

**Sports Exhaust System (176)**

Information: **Retrofitting**

Model Year: **As of 2017 up to 2019**

Vehicle type: **911 Carrera (991)/911 Carrera 4 (911)/911 Targa 4 (991)**

Engine Type: **MDCKA (3.0 L)**



Figure 1

Notes: The sports exhaust system is activated and deactivated using the switch console with the additional "Twin tailpipe" button. The sports exhaust system is also activated by pressing the "Sport" and "Sport Plus" buttons. The sports exhaust system can be switched off separately in these modes using the "Twin tailpipe" button.

**Strip for switches and tailpipes** must also be ordered. The switch console is modular and must be assembled in accordance with the new vehicle equipment.

Engine power and exhaust behaviour of the vehicle are not affected.

Part Information.: **991.044.200.30** ⇒ Sports exhaust system, set

Also order the following:

**991.044.200.24** 1 x ⇒ Tailpipe, silver, set

**991.613.955.50.DML<sup>1</sup>** 1 x ⇒ Combined switch (switch console), I-no. 652, Coupé

<b>991.613.957.50.DML<sup>1</sup></b>	1 x	⇒ Combined switch (switch console), I-no. 653, Coupé
<b>991.613.959.50.DML<sup>1</sup></b>	1 x	⇒ Combined switch (switch console), I-no. 651, Coupé
<b>991.613.967.50.DML<sup>1</sup></b>	1 x	⇒ Combined switch (switch console), I-no. 552, Cabriolet
<b>991.613.963.50.DML<sup>1</sup></b>	1 x	⇒ Combined switch (switch console), Targa

<sup>1</sup> Depending on vehicle equipment

Parts List:

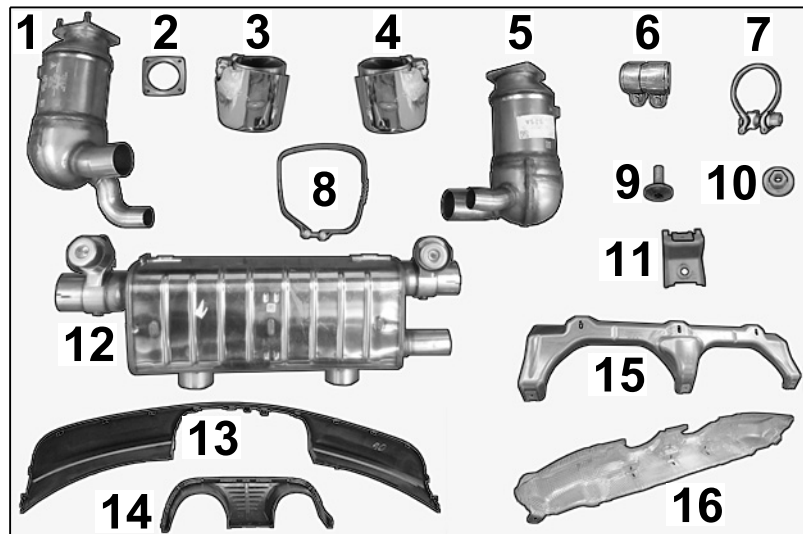


Figure 2

9P1.254.400.A	1 x	Left catalytic converter ⇒ Figure 2-1-
9P1.251.263	2 x	Seal ⇒ Figure 2-2-
9P1.251.187.B <sup>2</sup>	1 x	Tailpipe, silver ⇒ Figure 2-3-
9P1.251.188.B <sup>2</sup>	1 x	Tailpipe, silver ⇒ Figure 2-4-
9P1.254.450.A	1 x	Right catalytic converter ⇒ Figure 2-5-
9P1.253.145	2 x	Clamping sleeve ⇒ Figure 2-6-
997.111.230.80	2 x	Clamp ⇒ Figure 2-7-
9P1.251.751	2 x	Clamp on main silencer ⇒ Figure 2-8-
999.073.418.01	2 x	Tapping screw, ST 4.8 x 19-C ⇒ Figure 2-9-
999.076.091.01	2 x	Hexagon nut, M6 ⇒ Figure 2-10-
996.505.649.01	1 x	Bracket ⇒ Figure 2-11-
9P1.251.053.A	1 x	Main silencer ⇒ Figure 2-12-
991.505.811.04OK1	1 x	Rear apron (black, grained) ⇒ Figure 2-13-
991.505.651.04OK1	1 x	Tailpipe cover (black, grained) ⇒ Figure 2-14-
991.505.639.03	1 x	Rear support ⇒ Figure 2-15-
991.505.475.04	1 x	Heat shield ⇒ Figure 2-16-
999.507.309.02	4 x	Speed nut, ST 4.8 (not shown)

999.084.642.02	8 x	Hexagon nut, M8 (not shown)
991.505.837.02	1 x	Lower retaining strip, middle (not shown)
991.505.837.03	2 x	Lower retaining strip, outer (not shown)
999.190.191.30	3 x	Blind rivet, A3.2 x 17 (not shown)
9A7.007.483.00	4 x	Torx screw (for securing seat), (not shown)
9P3.974.280	1 x	Wire harness for sports exhaust system (not shown)
999.650.531.00	1 x	Cable ring eyelet (not shown)
999.650.566.22	1 x	Socket contact (not shown)
991.044.200.15	1 x	Cable casing (not shown)
999.073.227.09	1 x	Tapping screw, ST 4.8 x 19 (not shown)
N 020.904.4	15 x	Tie-wrap (not shown)
999.073.236.0A	8 x	Countersunk screw, M6 x 10 (for securing heat shield for turbocharger)

<sup>2</sup> Contained in set 991.044.200.24.

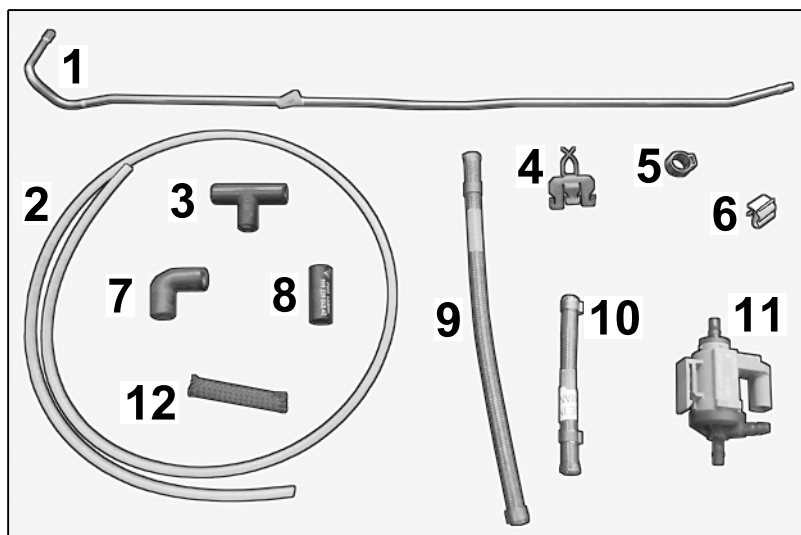


Figure 3

Parts included for vacuum supply system

9P1.251.838.A	1 x	Vacuum line, metal ⇒ Figure 3-1-
900.918.005.40	1 x	Plastic tube (5 x 1 x 1,000 mm) ⇒ Figure 3-2-
06E.133.794	3 x	T-piece ⇒ Figure 3-3-
999.651.363.01	1 x	Cable holder ⇒ Figure 2-4-
999.512.707.00	4 x	One-ear hose clamp, 9.6-11.3 ⇒ Figure 3-5-
999.651.401.01	4 x	Clip (for securing vacuum line, metal) ⇒ Figure 3-6-
9A1.110.666.00	2 x	Moulded hose ⇒ Figure 3-7-
999.239.048.40	1 x	Connecting hose (4.5 x 2.5 x 28 mm) ⇒ Figure 3-8-

991.111.504.00	1 x	190-mm steel flexi-pipe ⇒ <i>Figure 3-9-</i>
991.111.502.00	1 x	93-mm steel flexi-pipe ⇒ <i>Figure 3-10-</i>
7PP.906.283.F	1 x	Change-over valve ⇒ <i>Figure 3-11-</i>
999.181.518.50	1 x	Protective tube, L = 50 mm ⇒ <i>Figure 3-12-</i>

Materials:	000.043.172.00	1 x	Sealing cord
	000.043.004.82	1 x	Optimol-HT mounting paste
	— — —		Rust solvent, commercially available, e.g. WD40

Notes: **Identifying features when installed:**  
In addition to the Porsche logo, a part number is shown on the main silencer, catalytic converters and tailpipes.

The relevant legal regulations must be observed in the various countries.

Tools: **9900 - PIWIS Tester 3**  
**T10118 - Assembly tool**  
**P300 - Socket-wrench insert**  
**Transmission and Engine Jack**

- Assembly: 1 Preparatory work:
- 1.1 Move convertible top to service position.
    - 1.1.1 Cabriolet: ⇒ *Workshop Manual '6101IN Convertible-top service position (Cabriolet)'*
    - 1.1.2 Targa: ⇒ *Workshop Manual '6101IN05 Convertible-top service position'*



#### WARNING

#### Moving components

- **Danger of limbs being trapped or severed**
- ⇒ **Do not reach into the danger area.**
- ⇒ **Secure the system to prevent it from being activated accidentally.**
- ⇒ **Keep third parties away from the danger area.**

- 1.2 Extend the rear spoiler manually using the rocker switch in the passenger compartment.
- 1.3 Remove left door sill trim. ⇒ *Workshop Manual '680519 Removing and installing inner door sill trim'*
- 1.4 Remove left front seat. ⇒ *Workshop Manual '72011901 Removing and installing front seat'*

1.5 Remove rear seat cushion. ⇒ *Workshop Manual '745719 Removing and installing rear seat cushion'*

1.6 **Only** for Targa:  
Remove trim panels and cover in the passenger compartment.

