



# Honda Civic Type R

## Cat Back

### Installation Instructions

**XFORCE RECOMMENDS AN AUTHORISED PROFESSIONAL TO INSTALL ALL PRODUCTS**

**WARNING:** When working on any vehicle exercise extreme caution. Please allow the vehicles exhaust system to be cool enough to touch before removal. Failing to do so may result in severe burns. If working without a hoist refer to the vehicles manual to check correct lifting specifications. Always wear safety glasses, protective gloves and ensure your working in a safe area. Serious injury or death can occur if the correct safety measures are not followed.

**Attention:** Please read the instructions carefully. XFORCE will only warrant manufacturing faults. This does not extend to damage or breakage due to incorrect fitment.



## What's in the box

1. ES-HCR17-C1
2. ES-HCR17-C2
3. ES-HCR17-C3
4. ES-HCR17-C4
5. ES-HCR17-VMKR
6. 3 X TIPS
7. 2 X 2 BOLT FLANGE GASKETS
8. 2 X SLIP JOINT CLAMPS
9. VAREX WIRING HARNESS AND CONTROL BOX
10. 4 X NUTS AND BOLTS (FOR FLANGES)



## Required Tools and Equipment

1. Spanners and Sockets required 10mm, 12mm, 14mm, 15mm, 16mm
2. 3/8" Ratchet
3. 200mm long 3/8 Extension bar
4. Can of spray lubricant
5. Tube of O2 Sensor safe sealant for the 2 bolt Gasket and Slip Joint
6. 2-3 Rags for excess sealant
7. 1/2" Tension Wrench with 15mm deep socket, set to 80 Foot Pounds
8. Safety Glasses or Goggles
9. Protective Gloves
10. Safety Boots



## Step 1

**The entire fitting process must be conducted by a professionally trained technician (this also includes hoist operation).**

1 Raise vehicle on a 2 post hoist making sure hoist arms are in the correct lifting positions (as per owners manual) and that you or someone else isn't under the vehicle while hoist is moving. Once the Vehicle is at a workable height engage the hoist safety locks.



