



# iPE Exhaust

Automotive exhaust system engineering

***Mercedes-Benz***

***W205-C300***

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](mailto:info@ipe-f1.com).

## 2.Tools required for the installation

Tool name	Tool appearance
<b>Rust inhibitor / lubricant</b>	
<b>Hexagon socket</b>	
<b>Hexagon wrench</b>	
<b>Torque wrench</b>	

### 3. Mercedes-Benz C300(W205) 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 bushes and mid pipe connect clamps.(Fig.1,2)



Fig. 1



Fig. 2

**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 lower guard screw.(Fig.3A)

3. Remove the pull rod.(Fig.3B)

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

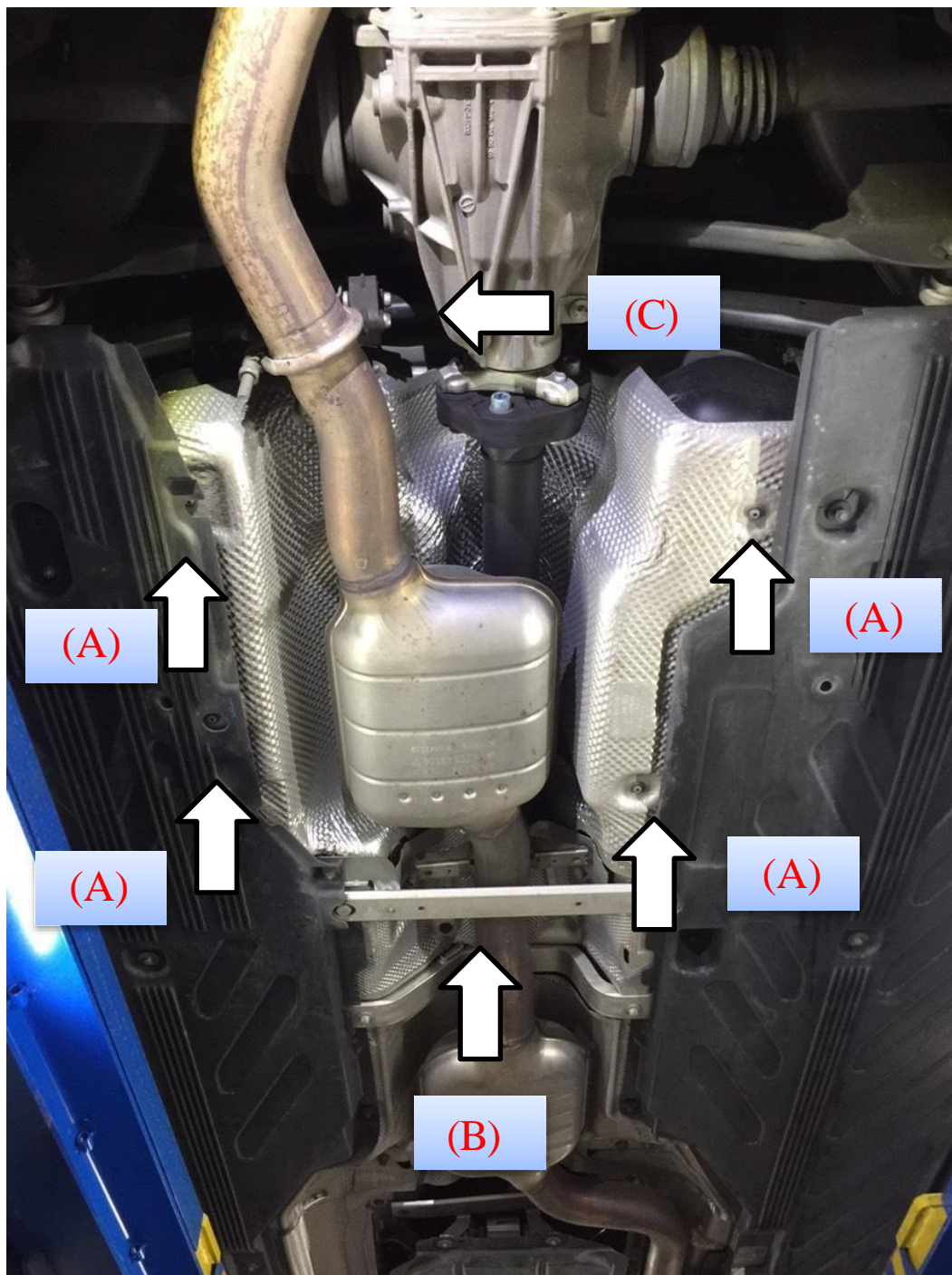


Fig. 3

4. Remove the two front lower guard. (Fig.4,5)

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

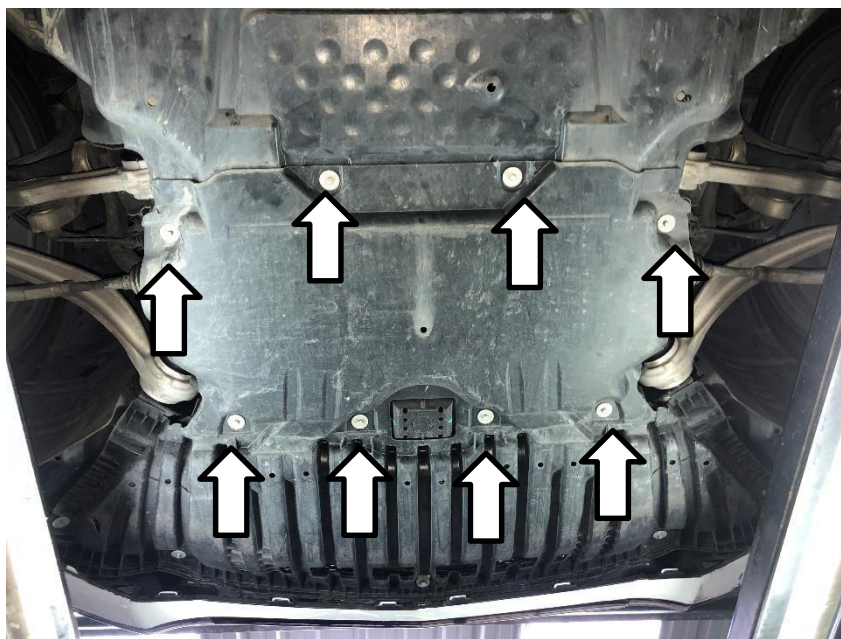


Fig. 4

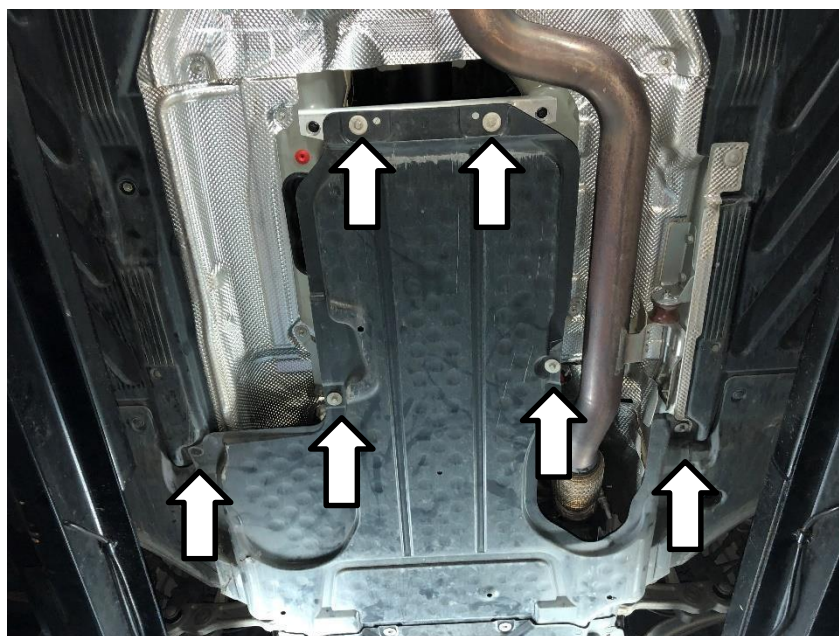


Fig. 5



5. Remove the front bushes screw.(Fig.6A)
6. Remove the clamps at the junction of the front pipe and the catalyst.  
(Fig.6B), and remove the mid pipe bushes (Fig3C) to remove the original exhaust pipe.