1.6.1 Remove center trim panel ⇒ *Figure 4-1-* and trim panel at the left side ⇒ *Figure 4-2-* from the roll-over bar. ⇒ *Workshop Manual '708119 Removing and installing trim panel for roll-over bar'*

1.6.2 Remove rear side trim panel at the left ⇒ *Figure 4-3-*. ⇒ *Workshop Manual '707519 Rear side trim panel'*

1.6.3 Remove trim panel for rear wall ⇒ *Figure 5-1-* and sound absorber ⇒ *Figure 5-2-*.

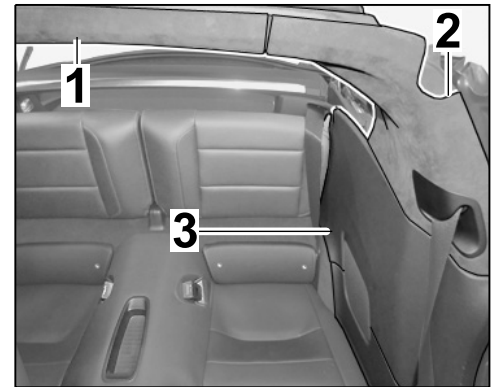


Figure 4

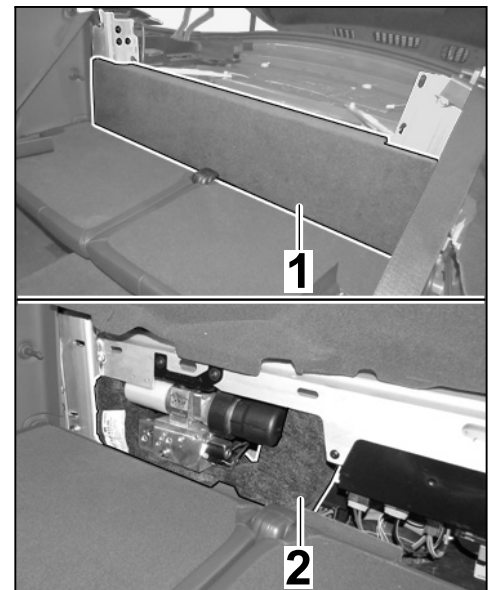


Figure 5

1.6.4 Remove rear cover/shield ⇒  
*Figure 6-1-*. ⇒ *Workshop Manual '70531910 Removing and installing rear cover'*

1.6.5 Remove rear cover ⇒ *Figure 6-2-*.  
⇒ *Workshop Manual '70531911 Removing and installing rear cover (Targa)'*

1.6.6 Remove trim panel for convertible top compartment at the center ⇒ *Figure 6-3-* and trim panel for convertible top compartment at the left side ⇒ *Figure 6-4-*. ⇒ *Workshop Manual '700819 Removing and installing trim panel for convertible top compartment (Targa)'*

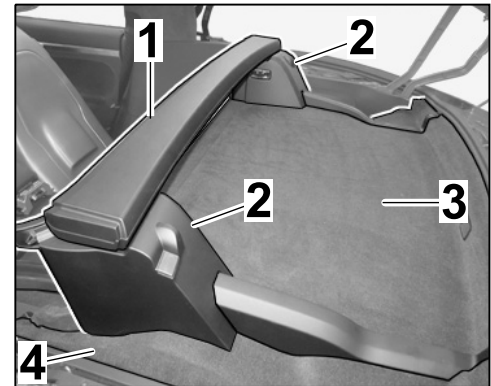


Figure 6

1.6.7 Loosen trim panel for convertible top compartment at the right side ⇒ *Figure 7-1-* and set it aside ⇒ *Figure 7-arrow-*.

1.7 **Only** for Cabriolet:  
Remove trim panels and cover in the passenger compartment.

1.7.1 Remove rear side trim panel at the left. ⇒ *Workshop Manual '707519 Removing and installing rear side trim panel (Cabriolet)'*

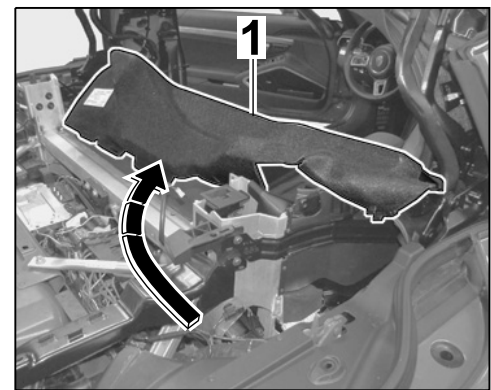


Figure 7

1.7.2 Remove trim panel for rear wall. ⇒  
*Workshop Manual '703119 Removing and installing trim panel for rear wall'*

1.7.3 Remove rear cover. ⇒ *Workshop Manual '705319 Removing and installing rear cover'*

1.7.4 Remove trim panel for convertible top compartment. ⇒ *Workshop Manual '700819 Removing and installing trim panel for convertible top compartment (Cabriolet)'*

1.8 **Only** for Coupé:  
Remove trim panels and cover in the passenger compartment.

1.8.1 Remove rear roof trim panel. ⇒ *Workshop Manual '708519 Removing and installing rear roof trim panel'*

1.8.2 Remove B-pillar trim panel at the left and right. ⇒ *Workshop Manual '706719 Removing and installing B-pillar trim panel'*

- 1.8.3 Remove C-pillar trim panel at the left and right. ⇒ *Workshop Manual '706819 Removing and installing C-pillar trim panel'*
- 1.8.4 Remove rear side trim panel at the left and right. ⇒ *Workshop Manual '707519 Removing and installing rear side trim panel (Coupe)'*
- 1.8.5 Remove rear cover. ⇒ *Workshop Manual '705319 Removing and installing rear cover (Coupe)'*
- 1.8.6 Remove moulded part ⇒ *Figure 8 -1-*.

2 Remove the following components in the rear area.

- 2.1 Remove engine-compartment blower. ⇒ *Workshop Manual '198119 Removing and installing engine-compartment blower'*
- 2.2 Remove air guide. ⇒ *Workshop Manual '243619 Removing and installing air guide'*
- 2.3 Remove tail lights. ⇒ *Workshop Manual '943119 Removing and installing tail light'*
- 2.4 Remove rear apron. ⇒ *Workshop Manual '635519 Removing and installing rear apron'*
- 2.5 Remove bumper together with heat shield. ⇒ *Workshop Manual '635019 Removing and installing rear bumper'*
- 2.6 Remove rear spoiler. ⇒ *Workshop Manual '66581905 Removing and installing rear spoiler'*
- 2.7 Remove air guide on charge-air cooler ⇒ *Figure 9-1, 2-*. ⇒ *Workshop Manual '211019 Removing and installing air guide for charge-air cooling'*

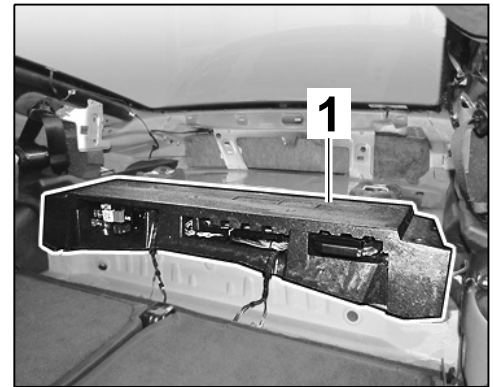


Figure 8

- 2.8 Remove pressure pipe ⇒ *Figure 10-1-*. ⇒ *Workshop Manual '214119 Removing and installing pressure pipe'*

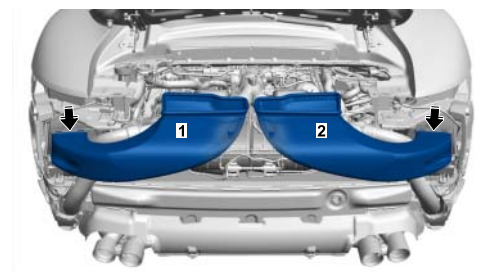


Figure 9

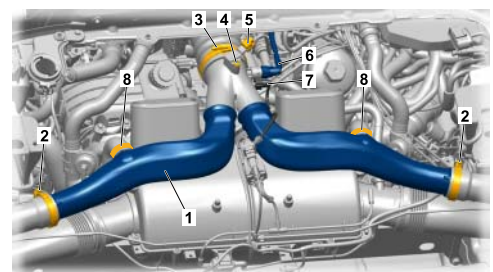


Figure 10

- 2.9 Remove air cleaner housing ⇒ *Figure 11 -1-*.  
⇒ *Workshop Manual '242519 Removing and installing air cleaner housing'*
- 2.10 Remove DME control unit and holder. ⇒  
*Workshop Manual '247019 Removing and installing DME control unit'*

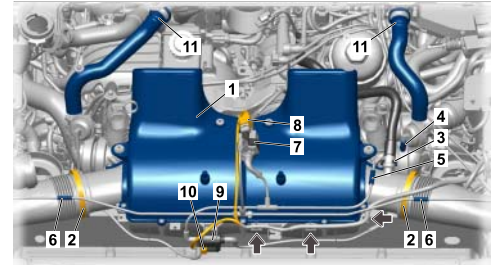


Figure 11

**NOTICE****Incorrect line routing**

- Risk of damage to lines and hoses
  - Malfunction and fault memory entry on control unit
- ⇒ Avoid small bending radii when routing lines.
- ⇒ File down edges and burrs in the routing area or mask them with adhesive tape.
- ⇒ Maintain a sufficient distance from components exposed to high temperatures while driving.

