



iPE Exhaust

Automotive exhaust system engineering

Mercedes-Benz

G63 (W463)

Product installation instruction

WWW.IPE-f1.com

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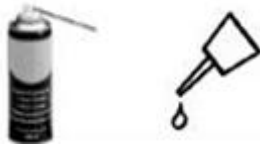






1. Important information

iPE developed exhaust systems based on the OEM exhaust to avoid issue with installation. Modern car keys and the vehicle itself have an inductive power transmission function, we suggest to keep the car key at least 5 meters away from the vehicle for safety purpose. Please wear insulated gloves to replace the exhaust pipe when hot, or replace it after cool down to avoid burns.

When setting the valve to open automatically, please do not let the valve open prematurely to avoid resonance; it is recommended to set the timing of valve opening to 60% of the throttle. For detailed setting options, please refer to the control box setting page.

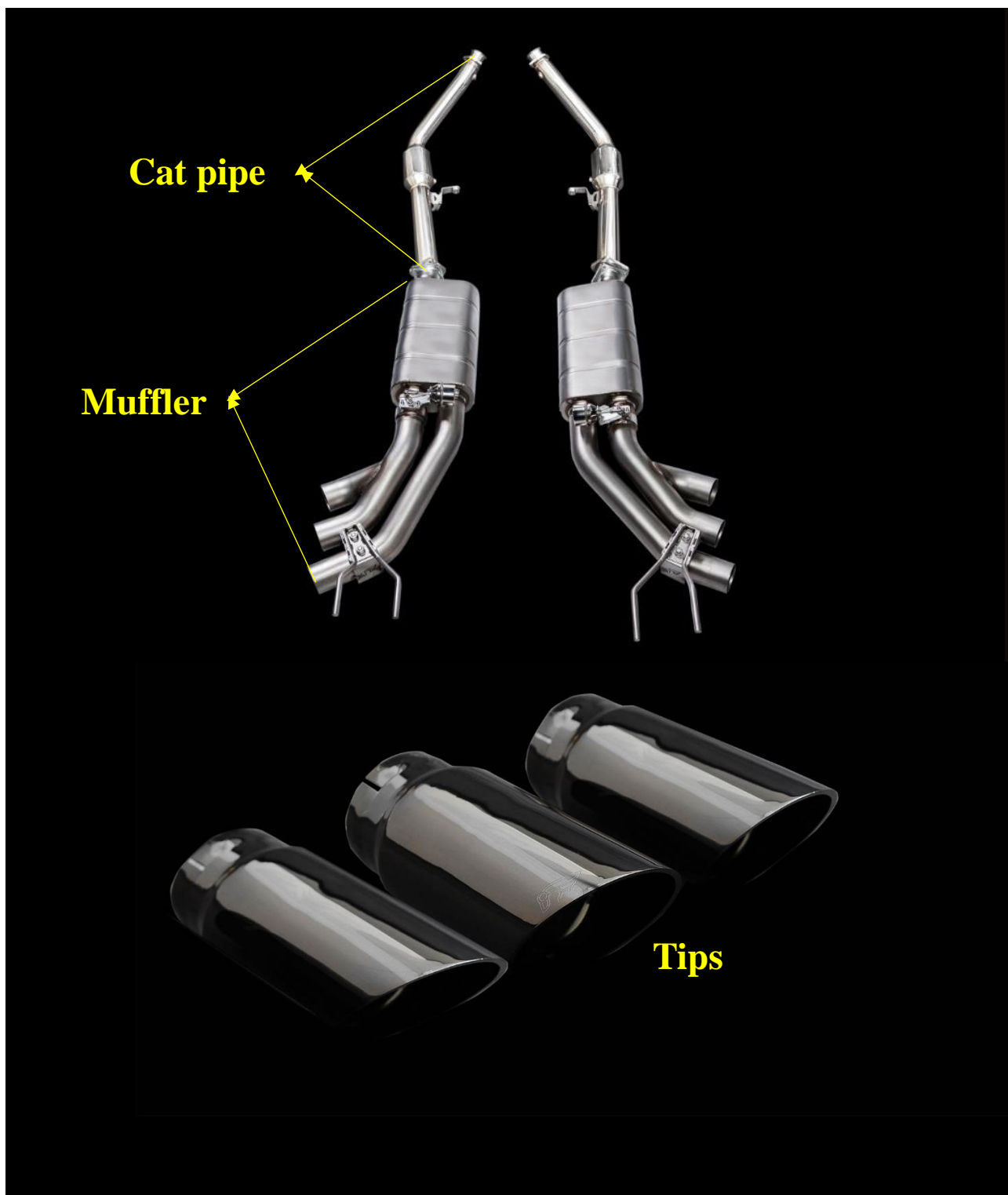
The iPE exhaust system is an evolution designed based on OEM spec. If the vehicle has ECU tuning, there may be possible resonance from the exhaust system. If you have any questions about this installation instruction, please contact your local iPE dealer or email us at info@ipe-f1.com

2. Tools required for the operation process

Tool name	Tool appearance
Rust inhibitor / lubricant	
Hexagon socket 10mm 13mm	
Hexagon wrench 13mm	
Torque wrench 13mm	
Star shaped screwdriver T25	
Ratchet wrench 10mm 13mm	
Universal long post 13mm	

3. Mercedes-Benz G63(W463)

product assembly appearance



4. Steps to remove the original exhaust and related key points

lift up the vehicle to the working position.