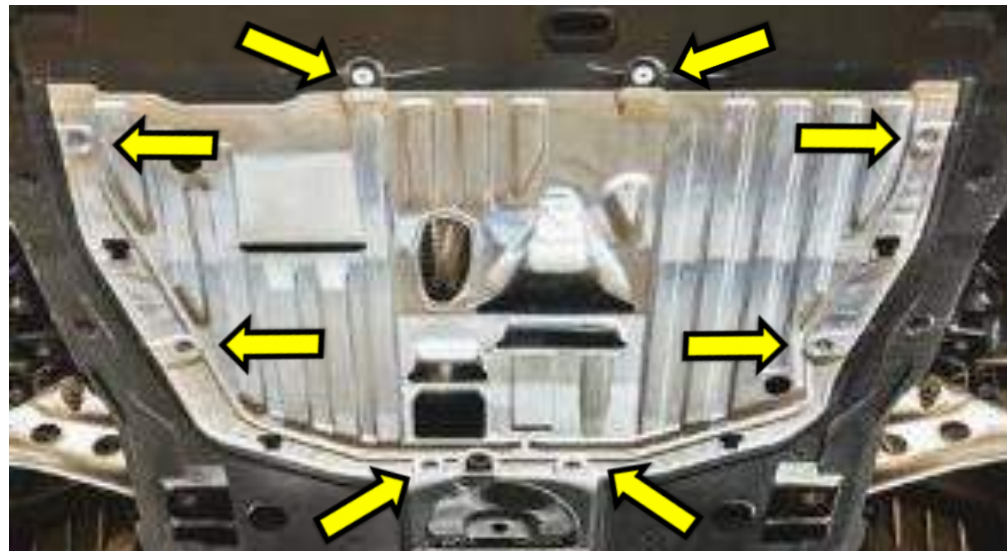


## Step 2

Remove 2 x Phillips head screws at the front edge of the belly pan

Remove 6 x plugs with a flat head screwdriver

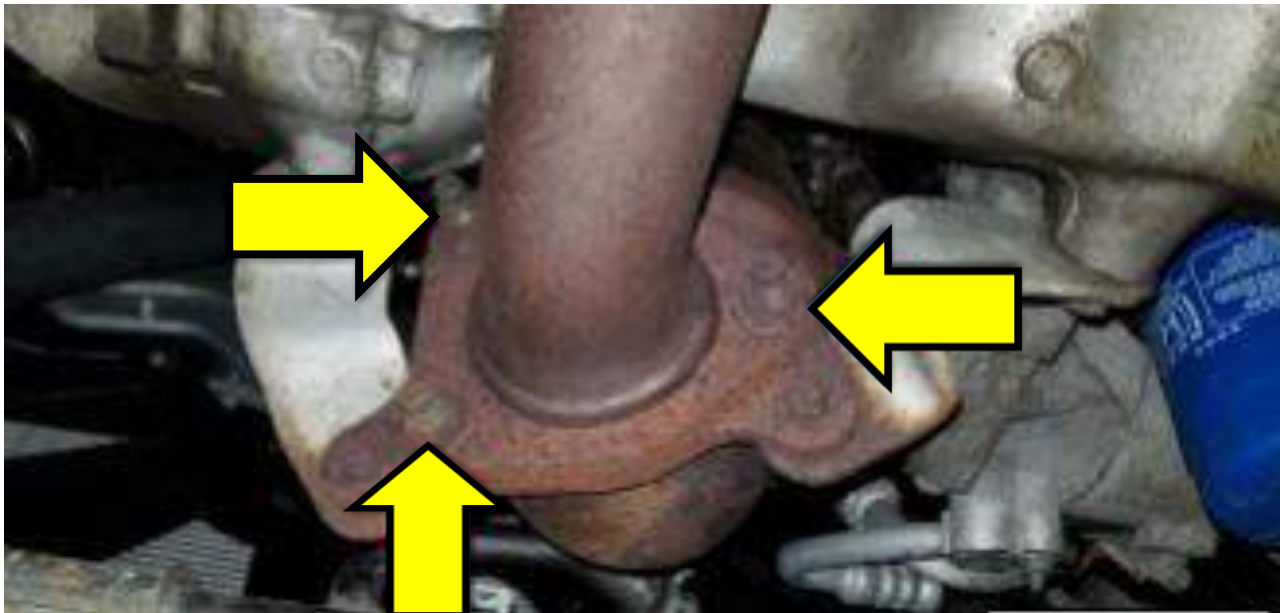
Slide belly pan rearward to release it from 4 x tabs





## Step 3

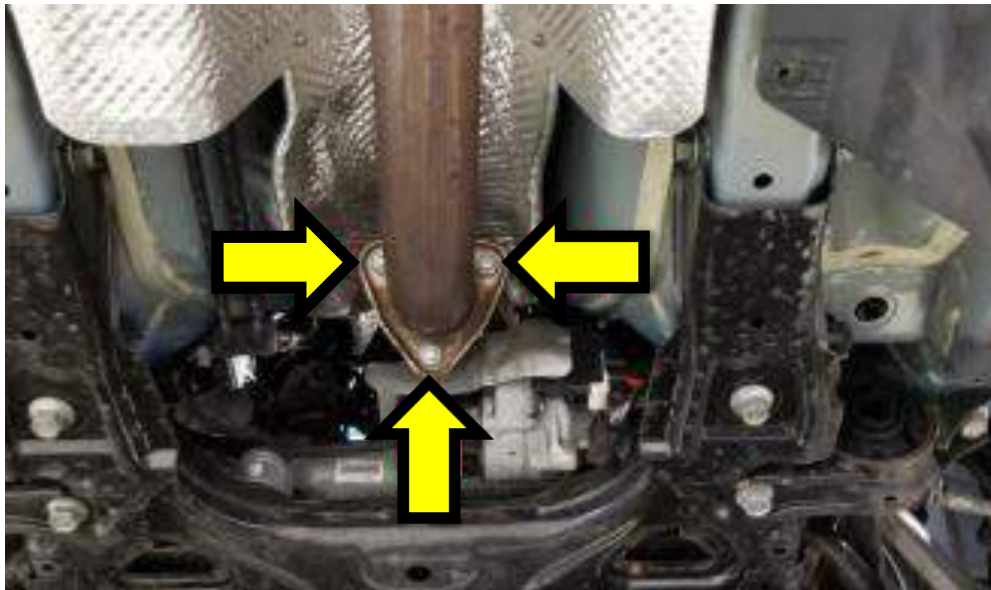
Spray lubricant on the studs and then  
remove 3 x nuts with a 14 mm socket  
between the down pipe and the front pipe