## 3 Install wire harness for sports exhaust system.

## 3.1 Prepare wire harness for sports exhaust system.

- 3.1.1 Cut socket contact and cable ring eyelet off wire harness for sports exhaust system.
- 3.1.2 Feed wire harness for sports exhaust system out of the existing cable casing.
- 3.1.3 Cut a 1.8 m length off the supplied cable casing.
- 3.1.4 Pull wire harness for sports exhaust system ⇒ *Figure 12 -1-* into the 1.8 m long cable casing using welding wire (e.g. MIG welder coil).

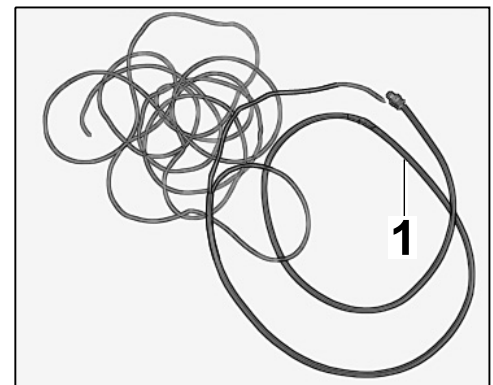


Figure 12



3.2 Overview of routing of wire harness for sports exhaust system:

- 1 – Engine compartment
- 2 – Sleeve
- 3 – Wire harness in passenger compartment, right
- 4 – Wire harness in passenger compartment, left
- 5 – Control unit for rear-end electronics

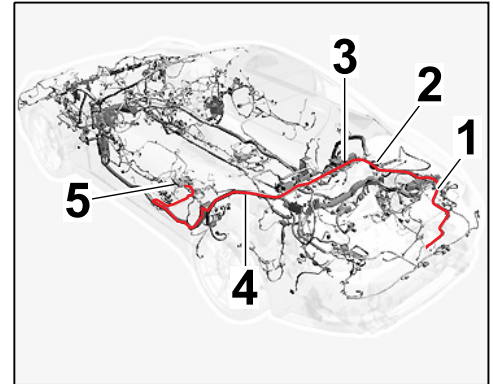


Figure 13

3.3 Punch grommet ⇒ Figure 14 -1- (⇒ Figure 14 -arrow-).

3.4 Guide wire harness for sports exhaust system through the grommet into the passenger compartment.

Length of wire harness for sports exhaust system in the engine compartment from grommet to connector is approx. 1.4 m.

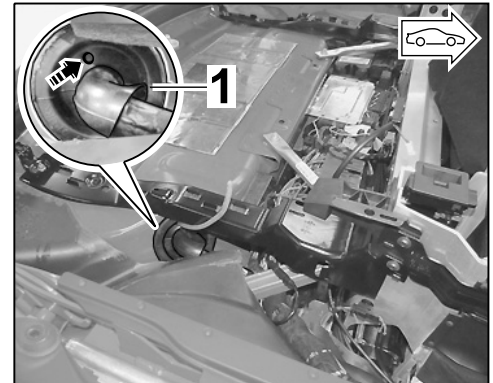


Figure 14

3.5 Route wire harness for sports exhaust system ⇒ Figure 15 -1- in the engine compartment at the right and secure to the standard engine wire harness with a tie-wrap.

- 2 – Engine wire harness
- 3 – Right engine mount

Route wire harness for sports exhaust system parallel to the standard wire harness for the vacuum valve.

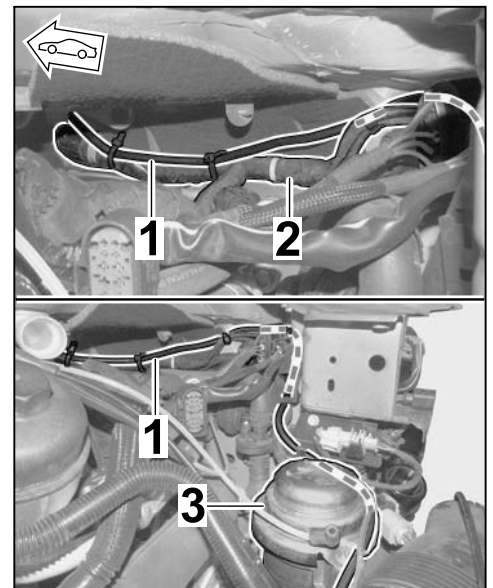


Figure 15

- 3.6 Route wire harness for sports exhaust system ⇒ *Figure 16-1*- along the wire harnesses in the passenger compartment at the left and right.

Route BN line to ground point 15 ⇒ *Figure 16-2*-.

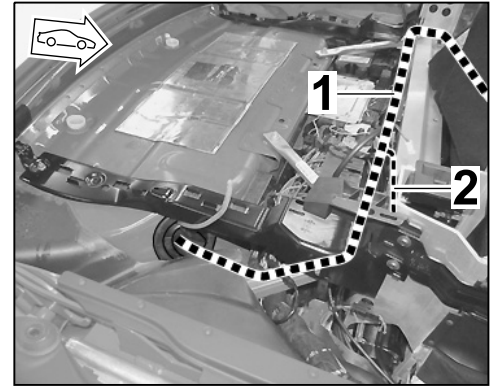


Figure 16

- 3.7 Connect BN line to ground point 15 (shown on the Targa).

- 1 – Center bearing for backrest
- 3 – Hydraulic pump

3.7.1 Shorten BN line.

3.7.2 Crimp BN line and cable ring eyelet together.

3.7.3 Secure cable ring eyelet to ground point 15 ⇒ *Figure 17-2*-.

**Tightening torque 9.7 Nm  
(7.5 ftlb.)**

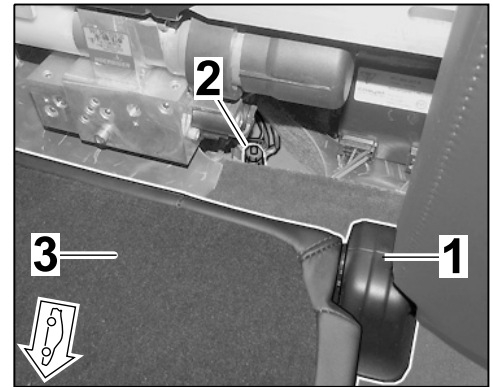


Figure 17

- 3.8 Route wire harness for sports exhaust system ⇒ *Figure 18-1*- further along wire harness in passenger compartment at the left, in cable duct ⇒ *Figure 18-2*- to the rear-end electronics control unit.

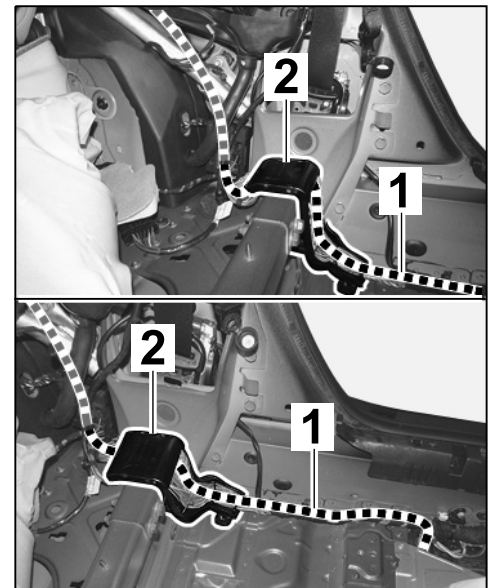


Figure 18

- 3.9 Remove rear-end electronics control unit.
  - 3.9.1 Fold back the carpet.
  - 3.9.2 **Only** for Targa/Cabriolet: Unscrew four screws ⇒ *Figure 19-2-* and one hexagon nut ⇒ *Figure 19-1-* and remove reinforcement plate ⇒ *Figure 19-3-*.
  - 3.9.3 Remove rear-end electronics control unit ⇒ *Figure 19-4-* from the foam holder and disconnect electric plug connections.
- 3.10 Connect wire harness for sports exhaust system to the rear-end electronics control unit.

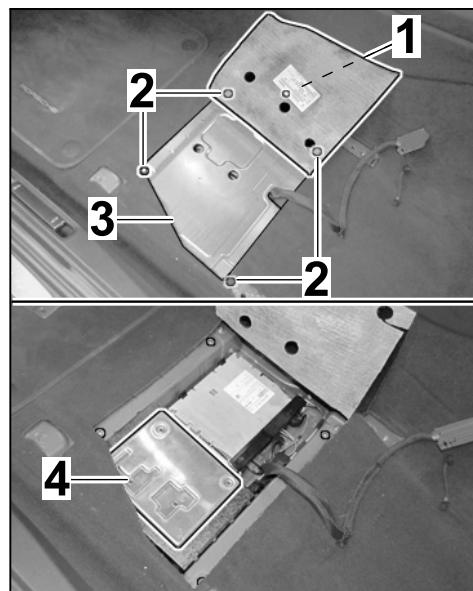


Figure 19

- 3.10.1 Press down the locking mechanism ⇒ *Figure 20-arrow-* and push the grey plug socket ⇒ *Figure 20-1-* out of the plug carrier (coding: blue) ⇒ *Figure 20-2-*.
- 3.10.2 Shorten BK/YE line.  
Crimp socket contact (999.650.566.22) and BK/YE line together.