1. Loosened the cat-back section screws and removed, Lubricated bushes then removed the cat-back assembly (Fig. 1).

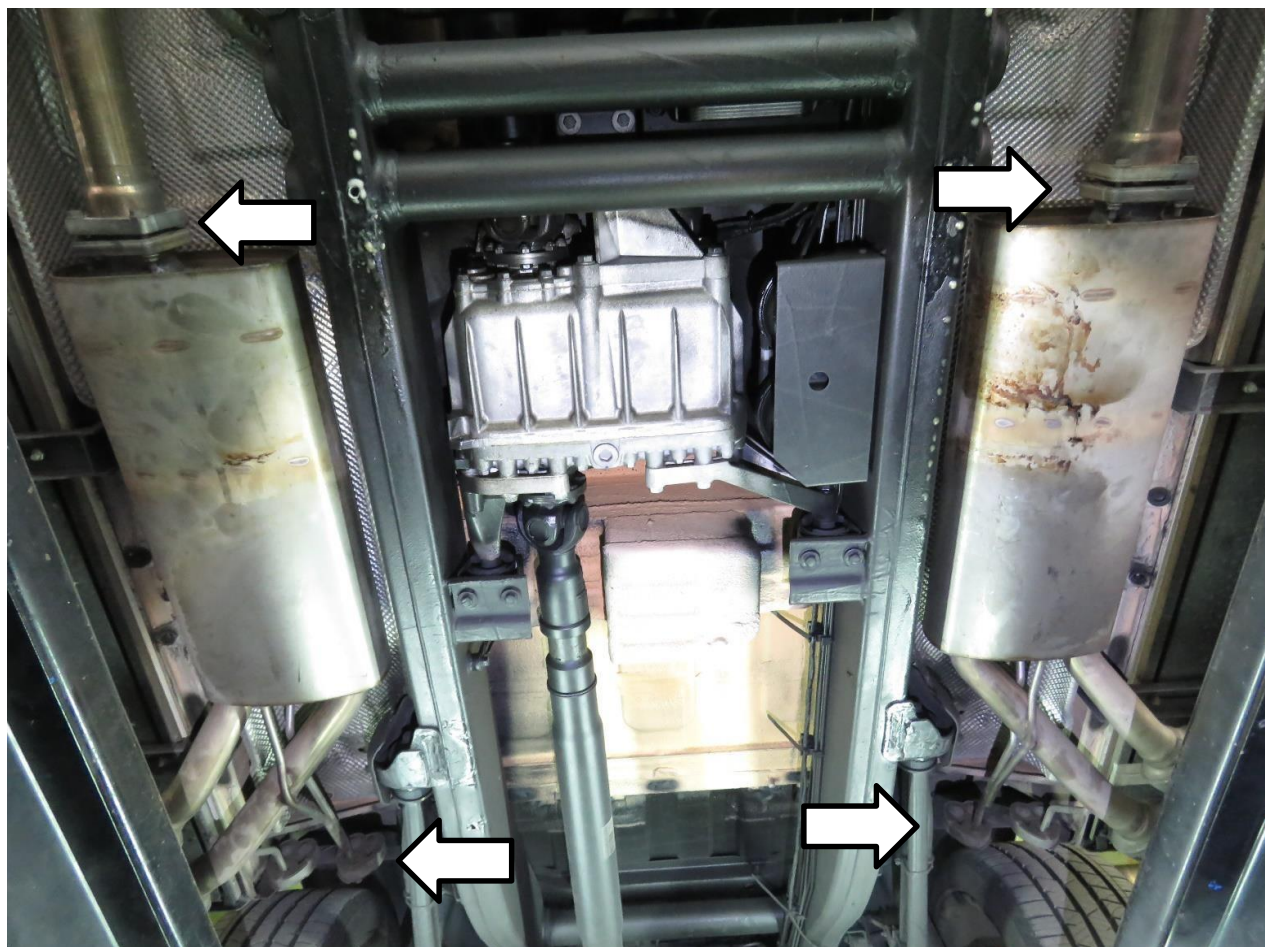


Fig. 1

Warning: Please put in park before lifting up, clear the surrounding area and pay attention to the height to ensure the safety of people and vehicles!

After the screws are removed, placed neatly to avoid confusion during reinstall, Lubricant for disassemble might be necessary.

