



iPE Exhaust

Automotive exhaust system engineering

Mercedes-AMG GTS

Product installation instruction

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1.Important information

- i. Please read the installation manual before installing the iPE exhaust.
- ii. Please install by the technician of the car exhaust system or familiar with the iPE exhaust system.
- iii. This manual provides detailed installation instructions to ensure proper use and disassembly that the iPE exhaust is properly installed and used. If improper use and disassembly, the company does not assume any responsibility for loss and personal injury.
- iv. When installing the iPE exhaust system, please lock according to the torque value of the manual to avoid abnormal damage to the screws and nuts.
- v. If the exhaust pipe of the car still at a high temperature, please wear insulated gloves for the exhaust pipe installation work, or install it after cooling down.
- vi. Before starting, be sure to wipe off the oil on the exhaust pipe to avoid burning and high temperature.
- vii. The iPE exhaust system is designed according to the original engine data. If the computer is upgraded to change the engine parameters, the exhaust pipe may generate resonance, resonance or other abnormal sound. iPE can provide a modified version of the exhaust pipe for such vehicles.
- viii. If you have any questions about this installation instruction or use of the iPE exhaust system, please contact your local iPE dealer or contact us at info@ipe-f1.com.

2. Tools required for the installation

Tool name	Tool appearance
Rust inhibitor / lubricant	
Hexagon socket 10 、 12 、 13 、 14mm	
Outer hex wrench 12 、 13 、 14mm	
Torque wrench	
Star screwdriver	
Word screwdriver	
Star socket	

3. Mercedes-AMG GTS product assembly



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

Lift up the vehicle to the working position.

1. Remove the left and right spoilers. (Fig.1)

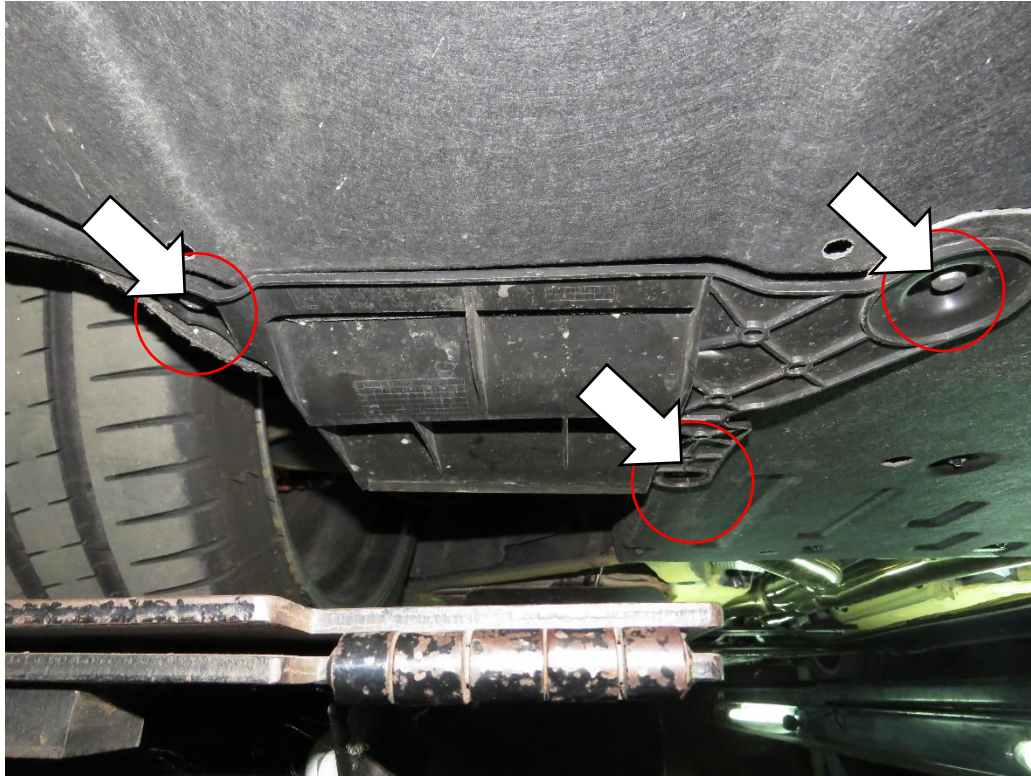


Fig. 1

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!

Remove of the rear lower guard plate:

2. Use a 10mm hexagon socket to remove the rear lower guard plate.

(Fig 2)



Fig. 2

Removal of rear protective frame:

3. Use a 13mm hexagon socket to remove the rear protective frame.
(Fig 3).

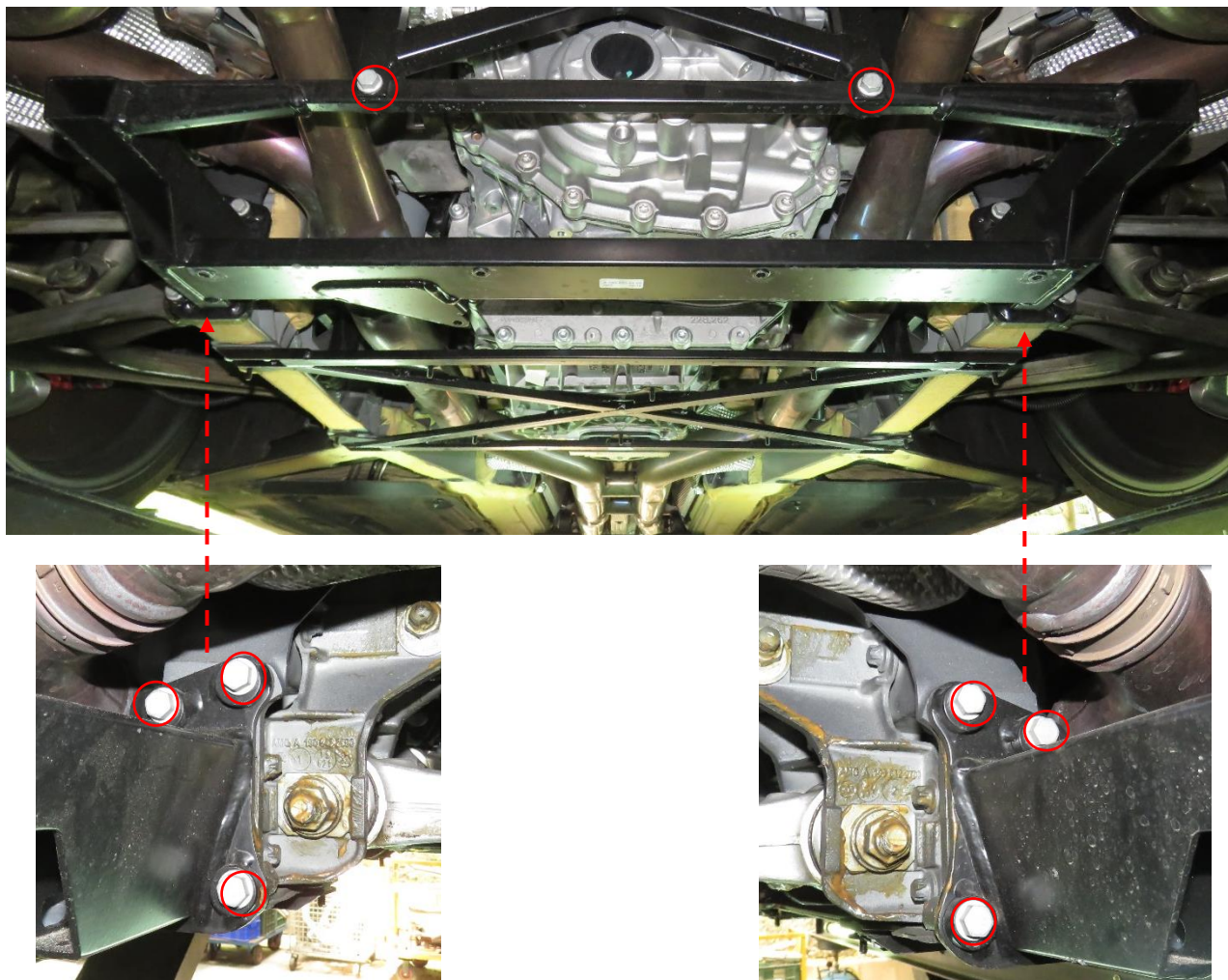


Fig. 3

Warning: After the screws are removed, placed neatly to avoid confusion during reinstall.

4. Use the E10 star sleeve to remove both chassis reinforcements.

(Fig 4)