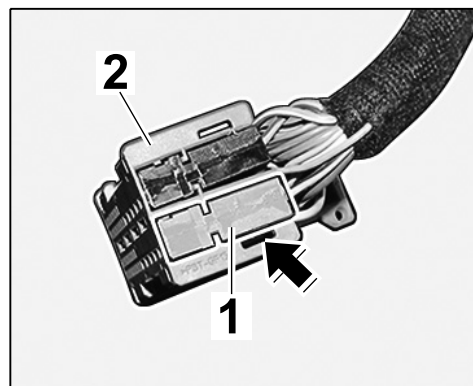


Figure 20



### Information

Ensure socket contact is seated securely.

- 3.10.3 Insert socket contact ⇒ *Figure 21 -1-* into chamber A2 of the grey plug socket ⇒ *Figure 21 -2-*.

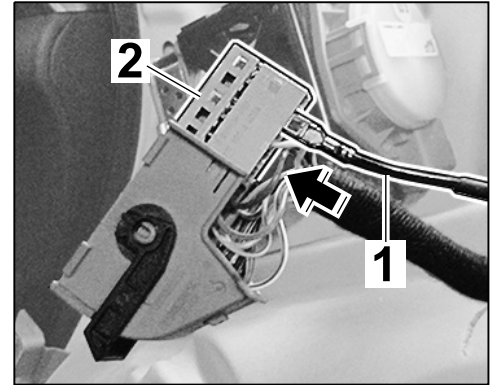


Figure 21

- 3.10.4 Push grey plug socket ⇒ *Figure 22 -1-* into the plug carrier (coding: blue) ⇒ *Figure 22 -2-* until the locking mechanism ⇒ *Figure 22 -arrow-* engages.

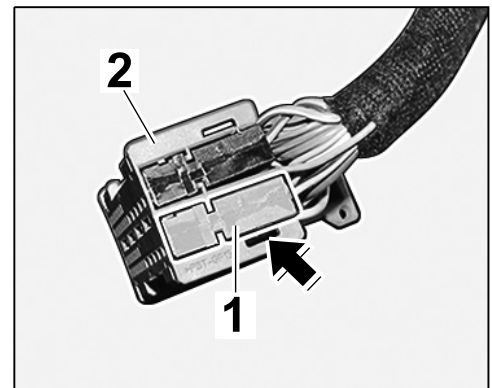


Figure 22

- 3.11 Seal grommet ⇒ *Figure 23 -1-* with sealing cord (000.043.172.00).
- 3.12 The interior equipment is installed in reverse order to removal.
- 3.13 Install left front seat. ⇒ *Workshop Manual '72011901 Removing and installing front seat'*
- 3.14 Install inner door sill trim at the left. ⇒ *Workshop Manual '680519 Removing and installing inner door sill trim'*

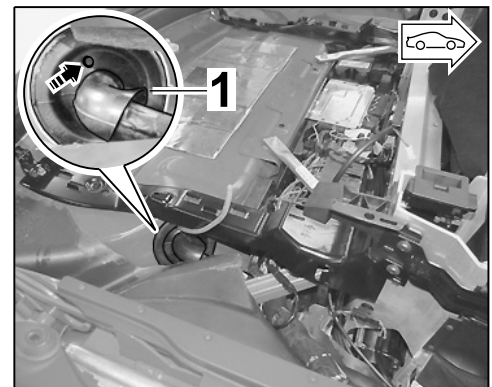


Figure 23

- 4 Install DME control unit and holder. ⇒ *Workshop Manual '247019 Removing and installing DME control unit'*

**CAUTION****Hot components**

- Risk of burns
- ⇒ Let hot components cool down.
- ⇒ Wear personal protective gear.

- 5 Remove exhaust system.
  - 5.1 Remove heat shield for turbocharger at the left ⇒ *Figure 24 -2-* and right.

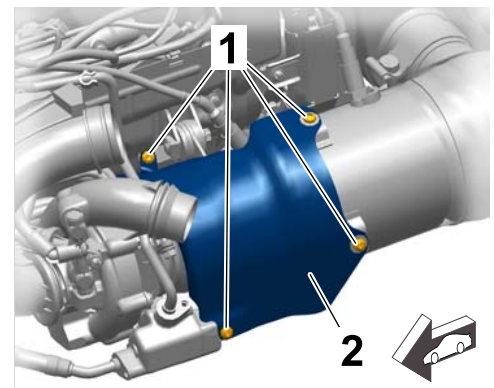


Figure 24

**WARNING****Danger of objects or loads falling down**

- Risk of squashing or crushing
- ⇒ Secure components to prevent them from falling down.

**Information**

The exhaust system must only be removed with the help of another person.

- 5.2 Remove exhaust system. ⇒ *Workshop Manual '260119 Removing and installing exhaust system'*
- 6 Install vacuum line.
    - 6.1 Assemble vacuum line.
      - 6.1.1 Cut off 3 sections (length: 25 mm, 70 mm, 350 mm) of plastic tube (9P1.251.838.A).

**Information**

Insert plastic tubes at least 12 mm into the steel flexi-pipe/moulded hose or connecting hose.

- 6.1.2 Connect components together as shown in Figure 33.

- 1 – 190-mm steel flexi-pipe
- 2 – One-ear hose clamp
- 3 – Plastic tube (25 mm)
- 4 – Moulded hose
- 5 – Plastic tube (70 mm)
- 6 – 50-mm hose
- 7 – T-piece
- 8 – Plastic tube (350 mm)
- 9 – Moulded hose

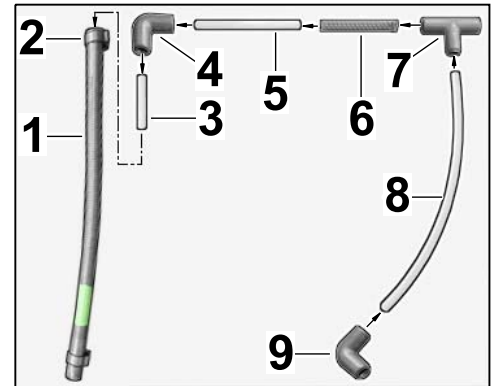


Figure 25

Press one-ear hose clamp ⇒ *Figure 25-2-* together.

- 6.1.3 Insert metal vacuum line (9P1.251.838.A) ⇒ *Figure 26-3-* as far as the marking (white) ⇒ *Figure 26 -arrow a-* into the T-piece ⇒ *Figure 26 -4-*.

Insert metal vacuum line as far as the marking (white) ⇒ *Figure 26 -arrow a-* into the 93-mm steel flexi-pipe ⇒ *Figure 26-1-*.

Press one-ear hose clamp ⇒ *Figure 26-2-* together.

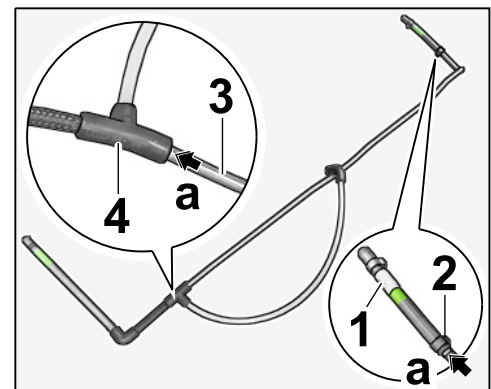


Figure 26

- 6.2 Secure assembled vacuum line ⇒ *Figure 27-1-* to the engine carrier with four clips ⇒ *Figure 27-2-*.

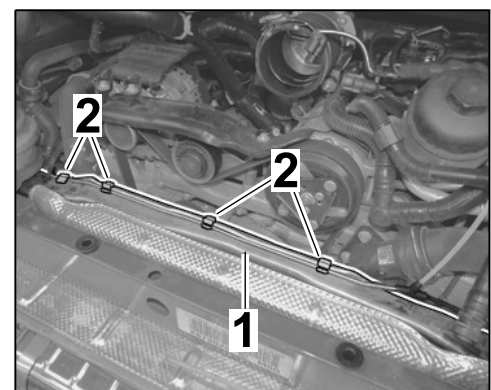


Figure 27

- 6.3 Clip cable holder ⇒ *Figure 28-1-* to the engine carrier ⇒ *Figure 28-2-*.  
Clip steel flexi-pipe ⇒ *Figure 28-2-* into cable holder.

7 Install sports exhaust system.

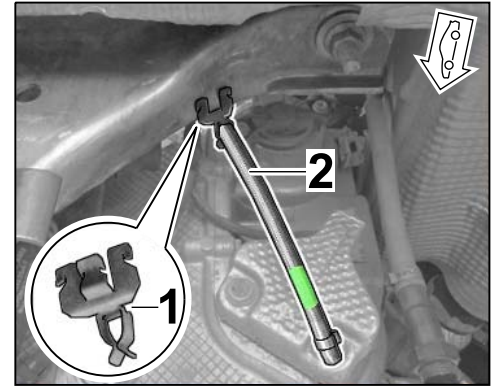


Figure 28

- 7.1 Install right catalytic converter ⇒ *Figure 29-1-* with a new seal on the turbocharger ⇒ *Figure 29-3-* and secure with a new hexagon nut ⇒ *Figure 29-2-* to prevent it from falling down.