2. Remove the left and right sides oxygen sensors before unscrew the cat pipe (Fig.3, Fig.4).

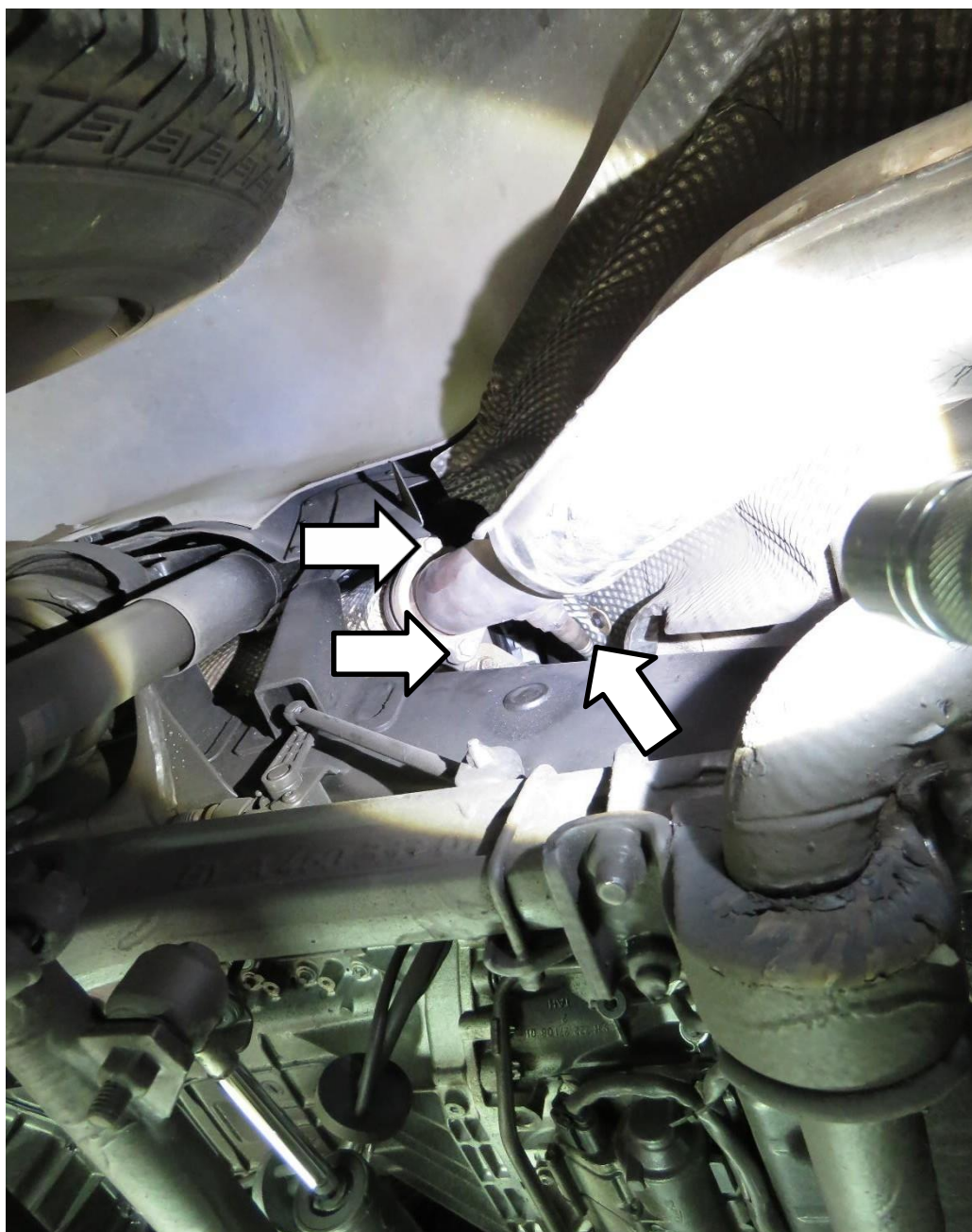


Fig.3

Warning: After the screws are removed, they are placed neatly to avoid confusion during reinstall. Use an appropriate tool to remove the oxygen sensor to avoid wire damage!

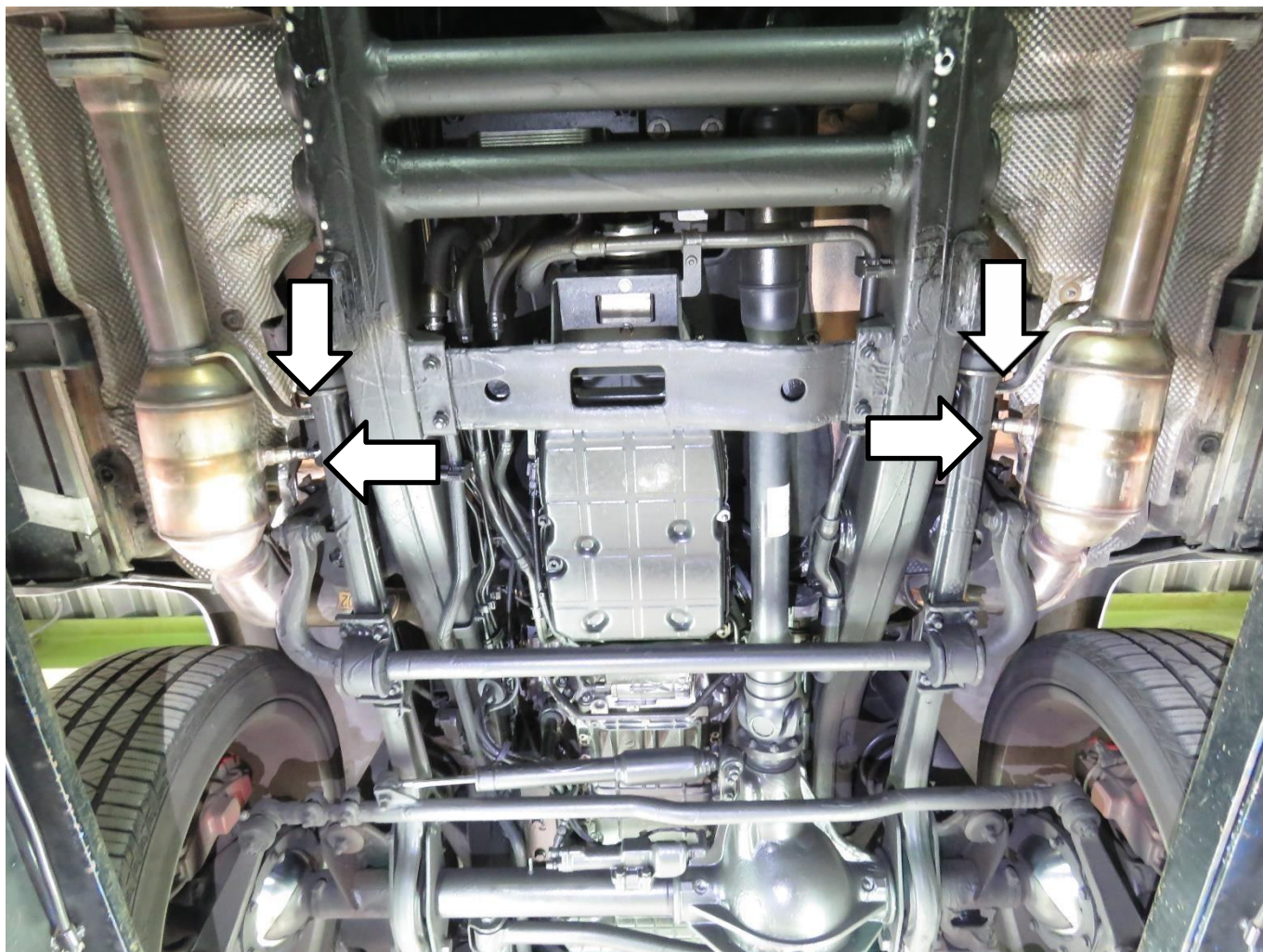


Fig.4

5. Steps and related points for installing the iPE exhaust

1. Install the iPE cat pipes in place (Fig. 5, Fig.6).

Warning: lock these screws with proper torque setting.