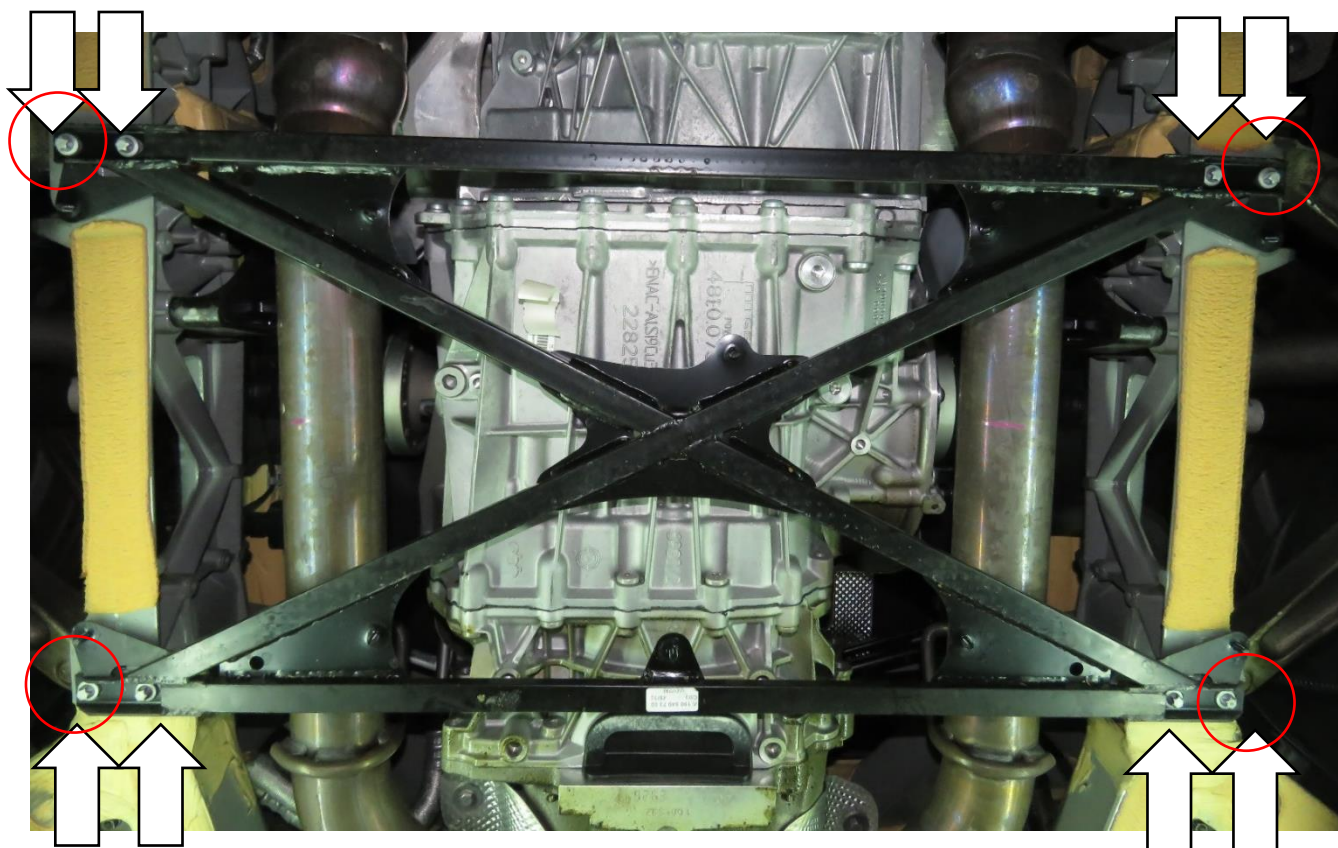


Fig. 4

Warning: External screw and nut pair lock

Removal of the original Catback exhaust system:

5. Loosen the clamp screws and remove the mid pipe bush screws.
6. Loosen the screws of the mid pipe support frame first, and then remove the muffler bushes.

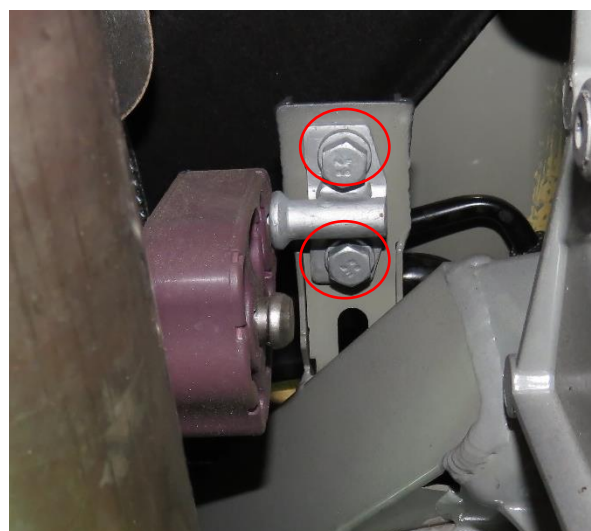
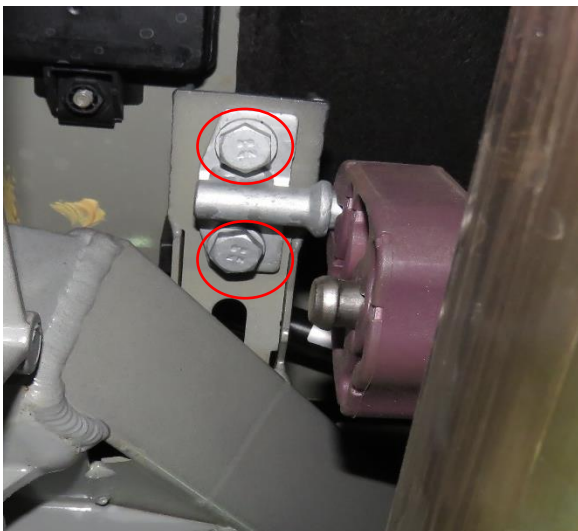
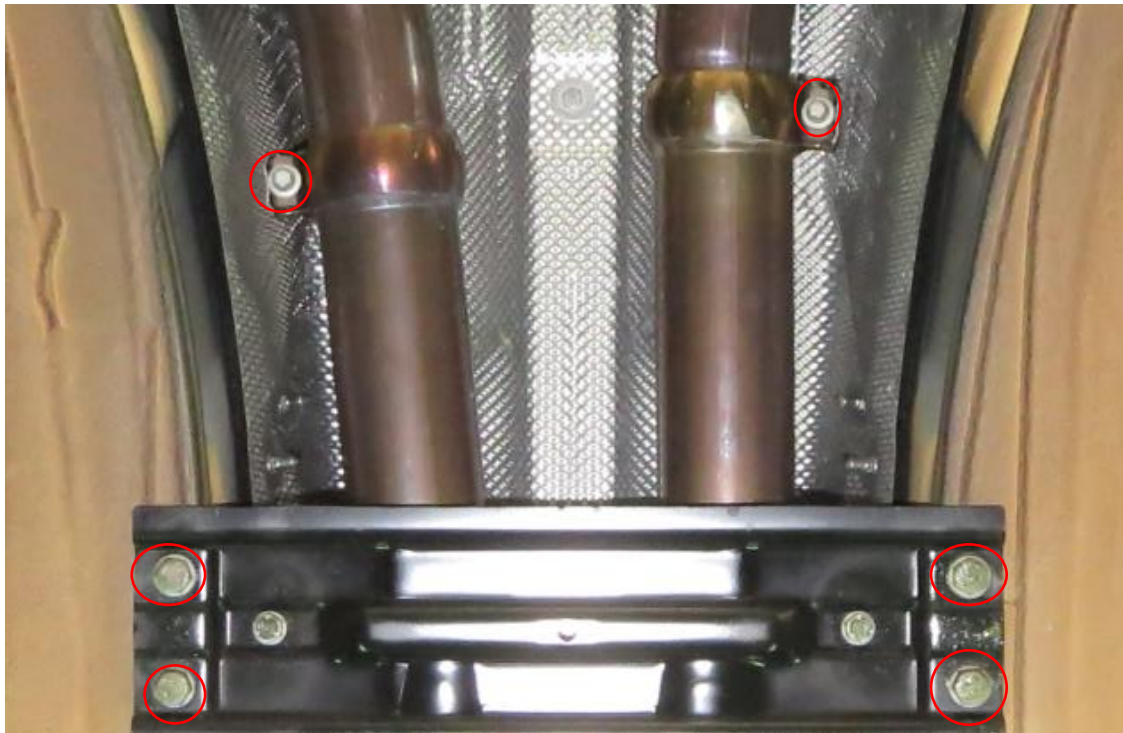