**Information**

- When re-installing oxygen sensors, only grease the thread with lubricant.
- New oxygen sensors have already been greased and the thread is installed with a protection cap.

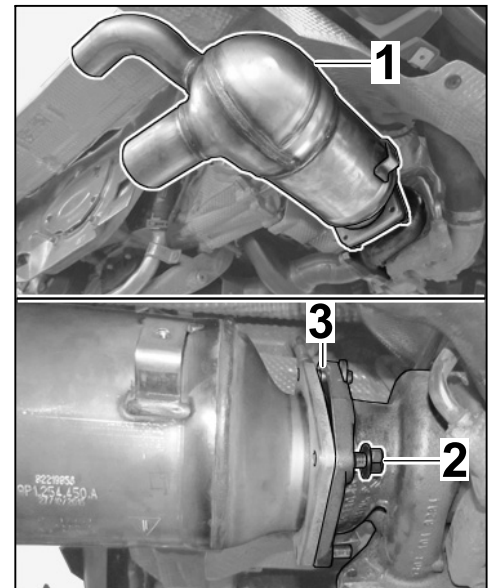


Figure 29



**Information**

The oxygen sensors can only be screwed by 4 – 5 turns without disconnecting the electric plug connections.

- 7.2 Install oxygen sensors upstream of catalytic converter ⇒ *Figure 30-1*- and downstream of catalytic converter ⇒ *Figure 30-2*- on the right catalytic converter.

**Tightening torque 50 Nm (37 ftlb.)  
+/-8 Nm (+/-6 ftlb.)**

- 7.3 Install left catalytic converter with a new seal on the turbocharger and secure with a new hexagon nut to prevent it from falling down.



**Information**

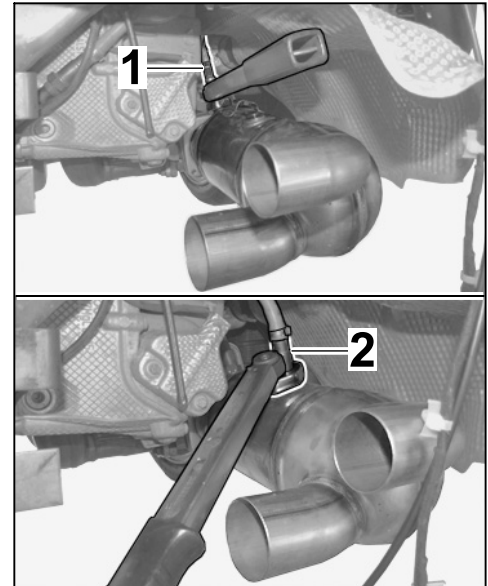
The oxygen sensors can only be screwed by 4 – 5 turns without disconnecting the electric plug connections.

- 7.4 Install oxygen sensors upstream and downstream of catalytic converter on the left catalytic converter.

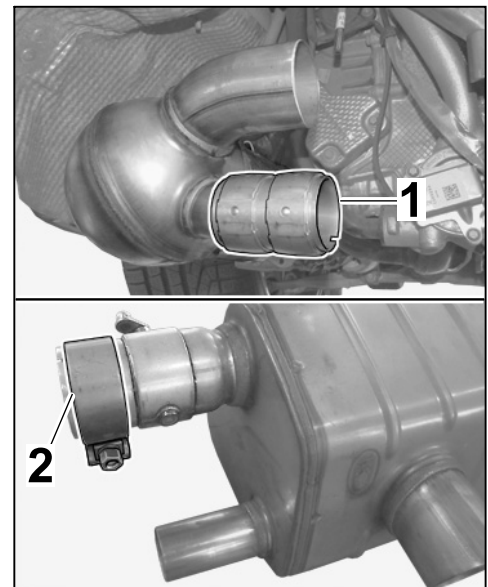
**Tightening torque 50 Nm (37 ftlb.) +/-8 Nm (+/-6 ftlb.)**

- 7.5 Install clamping sleeve at the left ⇒ *Figure 31-1* - and right on the catalytic converters.

Install clamps ⇒ *Figure 31-2*- on the main silencer.



*Figure 30*



*Figure 31*

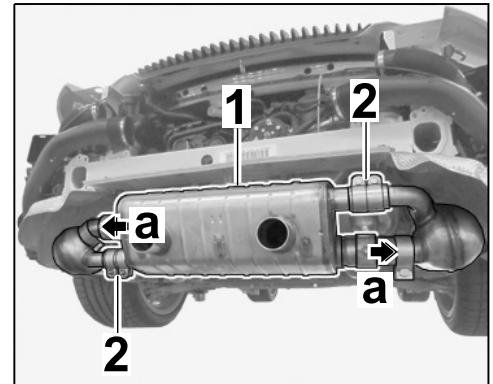




**Information**

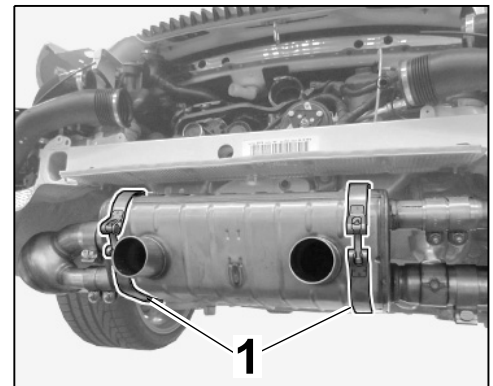
- Apply a light coating of high-temperature grease (e.g. Optimoly HT, Part No. 000.043.004.00) on the clamp or pipe adapter before installation.

- 7.6 Guide main silencer ⇒ *Figure 32-1-* into the catalytic converter at the left and right with the help of another person ⇒ *Figure 32-a-*.  
Slide clamping sleeves ⇒ *Figure 32-2-* over the pipe adapters.



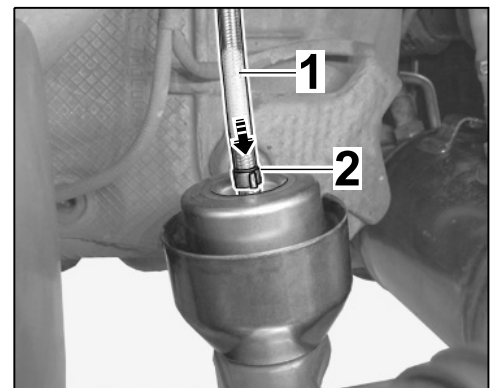
*Figure 32*

- 7.7 Install restraining straps ⇒ *Figure 33-1-*.



*Figure 33*

- 7.8 Slide vacuum line at the left and right ⇒ *Figure 34-1-* onto the exhaust flap control box and press one-ear hose clamp ⇒ *Figure 34-2-* together.

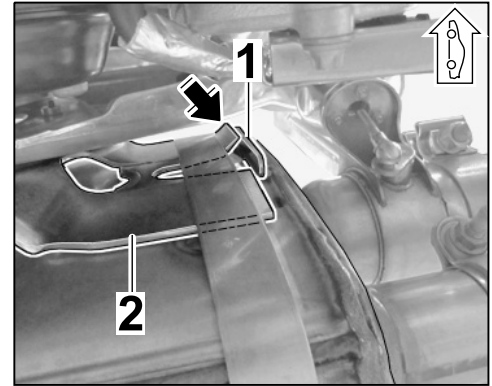


*Figure 34*

- 7.9 Position main silencer with lock ⇒ *Figure 35*  
-1- on the main silencer holder ⇒ *Figure 35*  
-2- (⇒ *Figure 36* -**arrow**-).

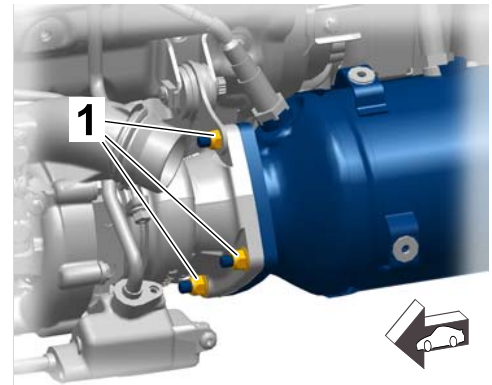
Tighten restraining straps.

**Tightening torque 15 Nm (11 ftlb.) +/-10 %**

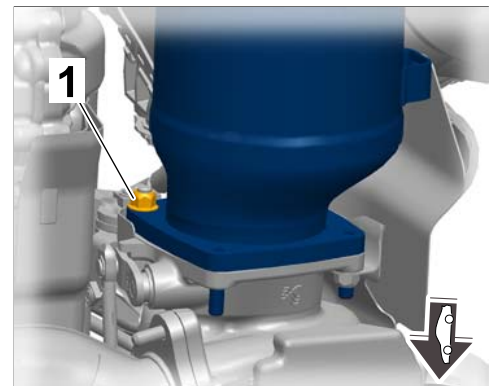


*Figure 35*

- 7.10 Install and tighten the remaining hexagon nuts ⇒ *Figure 36* -1- securing the catalytic converters to the turbocharger.  
**Tightening torque 25 Nm (19 ftlb.) +/-10 %**



*Figure 36*

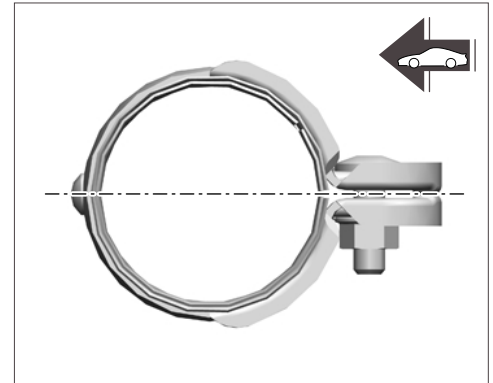


*Figure 37*



**Information**

It is important to ensure that the clamps and pipe joiners are tightened in horizontal position.



