

ROUSH Active 10 Exhaust

Installation Instructions
P/N: 422128 (R1318-5231 LITE)
Fastback GT Convertible GT V8



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Application: 2018 Ford Mustang

Important Note:

Before installing the ROUSH Performance Product, please read through the installation procedure and verify that all items are present. If you are missing hardware or have any questions, please contact ROUSH Performance at 1-800-59-ROUSH, 9:00 AM to 5:00 PM EST.

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**PACKING LIST FOR 2018+ MUSTANG GT ACTIVE LITE QUAD-TIP EXHAUST KIT
 (COUPE AND CONVERTIBLE)**

Description	Part Number	Quantity
Active Exhaust Quad Tips		
Muffler V8 Active LH	1315-5232AVCV	1
Muffler V8 Active RH	1315-5230AVCV	1
On/Off Active Switch Wiring Harness	1118-9L430	1
Dual Valve Y Harness	1118-9L432	1
LH Tip, Dual Wall Round (Black)	1318-AVTIPLH	2
RH Tip, Dual Wall Round (Black)	1318-AVTIPRH	2
Exhaust Heat Shield Kit		
Exhaust Heat Shield	1315-5231SHLD	2
M8-1.25 DIN 6923 Steel Class 8 Zinc Flange Nut	NM8X125HF	4
M10x30/M8x16 - Exhaust Heat Shield Stud	W717354	4
Exhaust Pipe With Valve RH	1315-6505RH	1
Exhaust Pipe With Valve LH	1315-6506LH	1
Zip Ties	ZIP-TIE-KIT	1
Edge Clips Zip Tie	156-00865	3
Exhaust Hardware Kit, MOR		
Rivet Nut M8x1.25 - Zinc Plated	95105A191	4
Exhaust Hanger - Rubber Isolator	BR3Z-5A262	2
Bolt - M8x1.25x29 Hex Flange Dogpoint Fully Threaded 8.8	W500224	4
Quad Tip Mustang Exhaust Hardware Kit		
Clamp - 2.5" Torca Accuseal - Tip to Muffler (304SS)	10-0338	4
Clamp - 2.5" Torca Duraseal - Pipe to Muffler (409SS)	94-0053	2
Exhaust Hanger, LH	1315-5A261	1
Exhaust Hanger, RH	1315-5G298	1
Heat Shield Clamp - 2.5"	16700070	4
Block off gasket	CV6Z-9450	2
Nut, Flange M8 x 1.25	NM8X125HF	4
Exhaust Hardware Kit		
Installation Nut - M10x1.5	W500224-S437	1
Bolt - M8x1.25x29 Hex Flange Dogpoint Fully Threaded 8.8	90592A024	1

EQUIPMENT AND SUPPLIES REQUIRED

- Trim Tool
- Tape Measure
- Scissors
- Masking Tape
- Center Punch
- Marker
- 7 mm Deep Socket
- 8 mm Socket
- 10 mm Socket
- 3/8" 13 mm Socket
- 3/8" 15 mm Socket
- 17 mm Socket

- Drill
- 1/8", 1/4" and 17/32" Drill Bits
- Philips Head Screwdriver
- Wire Cutters
- Exhaust Pipe Cutting Tool
- Needle-nose Pliers
- 3/8" Drive Ratchet
- 3/8" Extension
- 3/8" Torque Wrench
- Small Pick
- Flat-head Screwdriver
- Razor Blade
- Deburr Tool
- 20 mm Hole Saw/Drill Bit
- Corrosion Inhibitor (Motorcraft PMP-19500-6000
Clear Topcoat recommended)

If you are missing any items, please call us toll free at 1-800-59-ROUSH.

LIMIT OF LIABILITY STATEMENT

The information contained in this publication was accurate and in effect at the time the publication was approved for printing and is subject to change without notice or liability. ROUSH Performance Products (RPP) reserves the right to revise the information presented herein or to discontinue the production of parts described at any time.

