



iPE Exhaust

Automotive exhaust system engineering

Mercedes-Benz

W177-A250

Product installation instruction

Important information

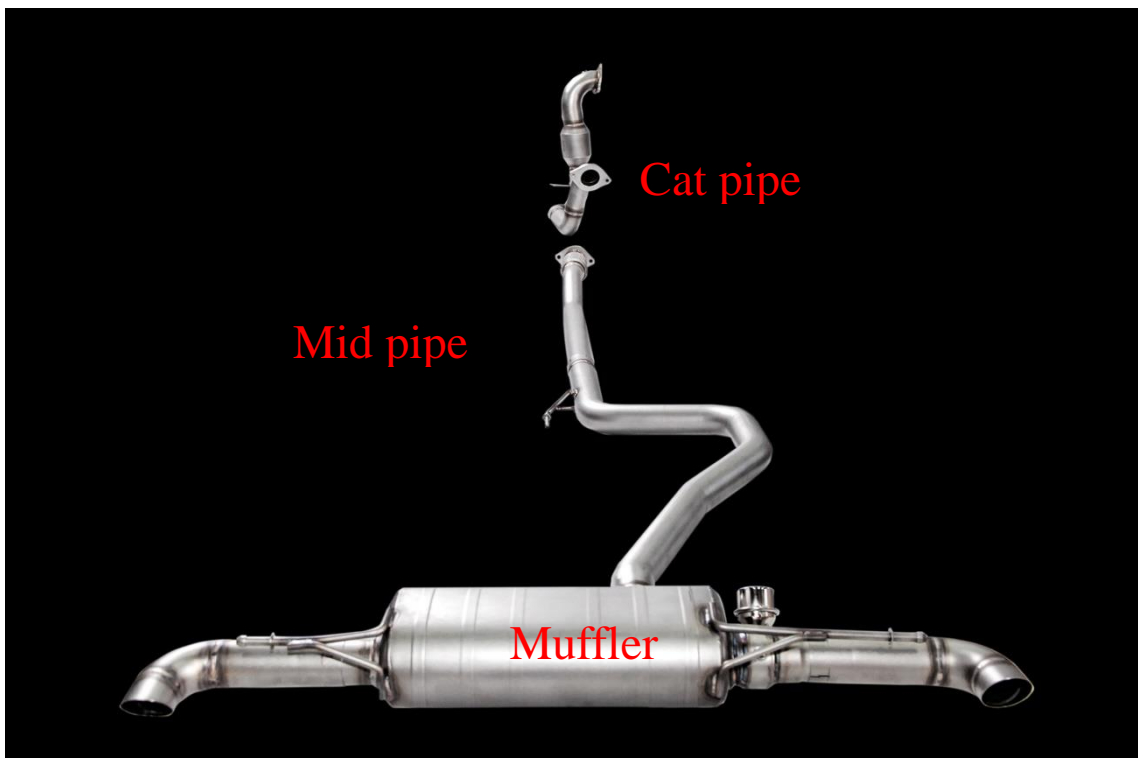
iPE developed exhaust systems based on the OEM exhaust to avoid issue with installation. Modern car keys and the vehicle itself have an inductive power transmission function, we suggest to keep the car key at least 5 meters away from the vehicle for safety purpose. Please wear insulated gloves to replace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