## Step 4

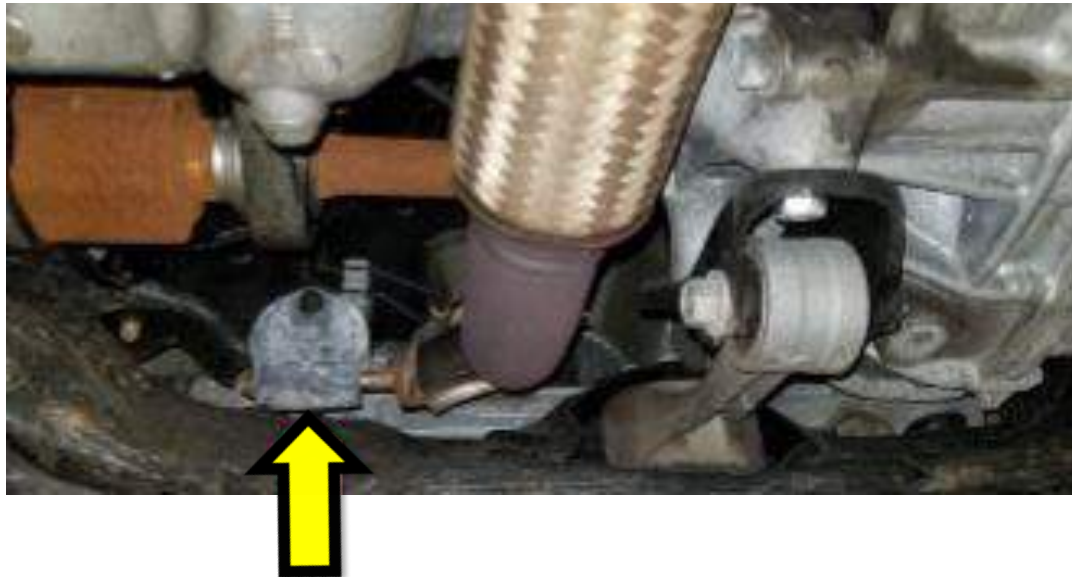
Spray lubricant on the studs and then remove 3 x nuts with a 14 mm socket between the down pipe and the front pipe





## Step 5

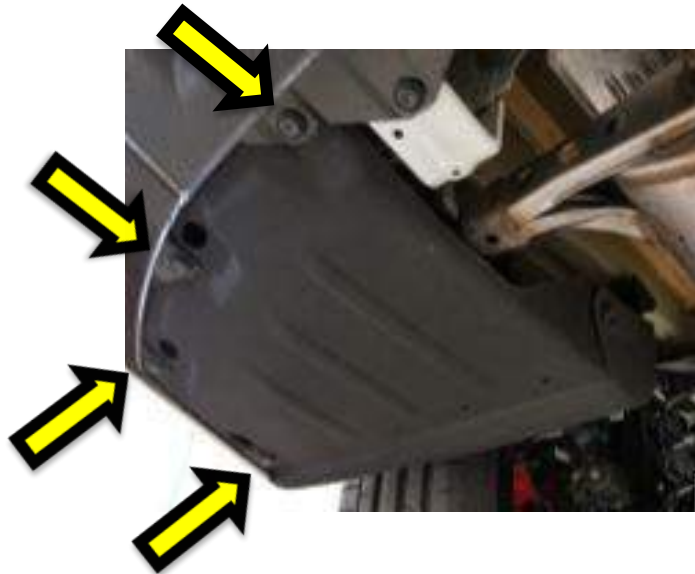
Lubricate the rubber and slide it off the support hooks  
Then remove the front pipe