Clamps must be horizontal when tightened

7.11 Tighten clamping sleeves ⇒ *Figure 38-4-* and clamps ⇒ *Figure 38-1-*.

7.11.1 Tighten clamping sleeves.  
**Tightening torque 30 Nm (22 ftlb.)**

7.11.2 Tighten clamps.  
**Tightening torque 55 Nm (41 ftlb.) +/-10%**

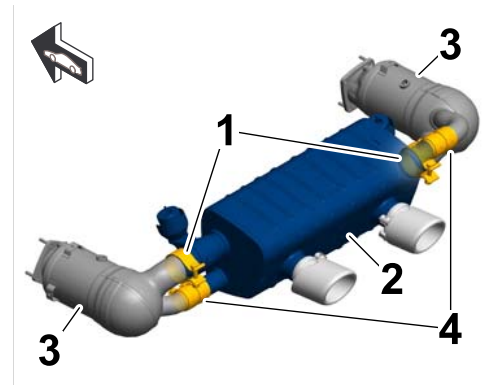


Figure 38

7.12 Install heat shield for turbocharger at the left ⇒ *Figure 39-2-* and right.

8 Convert heat shield on bumper.

8.1 Remove standard heat shield from rear bumper.

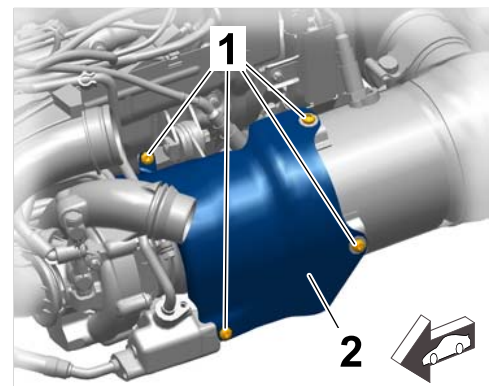


Figure 39

- 8.1.1 Unscrew tapping screw ⇒ *Figure 40-1-* and remove bracket ⇒ *Figure 40-2-*.

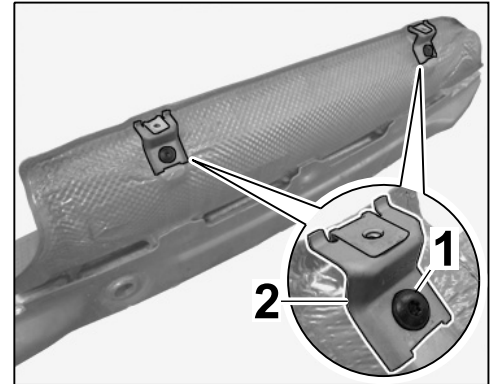


Figure 40

- 8.1.2 Unscrew hexagon nuts ⇒ *Figure 41-1-* and remove rear supports ⇒ *Figure 41-2-*.

- 8.1.3 Disconnect heat shield and rear bumper.

- 8.2 Assemble new heat shield and bumper.

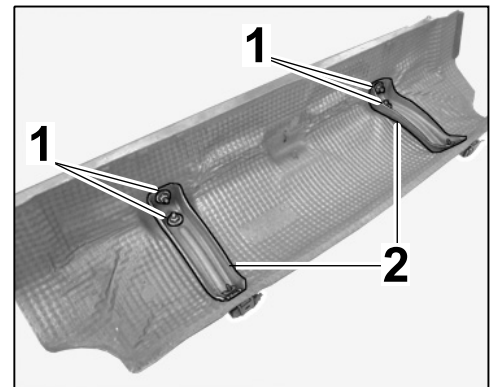


Figure 41

- 8.2.1 Position rear support ⇒ *Figure 42-1-* on the heat shield. Screw on and tighten hexagon nuts ⇒ *Figure 42-2-*.

**Tightening torque 9.7 Nm  
(7.5 ftlb.)**

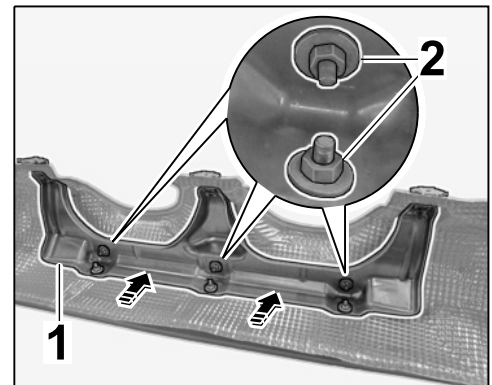


Figure 42

- 8.2.2 Position fastening bracket ⇒ *Figure 43-1-* and screw in and tighten tapping screw ⇒ *Figure 43-2-*.  
**Tightening torque 2.8 Nm (2 ftlb.)**

9 Convert rear apron.

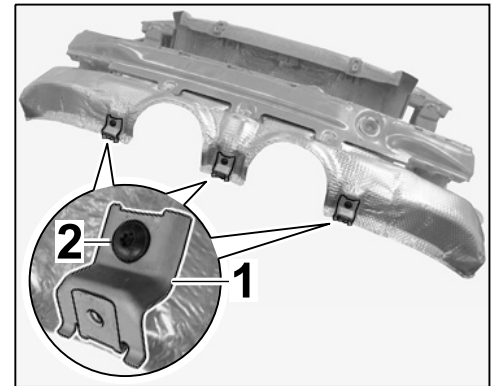


Figure 43

- 9.1 Remove rear skirt. ⇒ *Workshop Manual '636819 Removing and installing rear skirt'*

- 9.2 Make cut-out for new rear skirt.

- 9.2.1 Mark rear apron.



Figure 44

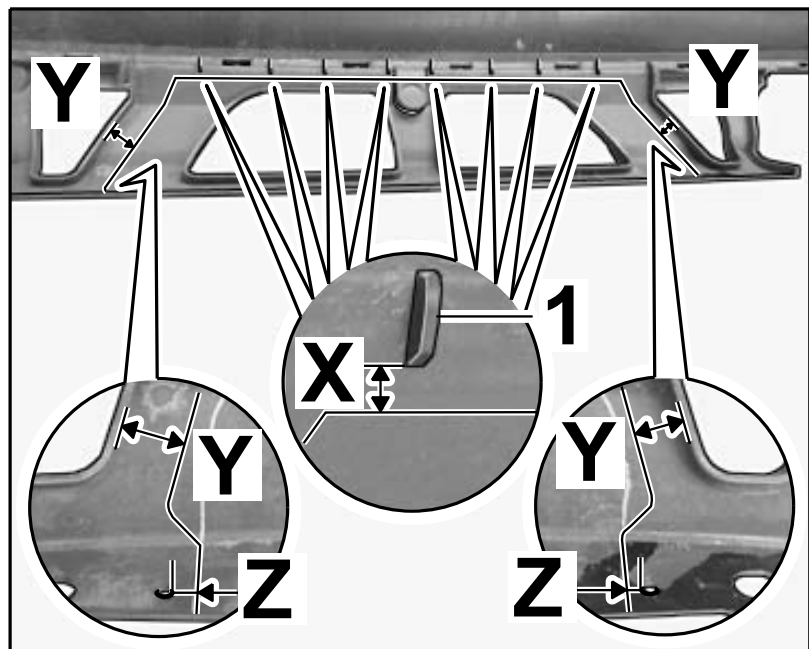


Figure 45

- 1 - Bar
- X - Distance from bar: 5 mm
- Y - Dimension = 16 mm

Z – Distance from edge of hole: 5 mm

9.2.2 Saw along the marking using a body saw.

Re-work cut edges if necessary.

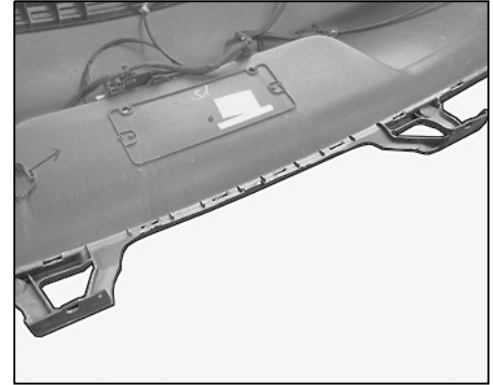


Figure 46

9.3 Clip tailpipe cover ⇒ *Figure 47-1*- into the rear skirt ⇒ *Figure 47-2*-.

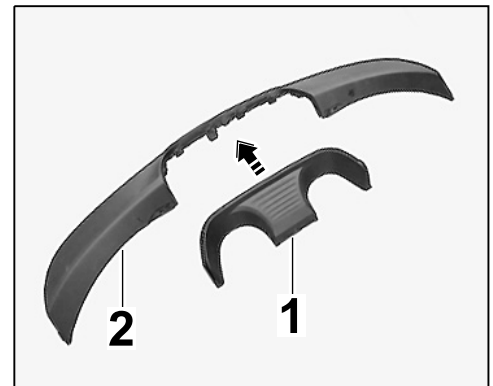


Figure 47

9.4 Clip rear skirt ⇒ *Figure 48-1*- into the rear apron ⇒ *Figure 48-2*-.  
Screw in and tighten screws ⇒ *Figure 48-3*-.