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

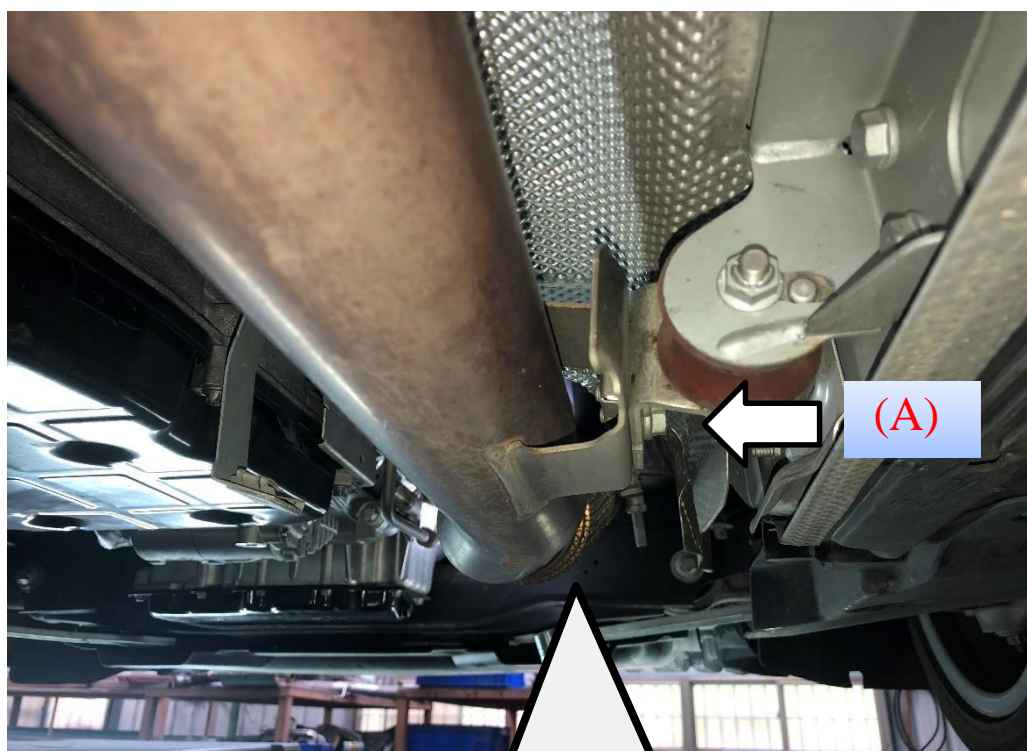
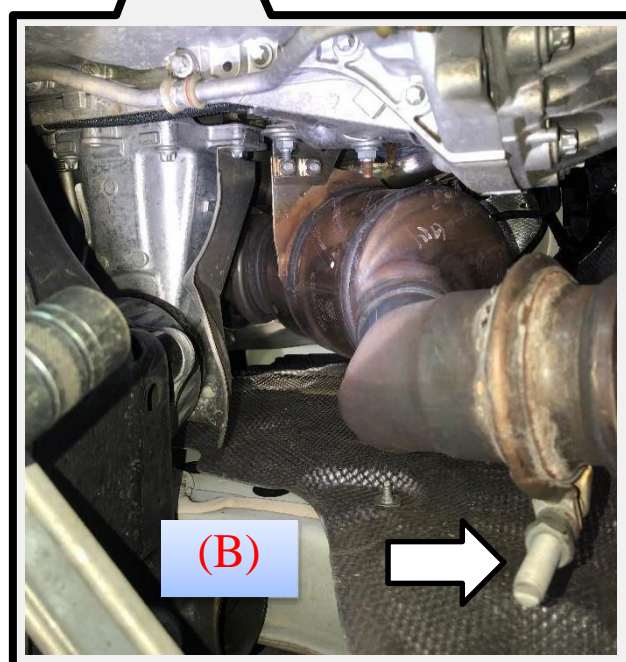


Fig. 6



7. Remove the engine upper guard (Fig.7) and the air filter assembly (Fig.8)



Fig. 7

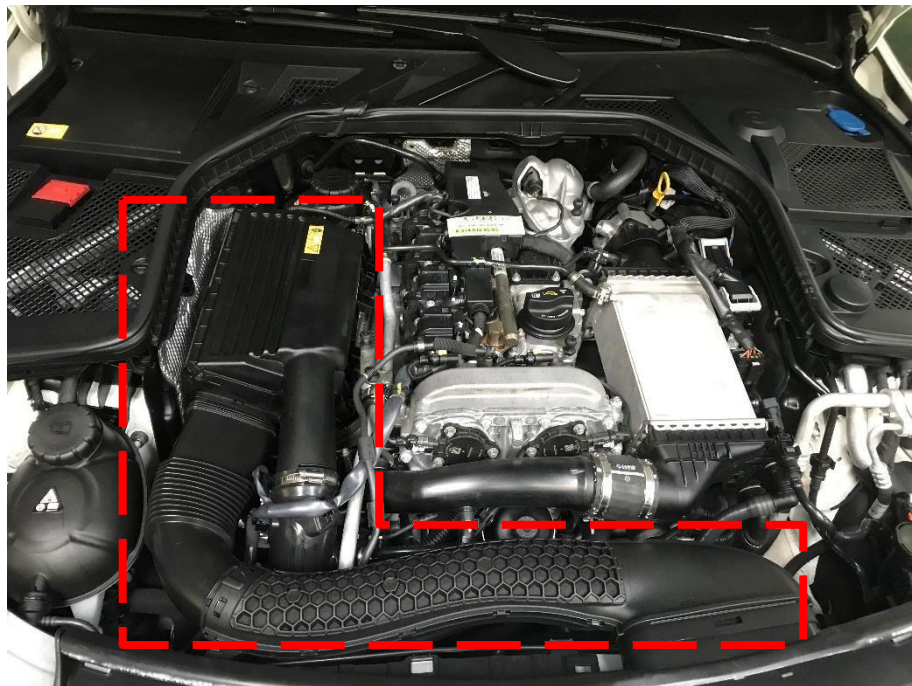


Fig. 8



8. First the oxygen sensor plugs can be unplugged and removed the catalyst and the oxygen sensor.

9. Remove the cat pipe clamp screws (Fig.9) and bushes screw to remove the rear catalyst.

※Use an appropriate tool to remove the oxygen sensor to avoid wire damage!