Fig. 5

7. Remove the both heat shields. (Fig 6)

8. Remove the electronic valve plug of R & L side. (Fig 7)

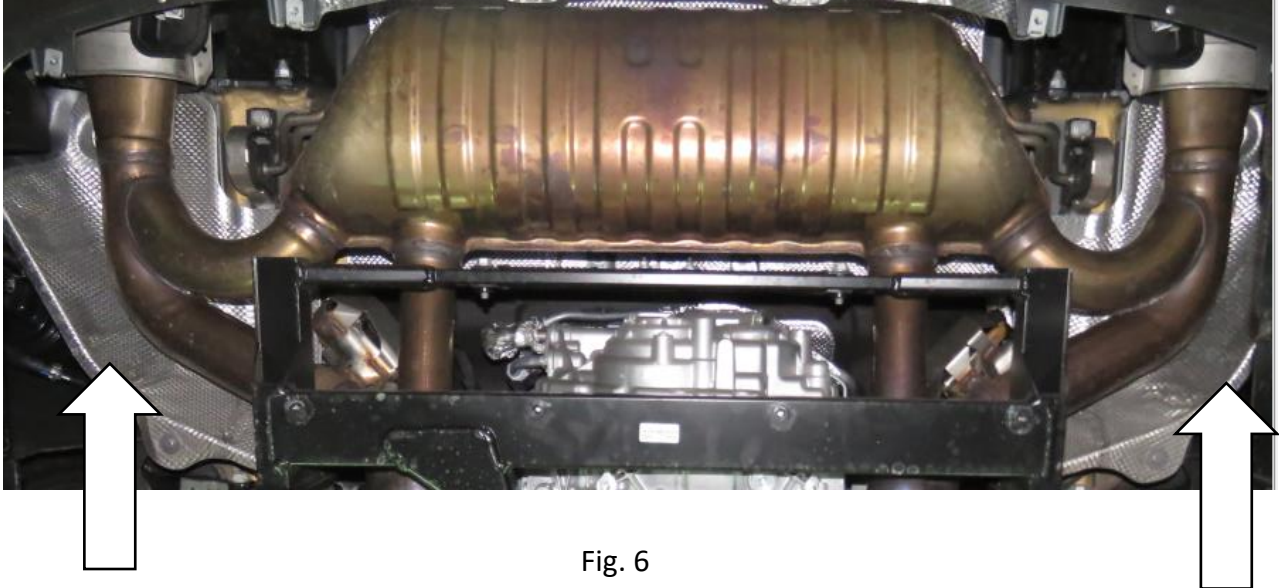


Fig. 6

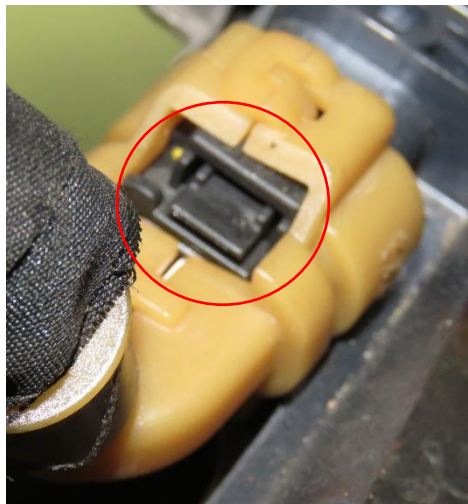


Fig. 7

Warning: make sure not to injure yourself or damage any part of the vehicle during this process!

9. Remove the bushes of the muffler.
10. Remove the mid pipe of bracket and then the original catback exhaust system can be removed.

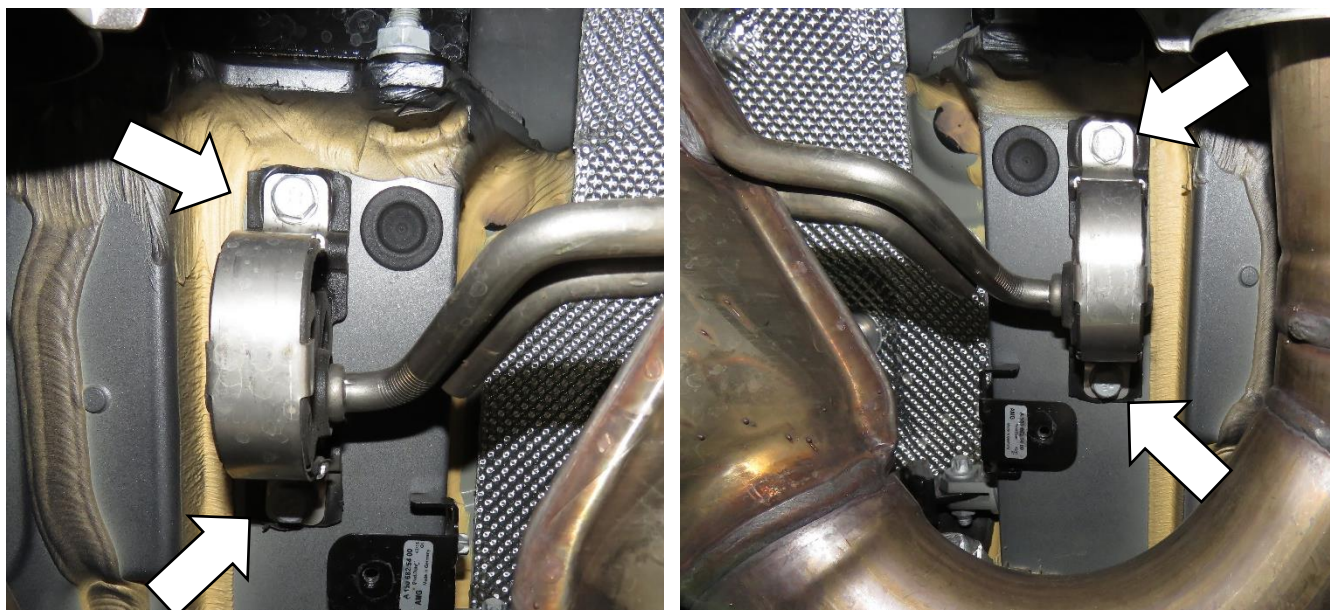


Fig. 8

Removal of the original catpipe section:

11. Remove the bracket below the catpipe. (Fig 9)

12. Use a saw blade to cut off the bottom of the catpipe. (Fig10)

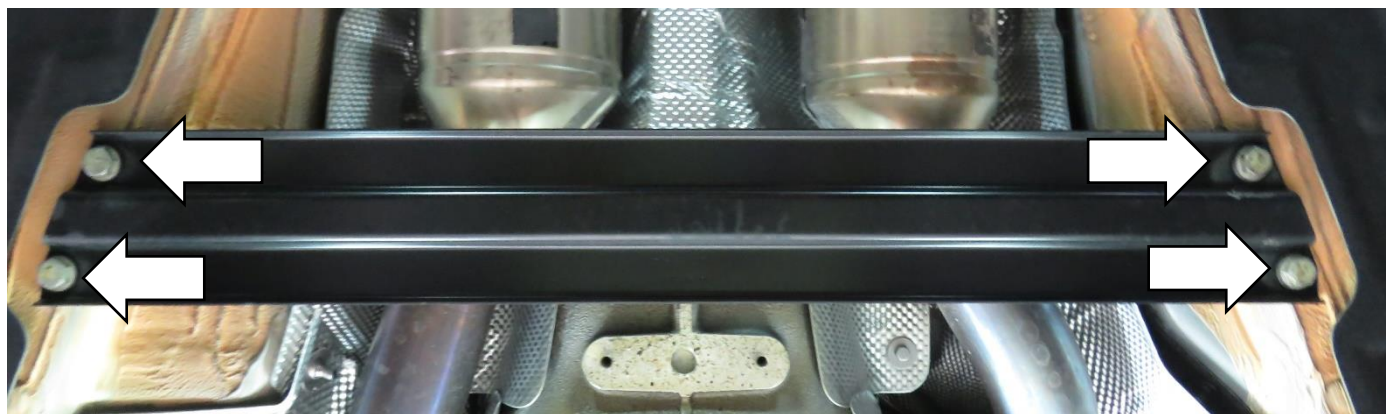


Fig. 9

R side cutting position.

Cut off at about 3CM
below the heat shield.



L side cutting position.

Cut off at about 3CM
below the heat shield.

Fig. 10

13. Remove the protective cover of the catpipe, this protective cover is a Tenon type. (Fig 11)

14. Remove the heat shield of the catpipe.(Fig 12)



Fig. 11



Fig. 12

15. Unscrew the clamps of the catpipe. (Fig 13)

16. Unscrew the oxygen sensor on both sides. (Fig 14)

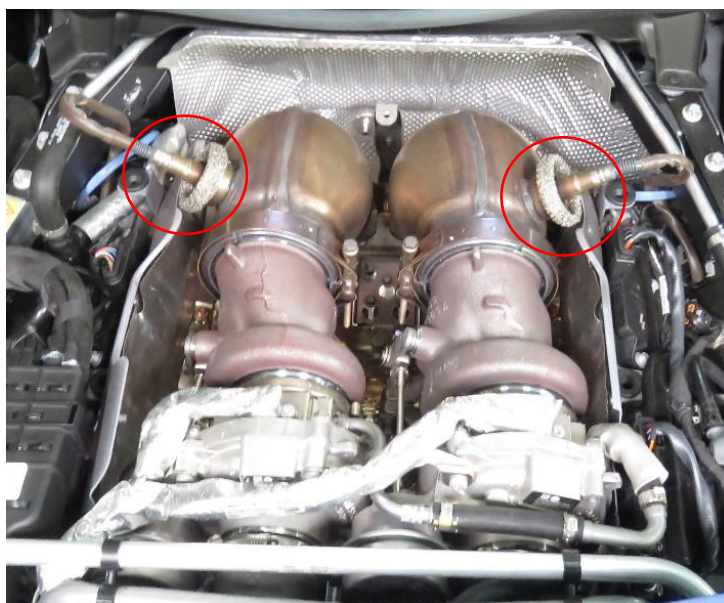


Fig. 13



Fig. 14

Warning: Please use appropriate tools to remove the oxygen sensor to avoid cables damage!

5. Steps and focused points for installing the iPE exhaust

1. Install the catpiepe to the position and screw in the bush screws.

Then tighten the bush screws after tightening the clamps according to the original factory torque. (Fig 11)