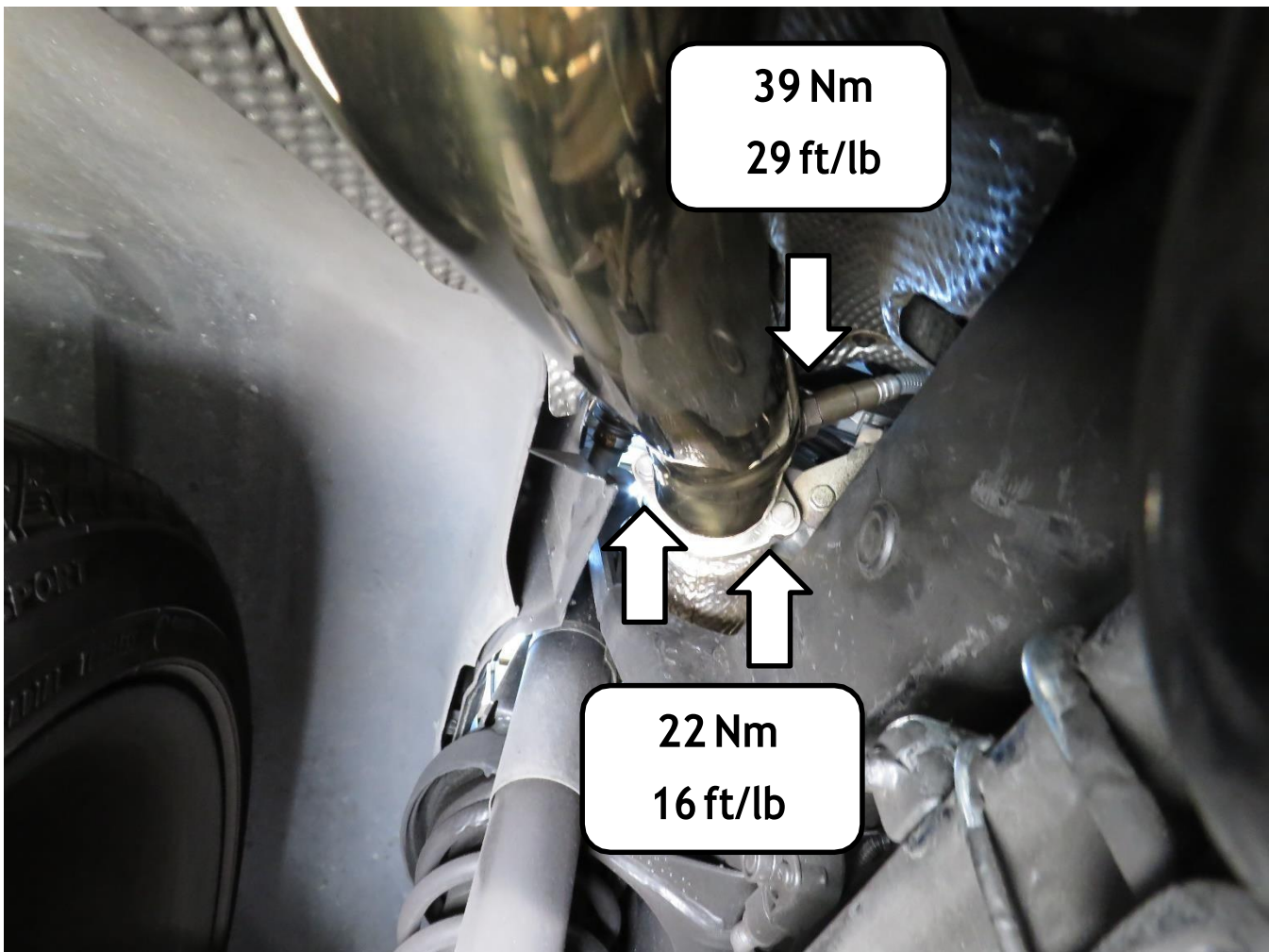


Fig.5

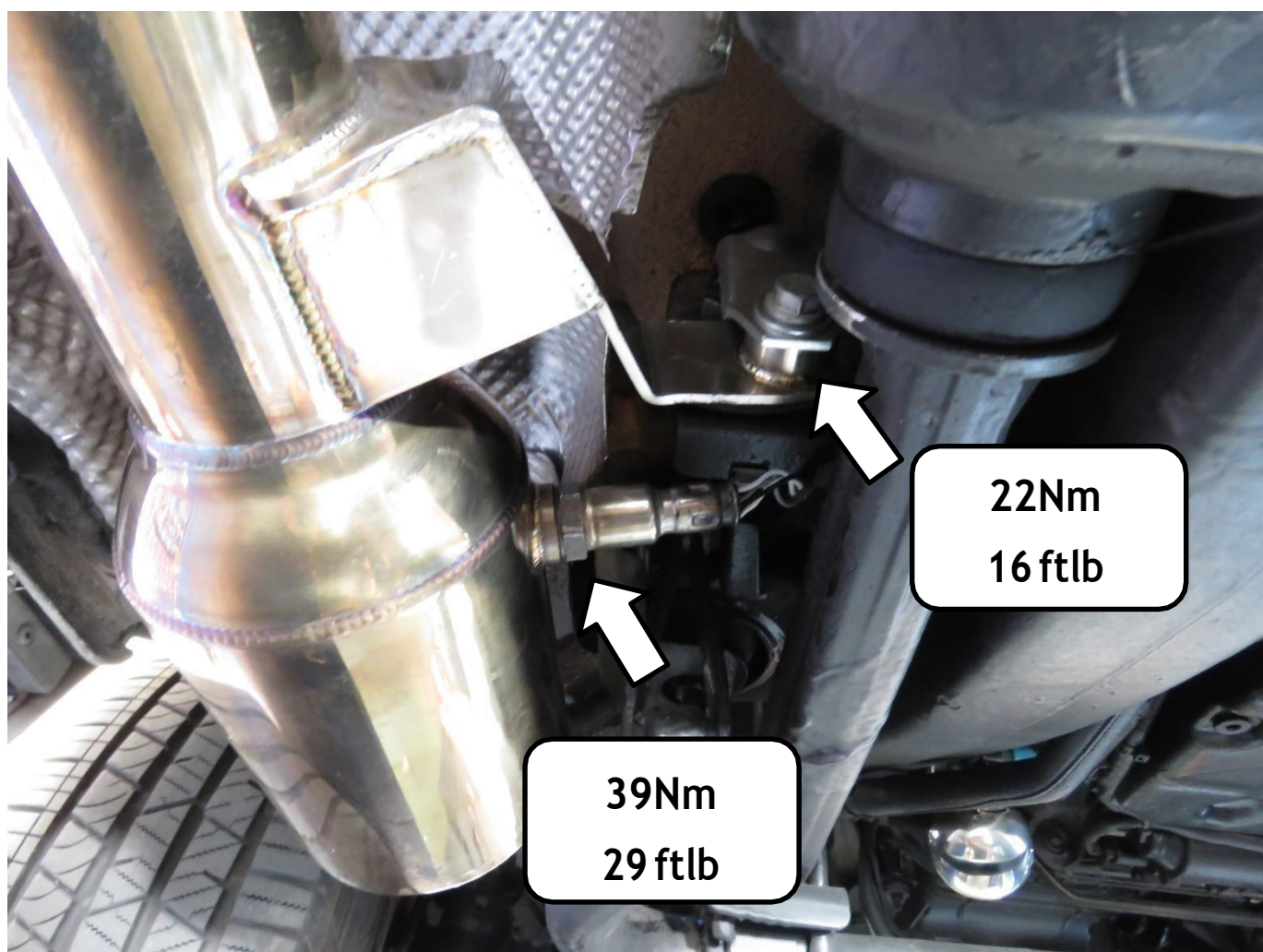


Fig.6

2. Install the iPE catback section to the position. The muffler and tips should be positioned horizontally and locked under appropriate clearance to avoid collision and unwanted noise. (Fig. 7).
3. Install all the removed parts, and lock them with proper torque setting.