SAFETY PRECAUTIONS



CAREFULLY READ THE IMPORTANT SAFETY PRECAUTIONS and WARNINGS BEFORE PROCEEDING WITH THE INSTALLATION!

Appropriate disassembly, assembly methods and procedures are essential to ensure the personal safety of the individual performing the kit installation. Improper installation due to the failure to correctly follow these instructions could cause personal injury or death. Read each step of the installation manual carefully before starting the installation.

- Always wear safety glasses for eye protection.
- Place ignition switch in the OFF position.
- Always apply the parking brake when working on a vehicle.
- Block the front and rear tire surface to prevent unexpected vehicle movement.
- If working with a lift, always consult vehicle manual for correct lifting specifications.
- Operate the engine only in well-ventilated areas to avoid exposure to carbon monoxide.
- Do not smoke or use flammable items near or around the fuel system.
- Use chemicals and cleaners in well-ventilated areas.
- Batteries produce explosive gases, which can cause personal injury. Therefore, do not allow flames, sparks or flammable substances to come near the battery.
- Keeps hands and any other objects away from the radiator fan blades.
- Keep yourself and your clothing away from moving parts when the engine is running.
- Do not wear loose clothing or jewelry that can get caught in rotating parts or scratch surface finishes.
- Allow the engine, cooling system, brakes and exhaust to cool before working on a vehicle.

WORK SAFELY!

Perform this installation on a good clean level surface for maximum safety and with the engine turned off.

NOTE: For convertible installation ONLY, follow the section below titled “Rear Sub Frame Removal”

REAR SUB FRAME REMOVAL

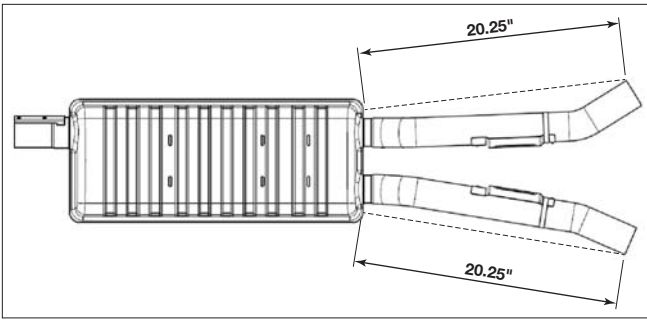
1. Convertible Mustangs have a rear sub frame connector that needs to be removed in order to install the ROUSH exhaust system. In order to do so, remove sixteen (16) 15 mm bolts and lower the sub frame connector to the ground with the help of an assistant. After removal, follow the remaining steps in the installation guide before finally following the reverse of this step to re-install the sub frame connector. Torque to 46 lb-ft (63 Nm).



REMOVING STOCK EXHAUST

1. Using a suitable exhaust pipe cutting tool, cut completely through the stock exhaust in the two (2) locations shown below.