## Step 6

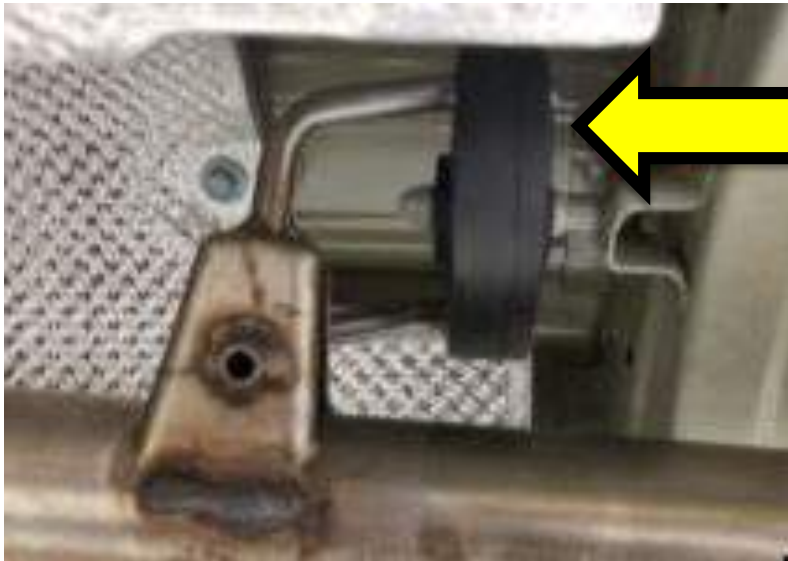
Remove the plastic clips and fold down the cover to gain access to the 2 left and 2 right rubbers on the rear muffler assembly.





## Step 7

Lubricate the 2 right, 2 left and middle rubbers for easy removal.





## Step 8

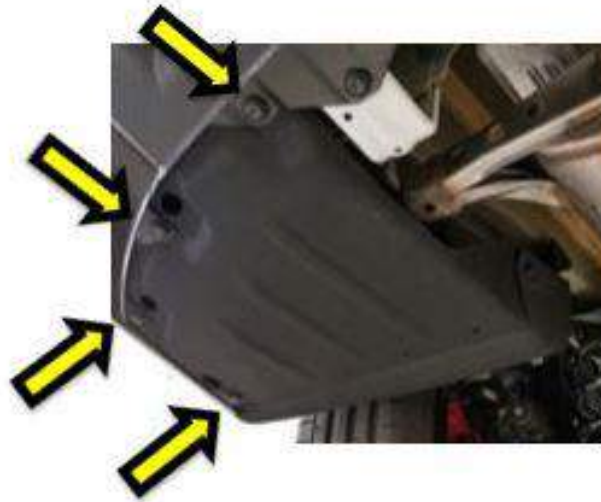
With help from an Adult remove the factory exhaust from the vehicle in readiness to fit the Xforce Vorex System.