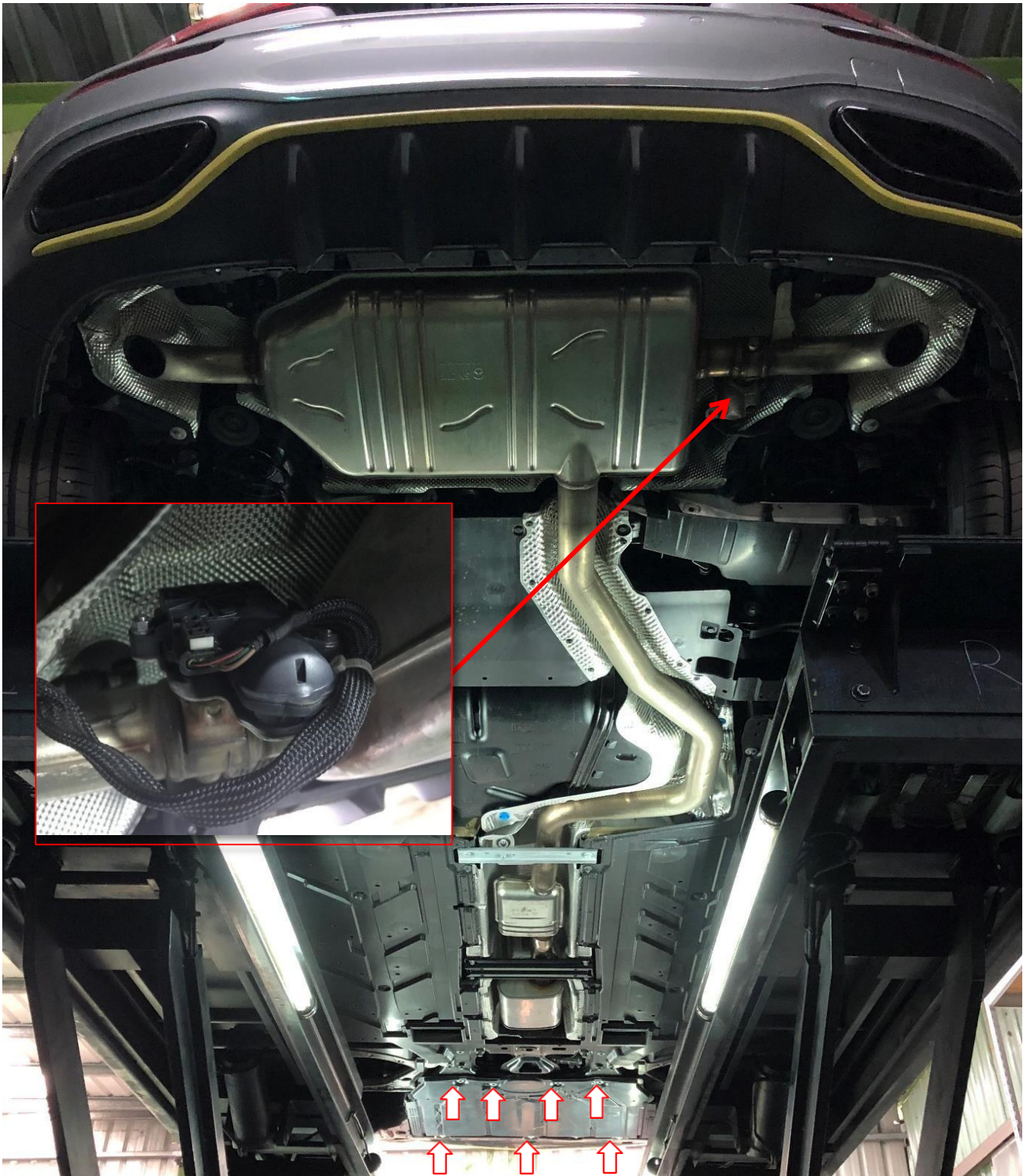
Mercedes-Benz W177-A250

Product assembly appearance

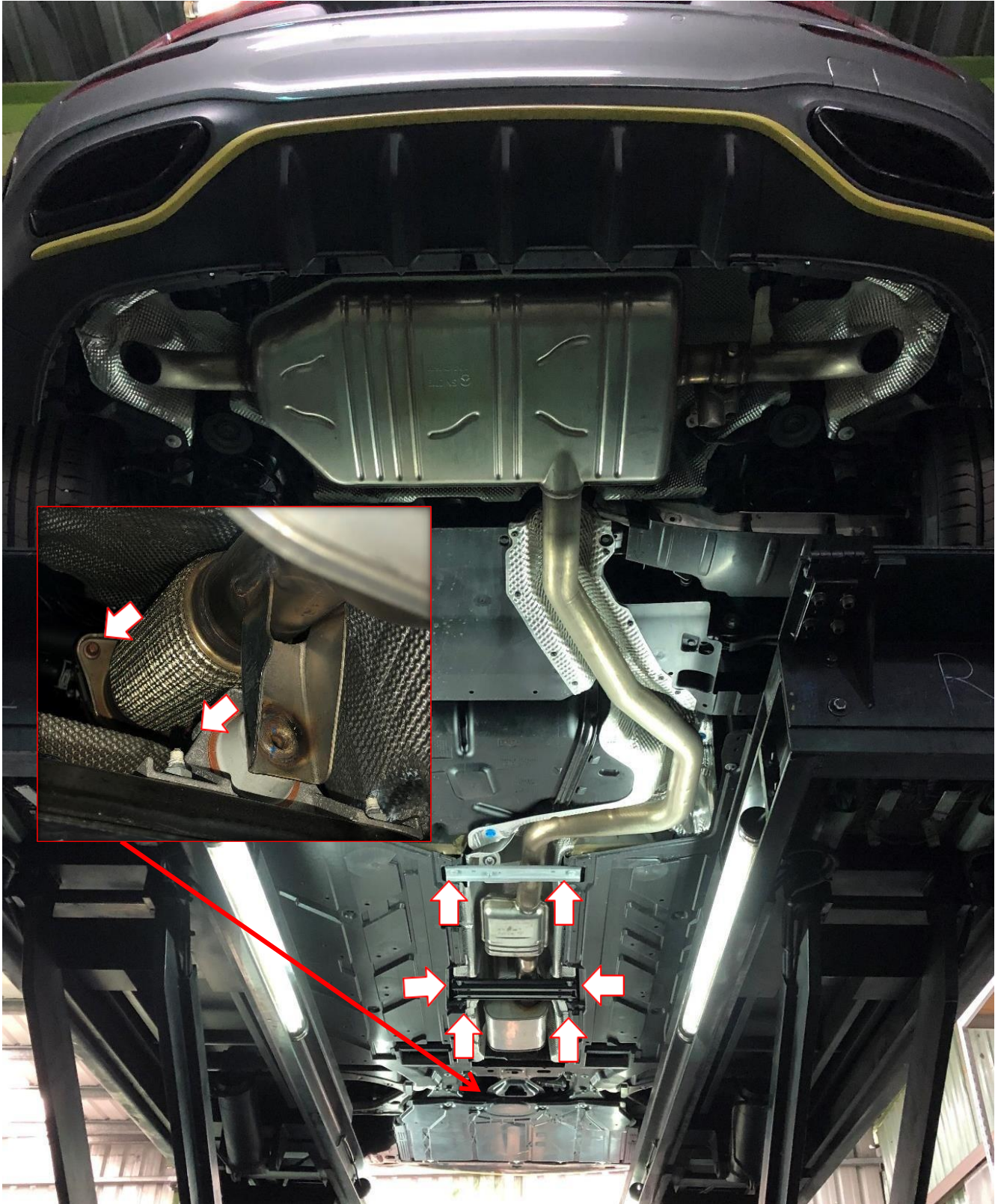


(1) Remove the original exhaust pipe

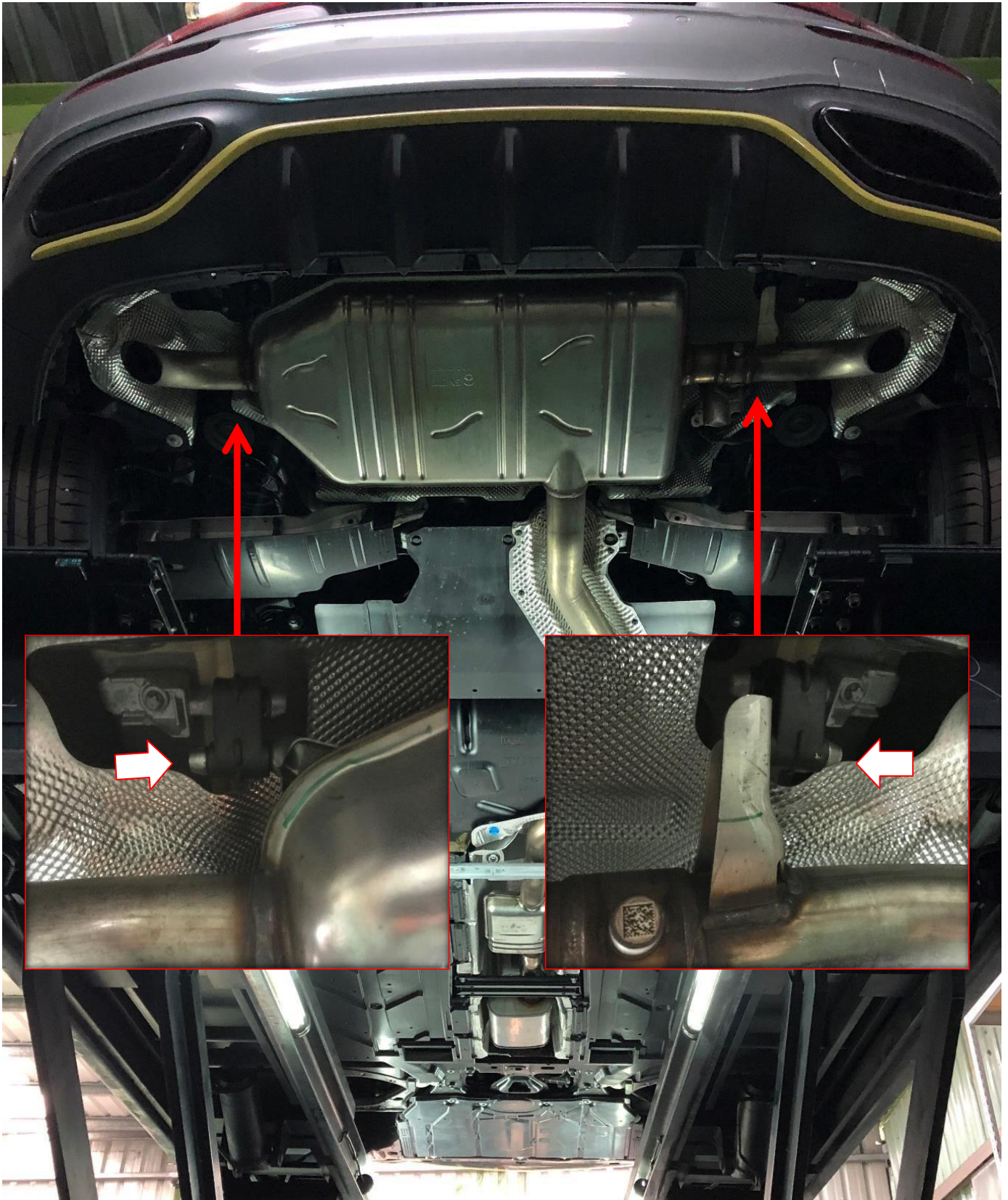
1. Remove the lower guard and the muffler valve control electronic plug.