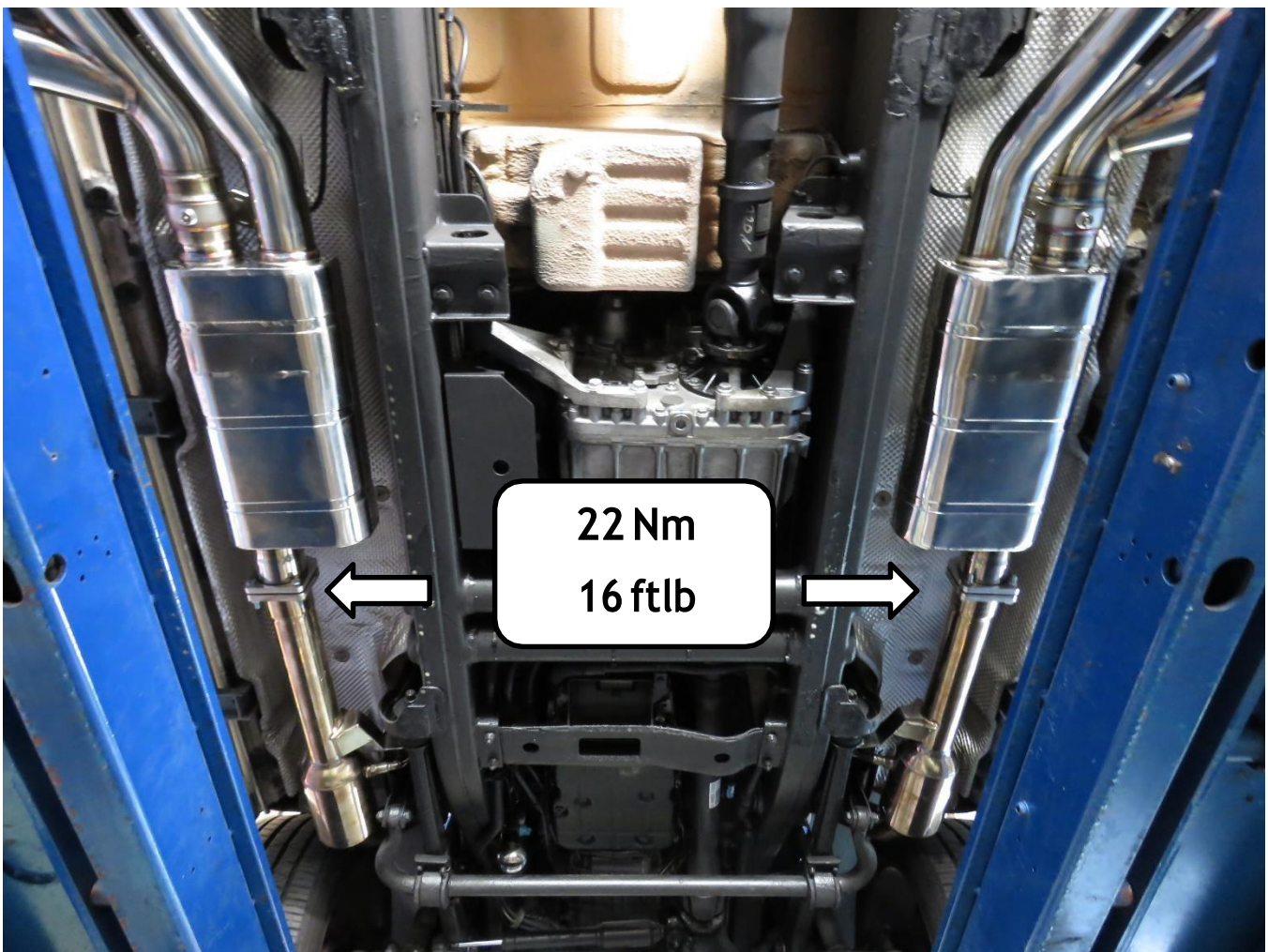


Fig.7

Warning: Please ensure all screws torque appropriate

4. When face the front of the car, the vacuum source will be on the upper right corner where the red frame is (Fig .8).
5. Disconnect the vacuum tube and connect the vacuum tube to the three-way vacuum tube (Fig.9).