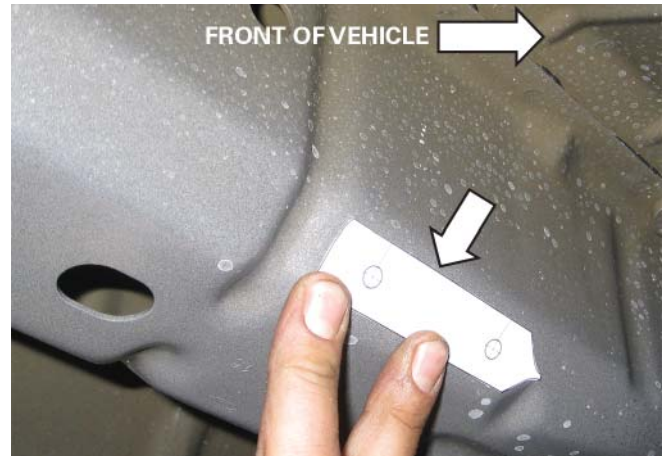
Exhaust Cut Point



2. Remove the two (2) 13 mm bolts that retain the exhaust hangers on the IRS sub frame. Push up on heat shields.

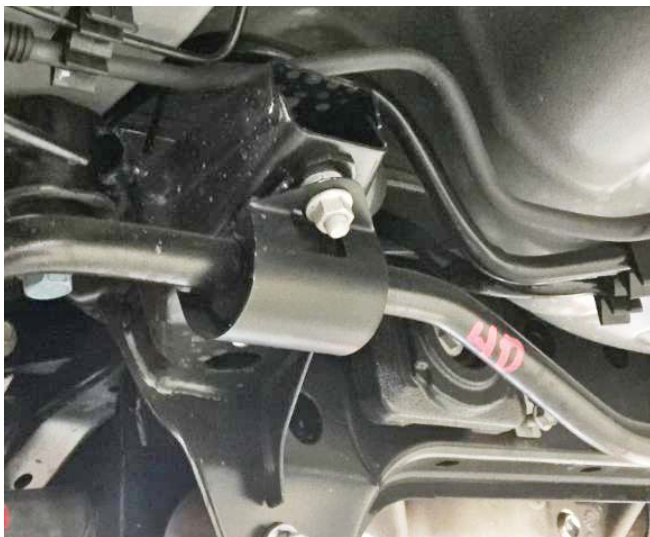


- Unhook each exhaust hanger from the sub frame and remove each muffler assembly by sliding the inlets down and forward to extract the rear exhaust hangers from their mounts.



QUAD TIP GT V8 EXHAUST INSTALLATION

- With the rear wheels off of the ground, remove and replace the rear sway bar bushing bolts one at a time with the new studs (P/N: W717354) that are found in the heat shield kit (P/N: 1315-5231EXHK). Install the heat shields (P/N: 1315-5231SHLD) with the nuts (P/N: NM8X125HF) that are included in the heat shield kit.



- Drill all four (4) pilot holes that were marked in the previous step with a 1/8" drill bit followed by a 17/32" drill bit.



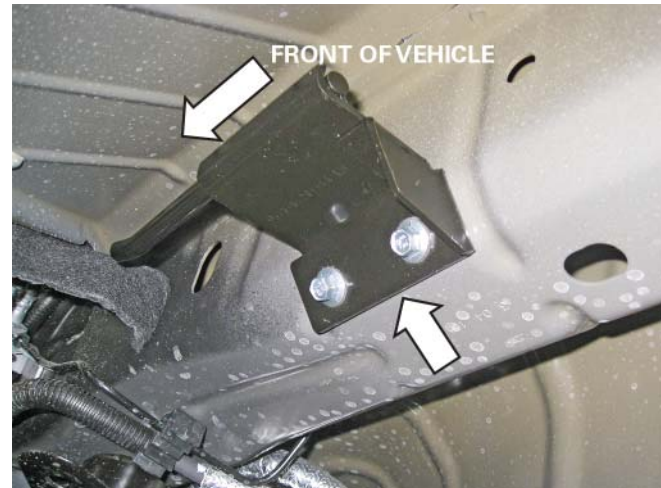
- Locate the template onto the rear chassis sub frame as shown in the pictures below and mark the drill holes with a center punch. Use the same template to mark the holes on both the RH and LH sides of the vehicle.



4. Deburr the drilled holes and apply automotive clear coat. Install four (4) rivet nuts (P/N: 95105A191) using the supplied bolt (P/N: 500224) and nut (P/N: 90592A024) from the rivet nut installation kit (P/N: R1315-5231HWK). Insert the nut onto the bolt and thread the bolt into the rivet nut. Hold the nut with a 17 mm wrench and tighten the bolt nut with a 10 mm socket until the rivet nut is fully seated.