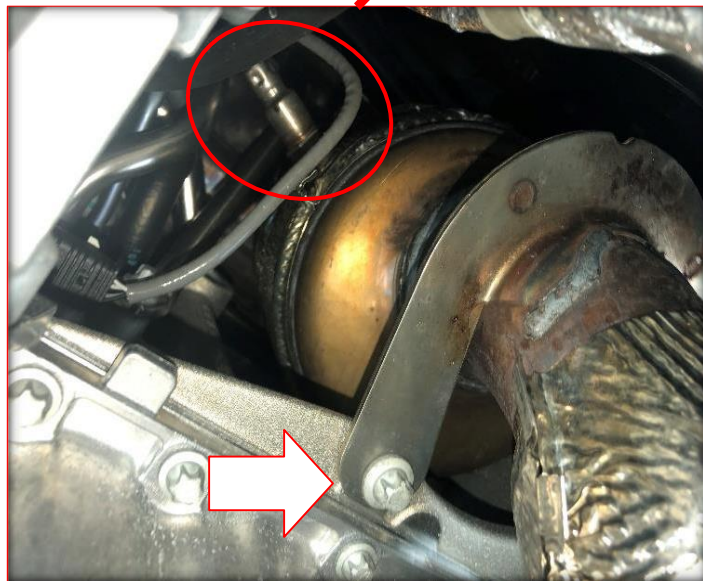
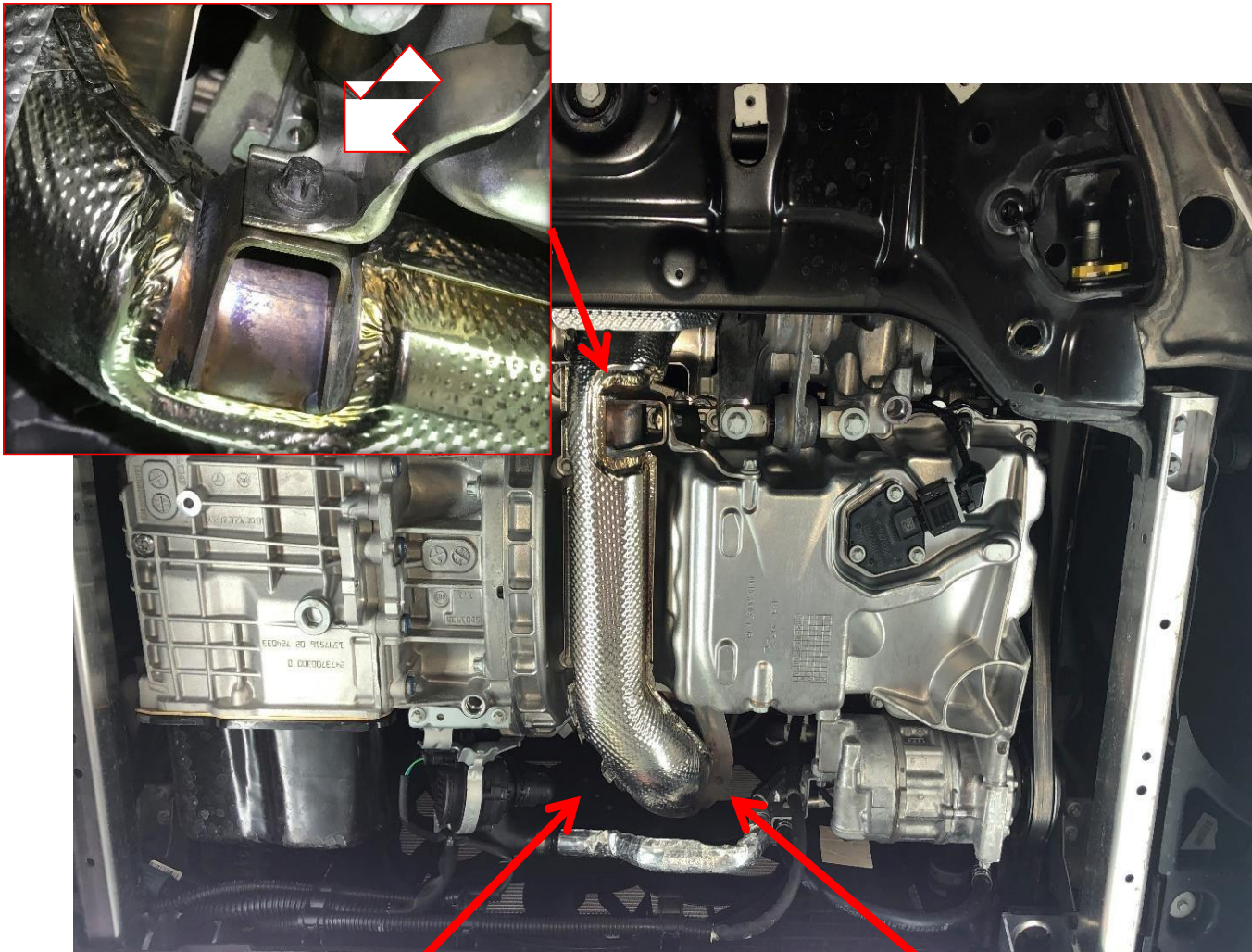
2. Remove the cat pipes and the front pipe retainer screw.
3. Remove the chassis support braces.



4. Remove the left and right bushes then remove the original exhaust pipes.

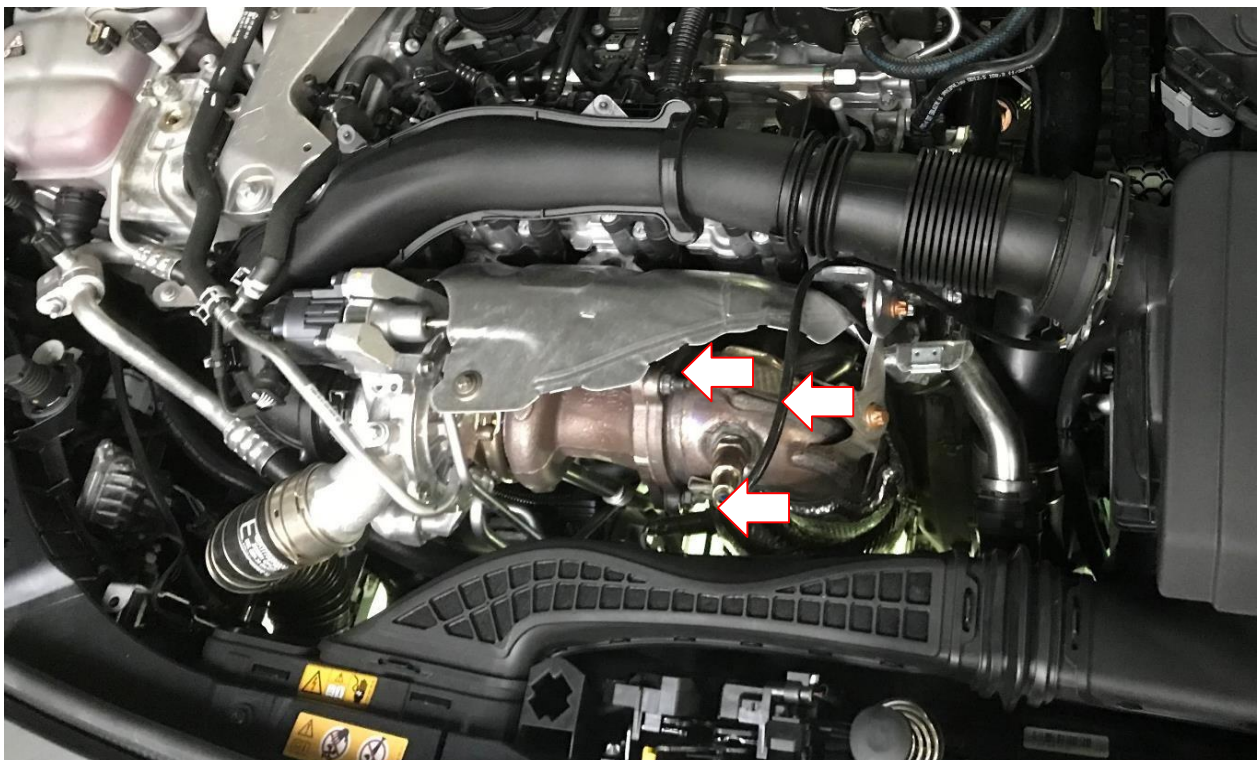
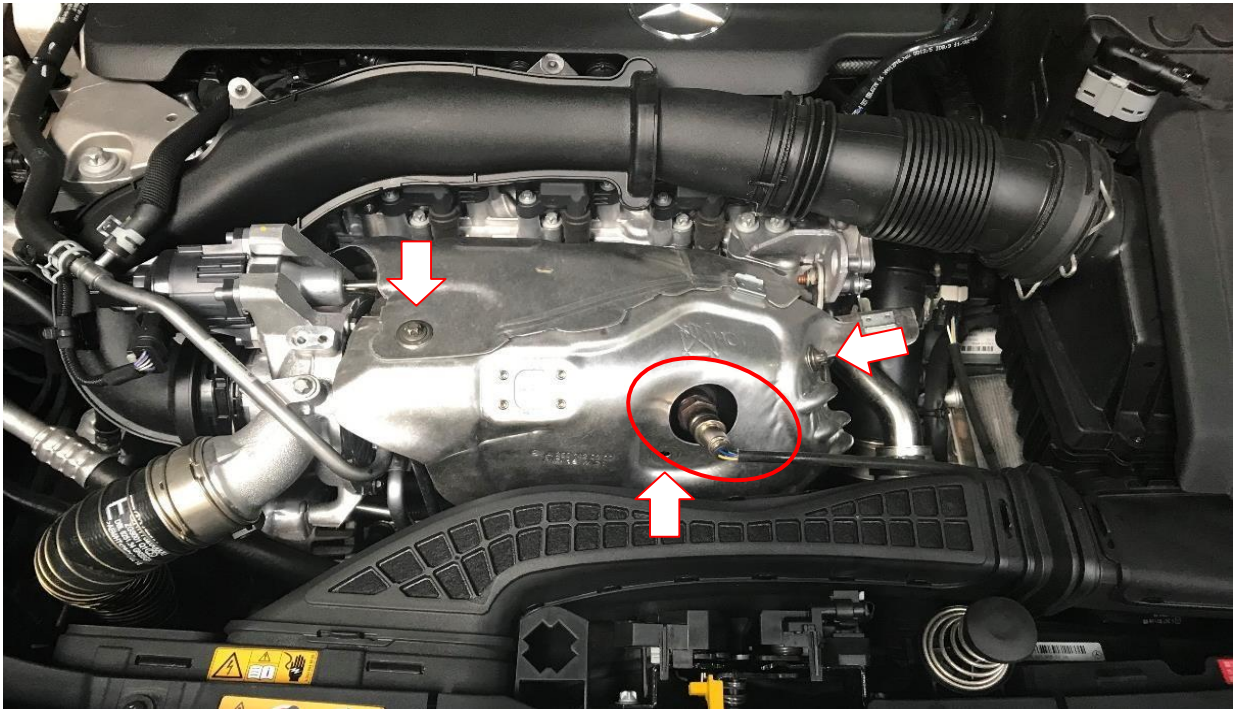


