

## Exhaust System Installation for Subaru Impreza WRX + STI PNs-140264,140381,140418, & 140595



**\*\*\*\*\* Please compare the parts in the box with the bill of materials provided \*\*\*\*\*  
(view the following pages) to assure that you have all the parts necessary for this installation.**

These instructions have been written to help you with the installation of your Borla Performance System. Please read this document completely before beginning the installation of your system.

To ensure this part number fits your specific model year, please visit our website for the latest model year listings at [www.BORLA.com](http://www.BORLA.com)

**Thank you for purchasing a Borla Performance Cat-Back™ Exhaust System.**

**Borla Performance Cat-Back™ Exhaust Systems (PN-140264, 140381) are designed for the Subaru Impreza WRX Sedan equipped with a 2.5L opposed 4-cylinder engine, AWD automatic or manual transmissions.**

**Borla Performance Cat-Back™ Exhaust System (PN-140418) is designed for the Subaru Impreza WRX STI Sedan equipped with a 2.5L opposed 4-cylinder engine, AWD manual transmission.**

**Borla Performance Cat-Back™ Exhaust System (PN-140595) is designed for the Subaru Impreza WRX & WRX STI Sedan equipped with a 2.0L & 2.5L opposed 4-cylinder engine, AWD automatic or manual transmissions.**

Borla Performance Industries recommends that an exhaust shop or professional after market parts installer perform the installation of this system. However, if you decide to perform the installation on your own it is recommended that two people are used. This installation should not be performed by one person due to the risk of injury. Ensure the installers use all under car safety precautions including eye protection.

*Please take time to read and understand the following...*

By installing your Borla Performance Exhaust System, you indicate that you have read this document and you agree with the terms stated below.

It is the responsibility of the purchaser to follow all installation instruction guidelines and safety procedures supplied with your Borla Performance Exhaust System.

Borla Performance Industries assumes no responsibility for damages occurring from misuse, abuse, improper installation, improper operation, lack of responsible care, or all previously stated reasons resulting from incompatibility with other manufacturer's products and/or systems.

Included with your Borla Performance Exhaust System is a warranty card. Please read it carefully before you begin any work on your vehicle. If you should have any questions regarding our warranty policy, installation, or any other matter pertaining to your new Borla Performance Exhaust System, please give us a call at the number provided on the warranty card.

**Minimum Required Tool List:**

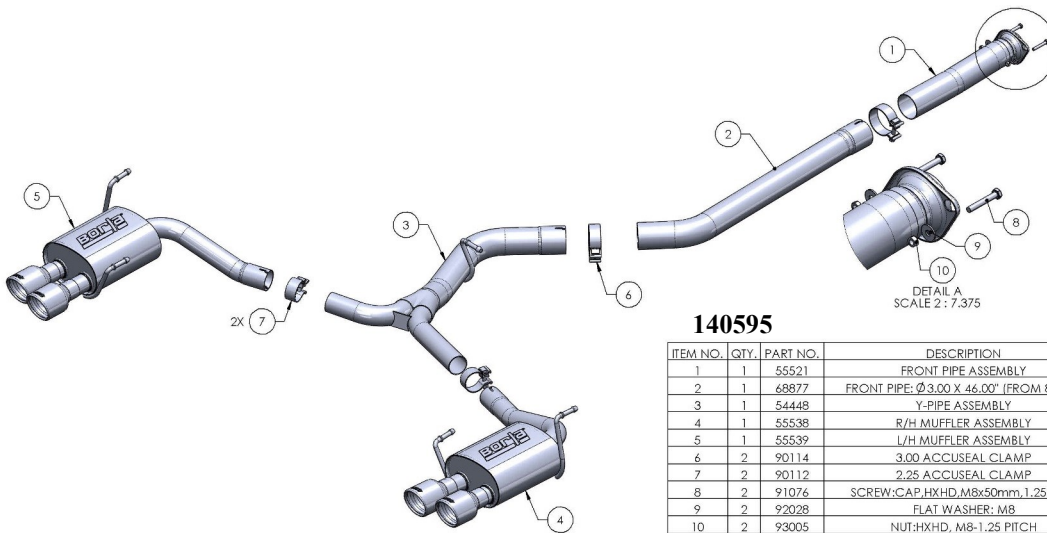
**TOOLS:**

- 1 3/8" Drive Ratchet
- 2 3/8" Drive Extension 3"
- 3 15mm Deep Well Socket
- 4 13mm Socket
- 5 14mm Socket
- 6 Pry Bar