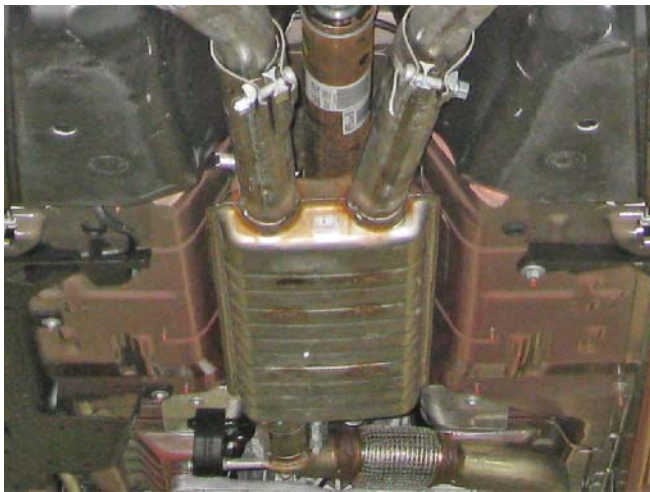
5. Install the two (2) supplied exhaust hangers (P/N: 1315-5A261 and 1315-5G298) and four (4) bolts (P/N: W500224) as shown below. Torque to 18 lb-ft (25 Nm).



6. Remove the two (2) IRS sub frame mounted exhaust hangers from the stock exhaust system and slide them onto each side of the ROUSH exhaust.



7. Slide the rubber exhaust isolators (P/N: BR3Z-5A262) onto the rear muffler hangers. Install the block off gaskets (P/N: CV6Z-9450), followed by the block off plates and finally the outlet couplers onto both of the flanged outlets on the muffler assemblies (P/N: 1315-5232AVCV and 1315-5230AVCV). Secure the outlet couplers with the four (4) nuts (P/N: NM8X125HF) and torque to 18 lb-ft (25 Nm). Slide on the heat shield clamps (P/N: 1600070). Slide the exhaust pipe clamps (P/N: 94-0053) onto each outlet of the forward section of the factory exhaust.



8. Install each side of the ROUSH exhaust system by inserting the rear exhaust hangers first and then sliding each side forward to fully seat the inlets with the forward section of the stock exhaust. Be sure to connect the rubber isolators to the hangers that were installed in step 7 and also reinstall the two (2) IRS sub frame exhaust hangers with the two (2) 13 mm bolts that were removed in step 2 and torque to 18 lb-ft (25 Nm). Tighten the heat shield clamps. Torque the exhaust pipe clamps to 35 lb-ft (47 Nm).





ACTIVE LITE EXHAUST INSTALLATION

1. Begin the installation by first opening the hood and disconnecting the battery (refer to the owner's manual for guidance). Next open the trunk and remove the spare tire cover panel and rear trunk trim panel. To remove the rear trunk trim panel, loosen the four (4) plastic nuts by hand, push the outer ends forward towards the front of the vehicle and slide the panel upwards to release the remaining clips that are on the backside of the panel.



2. Remove two (2) push pins along the passenger side trunk carpet if the vehicle is a fastback. If the vehicle is a convertible, remove the three (3) push pins along the passenger side trunk carpet.

NOTE: Right-hand drive vehicles must mount the module on the right-hand side of the vehicle.



3. Remove the bottom portion of the rear seat by pushing in on the latches that are under the front edge on each side and lifting the seat up.



4. Remove the door sill trim piece by first lifting up at the front corner and then disengaging the clips along the bottom.



5. Remove the rear quarter panel trim piece by first removing the seat belt guide trim ring and then firmly pulling inwards along the panel to disconnect the plastic clips along the back.

NOTE: For fastback models, first release the upper portion of the rear seat and fold it down to gain access to the seat belt guide trim ring.



NOTE: For convertible models, after removing the seat belt guide trim ring, remove the top trim piece by first lifting up at the front and disengaging the clips along the bottom. Now remove the quarter panel trim piece as previously instructed.



6. Remove the passenger side trunk carpet.

NOTE: For fastback models, remove the push pin that is located near the passenger side rear seat belt.