5. Remove the rear oxygen sensor and cat pipes bushes screw.



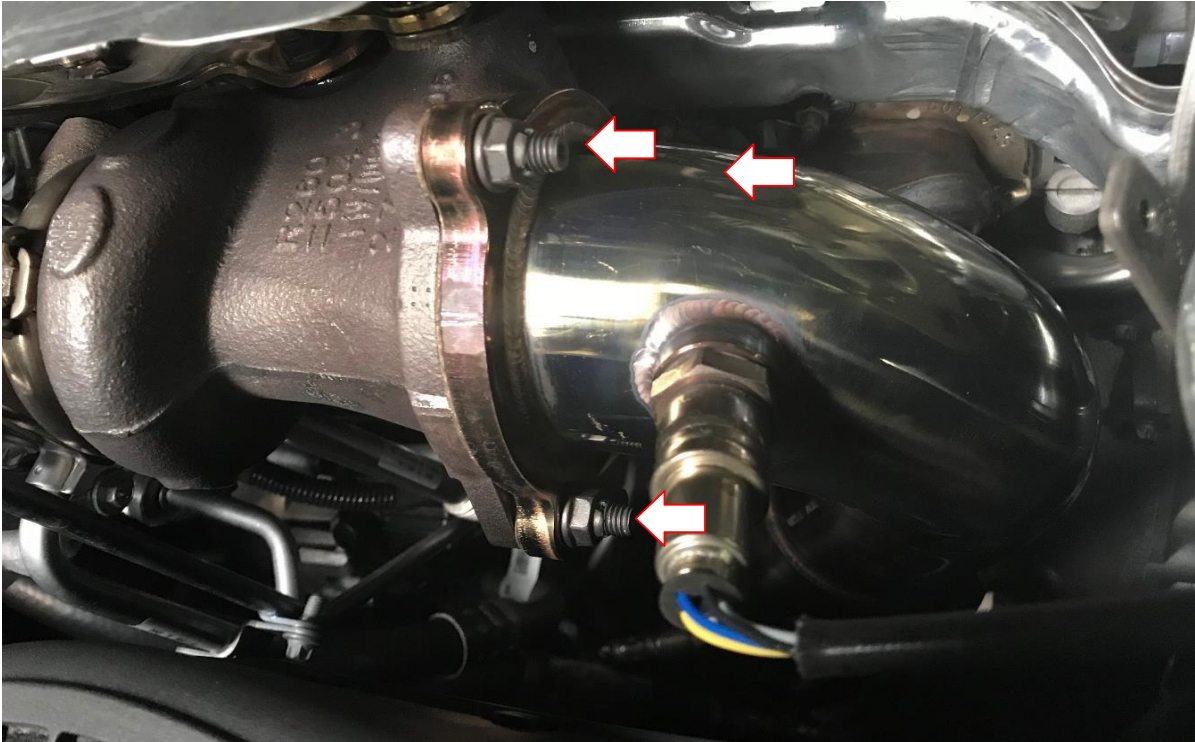
6. Remove the front oxygen sensor and heat insulant cover.