Waring: do not use lubricant or rust remover organic solvent when the exhaust has high temperature!



Fig. 9



Fig. 10

## 5. Steps and focused points for installing the iPE exhaust

1. Install the front and rear oxygen sensor in cat pipe.
2. Install the iPE front cat pipe, bushes, clamps and oxygen sensor plug install to positioning. (Fig.11)

**Warning: lock these screws with proper torque setting.**

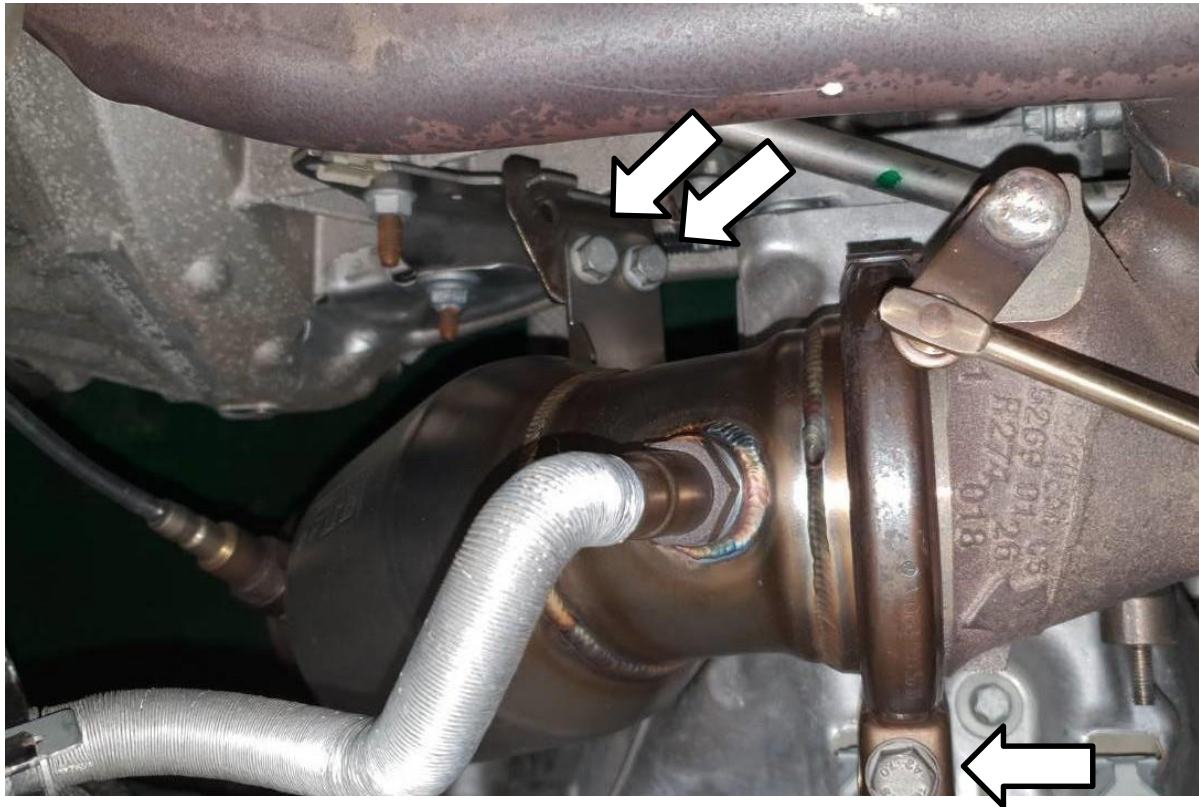


Fig. 11



3. Insert the front pipe into the catalyst (Fig.12) and lock the clamp without screw (fix the front pipe) then lock the bush screws. (Fig.13)