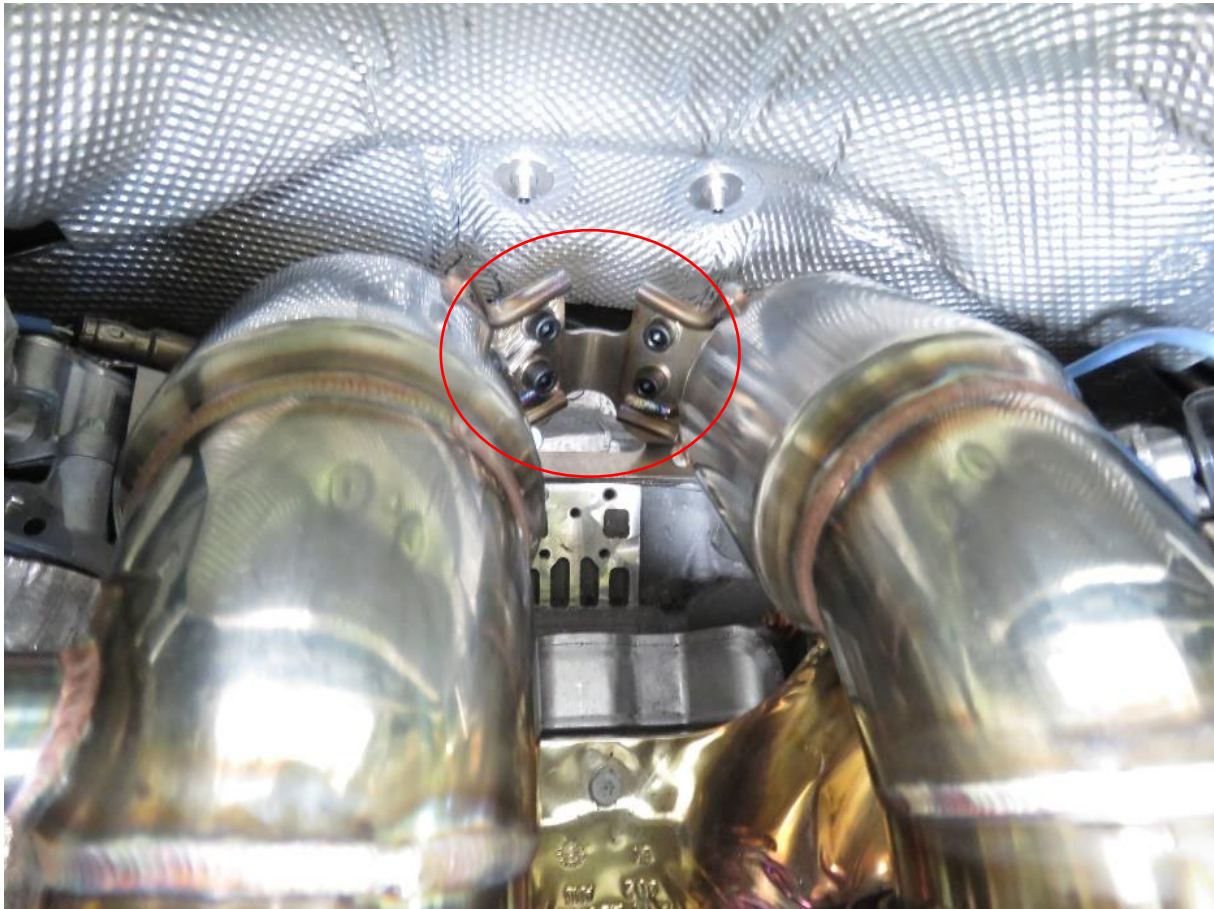


Fig. 15

Warning: Please use appropriate tools to remove the oxygen sensor to avoid cables damage!

2. The mid pipe clamps use the original clamps, and the support frame is installed to the position (Fig 16)

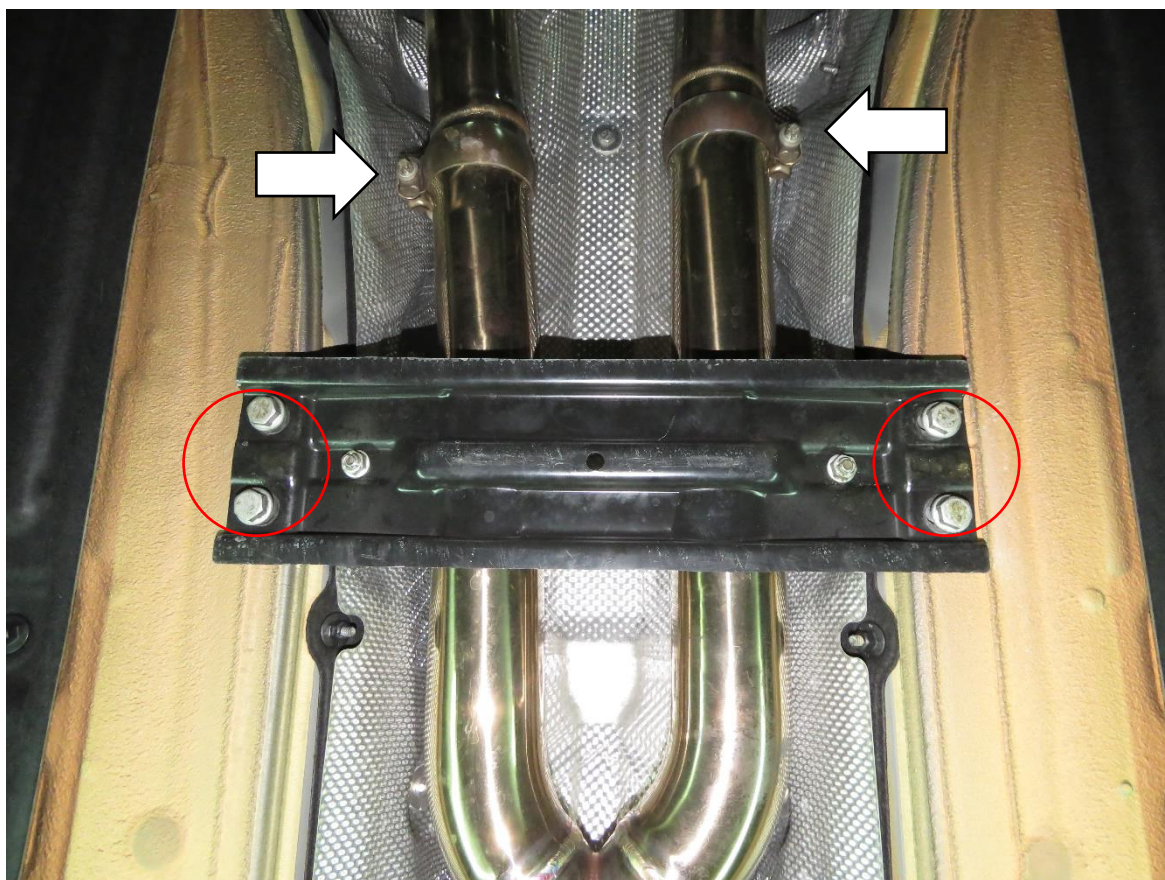


Fig. 16

Warning: lock these screws with proper torque setting.