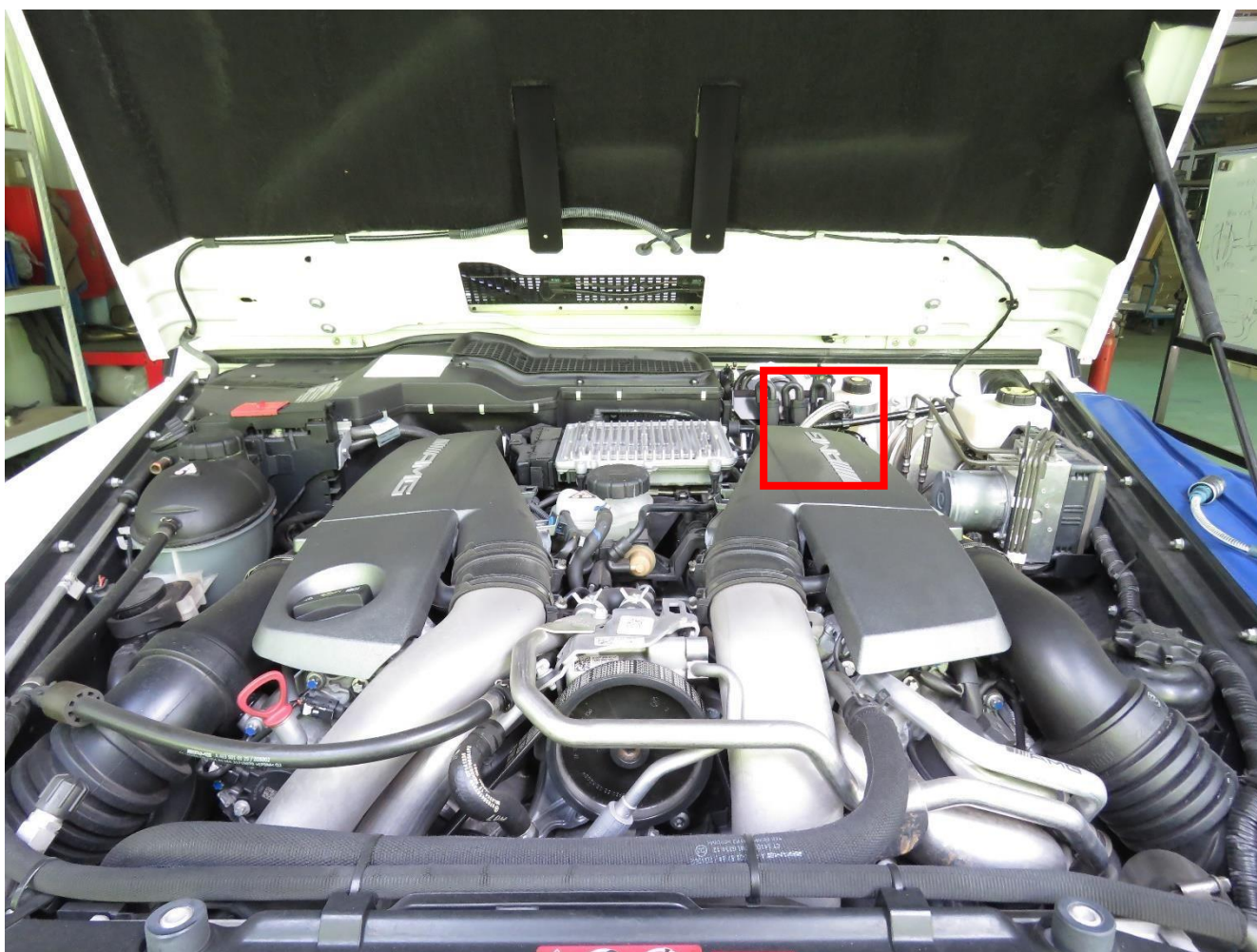


Fig.8

Warning: When taking over, be careful not to interfere, so as to avoid damage to the vacuum tube.

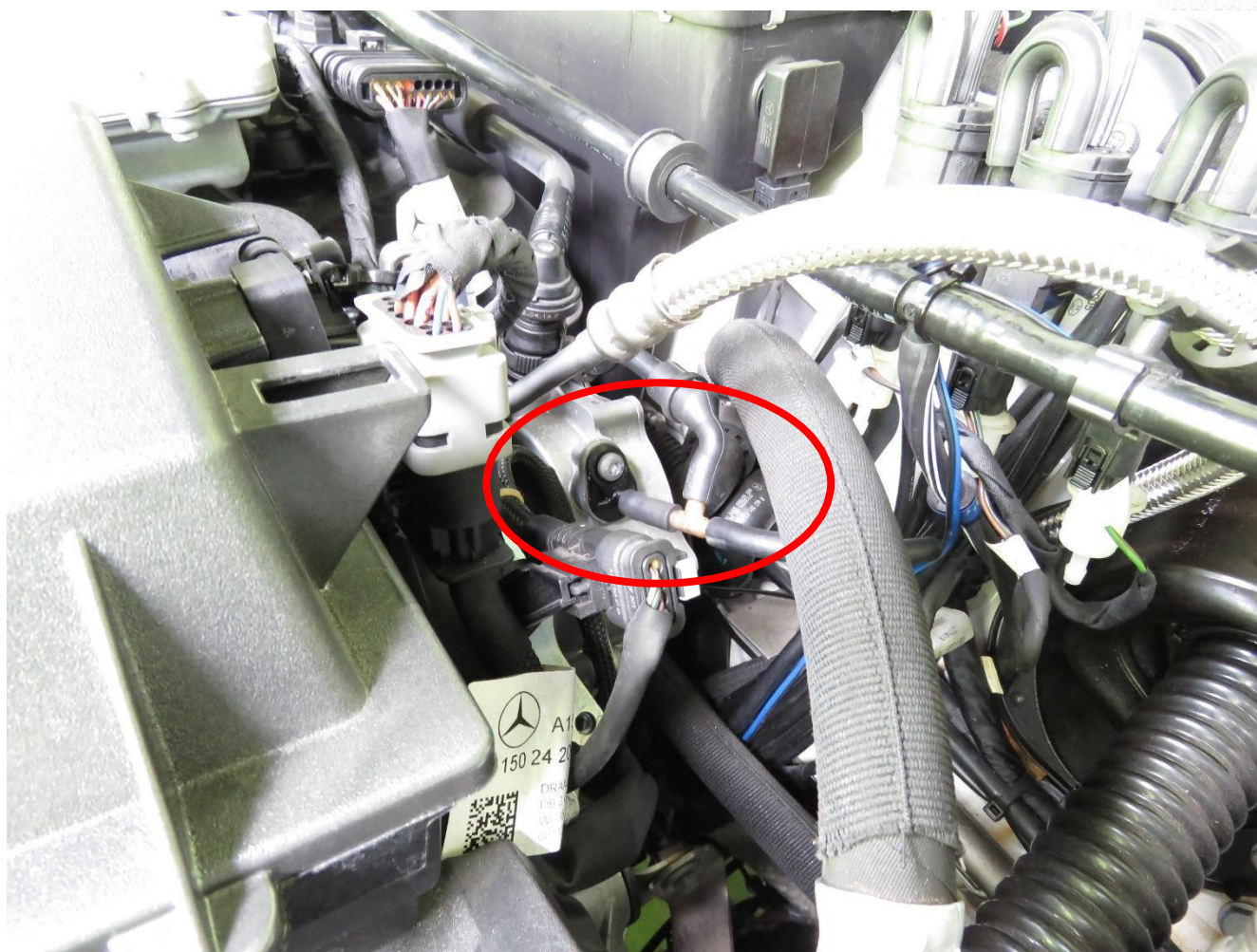


Fig.9

6. Vacuum tube and solenoid valve wiring can be extended from the lower left fixing ring of the brake master cylinder to the bottom of the vehicle (Fig.10, Fig .11).

