Read through the entire manual before proceeding with installation.

Any procedures presented in this guide are suggestions only, and it is the responsibility of the owner/operator to ensure that the installation is done only by trained, qualified individuals, and performed according to all applicable codes including, but not limited to, local codes for your municipality, city, county and state; this includes all electrical and mechanical work. All workers must be trained in the proper safety procedures and appropriate PPE and attire must be worn at all times.

NOTE: Only kits installed at the factory are covered under warranty.

PRE-INSTALLATION

- Prior to unpacking, check all components for shipping damage.
- Keep the shipping container to protect the unit until installation is complete.
- Verify the correct parts are received by comparing the nameplate with the packing list.
- Locate nameplate and note direction (if applicable).
- Verify that the recommended gaskets are of proper size for the mating surface openings and ensure that all mating surfaces are clean and free of foreign material before installation.
- When cleaning the surfaces, do not use abrasive materials such as steel wool or wire brushes. Use only isopropyl alcohol and clean with soft rags (Do not use chloride or halide-based cleaners).
- Do not cover or block the explosion relief cover components.
- Observe all OSHA mandated regulations for the safe rigging of exhaust equipment.
- Do not use any lifting device directly on the explosion relief cover components.
- Prior to welding or other potentially damaging work in the area, protect the explosion relief cover components.
- Flanged faces must be parallel with each other and mating surfaces must also be parallel, flat and smooth.
- Ensure that relief nozzle is located as close as possible to inlet of silencer/in the first chamber of the silencer. Ideal configuration is 180° from inlet when possible.
- Gather all kit components including thin steel plate, graphite gasket, bolts, washers, springs, hex nuts and jam nuts.
- Ensure cover is pointed away from pedestrian areas and that nothing in the area is sensitive to hot exhaust gas or potential flame.

INSTALLATION

With hardware nearby, install graphite gasket and steel cover and align bolt holes with those of the flange on the silencer. (Only if needed to hold cover and gasket aligned, loosely install a couple of bolts and nuts to hold the plate and gasket as well as keep the bolt holes aligned.)

1. To install the fastener assembly:
    a) Take a bolt and slide a washer over the threads.
    b) Slide a spring over the threads.
    c) Place the bolt, washer and spring assembly through the open bolt holes of the cover. Continue to push through the gasket bolt holes, then through the bolt holes of the welded flange.
    d) Thread the (taller) hex nuts (wait on the jam nuts).
    e) Do this in all remaining open bolt holes (and lastly in any places where you MAY have used a temporary alignment bolt and nut) for standard 5 psi.
    f) Hand tighten each hex nut onto the bolts.
2. Once you have all bolt/washer/spring/nut assemblies installed, tighten all of the first hex nuts down to compress the spring down to 3.5” length (including washer). Tighten the bolts down in a cross pattern.
3. After all spring compressed lengths are correct, then install jam nuts and tighten the jam nuts to inhibit the hex nuts from moving (50 ft/lb).

CONTINUED

NOTE: Hex nut should not turn when torqueing jam nut. Ensure when torqueing to use new, clean and dry grade 5 zinc hardware provided by inExhaust™.

POST-INSTALLATION

- Review that all components of your exhaust system are properly installed and ready for operation.
- If there is any indication of leaks or damage, cease operation immediately and conduct a broader inspection to determine the cause and resolve.
- After the initial engine run and cool down, re-check all bolts for tightness and torque as required.
- Exhaust back-pressure must not exceed the allowable back-pressure specified by the engine manufacturer. Excessive exhaust back-pressure reduces engine power and engine life and may lead to high exhaust temperatures and smoke. Engine exhaust back-pressure should be estimated before the layout of the exhaust system is finalized and is recommended to be measured at the exhaust outlet under full–load operation, as needed.

MAINTENANCE

It is recommended that maintenance is performed monthly, or every 10 hours of operation, (whichever comes first).

Maintenance for a typical exhaust system installation will consist of physical and visual examination of the exhaust system for any sign of gas leakage, cracks, significant areas of damage or corrosion. Re-tighten any loose bolts if necessary.

- Visually inspect springs and hardware for deformation or breakage. Replace if worn.
- Replace explosion relief cover if cover is modulated or moved from backfire or other explosive circumstance.
- Check flange to ensure it remains flat and in good condition.
- Spot check spring compression length to ensure it is 3.5”. Tighten as needed.
- Spot check uncompressed spring length is at 4” length when ambient temperature. Replace springs if they are permanently deformed/compressed.

Note: If there is any indication of leaks or damage, cease operation immediately and conduct a broader inspection to determine the cause and resolve.

Thank you for choosing inExhaust as your exhaust system components solution!
For any questions, please contact us at insales@inExhaust.com.

This guide is also available on our website: www.inExhaust.com