

## 2011-15 Ford Raptor Cat-Back Exhaust

Part # 91K101



*STOP – Verify that all of the following components are included in kit before beginning installation:*

**Part #1** – Muffler & Drone Tube Assembly

**Part #2** – Over Axle Tubes & Tips

(2) – 2 ½” Band Clamps

(1) – 3” Band Clamp

### Required Tools

Jack and Jack Stands or Hoist  
Ratchet  
15mm Socket  
10mm Socket

Exhaust Hanger Rod Removal Tool  
Spray Lubricant  
Pry Bar  
Torque Wrench

### Torque Specifications

Band clamps - 30lb/ft-35lb/ft.

- Do not use impact on band clamps, overtightening can result in damaged clamp.

### Warranty Information

**IMPORTANT** – The warranty on this product is VOID if the product is not properly installed, or has been modified or altered in any way. If you believe that modification or alternate installation method will be required to fit an MRT Exhaust System on your vehicle, **please contact** MRT for assistance **BEFORE** making any modifications to the system.

## Begin with removing factory axle-back exhaust system:

**Step #1:** With the vehicle in the air, apply penetrating lubricant on the band clamp bolt and hangers to aid in removal.

**Step #2:** Loosen the band clamp forward of the factory large muffler.

**Step #3:** With an extra set of hands slide the two sections of tubing apart and remove each hanger rod from the rubber isolator. Carefully maneuver the factory exhaust system from the truck and set aside.

**Step #4:** Remove the rubber isolator and bracket near the spare tire from the frame and set aside. This will be used for installation of the MRT system.

## Installation steps for the MRT Axle-Back Exhaust System:

**Step #1:** Place the supplied 3" band clamp onto the outlet of the factory exhaust tubing.

**Step #2:** Install the muffler and drone tube assembly by inserting the inlet portion into the factory exhaust tubing. Insert the hanger rod into the rubber isolator and snug the band clamp down to keep in place. Do not tighten clamp yet!

**Step #3:** Place the rubber isolator and bracket assembly (removed in step 4 above) onto the hanger rod closest to the tips and one 2 ½" band clamp on each of the outlet sections of the muffler assembly.

**Step #4:** With an extra set of hands to help guide the over axle pipes into place insert the inlet portion to the muffler assembly. Install the bolts connecting the rubber isolator bracket into the frame. Snug the band clamps down to retain the over axle pipes location.

**Step #5:** Once the exhaust tips are in your desired location and you have checked for adequate clearance surrounding the exhaust tubing begin torquing the band clamps. Start with the forward most clamp and work your way toward the rear checking tip position along the way.

**Step #4:** Check all connection points and start vehicle to detect for leaks in a well ventilated area. If leaks are found review each step of the installation procedures and check for any missed steps in the process.

**Step #5:** If no leaks are found take vehicle for a drive and enjoy your new MRT exhaust system.

**Final Check:** Initial operation after installation will heat-cycle the tubing causing expansion and contraction. Because of this we suggest checking all clamps and re-tightening if necessary after 30 miles of driving.

MRT appreciates your business; please feel free to contact us at any point with questions or concerns at 734-455-5807 or via email at [Sales@MRT-Direct.com](mailto:Sales@MRT-Direct.com)