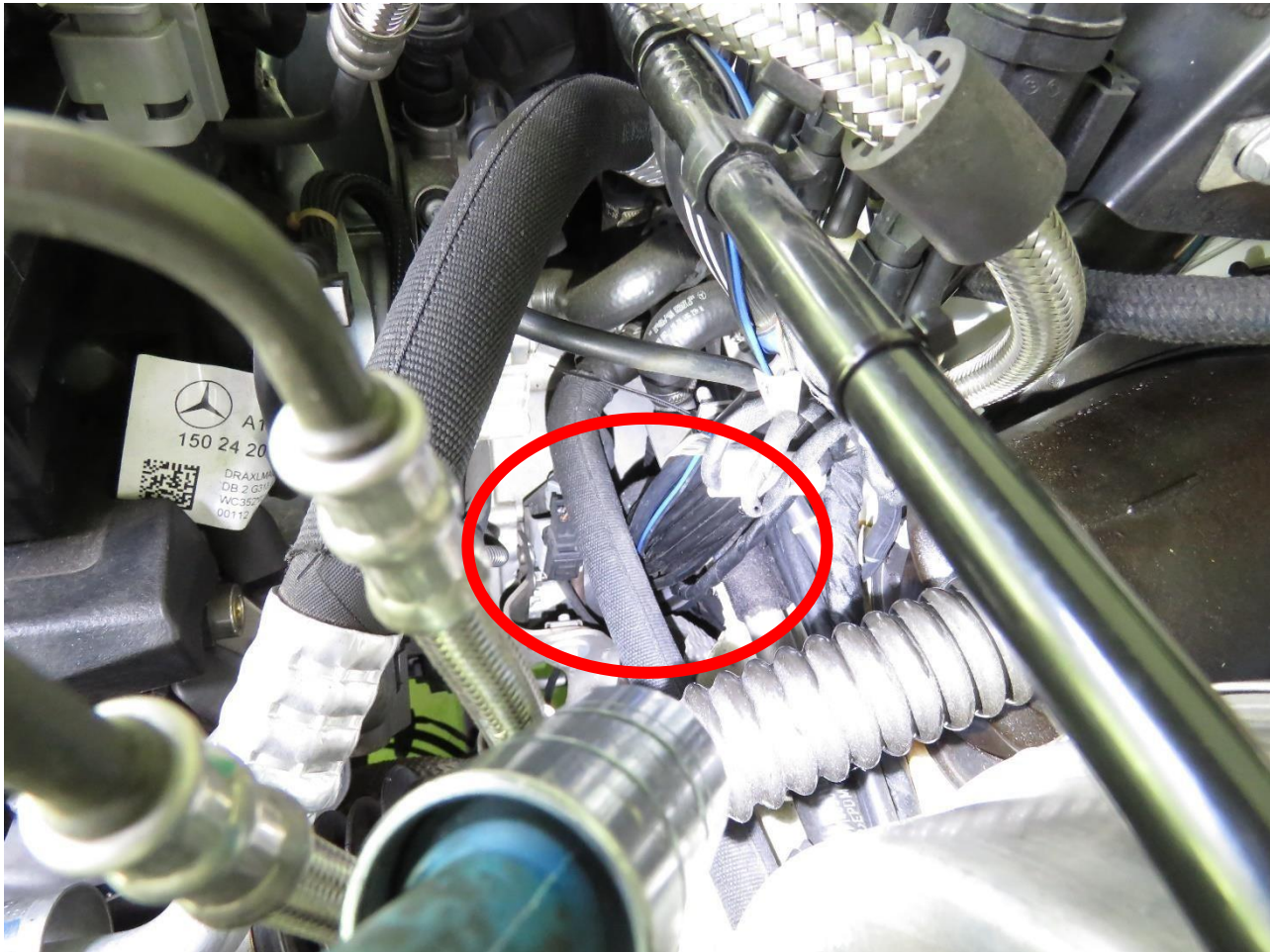


Fig.10

Warning: Be careful not to short-circuit or interference with vacuum source and wires; install all wires with care.