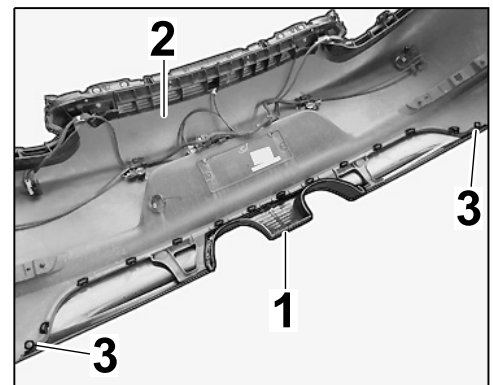


Figure 48

9.5 Secure center retaining strip ⇒ *Figure 49 -2-* and two retaining strips at the outside ⇒ *Figure 49-1-* to the rear apron using rivets.

10 Concluding work:

10.1 Install the air cleaner housing. ⇒ *Workshop Manual '242519 Removing and installing the air cleaner housing'*

10.2 Install pressure pipe. ⇒ *Workshop Manual '214119 Removing and installing pressure pipe'*

10.3 Connect vacuum line.

- A** – Without sports exhaust system
- B** – With sports exhaust system

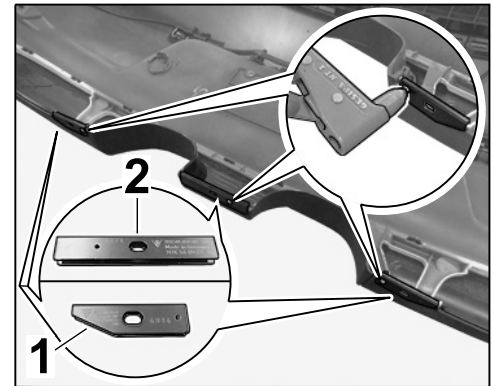


Figure 49

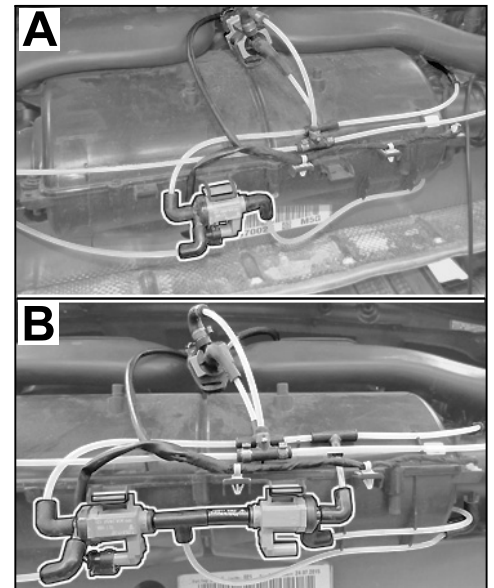


Figure 50

10.3.1 Install vacuum valve ⇒ *Figure 51 -1-* into the holder ⇒ *Figure 51 -a-*.

Pull off moulded hose ⇒ *Figure 51 -2-* (⇒ *Figure 51 -b-*).

Pull moulded hose ⇒ *Figure 59-2-* off the standard vacuum line.

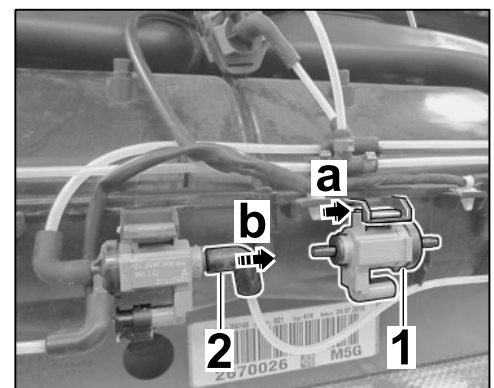


Figure 51

- 10.3.2 Cut 20 mm  $\Rightarrow$  *Figure 52-1*- off the plastic tube (900.918.005.40).

Make a marking in the center.

Install connecting hose (999.239.048.40)  $\Rightarrow$  *Figure 52-2*- and T-piece (06E.133.794)  $\Rightarrow$  *Figure 52-3*- as far as the marking on the plastic tube (20 mm).

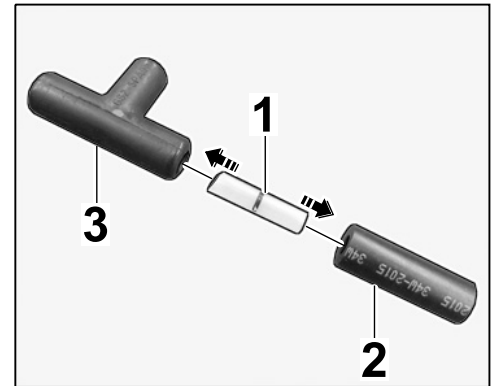


Figure 52

- 10.3.3 Install connecting line  $\Rightarrow$  *Figure 53-1*- between the vacuum valves  $\Rightarrow$  *Figure 53-a*-.

Insert standard vacuum line  $\Rightarrow$  *Figure 53-2*- at least 10 mm into the T-piece  $\Rightarrow$  *Figure 53-b*-.

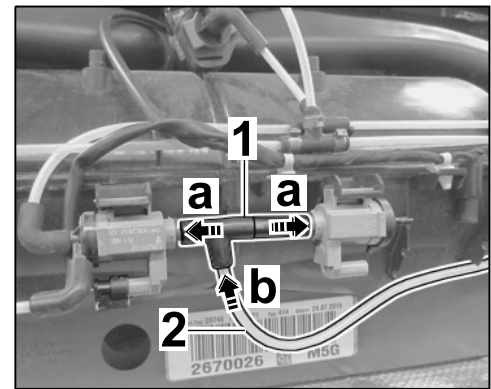


Figure 53

- 10.3.4 Cut 50 mm off the plastic tube (900.918.005.40)  $\Rightarrow$  *Figure 54-2*-.

Insert plastic tube (50 mm) at least 10 mm into the moulded hose  $\Rightarrow$  *Figure 54-1*- ( $\Rightarrow$  *Figure 54-arrow*-).

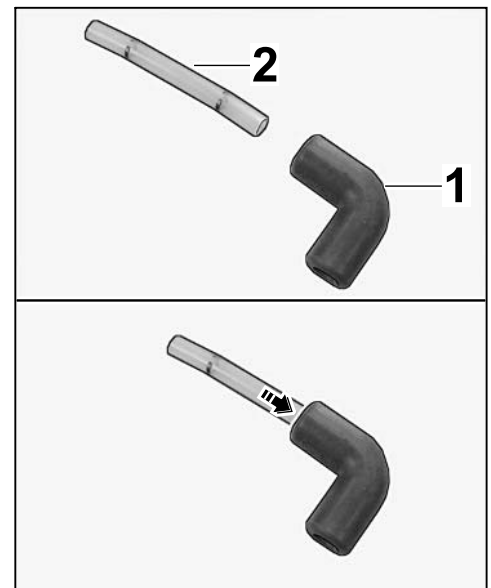


Figure 54



10.3.5 Install moulded hose ⇒ *Figure 55 -2-* on the vacuum valve.

Cut standard vacuum line ⇒ *Figure 55-1-* at the same height as the plastic tube (50 mm).

Cut 5 mm off the ends at both sides.

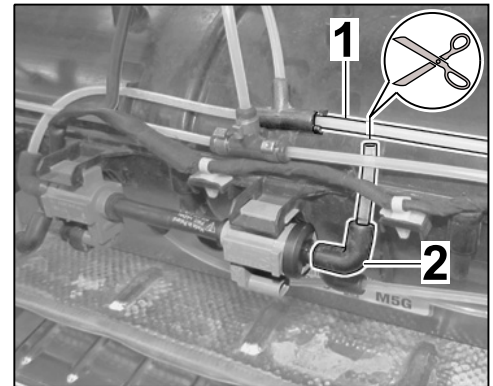


Figure 55

10.3.6 Insert the ends ⇒ *Figure 56 -arrows-* of the vacuum line you have just cut at least 10 mm into the T-piece ⇒ *Figure 56-1-*.

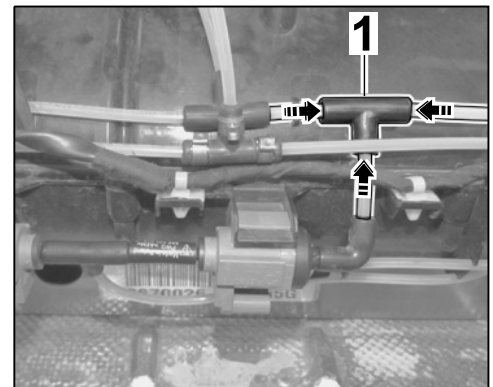


Figure 56

10.3.7 Connect the new vacuum line ⇒ *Figure 57-1-* to the new vacuum valve ⇒ *Figure 57-2-* (⇒ *Figure 57 -arrow-*).

Connect electric plug connection.