Active Module Relay



Dual Valve Y Harness



12V Outlet Connector



Fuse Tap

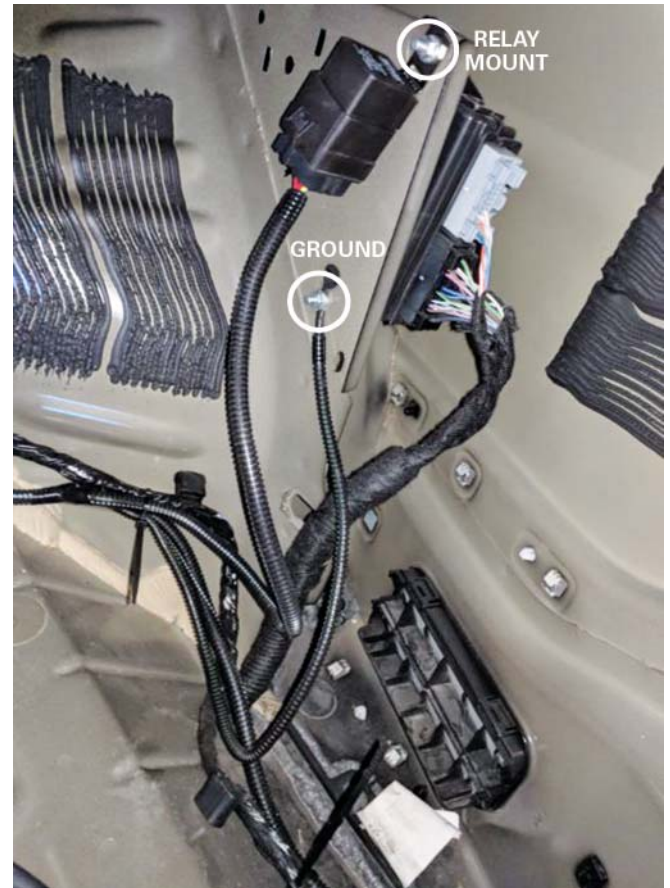


Active Valve Connector

- Remove the rubber cap that is on the passenger side of the trunk floor. Locate the section of the active exhaust wiring harness (P/N: 1118-9L430) and feed the one (1) connector through the hole in the trunk floor that the rubber cap was removed from. Fully seat the grommet from the active exhaust wiring harness into the sheet metal of the trunk floor.



- Remove the bottom bolt (MM) and insert the ring terminal between the bolt and the body panel. (Ground) Remove the top bolt (MM) and insert the relay between the bolt and the body panel. Tighten both of the bolts to 5 Nm.



- Route the wiring harness along the driver side of the trunk into the cabin and secure with both the standard 7" zip ties (P/N: CTUV740) and the zip ties with edge clips (P/N: 156-00865) as shown. Trim the tails of the zip ties once they are secure.
- Re-install the driver side trunk carpet (and trunk light, if equipped). Re-install the rear trunk trim panel by reversing the removal process outlined in step 2. Re-install the spare tire cover panel.
- Continue routing the wiring harness along the driver side of the vehicle and secure with the standard 7" zip ties (P/N: CTUV740) as shown.
- Remove the passenger side kick panel and door trim by pulling up firmly.
- Remove the two (2) 10 mm bolts that hold down the electrical tray.



14. Remove the zip ties from the door sill cover.



15. Remove the plastic push pins with trim removal tool.



16. Route the active exhaust wire harness along the outside of the factory wiring harness in the wire harness housing. Close the wire harness housing and apply new sections of tape to secure it closed.