7. Remove the cat pipes retainer screw, fan, radiator, and original cat pipes.

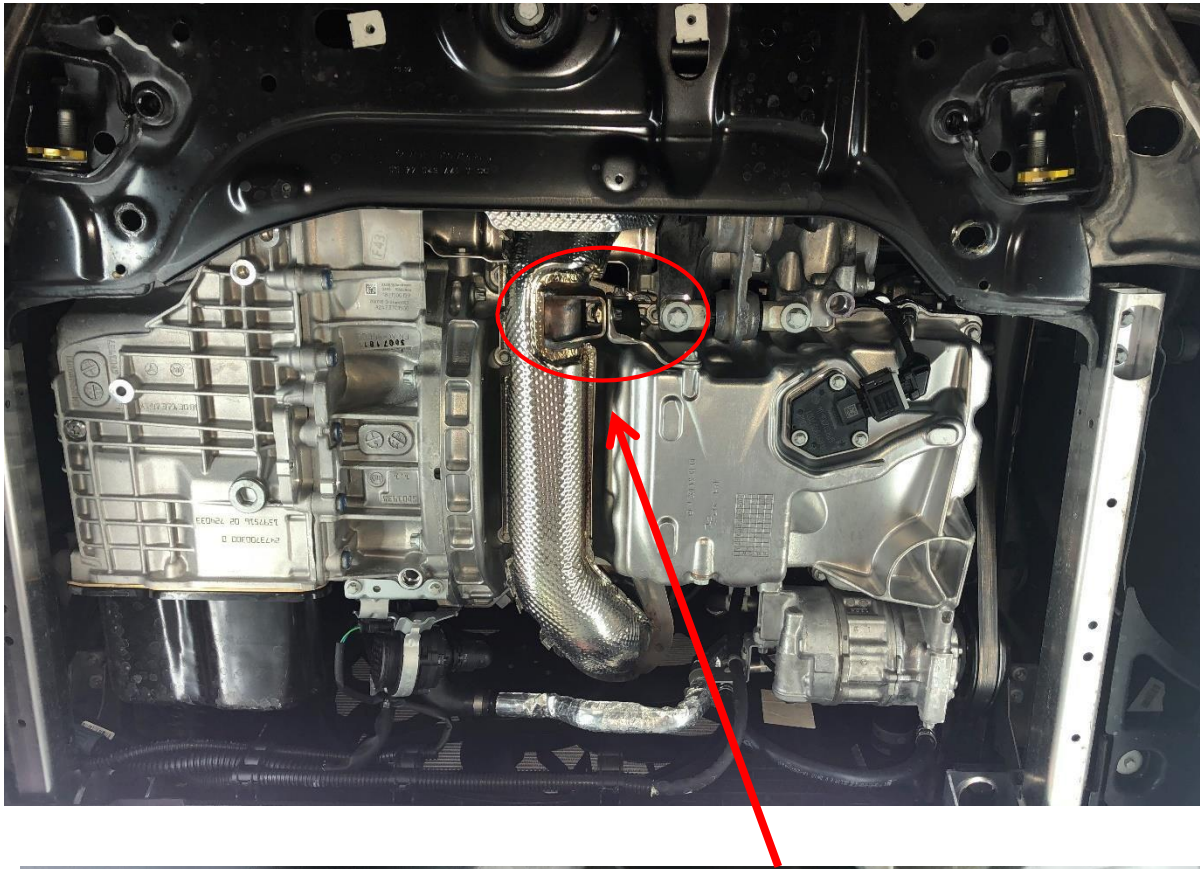


(2) Install the iPE exhaust system

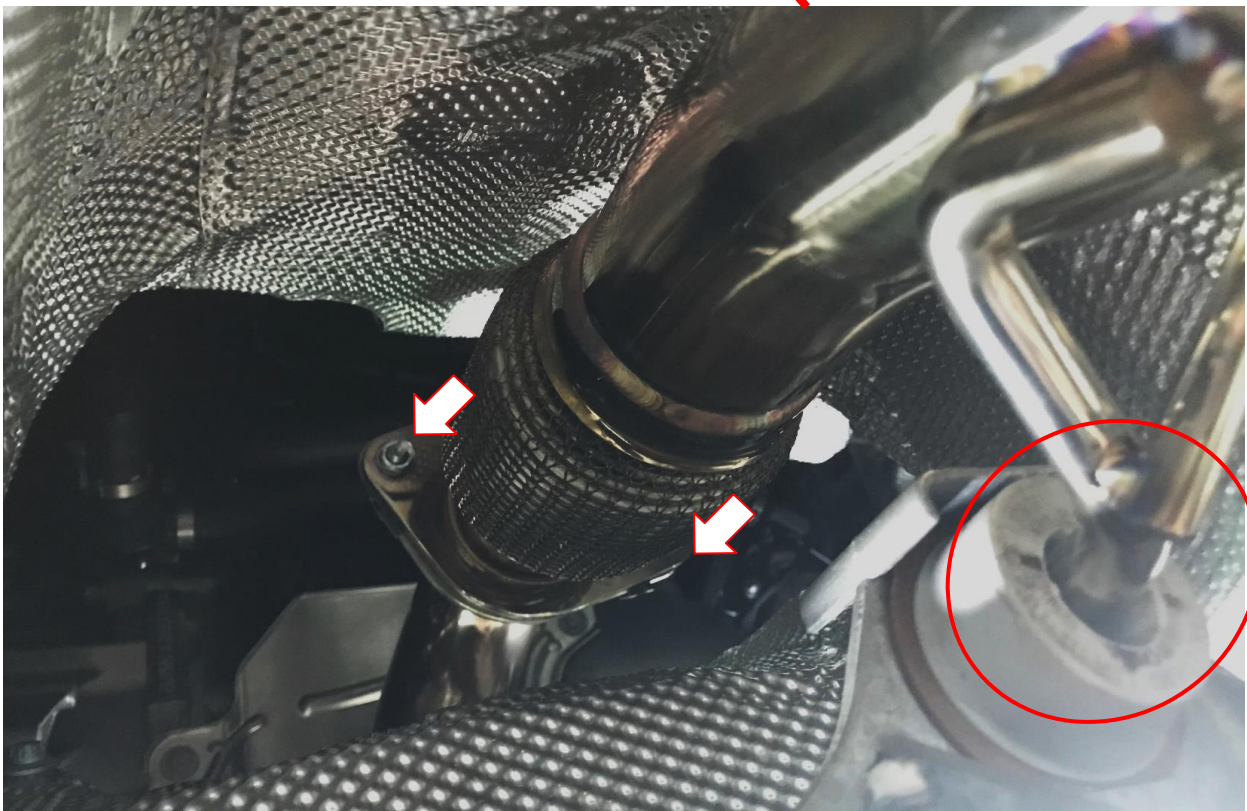
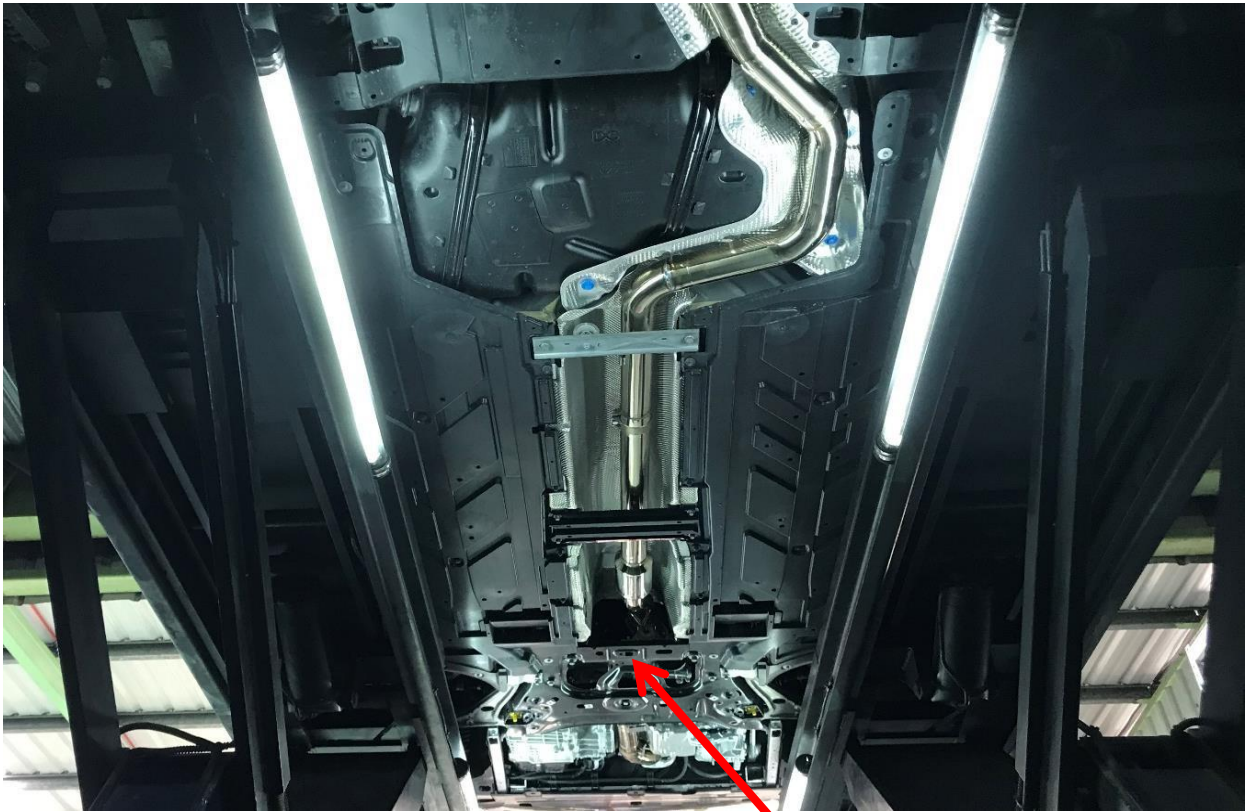
1. Refit the iPE cat pipe retainer, bushes with screws, then reinstall front and rear oxygen sensors, clamps.