**Warning: lock these screws with proper torque setting.**

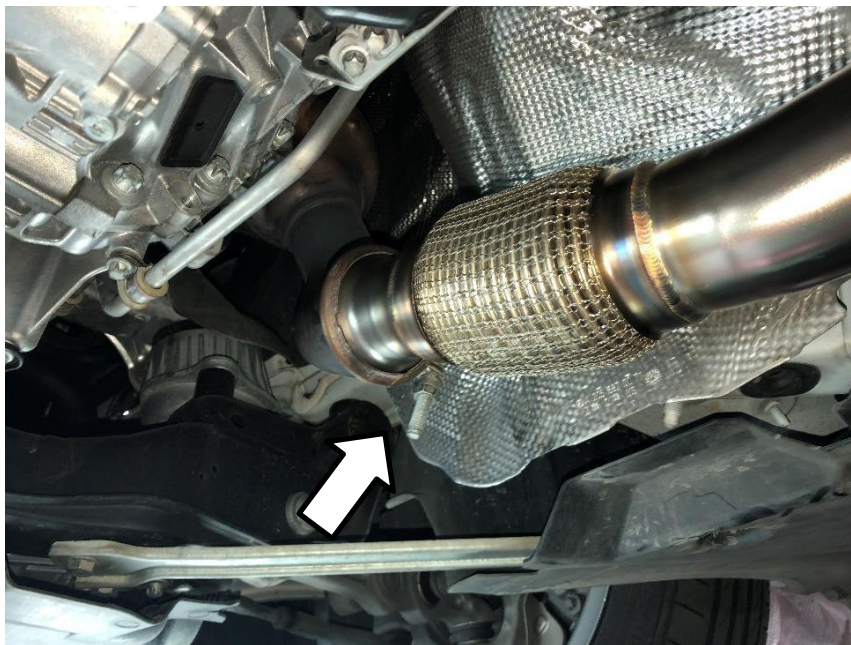


Fig. 12

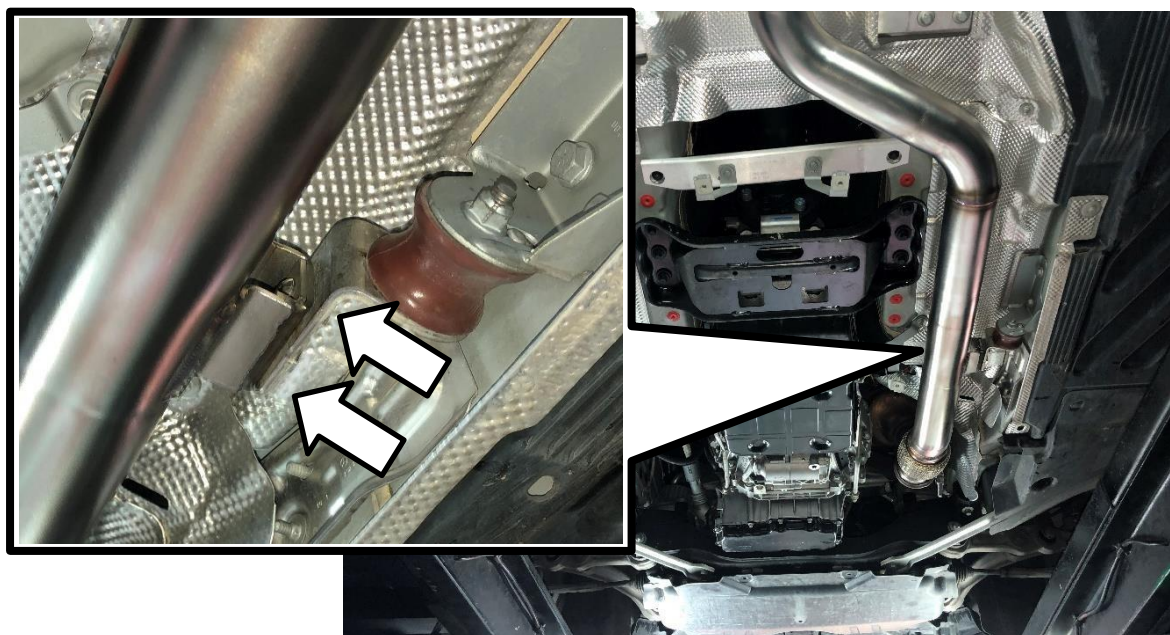


Fig. 13

4. Install the mid pipe to the positioning and put the bush back to the vehicle and the clamp without screw. (Fig.14A)
5. Install the chassis support and make sure to the gap between exhaust and chassis support at least 15mm. (Fig.14B)
6. Install the muffler to the positioning, and lock the bush returned to the vehicle. (Fig.14C)
7. Adjust the exhaust from the front to back; adjust all parts to proper position then screw the bushes and clamps.