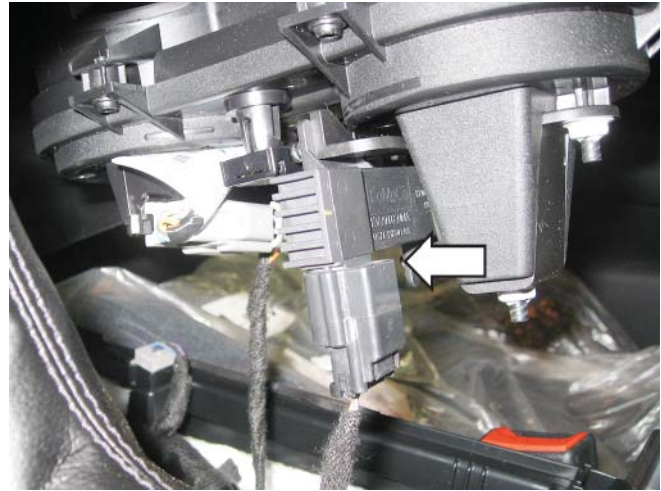
17. Reinstall the two (2) 10 mm fasteners that secure the door sill wire harness housing which were removed in step 13 and torque to 2 Nm. Reinstall the two (2) push pins that retain the carpet to the wire harness housing that were removed in step 15.
18. Re-install the rear quarter trim panel and the bottom portion of the rear seat by reversing the process outlined in steps 4 and 6.
19. Remove the side trim pieces along the center console by lifting the front lower corners and carefully disengage the retaining clips along the back. Remove two (2) 7 mm fasteners on each side of the console once the trim pieces are removed.



20. Remove the molded rubber tray from in front of the shifter.



21. Using a non-marring trim tool, gently lift each of the rear corners of the center console and disengage the retaining clips along the bottom from the rear all the way up to the front.



23. Release the clips for the shifter trim bezel and remove the top section of the center console from the vehicle.



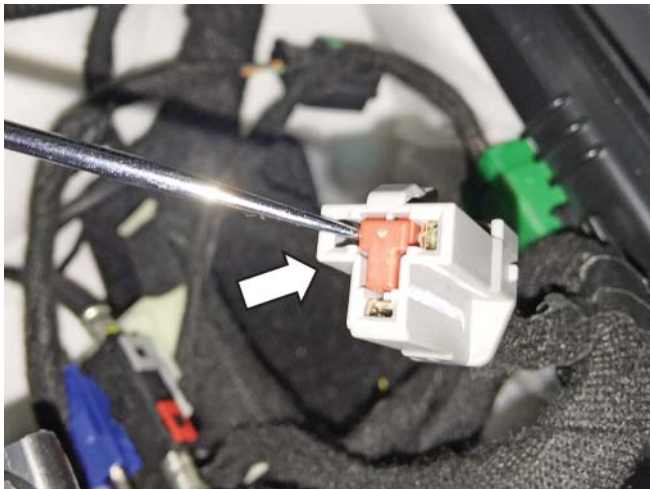
22. With the emergency brake fully engaged, lift the top portion of the center console up and unplug the connectors for the key fob detection circuit and for the cup holder lighting (if equipped). Pull back on the center console to release the clips.



24. Continue routing the wire harness up through the driver side kick panel area and secure as shown.



25. Unplug the connector for the 12-volt power outlet that is in the center console. Using a small pick, remove the red locking piece that is in the end of the connector. Carefully lift the tab for the grey with orange wire in the connector and remove the terminal from the connector.
26. De-pin the white and blue wire from the plug using a de-pinning tool.



27. Take the yellow lead from the active exhaust wiring harness (P/N: 1315-9L430) that has the same terminal on the end and insert it into the spot in the 12-volt power outlet connector that was de-pinned in step 24. Replace the red locking piece that was in the end of the connector.
28. Remove the rear clip and seal from the new connector that is bagged and taped to the active exhaust harness. Insert the clip and then the seal onto the grey with orange wire that was removed from the 12-volt power outlet connector and then insert into the new connector as shown.



29. Check to make sure all the connections are fully seated, slide the seal into place as well as the rear clip. Plug the connector into the active exhaust wiring harness (P/N: 1118-9L430) and press the red lock in the front of the connector to lock it in place.
30. Plug the factory 12-volt power outlet connector back into the 12-volt outlet in the center console and route the active exhaust wiring harness in the center console as shown.



31. Locate the lead on the active exhaust wiring harness with the fuse tap on the end and route it outside of the console along the dash structure up to the passenger side kick panel and secure the harness with standard 7" zip ties (P/N: CTUV740) as shown.