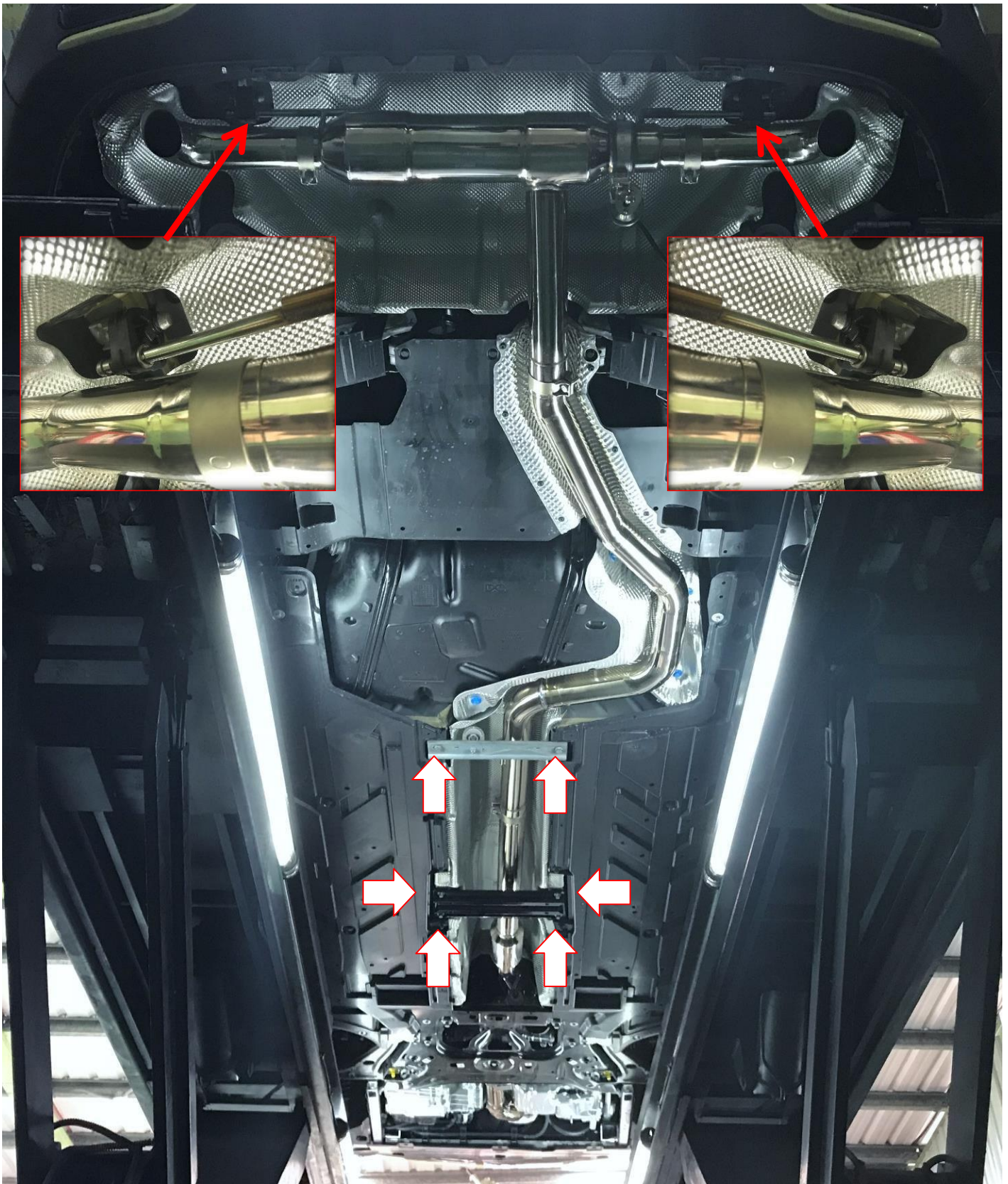
2. Screw tight the cat back bushes.



3. Screw tight the front pipe and cat pipe with retainer, and reinstall the front pipe bushes.



4. Install the mid pipe, muffler bushes, and screw chassis support braces.



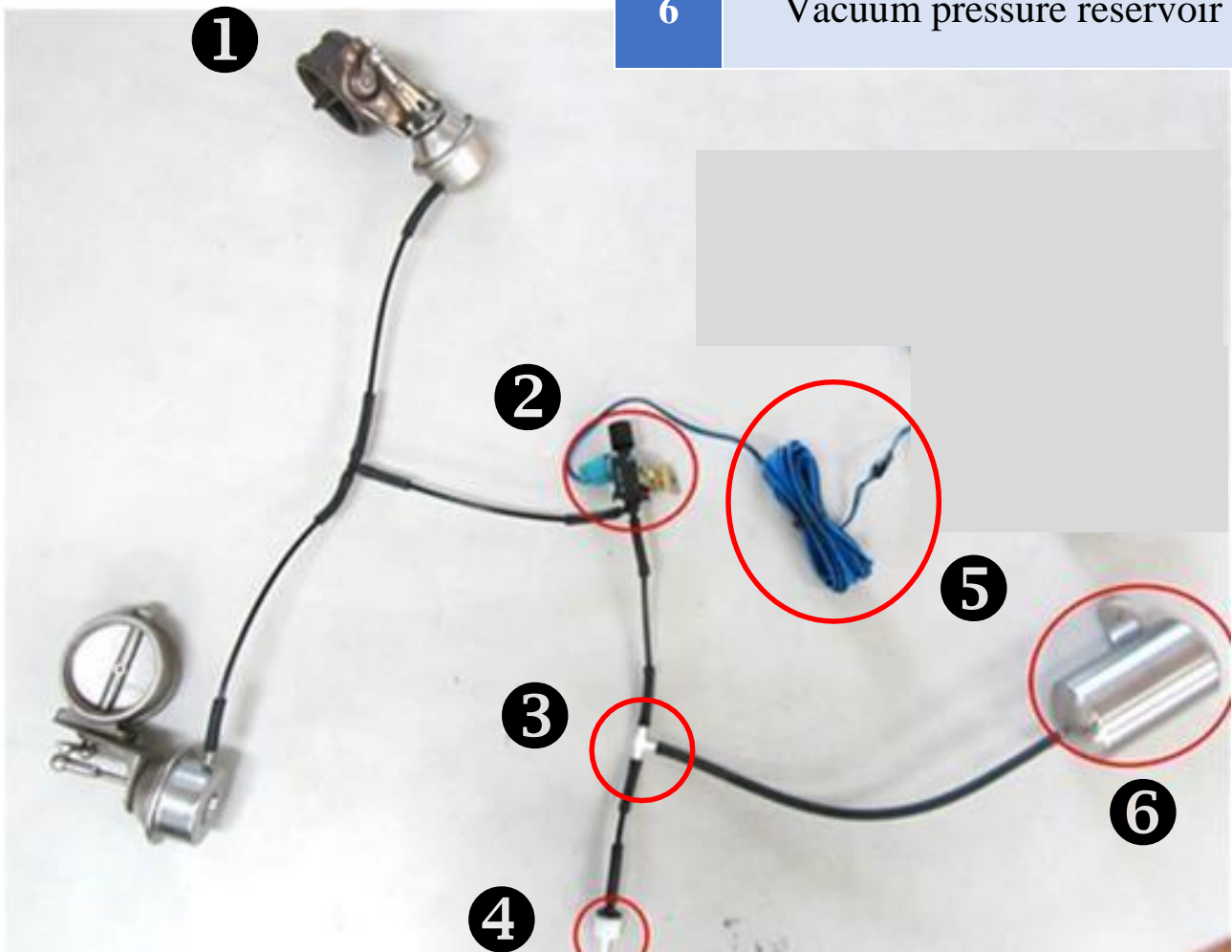
5. Make sure to adjust the gap between exhaust and chassis support braces at least 15mm. Adjust the exhaust from the front to back; adjust all parts to proper position then screw the bushes and clamps.