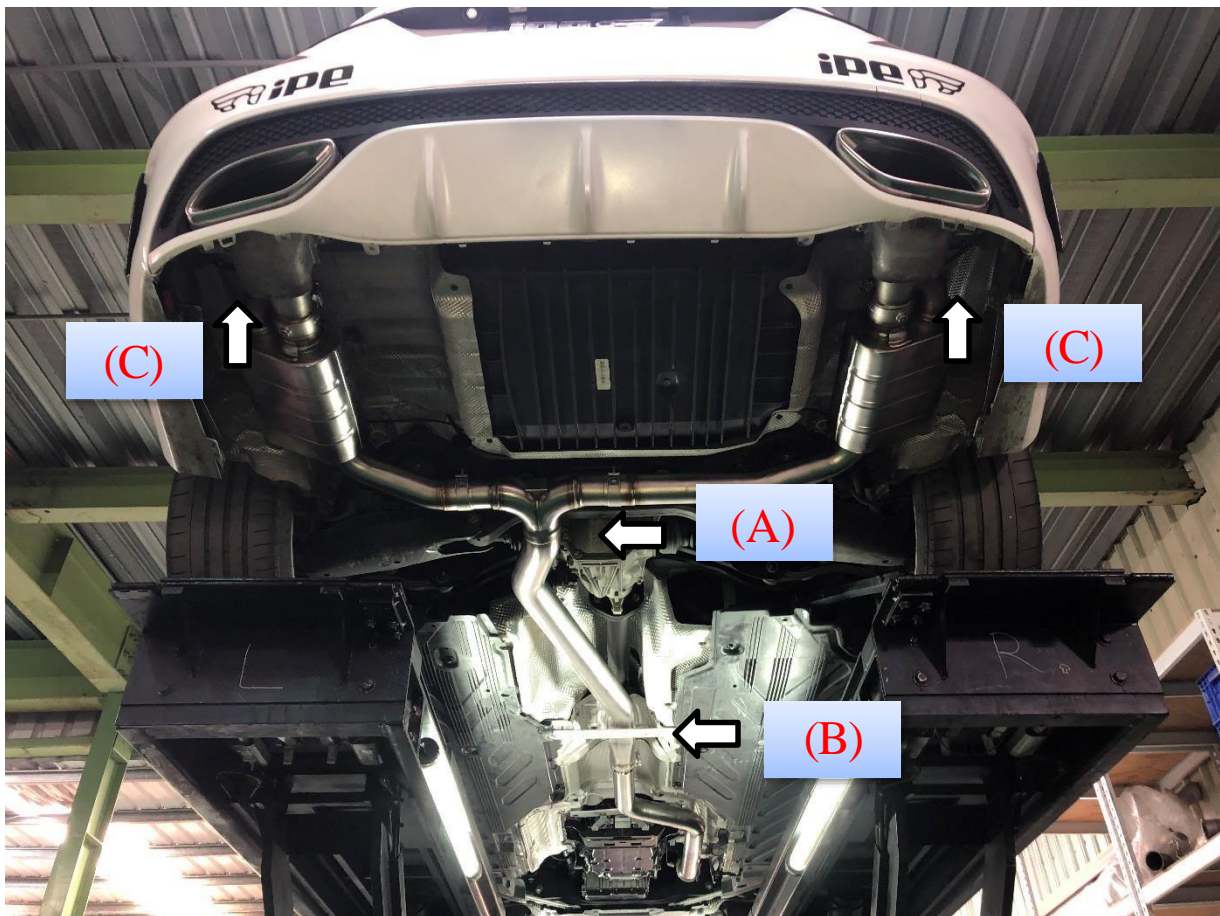
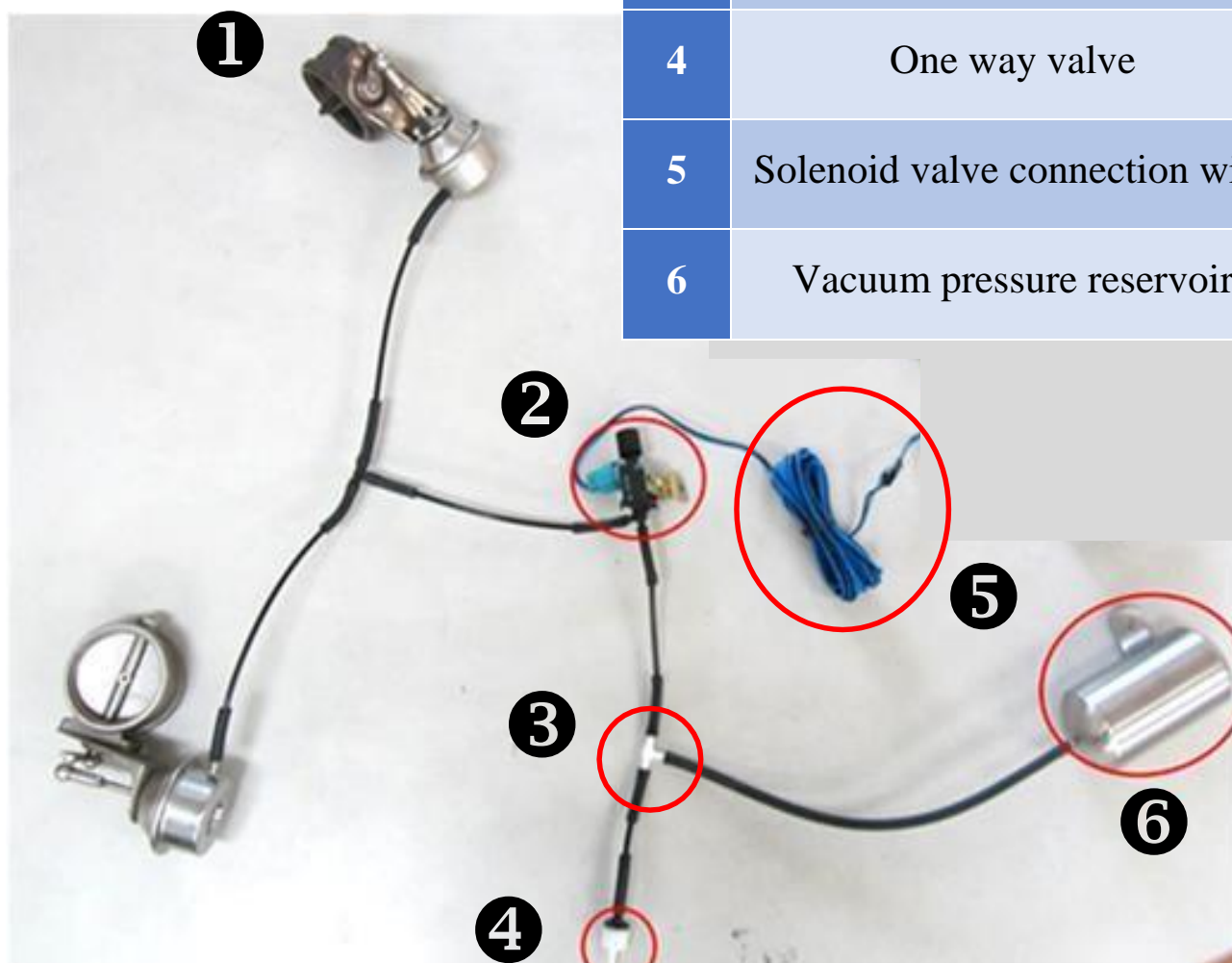