## Step 9

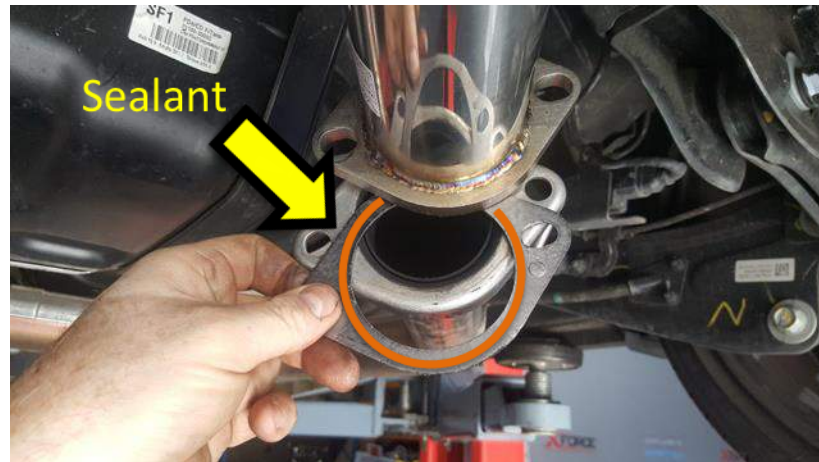
Fit the Xforce Muffler (ES-HCR17-VMKR) into the 4 rear supporting rubbers and replace the left and right covers





## Step 10

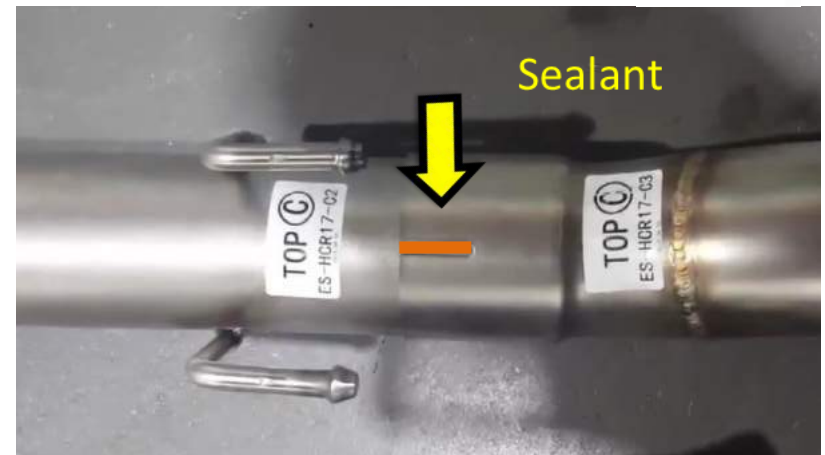
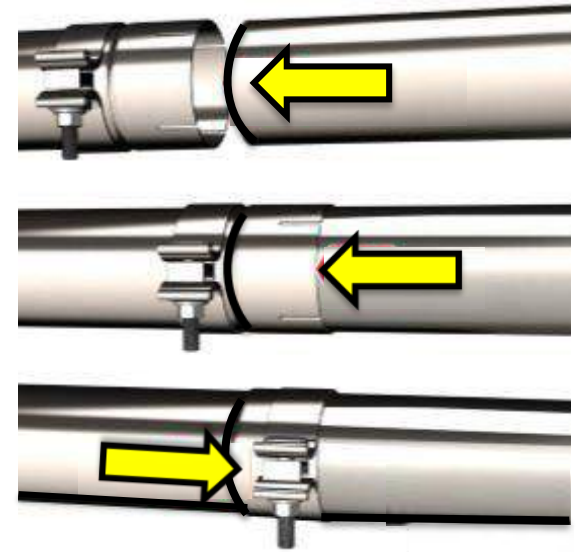
Fit the rear under axle pipe (ES-HCR17-C4) with the 2 bolt flange marked A to the rear muffler flange. Make sure you use O2 sensor safe sealant on the gasket and the clamp is over the flare marked B.





## Step 11

Fit the rear mid pipe (ES-HCR17-C3) to the C4 (marked B) using sealant on the slip joint at both ends and the clamp is over the flare marked C. Next is the ES-HCR17-C2, slide the join (marked C) making sure the hangers also locate on the middle rubber mount.





## Step 12

Fit the front pipe (ES-HCR17-C1) to the C2 (marked D) using sealant on the 2 bolt gasket then slide the hanger into the rubber near the front drive shaft. Next is to attach the 3 bolt flange (marked E) to the down pipe.