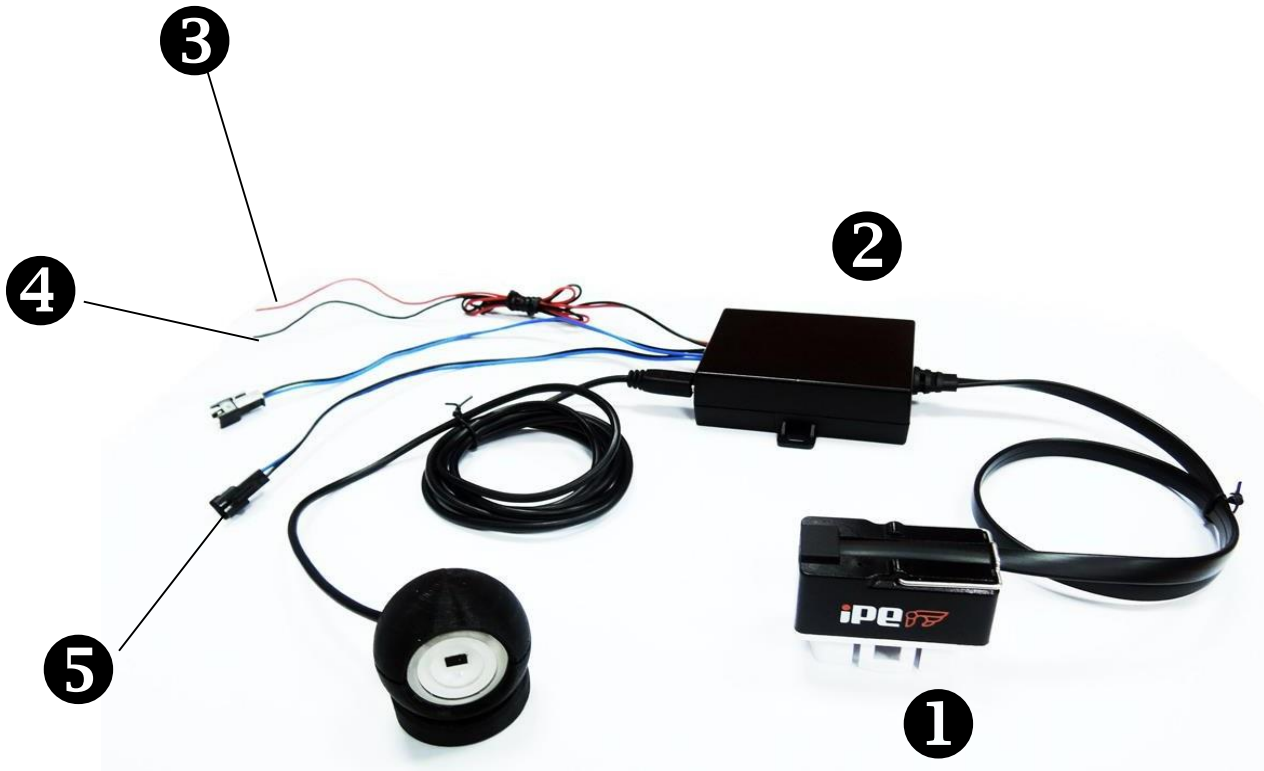


(3) Install the control box and wiring

※ The number of exhaust valves must be based on the actual exhaust pipe design.

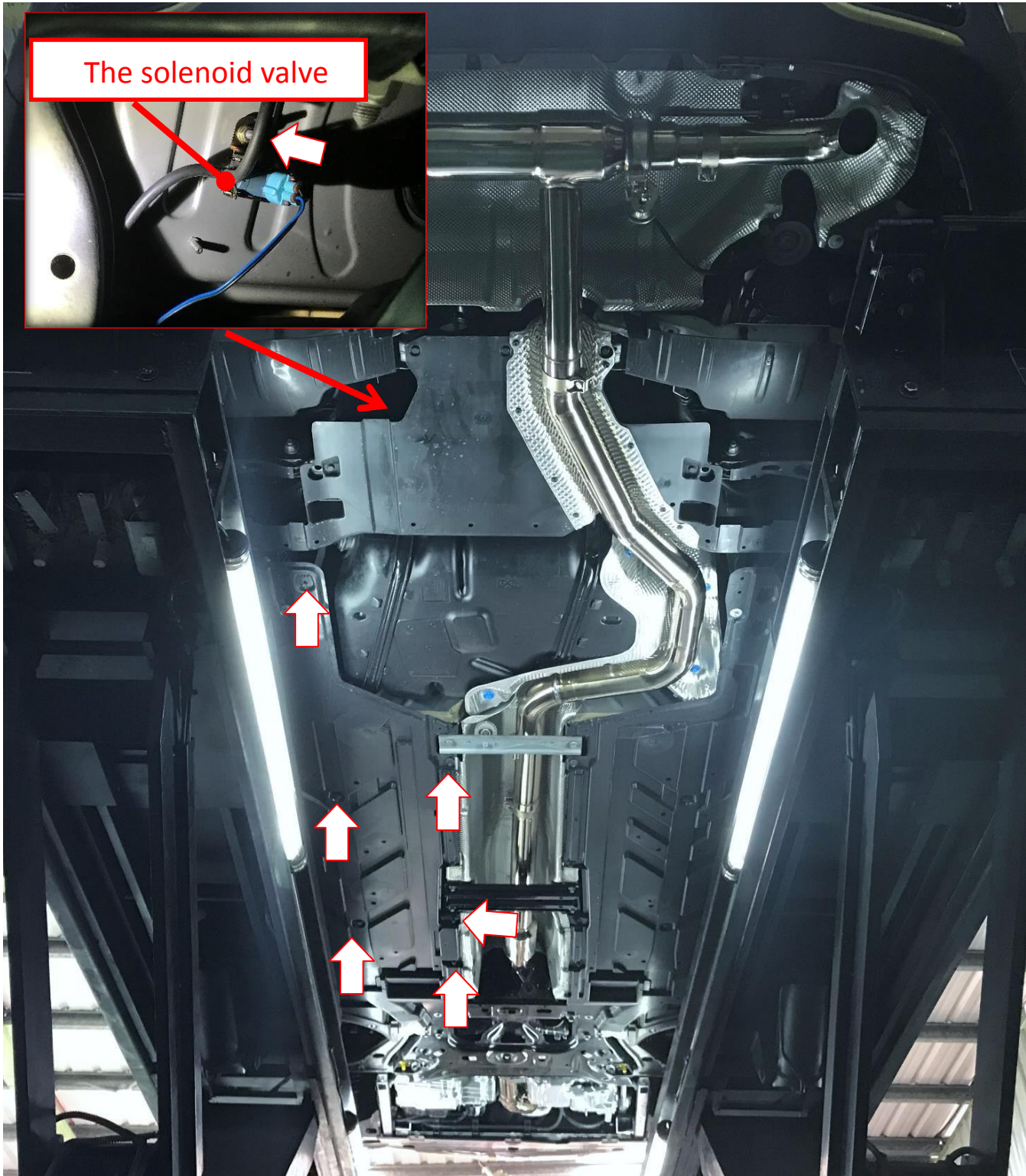
No.	Product
1	Exhaust valve
2	Vacuum solenoid valve
3	Three-way connector
4	One way valve
5	Solenoid valve connection wire
6	Vacuum pressure reservoir



