



## Installation Instruction Sheet

Part # 09-24603  
EVO R Series Full System



### Parts Included

- 1 - Muffler
- 1 - Mid pipe
- 1 - Head Pipe
- 1 - Exhaust Clamp
- 1 - Spark Arrestor & Spacer Ring
- 4 - Exhaust Springs
- 1 - Collar
- 1 - Flange

### Removal of Stock Exhaust

1. Loosen the clamp between the head pipe and muffler.
2. Remove the 2 bolts holding the muffler to the sub frame. Now remove the muffler & retain hardware for installation of your new system.
3. Remove the head pipe. Retain the flange nuts for installation of your new system.

### Installation of Big Gun Exhaust

1. Install the new flange and collar using the stock hardware.
2. Slide the new head pipe onto the collar using the 2 springs provided.
3. Slide the muffler clamp provided over the new mid pipe, then slide the mid pipe onto the new head pipe. (Do not tighten clamp at this time.)
4. Slide the new muffler onto the mid pipe and install the springs provided. (If not already installed.)
5. Adjust the mid pipe and head pipe so there is plenty of clearance.
6. Tighten the mid pipe clamp. Tighten all bolts and nuts starting with the head pipe and working your way back.





## Installation Tips

### ► USE LOCTITE

Always use LOCTITE (red recommended) when installing screws on your exhaust tip and base plate. Whenever you install a Spark Arrestor, Vortex Insert, new packing, etc., apply Loctite to all screws that were removed.

### ► TWIST

When installing your exhaust, keep in mind that the mid pipe coming out of the muffler is **NOT welded in place and is able to be twisted and taken completely out**. This allows for easier adjustment. If needed, remove the spring(s) to adjust the mid pipe, which generally makes it easier to adjust on your vehicle.

### ► CHECK GASKET

Many slip on models require the use of a stock (OEM) gasket where the mid pipe and head pipe meets. Often times this gasket comes off and is **stuck inside the stock pipe that is removed**. IF your exhaust system requires the use of the stock gasket, **GENTLY** try to remove this gasket to re-use. If it is not salvageable, then you should purchase a new OEM gasket to make a proper seal.

### ► LOOSEN

It is generally recommended that you **loosen all bolts, head pipe included**, when installing a new exhaust system (slip on or full system) and tighten only when everything is lined up correctly.

### ► TUNE

Since you now have a performance exhaust, the tuning of your fuel system is required. If you have a carbureted model, proper jetting is required. If you have a fuel injected system, the use of a fuel controller or programmer is required.

### ► WARRANTY

Refer to the Big Gun Exhaust Warranty Policy for proper maintenance information and guidelines on how to stay in accordance with the warranty. The complete Warranty Policy can be found on our website at [www.biggunexhaust.com](http://www.biggunexhaust.com).

**Limited Warranty:** Your Big Gun Exhaust system is warranted against manufacturing defects for material and workmanship for one (1) year from date of purchase from Big Gun Exhaust or from any authorized Big Gun Exhaust dealer, distributor, or exporter. During the warranty period [one (1) year], the warranty is limited to the repair or replacement of defective products. The warranty shall be void if the exhaust has been mounted on a vehicle and run, or it is determined that any alleged defect is the result of misuse, neglect, abuse, or modification of the product. There is no warranty for normal wear and tear of products, or for any damage that may have come about from a crash, or from improper maintenance of the muffler and/or packing. There is no warranty on exhaust with regard to any form of discoloration or bluing which are caused by tuning characteristics (i.e. cam timing, carburetor jetting, over heating due to lack of packing and incorrect fuel/air mixture) and is not caused by a defect in manufacturing.

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