**SHOP SUPPLIES:**

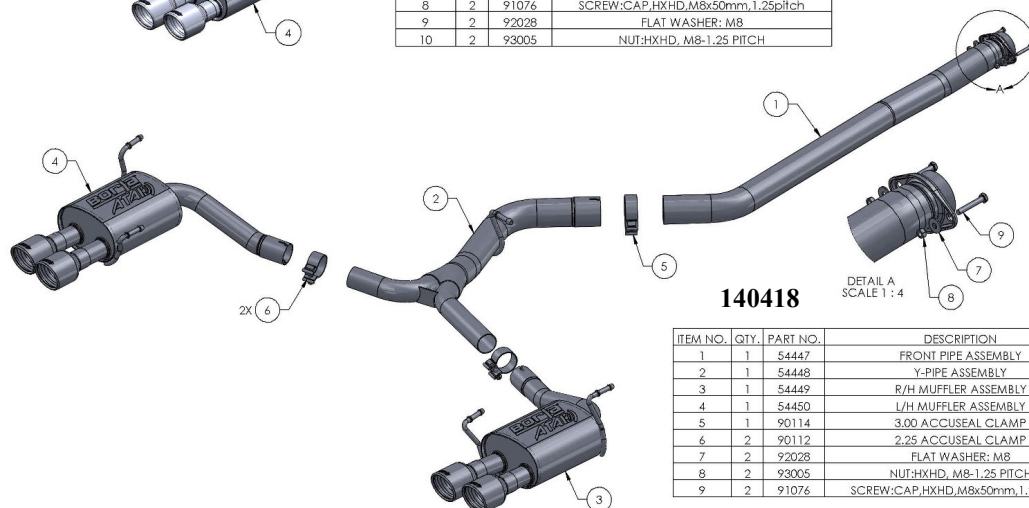
- 1 Spray Lubricant

**Borla Performance Cat-Back™ Bill of Materials**



**140595**

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	55521	FRONT PIPE ASSEMBLY
2	1	68877	FRONT PIPE: Ø 3.00 X 46.00" (FROM 80028)
3	1	54448	Y-PIPE ASSEMBLY
4	1	55538	R/H MUFFLER ASSEMBLY
5	1	55539	L/H MUFFLER ASSEMBLY
6	2	90114	3.00 ACCUSEAL CLAMP
7	2	90112	2.25 ACCUSEAL CLAMP
8	2	91076	SCREW:CAP.HXHD,M8x50mm,1.25pitch
9	2	92028	FLAT WASHER: M8
10	2	93005	NUT:HXHD, M8-1.25 PITCH



**140418**

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	54447	FRONT PIPE ASSEMBLY
2	1	54448	Y-PIPE ASSEMBLY
3	1	54449	R/H MUFFLER ASSEMBLY
4	1	54450	L/H MUFFLER ASSEMBLY
5	1	90114	3.00 ACCUSEAL CLAMP
6	2	90112	2.25 ACCUSEAL CLAMP
7	2	92028	FLAT WASHER: M8
8	2	93005	NUT:HXHD, M8-1.25 PITCH
9	2	91076	SCREW:CAP.HXHD,M8x50mm,1.25pitch

