTE: All illustrations in this manual are representative of the 2018+ Roush Performance Products Extreme Exhaust System.

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PACKING LIST FOR EXHAUST KIT

Description	Part Number	Quantity
Exhaust Kit – 5.0L - 422097	1318-5231ORR	
Muffler Assembly - LH	1315-5232ORR	1
Muffler Assembly - RH	1315-5230ORR	1
Exhaust Tips LH (Y-Tip)	1318-5255LH	1
Exhaust Tips RH (Y-Tip)	1318-5255RH	1
Clamp - Muffler to Tip	10-0338	2
Clamp - Muffler to Mid-pipe	94-0053	2
Online Installation Instructions	1315-P1INST	1

EQUIPMENT AND SUPPLIES REQUIRED

- 3/8" Drive Ratchet
- 3/8" Drive Extension 3"
- 15 mm Socket
- Spray Lubricant (Soapy Water/Glass Cleaner)
- Reciprocating Saw ("Sawzall")
- Marker

If you are missing any items, please call us toll free at 1-800-59-ROUSH.

LIMIT OF LIABILITY STATEMENT

The information contained in this publication was accurate and in effect at the time the publication was approved for printing and is subject to change without notice or liability. ROUSH Performance Products (RPP) reserves the right to revise the information presented herein or to discontinue the production of parts described at any time.

SAFETY PRECAUTIONS



CAREFULLY READ THE IMPORTANT SAFETY PRECAUTIONS and WARNINGS BEFORE PROCEEDING WITH THE INSTALLATION!

Appropriate disassembly, assembly methods and procedures are essential to ensure the personal safety of the individual performing the kit installation. Improper installation due to the failure to correctly follow these instructions could cause personal injury or death. Read each step of the installation manual carefully before starting the installation.

- Always wear safety glasses for eye protection.
- Place ignition switch in the OFF position.
- Always apply the parking brake when working on a vehicle.
- Block the front and rear tire surface to prevent unexpected vehicle movement.
- If working with a lift, always consult vehicle manual for correct lifting specifications.
- Operate the engine only in well-ventilated areas to avoid exposure to carbon monoxide.
- Do not smoke or use flammable items near or around the fuel system.
- Use chemicals and cleaners in well-ventilated areas.
- Batteries produce explosive gases, which can cause personal injury. Therefore, do not allow flames, sparks or flammable substances to come near the battery.
- Keeps hands and any other objects away from the radiator fan blades.
- Keep yourself and your clothing away from moving parts when the engine is running.
- Do not wear loose clothing or jewelry that can get caught in rotating parts or scratch surface finishes.
- Allow the engine, cooling system, brakes and exhaust to cool before working on a vehicle.

WORK SAFELY!

Perform this installation on a good clean level surface for maximum safety and with the engine turned off.

ORIGINAL EXHAUST SYSTEM REMOVAL

1. On both left and right sides, mark the exhaust pipe on the *upstream* side of the first bend – where the curve of the pipe becomes tangent with the rest of the upstream portion.
NOTE: This lines up with the outside of the outer sway bar bushing.



NOTE: The disassembly process is identical for the left and right sides of the OEM exhaust. This concludes the disassembly process for the OEM axle-back exhaust.

⚠ WARNING

Use extreme caution during installation. Torque all fasteners according to manufacturer's torque values and tightening sequence. **DO NOT** use air impact tools to tighten fasteners on **ROUSH Performance Products Exhaust Systems**. Use of such tools may result in bent flanges or gasket contact areas leading to exhaust leaks which may result in serious personal injury or death.

2. Cut the LH and RH exhaust pipes at the locations marked in step 1 using a reciprocating saw with a metal blade.



RPP EXHAUST SYSTEM INSTALLATION

3. With the exhaust pipe cut, slide the hanger out of the rubber mount and remove the muffler/tip assembly from the vehicle.



3. Insert the ROUSH muffler hanger into the mount at the rear of the vehicle, and then slide the new pipe over the existing pipe.



4. Slide the band clamp (94-0053/94-0052) over the joint in step 3 and torque the 15 mm bolt to 30 Nm.



5. Place the band clamp (10-0338) over the exhaust tip and slide the tip over the muffler. Once the tip is in position, torque the band clamp to 30 Nm (V8 shown).



6. Check the exhaust system for correct clearance under the vehicle and also for tip alignment as shown below. If alignment is off, loosen the required band clamp, adjust, and re-torque the band clamp.



7. Once the desired position and alignment have been achieved, make sure all band clamps are torqued to 30 Nm.



8. Before starting the vehicle, make sure to check all wires, hoses, brake lines, body parts, tires and any other components for safe clearance from the exhaust system.
9. Start the vehicle and check for any leaks. If any leaks are found, determine the cause (such as loose or incorrectly positioned clamp) and repair as necessary.

Congratulations!!! You have completed the installation of the ROUSH Performance Products, Ford Mustang Exhaust Kit. It is recommended that you save all parts removed from the vehicle during the installation of this kit.