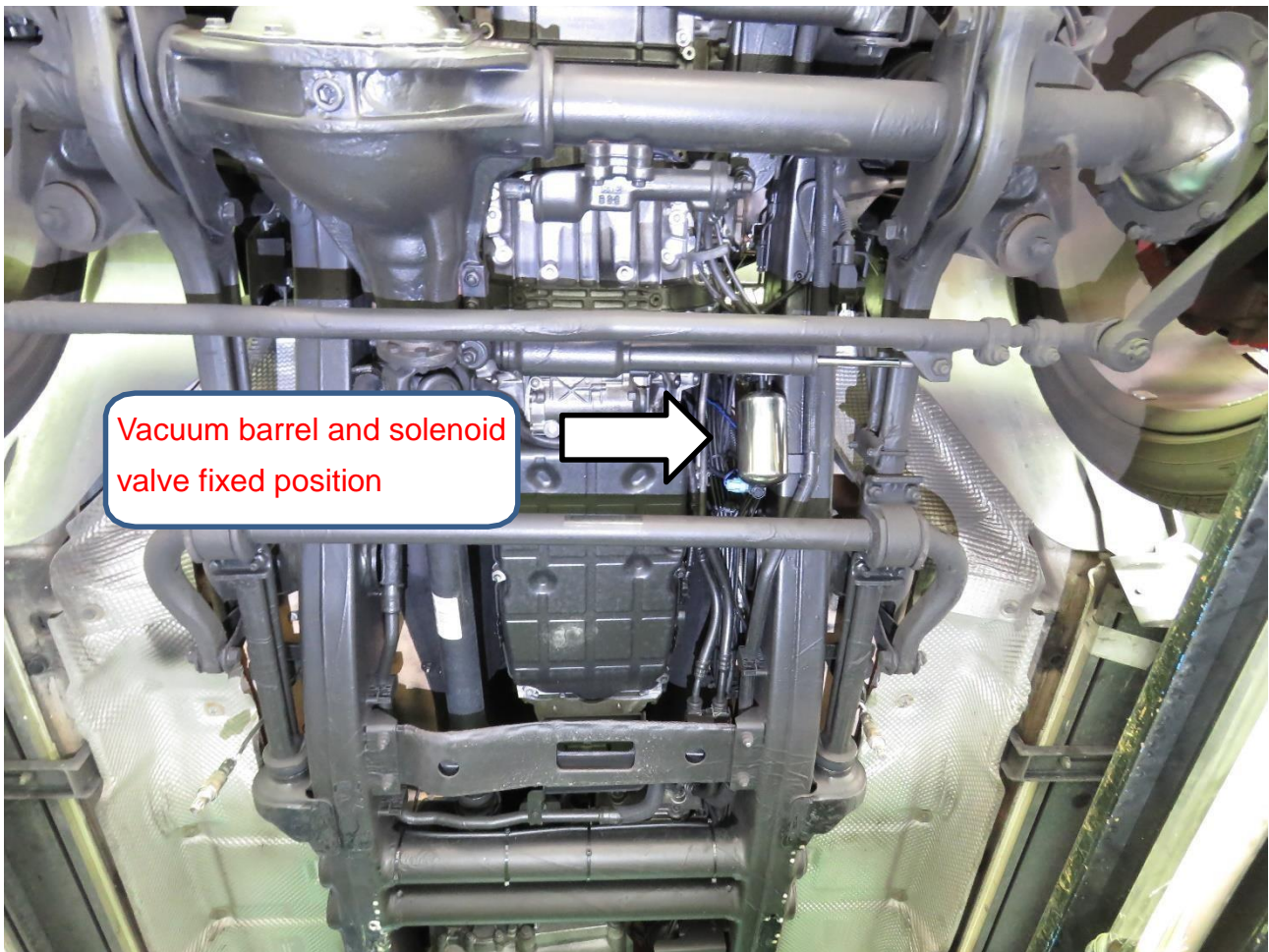


Fig.11

7. The solenoid valve wiring is lead to the cabin from the waterproof boot (Fig.12) showed in red square here.



Fig.12

Warning: Be careful with wiring, do not short-circuit and avoid interference with circuit and vacuum; do not pull the wire strongly during wiring

8. Remove the trim and fix the OBD control box to the appropriate position below the steering wheel, and connect the OBD plug and wiring (Fig.13).
9. Install all the removed parts, and lock them with proper torque and reverse all installation procedures.

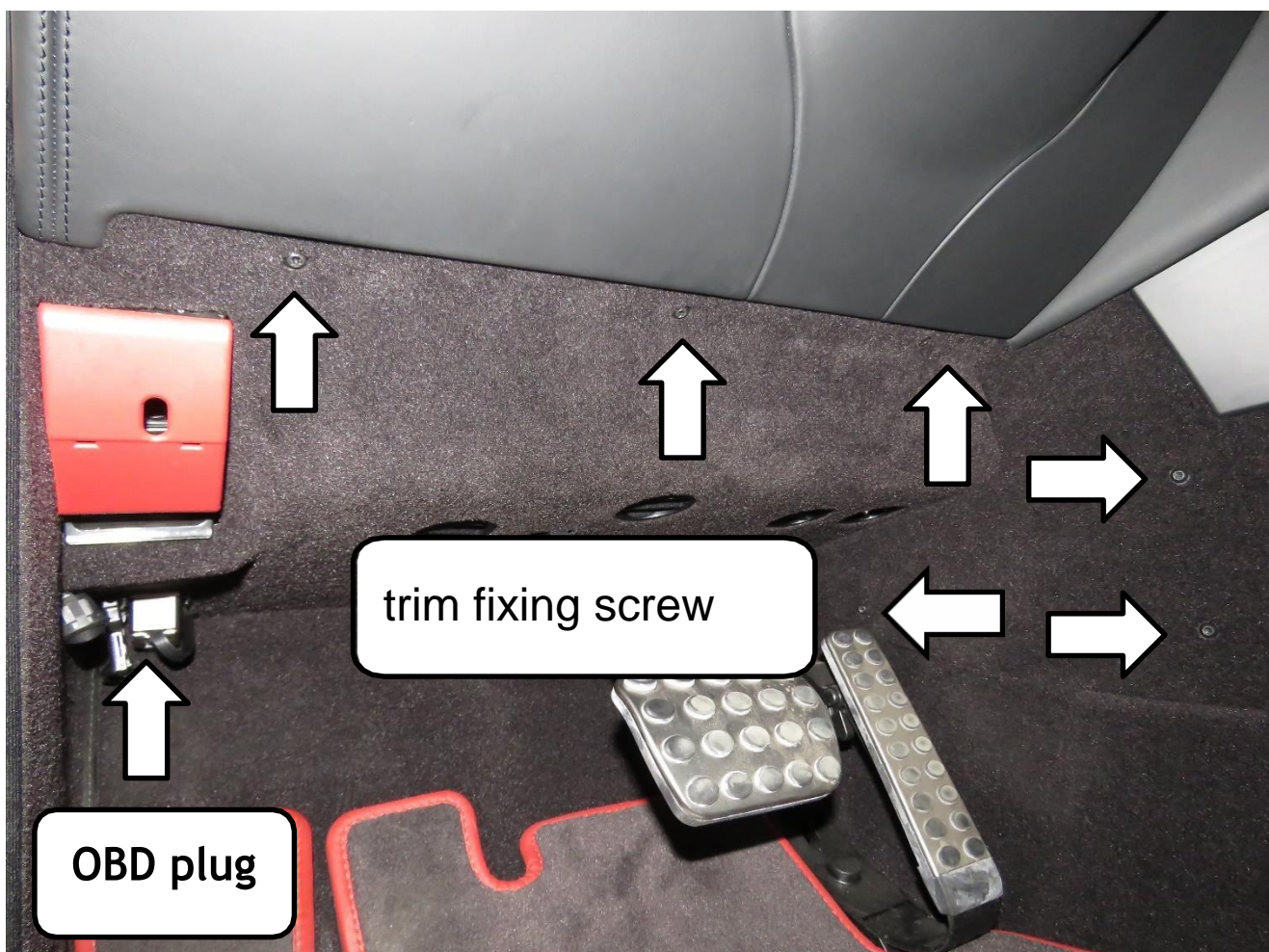


Fig.13

Warning: Be careful with wiring, do not short-circuit and avoid interference with circuit and vacuum; do not pull the wire strongly during wiring