Fig. 14

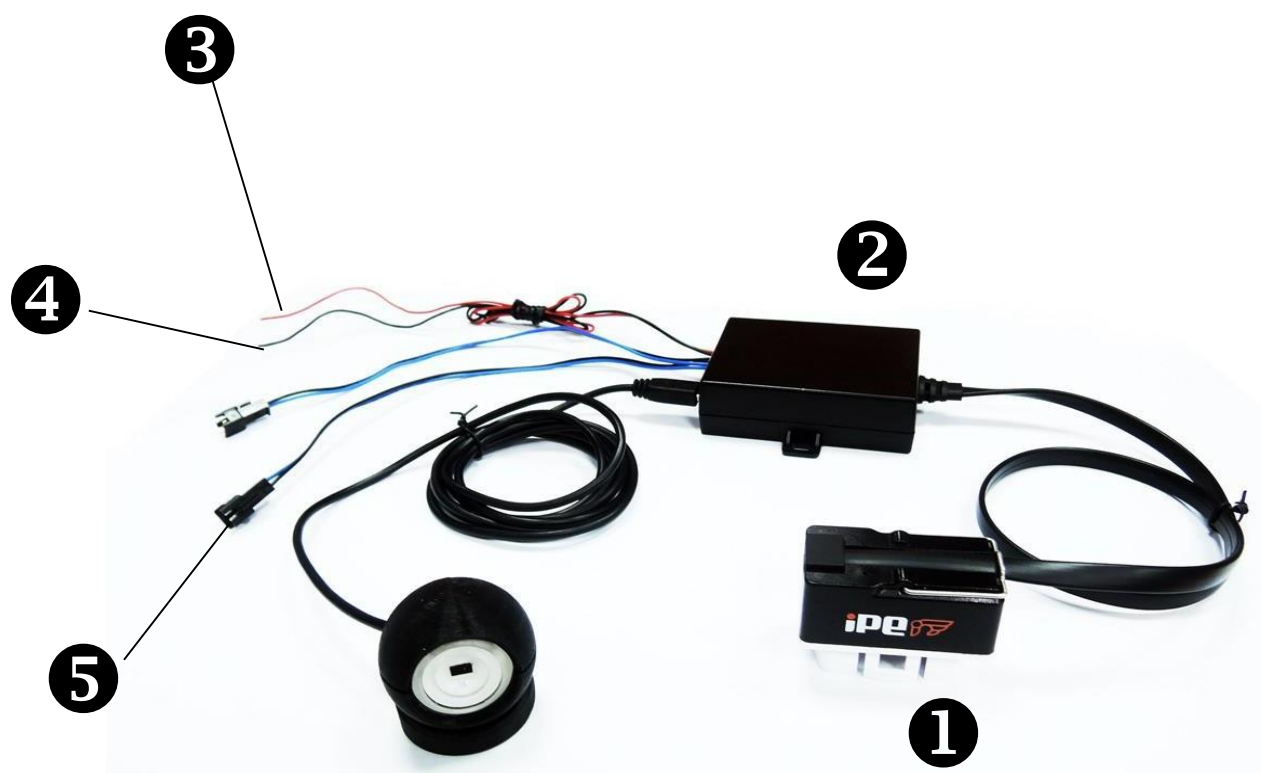
## 6. Install the control box and wiring

※ 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. Install the positive power supply of the host directly under the fuse box 032 relay in the cab (Fig. 16) the negative pole can be locked on the screw (Fig.15) and connected to the OBD II.