**Minimum Required Tool List:**

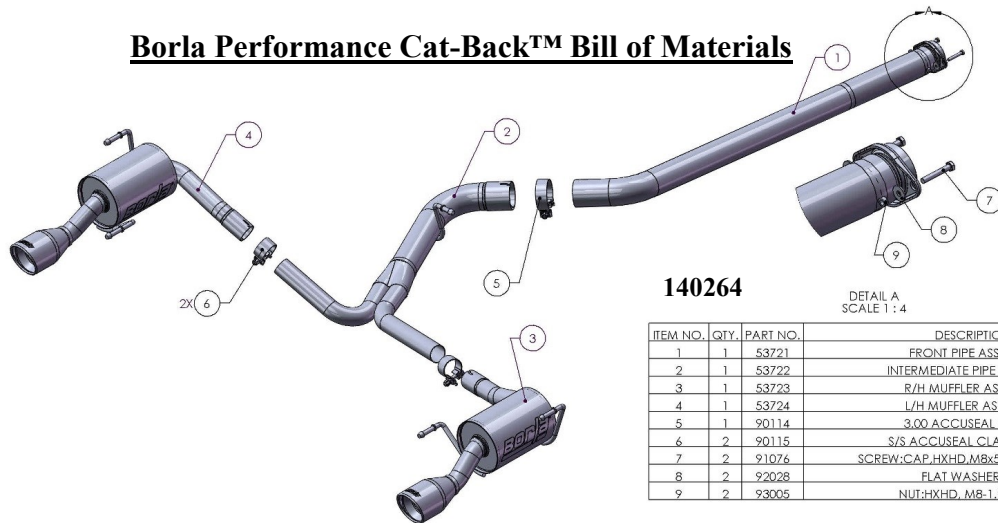
**TOOLS:**

- 1 3/8" Drive Ratchet
- 2 3/8" Drive Extension 3"
- 3 15mm Deep Well Socket
- 4 13mm Socket
- 5 14mm Socket
- 6 Pry Bar

**SHOP SUPPLIES:**

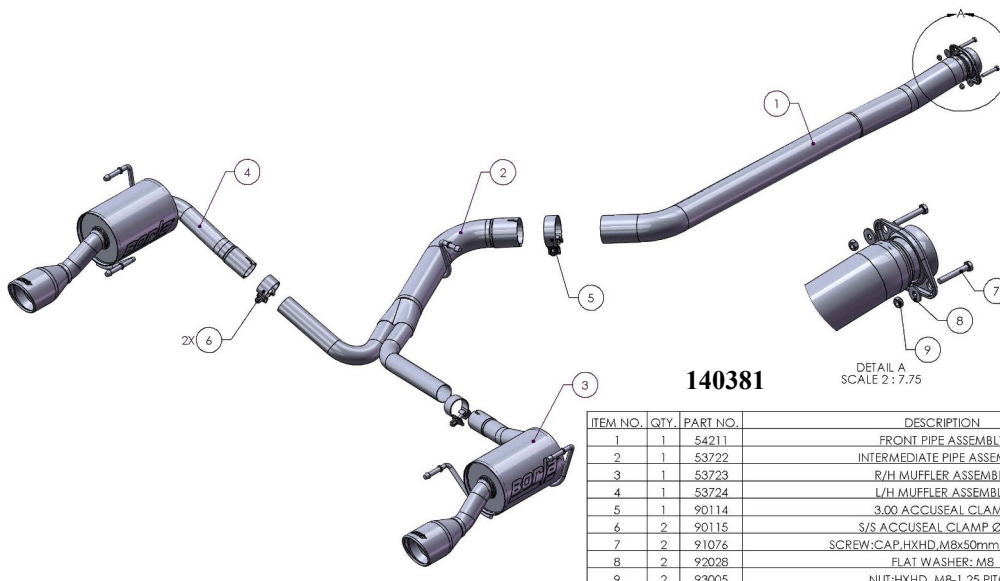
- 1 Spray Lubricant

**Borla Performance Cat-Back™ Bill of Materials**



**140264**

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	53721	FRONT PIPE ASSEMBLY
2	1	53722	INTERMEDIATE PIPE ASSEMBLY
3	1	53723	R/H MUFFLER ASSEMBLY
4	1	53724	L/H MUFFLER ASSEMBLY
5	1	90114	3.00 ACCUSEAL CLAMP
6	2	90115	S/S ACCUSEAL CLAMP Ø2.00
7	2	91076	SCREW:CAP,HXHD,M8x50mm,1.25pitch
8	2	92028	FLAT WASHER: M8
9	2	93005	NUT:HXHD, M8-1.25 PITCH