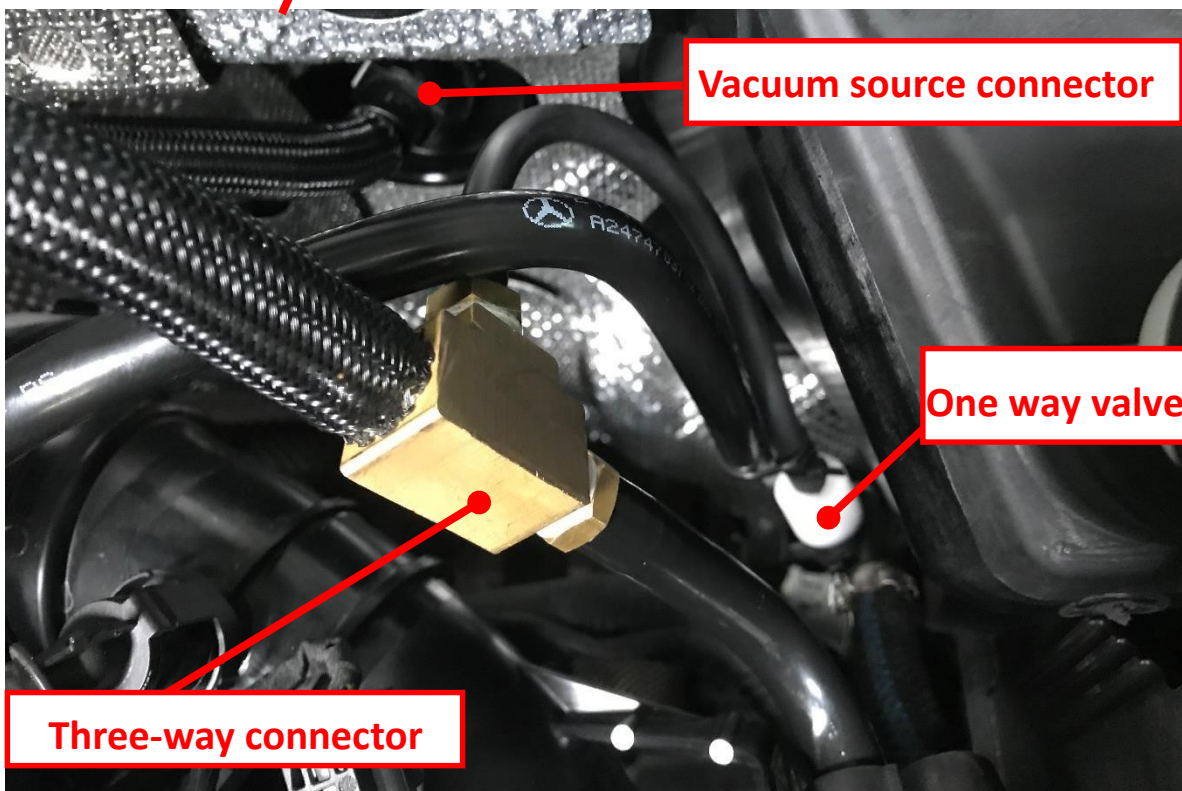
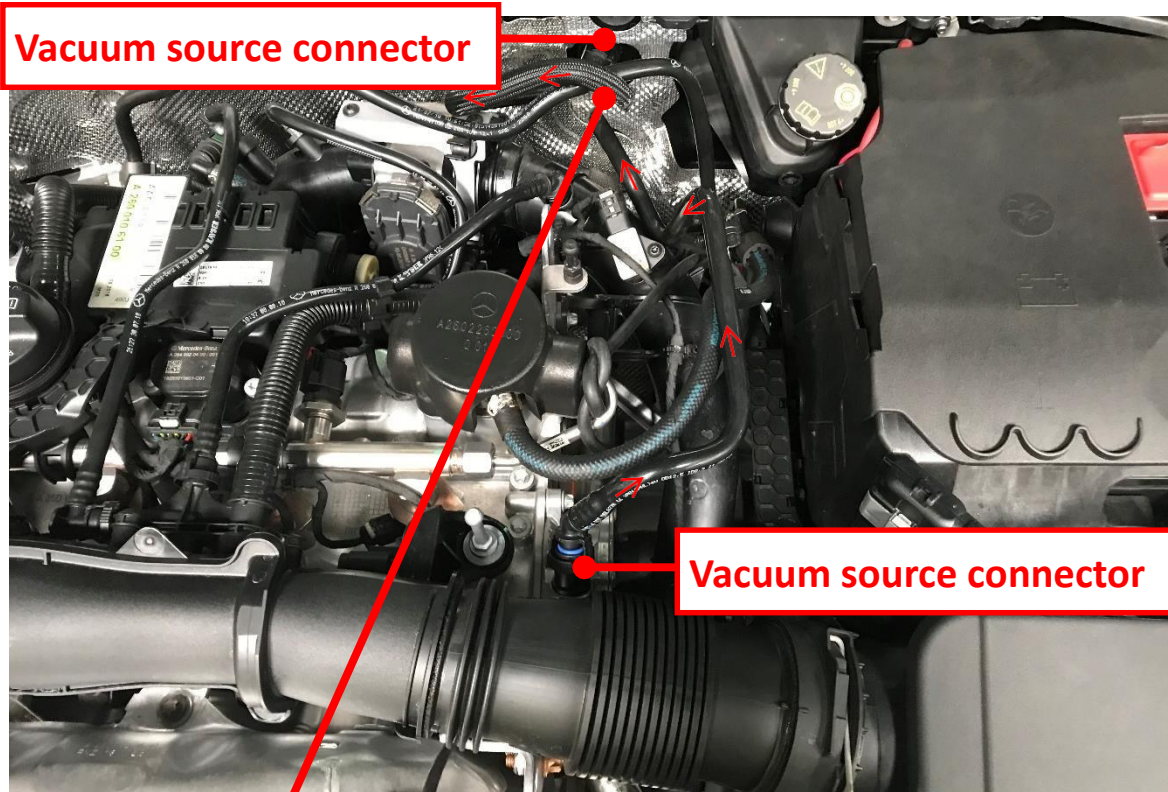


No	Product	No	Product
1	OBDII connector	4	Black (negative)
2	Solenoid valve controller	5	Blue black (solenoid valve)
3	Red (ACC positive)		

1. Remove the left guard and screw solenoid valve. Connect vacuum tube with vacuum valve and front vacuum source.



2. Use the three-way connector to link the vacuum source also attach with the one way valve.



3. Connect solenoid valve control line through the steering firewall.

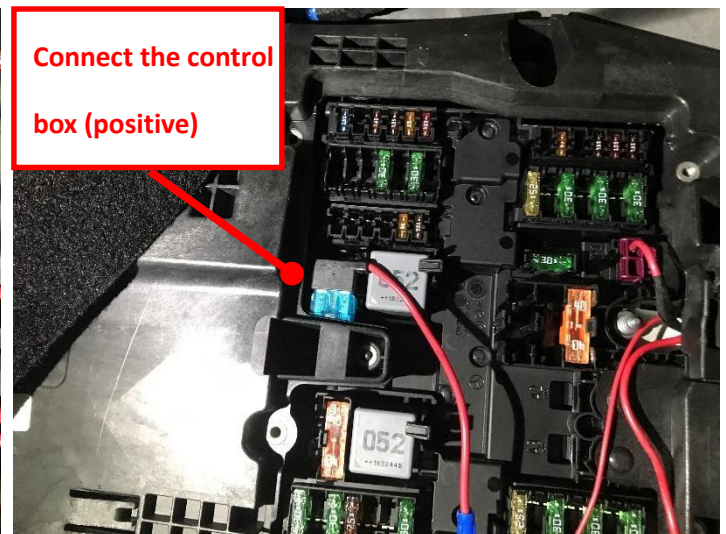
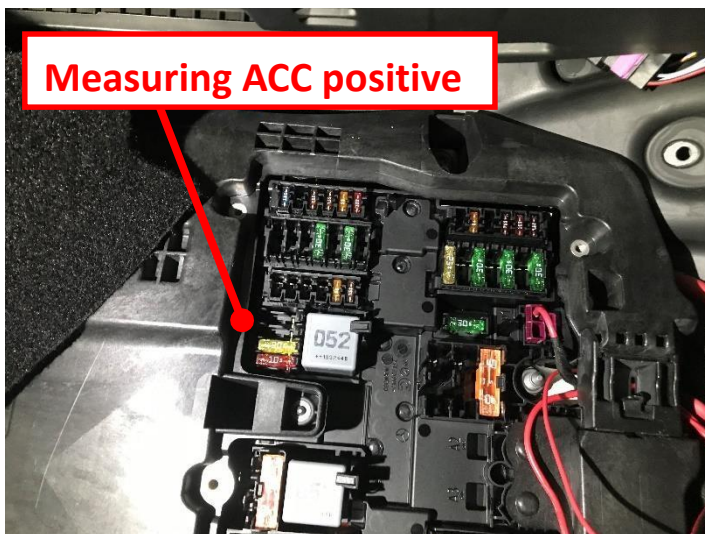


Warning: Pay attention to the steering column to prevent damage to the wires.

4. Removed the fuse box cover on the passenger side.



5. Measure the ACC positive power connection control box red power line (positive)



6. Install control box and OBD II on the driver side.



7. After installation, make sure the valve is working without problems, and reinstall the lower guard plate, engine cover trim, etc.