



X3 Race Bypass Pipe

SKU(s): 300DC0011

INCLUDED PARTS

(1) EVP Race Bypass

REQUIRED TOOLS

T-30 Torx

Spring Puller

Torque Wrench

INSTALLATION STEPS:

Step 1: Remove the rear valance from your X3. The panel is mounted with (5) T-30 Torx bolts. (3) along the top and (2) on the bottom.

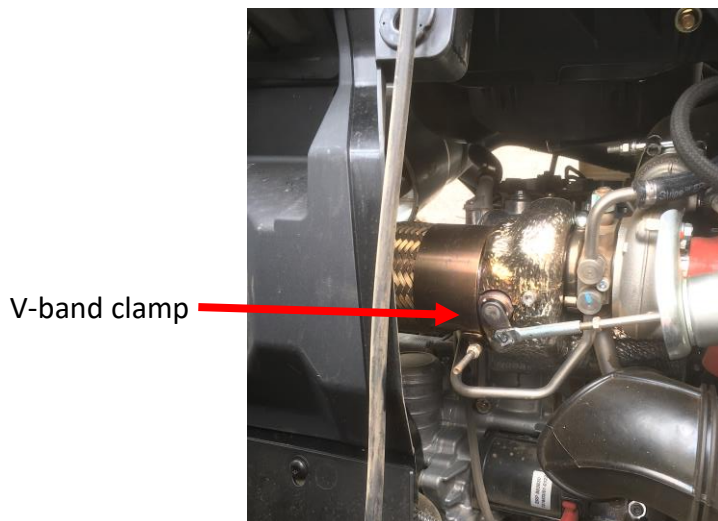
Step 2: Remove the four muffler springs (left image), using a spring puller. (Recommended) Remove the muffler by taking out the (4) mounting bolts (right images).



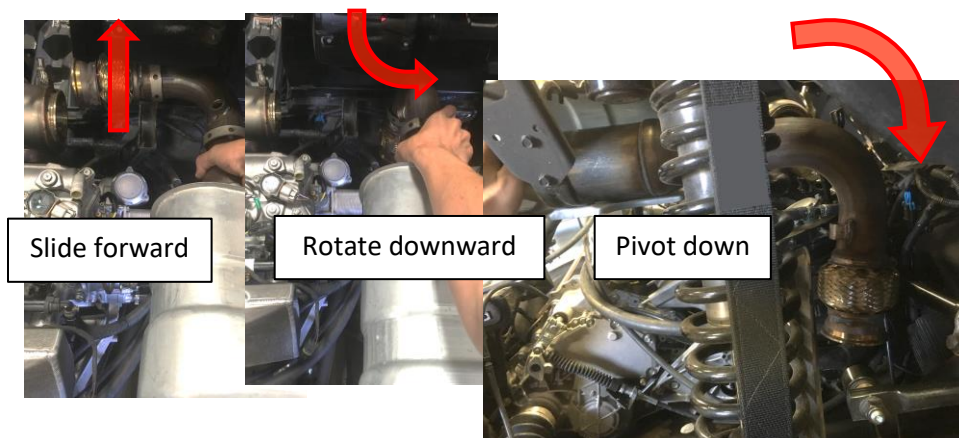
Step 3: Take the O2 sensor out of the exhaust. Treat the tip of the sensor gently.

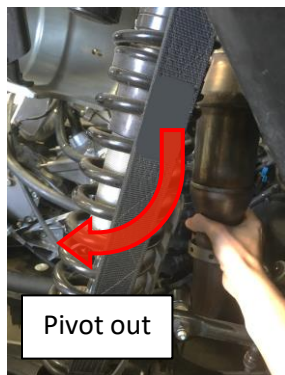
Step 4: Remove the two heat shield panels and clamps from the exhaust. These will be reinstalled later.

Step 5: Loosen the v-band clamp connecting the exhaust to the turbo. This clamp can be accessed through the access panel in the cabin of the car.



Step 6: To remove the turbo exhaust, slide it toward the front of the car, over the mount. Next, swing the turbo side down until it is vertical. Finally, pivot the entire converter out of the shielding and remove from the vehicle. Follow the images below. **NOTE:** These images were taken without the rear cargo rack for better visual instruction, the rack can be left on when removing the converter. Motions are indicated with thick red arrows.





Step 7: Insert the Race Bypass (by following the removal steps in reverse) and loosely secure the v-band clamp, attaching the bypass to the turbo with the exhaust gasket in place. Applying anti-seize lubricant to the clamp nut is also recommended.

Step 8: Apply the heat shield panels and loosely secure with the original clamps. Install the O2 sensor on the Race Bypass with anti-seize lubricant applied to the threads. **DO NOT** apply anti-seize to the tip of the sensor!

Step 9: Reinstall the muffler and loosely mount it using the four mounting bolts. Secure the muffler to the EVP Race Bypass with the four muffler springs.

Step 10: With the springs installed and all other mounts loosely in place, tighten the v-band clamp to 8 ft lb (97 in lb). Next tighten the heat shield clamps. Finally, tighten the muffler mounting hardware.

Step 11: Attach the rear valance with the (5) T30 Torx bolts. Installation of the Race Bypass is complete.

Thank you for choosing Evolution Powersports products. If you require further assistance, please call our Tech Support @ (715) 247-3862

Note: This product is exempt from the emission standards and related requirements of 40 C.F.R. § 1051 as provided by 40 C.F.R. § 1051.620, and California law [e.g., vehicle code §§ 27156 and 38391]. This product is sold only for use in connection with EPA certified, purpose-built, nonroad vehicles used solely for closed course, nonroad competition/racing and not used for any recreational purpose or on public highways or right of ways maintained by and open to the public. This product is sold only in connection with machines that do not fall under state and/or federal noise or emission standards/regulations. Purchasers who/that purchase this product represent and warrant that the product is purchased only in connection with EPA -certified, emission-regulations-exempt and noise-regulations-exempt competition/racing vehicles as interpreted under applicable state and/or federal law. Questions: Call Evolution Powersports at (715) 247-3862.