**140381**

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	54211	FRONT PIPE ASSEMBLY
2	1	53722	INTERMEDIATE PIPE ASSEMBLY
3	1	53723	R/H MUFFLER ASSEMBLY
4	1	53724	L/H MUFFLER ASSEMBLY
5	1	90114	3.00 ACCUSEAL CLAMP
6	2	90115	S/S ACCUSEAL CLAMP Ø2.00
7	2	91076	SCREW:CAP,HXHD,M8x50mm,1.25pitch
8	2	92028	FLAT WASHER: M8
9	2	93005	NUT:HXHD, M8-1.25 PITCH

**Caution!!!** *Never* work on a hot exhaust system. Serious injury in the form of burns can result if the vehicle has been in use and the exhaust system is hot, allow vehicle to cool for at least 1 hour. Always wear eye protection when working under any vehicle.

*Note:* It is our recommendation that you use a hoist or hydraulic lift to facilitate the installation of your new Borla Performance Exhaust System.

Taking all under car safety precautions, lift the vehicle using a hoist or hydraulic lift. Once this has been done, you may begin the removal of your old exhaust system from your vehicle.

*Note:* Before removing the original exhaust system from your vehicle, please compare the parts you have received with the bill of materials provided on the previous page to assure that you have all the parts necessary for the installation of your new Borla Performance Exhaust System.

*Note:* With a used vehicle, we suggest a penetrating spray lubricant to be applied liberally to all exhaust fasteners and allowing a significant period of time for the chemical to lubricate the threads before attempting to disassemble.

## Original Exhaust System Removal

1. Unbolt the flange located just ahead the front muffler. Place the hardware to the side for use during the installation of your new exhaust system. (See Fig. 1)
2. Lubricate all the hangers and rubber isolators.
3. Using a muffler stand or an additional person to hold the exhaust system into position, remove all the hangers from the rubber Isolators and remove the entire exhaust system from the vehicle. (See Fig. 2)



Figure 1



Figure 2

**WARNING:** Use extreme caution during installation. Torque all fasteners according to manufacturer's torque values and tightening sequence. **DO NOT** use air impact tools to tighten fasteners on Borla Performance Exhaust Systems. Use of such tools may result in bent flanges or gasket contact areas leading to exhaust leaks.

**NOTE:** When you first start your vehicle after the installation of your new Borla 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.



## Borla Performance Cat-Back™ Exhaust System Installation

1. Using the provided hardware, place the **Front Pipe Assembly** into position. Place a clamp over the expanded end of the front pipe. (See Fig. 3) **Do not tighten the clamp.**
2. Place a clamp over the expanded end of the **Intermediate Pipe** inserting the end into the **Front Pipe Assembly** carefully inserting the hanger into the rubber isolator. (See Fig. 4) **Do not tighten the clamp.**
3. Place a clamp over the expanded end of **L/H Muffler Assembly** inserting the left-side end into the **Intermediate Pipe Assembly** carefully inserting the hanger into the rubber isolator.
4. Repeat Step 3 for **R/H Muffler Assembly**. **Do not tighten the clamp.**
5. Check your exhaust system for proper clearance under the vehicle and also for tip alignment.
6. Once position has been determined to be correct, tighten the Accuseal™ clamp to 32-35 ft. lbs. making sure the clamp bolts are centered between the notches in the pipe. Tighten the flange hardware to 18-22 ft. lbs. (See Fig. 5)
7. Before starting your vehicle, make sure to check all wires, hoses, brake lines, body parts and tires for safe clearance from the exhaust system.
8. Start vehicle and check for any leaks. If any leaks are found, determine cause (such as loose hardware or incorrectly positioned clamp) and repair as necessary.

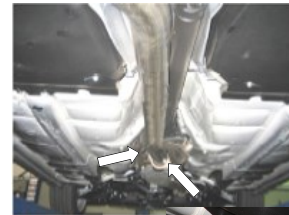
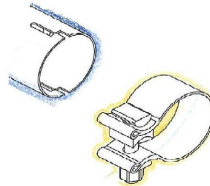


Figure 3



Figure 4



Figure 5



**WARNING:** Use extreme caution during installation. Torque all fasteners according to manufacturer's torque values and tightening sequence. **DO NOT** use air impact tools to tighten fasteners on Borla Performance Exhaust Systems. Use of such tools may result in bent flanges or gasket contact areas leading to exhaust leaks.

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