3. Install the sliding sleeve and bushes to the position.(Fig 17)
4. Install all the disassembled parts, restore and lock the appropriate torque according to the correct installation procedure.

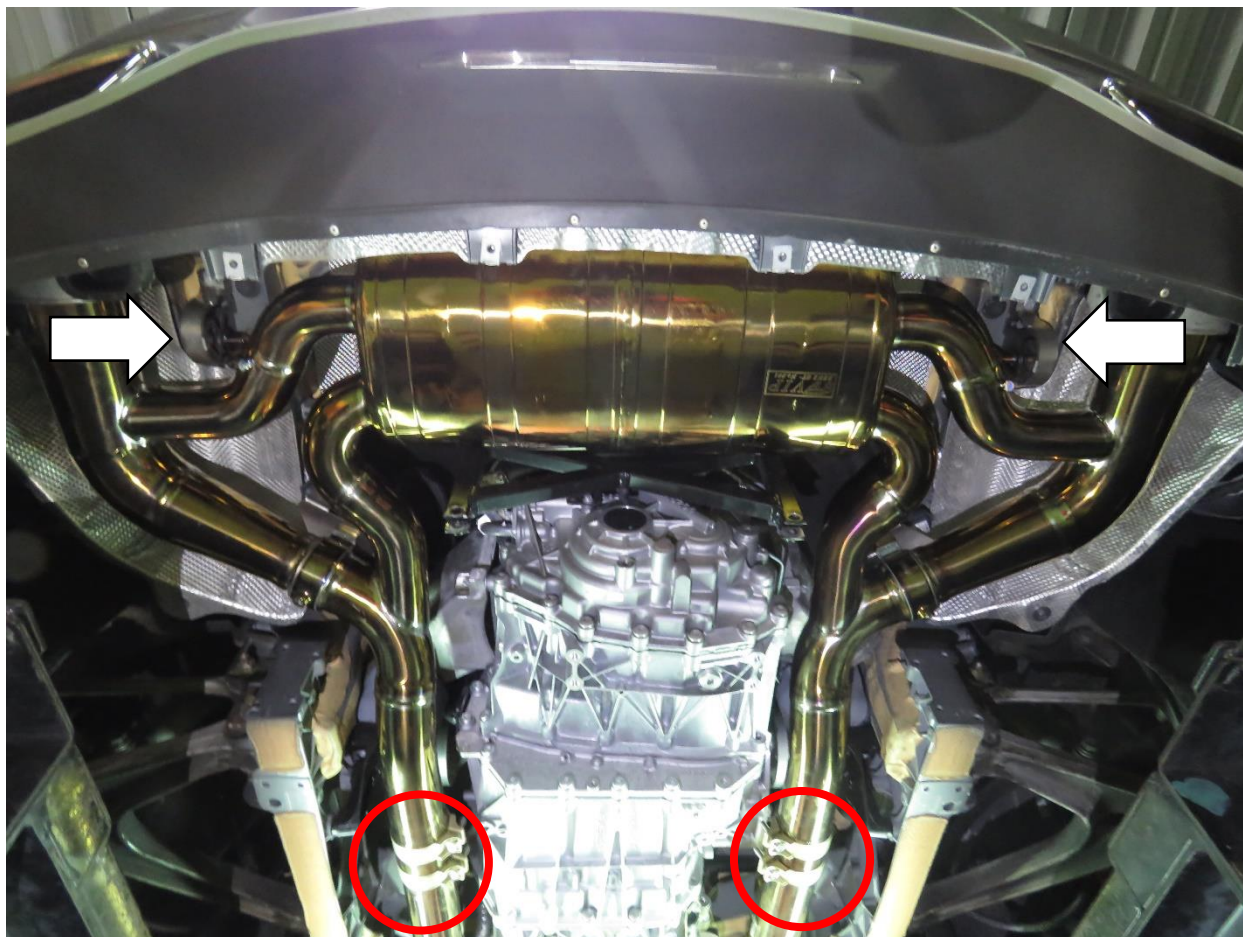


Fig. 17

Warning: lock these screws with proper torque setting.

6. Steps and focused points for installing the Valvetronic.

1. Remove the left and right original electric valve motors from the original exhaust pipe, and remove the screws show in the red circle.