**Warning:** Confirm that the positive and negative poles are correct to avoid burning the circuit.

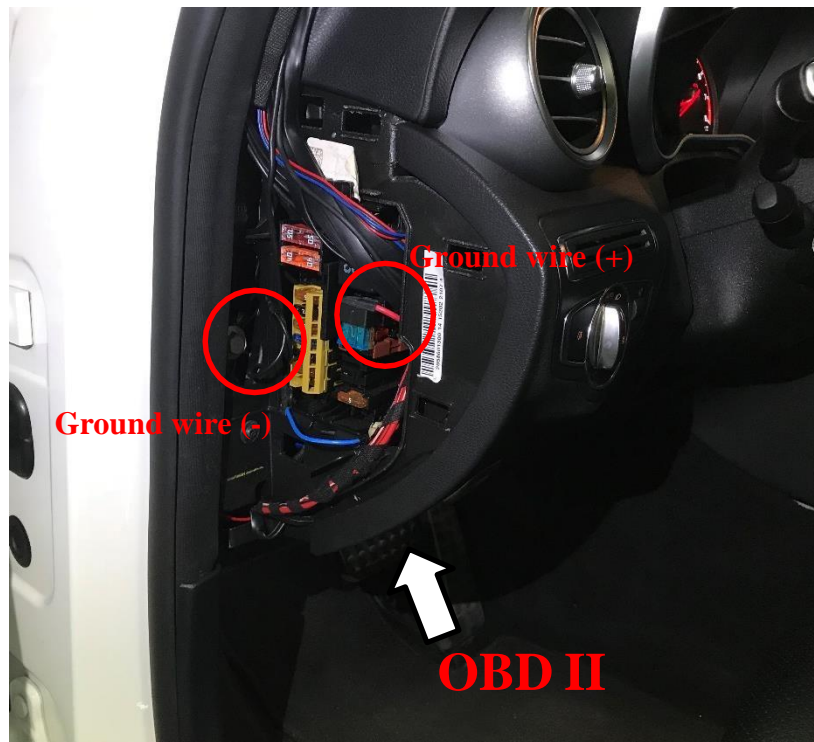


Fig. 15

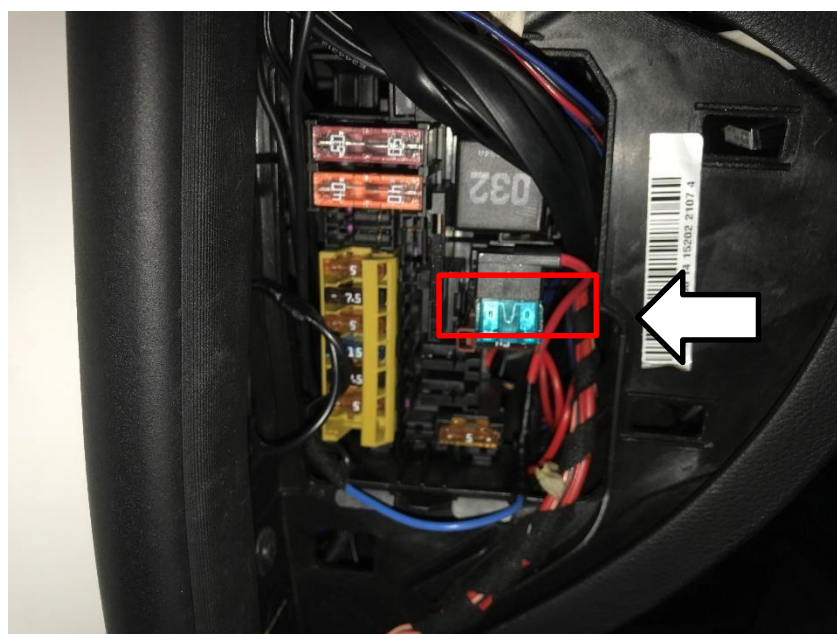


Fig. 16

2. Install vacuum pressure reservoir (Fig.18), one way valve, vacuum solenoid valve (Fig.17) fixed to the beam above the differential and connected to the vacuum tube.
3. Connect the vacuum tube to the exhaust valve and various vacuum components.

**Warning:** The connection wire and vacuum tube must be fixed to avoid damage caused by the rotation of the transmission shaft.



Fig. 17



Fig. 18



4. Remove the original L-shaped vacuum tube and use the three-way connection. (Fig.19)
5. The solenoid valve control line can pass through the line seal ring from inside the vehicle. (Fig.20)
6. After checking the wiring, replace the lower guard in order. ( refer to page 8)

**Warning: Make sure the wires and vacuum tubes are fixed to avoid damage.**



Fig. 19



Fig. 20