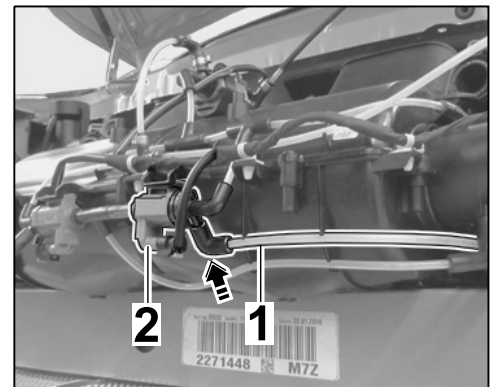


Figure 57

- 10.4 Install air guide for charge-air cooler ⇒ *Figure 58-1, 2-*.
- 10.5 Install rear spoiler. ⇒ *Workshop Manual '66581905 Removing and installing rear spoiler'*
- 10.6 Install engine-compartment blower. ⇒ *Workshop Manual '198119 Removing and installing engine-compartment blower'*
- 10.7 Install bumper.
- 10.7.1 Unscrew screws ⇒ *Figure 59-1-* on the heat shield.
- 10.7.2 Install bumper together with heat shield. ⇒ *Workshop Manual '635019 Removing and installing rear bumper'*

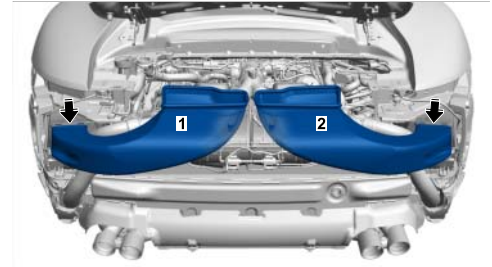


Figure 58



Figure 59

- 10.7.3 Tighten screws ⇒ *Figure 60-1-* on the heat shield.

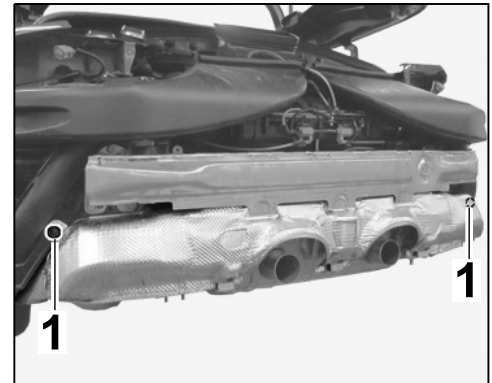


Figure 60

10.8 Install rear apron. ⇒ *Workshop Manual '635519 Removing and installing rear apron'*

Secure rear apron in the center using a new tapping screw (999.073.227.09 ⇒ *Figure 61-1-*).

10.9 Install tailpipe covers. ⇒ *Workshop Manual '263519 Removing and installing tailpipe cover'*

10.10 Install tail lights. ⇒ *Workshop Manual '943119 Removing and installing tail light'*

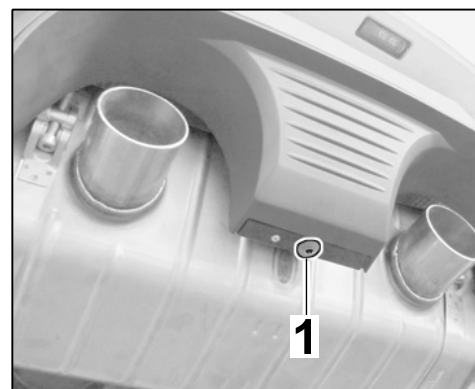


Figure 61

**WARNING**

**Moving components**

- **Danger of limbs being trapped or severed**
- ⇒ **Do not reach into the danger area.**
- ⇒ **Secure the system to prevent it from being activated accidentally.**
- ⇒ **Keep third parties away from the danger area.**

10.11 Retract the rear spoiler manually using the rocker switch in the passenger compartment.

10.12 Convert switch console.

10.12.1 Remove switch console. ⇒ *Workshop Manual '962719 Removing and installing switch console'*



**Information**

The switch console consists of a total of 16 buttons, 10 light guides and 10 trims. Each half can be used for the left or right row of the main body.

10.12.2 Assemble new switch console in accordance with the new vehicle equipment.

Install light guide at the correct side  
⇒ *Figure 62-1-* in the main body ⇒  
*Figure 62 -arrow-*.

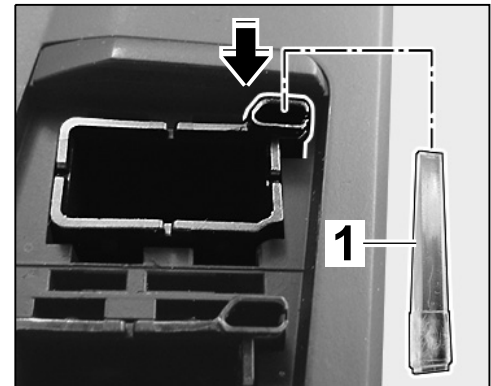


Figure 62

Install trim ⇒ *Figure 66-1-*  
underneath the button in the main  
body ⇒ *Figure 66 -arrows-*.

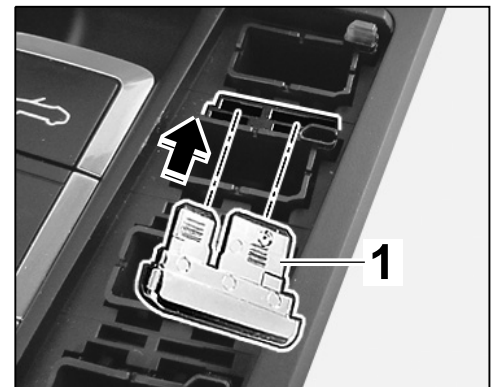


Figure 66

Position button ⇒ *Figure 67-1-* and  
clip it into the main body ⇒ *Figure  
67 -arrow-*.

10.12.3 Install switch console. ⇒ *Workshop  
Manual '962719 Removing and  
installing switch console'*

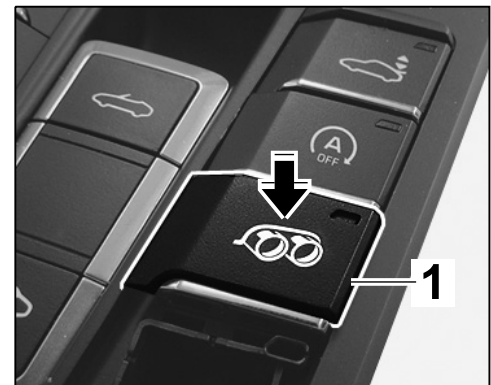


Figure 67

#### NOTICE

##### Voltage drop

- Risk of irreparable damage to control unit
- Risk of damage to control unit

- **Fault entries in the control unit**
  - **Coding in the control unit is aborted**
  - **Malfunctions in control unit, even during programming**
- ⇒ **Switch off the ignition and remove the ignition key before disconnecting the control unit.**
- ⇒ **Ensure that the power supply is not interrupted during programming.**
- ⇒ **Connect a battery charger with a current rating of at least Nominal value 90 A to the vehicle battery.**



### Information

The **9900 - PIWIS Tester III** instructions take precedence since the description may be different with later Tester releases.

The procedure described here has been structured in general terms; different text or additions may appear on the **9900 - PIWIS Tester III**.

## 11 Code the sports exhaust system.

11.1 **9900 - PIWIS Tester 3** must be connected before switching on the ignition.

11.2 Select the required vehicle type. PIWIS Tester Diagnostics starts.



### Information

The sport exhaust system button can only be coded on the right-hand side of the switch console.

11.3 Code keypad assignment. ⇒ *Workshop Manual '962755 Replacing switch console'*

11.4 Maintenance of vehicle data

11.4.1 Select Additional menu by pressing •F7" .

11.4.2 Select the "Maintenance of vehicle data" function. Press •F12" until "M numbers" appears in the Value group column.

11.4.3 Select "176 - Sports exhaust system" in the Coding value column. When you touch the Installed cell, a tick appears.

11.4.4 Save the values with •F8" . Wait until the message "Modified values have been buffered appears".

11.4.5 Press •F12" until •F8" can be activated.

11.4.6 Press •F8" to write values. Wait until the message "Generation of vehicle data is complete" appears.

11.4.7 Press •F12" to switch to Report management. Open the log by pressing •F10" and check that vehicle equipment "176 Sports exhaust system" is displayed.

- 11.5 Adapt coding.
- 11.5.1 Press **•F11** to return to the list of control units.  
Select all control units.
- 11.5.2 Switch to the "Codings/adaptations" menu.  
Select "Automatic coding" mode. Press **•F12** to continue.  
Wait until the message "Coding was completed successfully" appears. Press **•F12** to continue.
- 11.6 Read out the fault memories of all systems, work through any existing faults and erase the fault memories. ⇒ *Workshop Manual '033500 Fault memory for on-board diagnosis'*
- 11.7 Switch off ignition and disconnect **9900 - PIWIS Tester 3**.
- 11.8 Carry out a function test on the "sports exhaust system".  
The exhaust flaps open when you press the "Twin tailpipe" button. The noise of the exhaust motor can be heard.
- 11.9 Disconnect battery charger. ( ⇒ *Workshop Manual '2X00IN Battery trickle charging'*).

26 01 31 01: –Installing sports exhaust system–  
Includes:

Labor time: **724 TU**

Removing and installing exhaust system, rear skirt, strip for switches and rear BCM; replacing catalytic converters and main silencer; installing wire harness; coding sports exhaust system and strip for switches.

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