(Fig 18)

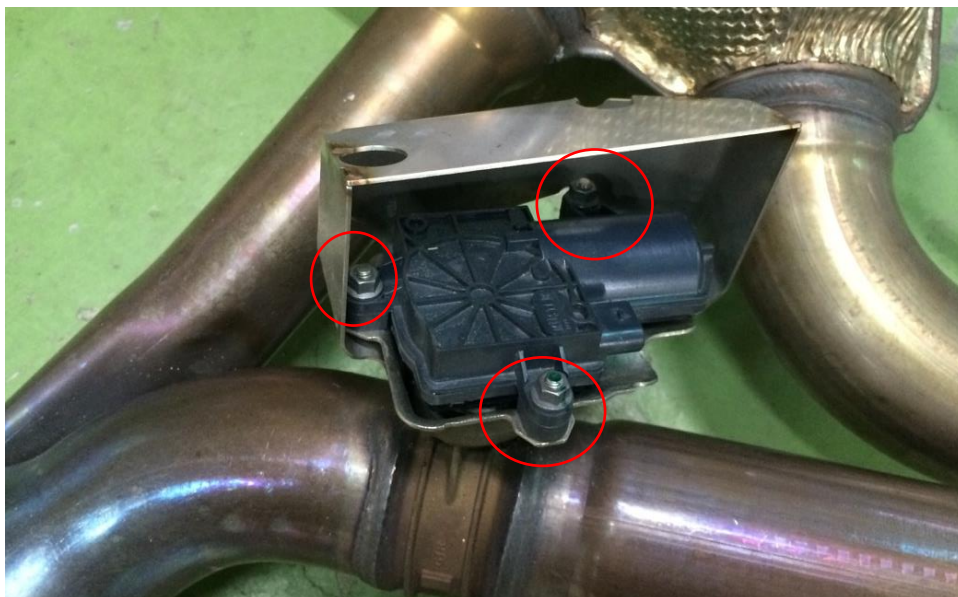


Fig. 18

2. The iPE muffler valve rotates the central axis to the end in the direction of the arrow. (Fig 19)

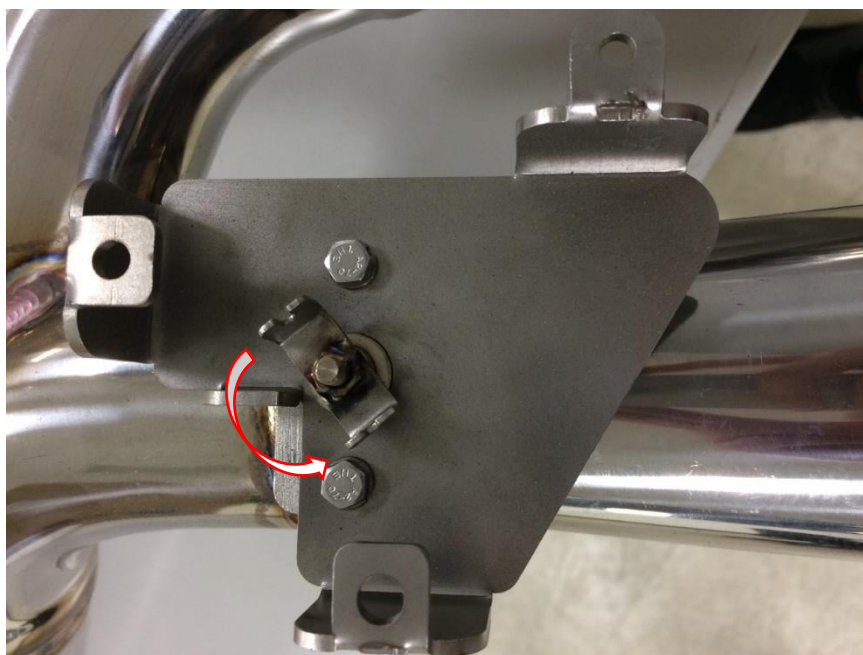


Fig. 19

3. Install the stock exhaust valve actuators onto both iPE mufflers' valves, exactly as shown. Make sure to snap the spring into the groove. (Fig 20)



Fig. 20

4. After installing the motor position, you need to rotate the motor in the direction of the arrow to align with the lock hole. (Fig 21)



Fig. 21

5. Tighten the M5 hexagon socket screws to complete the installation.

(Fig 22)

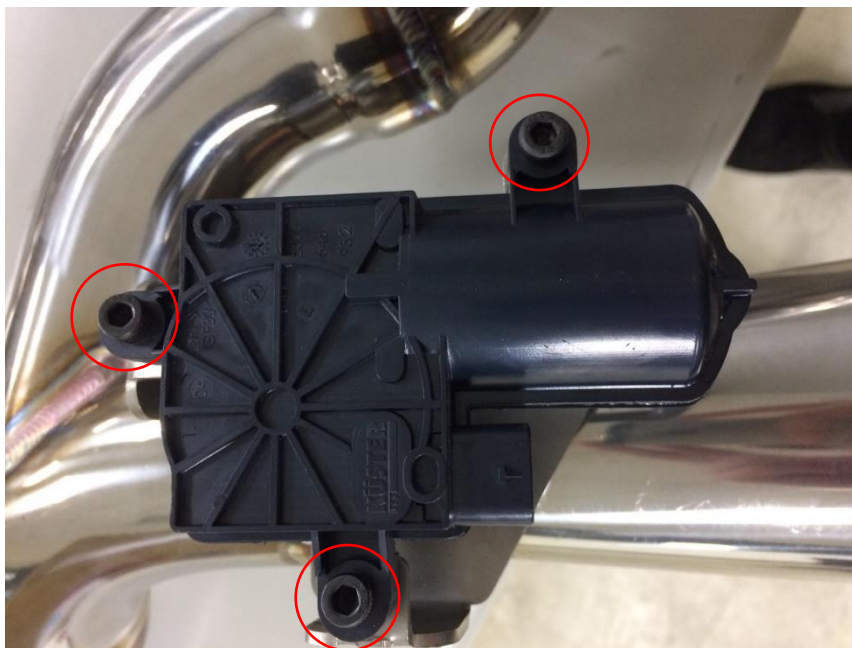


Fig. 22

6. After the exhaust pipe is installed on the car, plug in the electric valve connector. (Fig 23)



Fig. 23

Warning: After the valve motor is installed, the factory will send a closing signal to the valve after the vehicle is started. At this time, it is necessary to confirm whether the valve is tightly closed. No other settings are required.