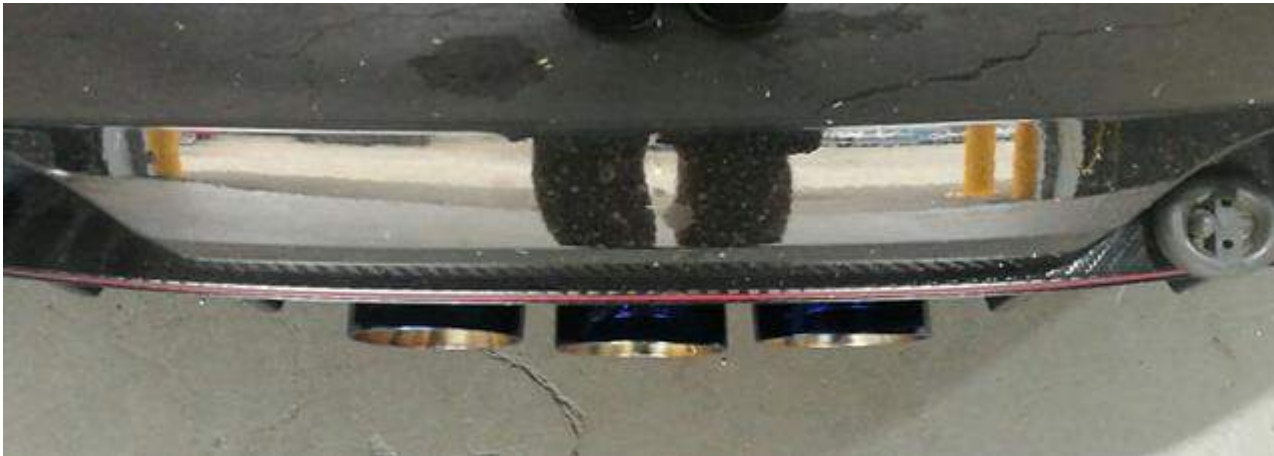
## Step 13

Tighten from the rear to the front checking for correct fitment along the way. Make sure you have good clearance between the pipe and vehicle. If the pipe is close to the floor rotate the pipe or side the slip joints in or out as you go ensuring good clearance and fitment.



## Step 14

Once everything is tight and your happy with the fitment, slide the 3 tips onto the rear muffler. Align to the desired position and tighten.





# VAREX

## Varex Key Fob Installation Instructions

**XFORCE RECOMMENDS AN AUTHORISED PROFESSIONAL TO INSTALL ALL PRODUCTS**

**WARNING:** When working on any vehicle exercise extreme caution. Please allow the vehicles exhaust system to be cool enough to touch before removal. Failing to do so may result in severe burns. If working without a hoist refer to the vehicles manual to check correct lifting specifications. Always wear safety glasses, protective gloves and ensure your working in a safe area. Serious injury or death can occur if the correct safety measures are not followed.

**Attention:** Please read the instructions carefully. XFORCE will only warrant manufacturing faults. This does not extend to damage or breakage due to incorrect fitment.