32. Remove the fuse panel cover in the passenger kick panel area and remove fuse #23 (10 amp) from the fuse panel. Plug the 10-amp fuse into the fuse tap that is located in the active exhaust wiring harness (P/N: 1118-9L430). Plug the fuse tap into the fuse slot location #23. The harness can be zip tied up out of the path of the airbag or it can be cut and reduced in length.



33. Reinstall the fuse panel cover.

34. Locate the red active on/off switch and determine the desired mounting location. Be sure to have enough wire routing length to accommodate your location.

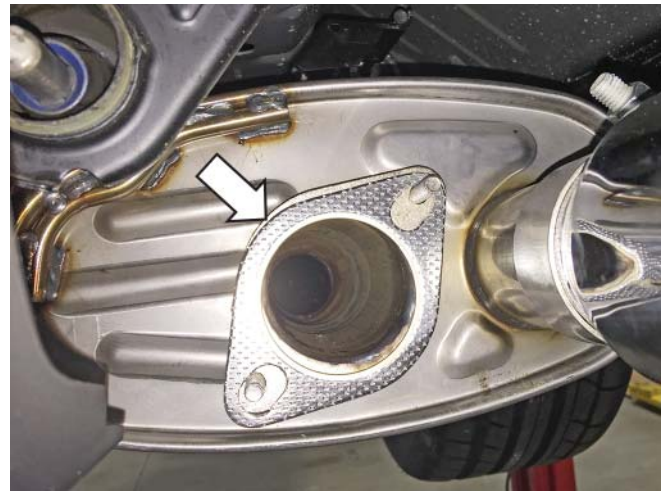


35. Trim out the drill template that is located on the last page of this installation manual. Mark the desired location. Using a step bit, drill a 13/16" hole.

36. Press the switch into the panel and reinstall all panels removed in the previous steps.



37. Locate the active exhaust valve assemblies (P/N's: 1315-6506LH and 1315-6505RH) and install them in place of the straight outlet couplers that are included on the ROUSH Quad Tip Exhaust. Reuse the existing gaskets, nuts, tips and clamps. Torque the nuts to 25 Nm (18 ft-lb) and torque the clamps for the exhaust tips to 47 Nm (34 ft-lb).



38. Slide each exhaust tip (P/N: 1318-AVTIPLH [left hand] and 1318-AVTIPRH [right hand]) onto the muffler outlets with the exhaust tip clamps (P/N: 10-0338). Align the tips to the rear valance. Torque the exhaust tip clamps to 35 lb-ft (47 Nm).



NOTE: If the vehicle is a convertible, be sure to re-install the rear sub frame by reversing step 1 titled "Rear Sub Frame Removal".

39. Locate the wiring harness that is routed through the grommet in the trunk floor. Route the short lead to the passenger side valve and the long lead to the driver side valve.
40. Secure the wiring to the sheet metal edge under the vehicle using the edge clips with zip ties (P/N: 156-00865) as shown and plug the respective connectors into each valve.

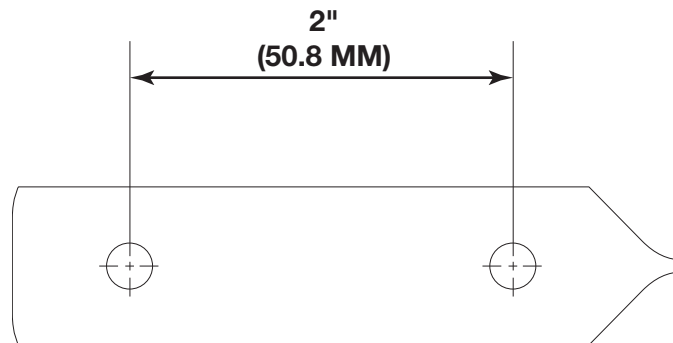


41. Reconnect the battery, start the vehicle and test your new ROUSH active exhaust.

Congratulations, the installation is complete!



DRILL TEMPLATE



NOTE: Print this page at 100% scale and verify that the drill template has printed properly by measuring it after it is printed.