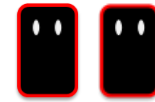
## What's inside the box

- 1 Varex Control Module
- 2 Main Wiring Harness (VK1 or VK2)
- 3 Key Fobs

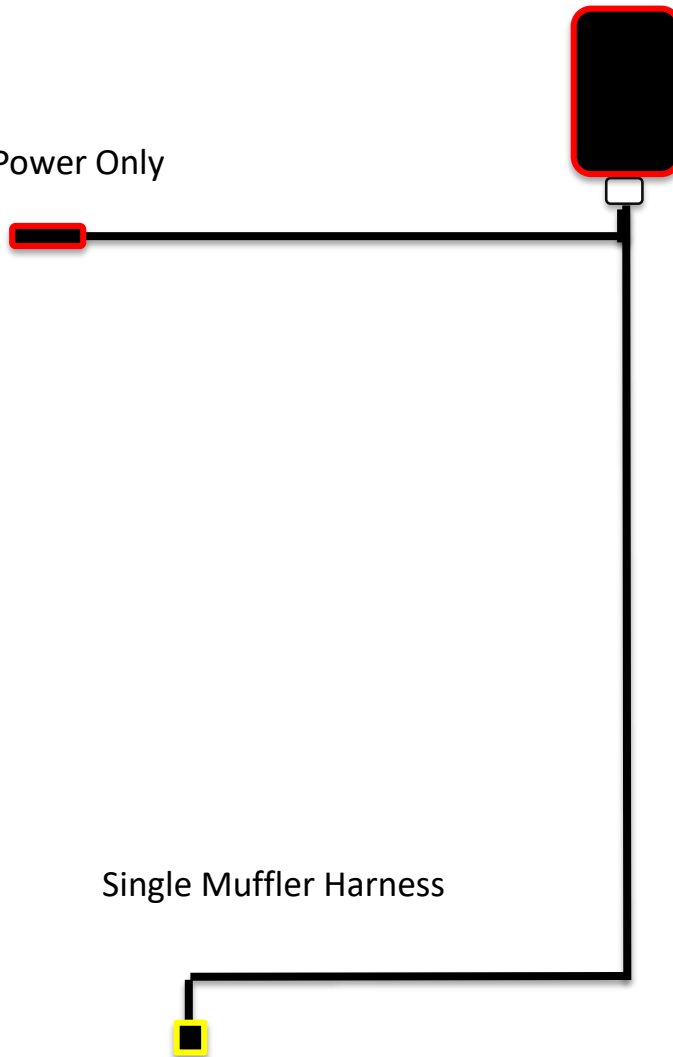


Varex  
Key Fob Module

Key Fobs



12 V Socket Plug  
For Accessories Power Only



**VK01**

For single muffler  
applications



## Step 15

Find a rubber grommet to allow access from the boot area to the underside of the car near the Varex Mufflers. Once located feed the black 2 pin plug through the rubber grommet and into the boot area to the underside of the car and connect to the muffler





## Step 16

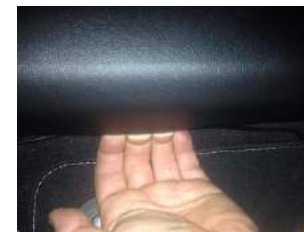
Feed the wiring through the boot towards the back seat, then run the wire into the cabin and under the back seat, towards the plastic cover between the carpet and the doors.

Put your fingers under the cover (pic 1) then push the wiring up under the cover (pic 2).

Do this all the way to the front of the cabin and feed the wire behind the kick panel Pic 3 (plastic cover near where your feet would be in the front of the car).



Pic 1



Pic 2



Pic 3



## Step 17

Plug the Key Fob box into the white 4 pin plug and the (pic 4)

Remove the panel under the glovebox (pic 5) and place the wiring and box on the panel (pic 6), run the wire (with the 12V Socket Plug) towards the 12V Socket.



Pic 4



Pic 5



Pic 6



## Step 18

Feed the wiring under the plastic between the centre console and the carpet moving it towards the centre of the car (pic 7 towards the seats) as far as is needed to reach the power socket (pic 8).

Turn the car on and test the system using the remote  
Button A will close the Varex and button B will open the Varex

Now enjoy the volume controllability of your new Varex System



Pic 7



Pic 8



## Step 19

Drive vehicle for 10mins, Return to **Step 13**, retention all nuts, bolts and enjoy the driving experience your new Xforce System provides.

Note: When you first start your vehicle after the installation of your new XFORCE Performance Exhaust System, there may be some smoke and fumes coming from the system. This is a protective oil based coating used in the manufacturing of mandrel bent performance exhaust tubing. This is not a problem and will disappear within a very short period of time after the exhaust has reached normal operating temperatures.