

## Installation for BMW 328i and 320i Sedan PN-140509,140657



**\*\*\*\*\* 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 Exhaust System.**

**Borla Performance Cat-Back™ Exhaust System (PNs-140509, 140657) are designed for the F30 BMW 328i and 320i Sedan equipped with a 2.0L Turbo 4-cylinder engine, automatic or manual transmissions.**

Borla Performance Industries recommends that an exhaust shop or professional after market parts installer, who has all the necessary equipment, tools and experienced personnel needed for proper installation, should perform the installation of this system. However, if you decide to perform the installation, we recommend someone should help you. Ensure the installer uses 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:**

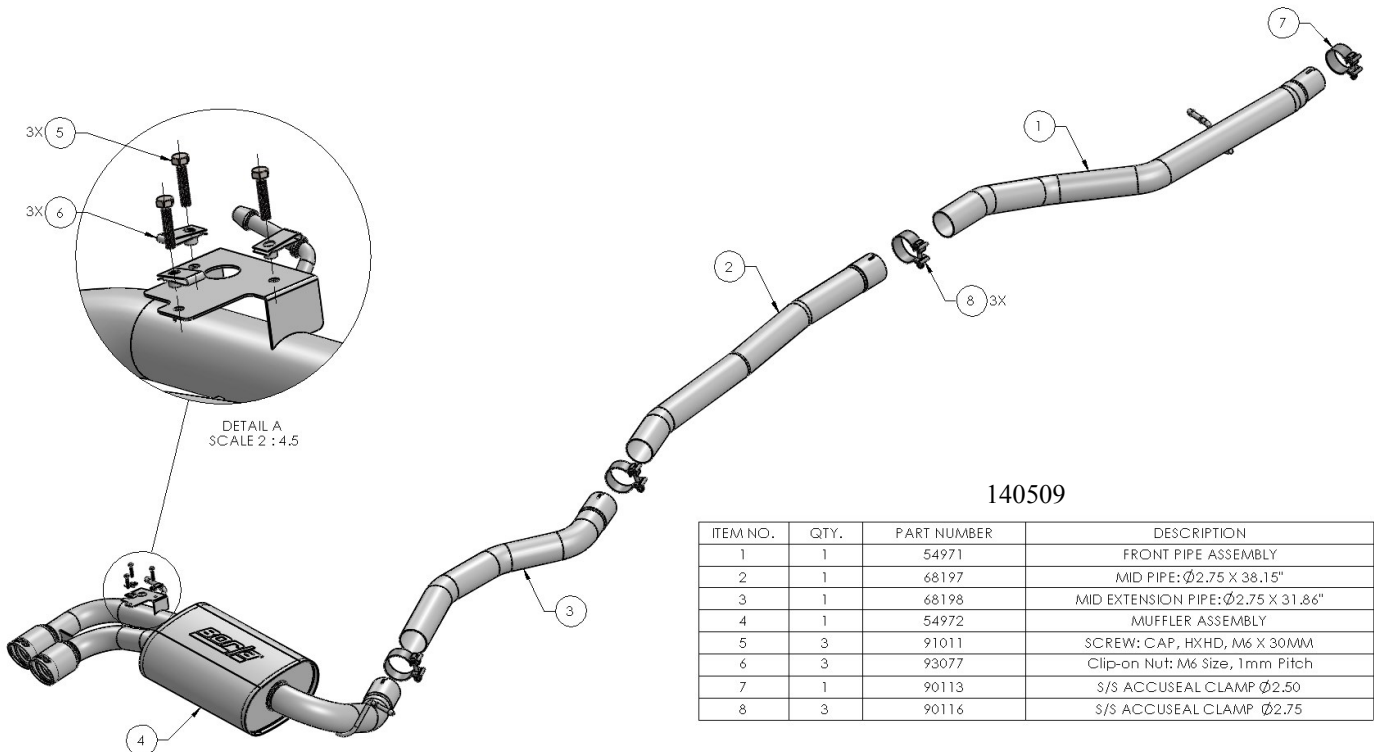
**TOOLS:**

- 1 3/8" Drive Ratchet
- 2 3/8" Drive Extension 3"
- 3 10mm, 13mm, 15mm Sockets
- 5 Pry Bar

**SHOP SUPPLIES:**

- 1 Spray Lubricant

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



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54971	FRONT PIPE ASSEMBLY
2	1	68197	MID PIPE: Ø2.75 X 38.15"
3	1	68198	MID EXTENSION PIPE: Ø2.75 X 31.86"
4	1	54972	MUFFLER ASSEMBLY
5	3	91011	SCREW: CAP, HXHD, M6 X 30MM
6	3	93077	Clip-on Nut: M6 Size, 1mm Pitch
7	1	90113	S/S ACCUSEAL CLAMP Ø2.50
8	3	90116	S/S ACCUSEAL CLAMP Ø2.75

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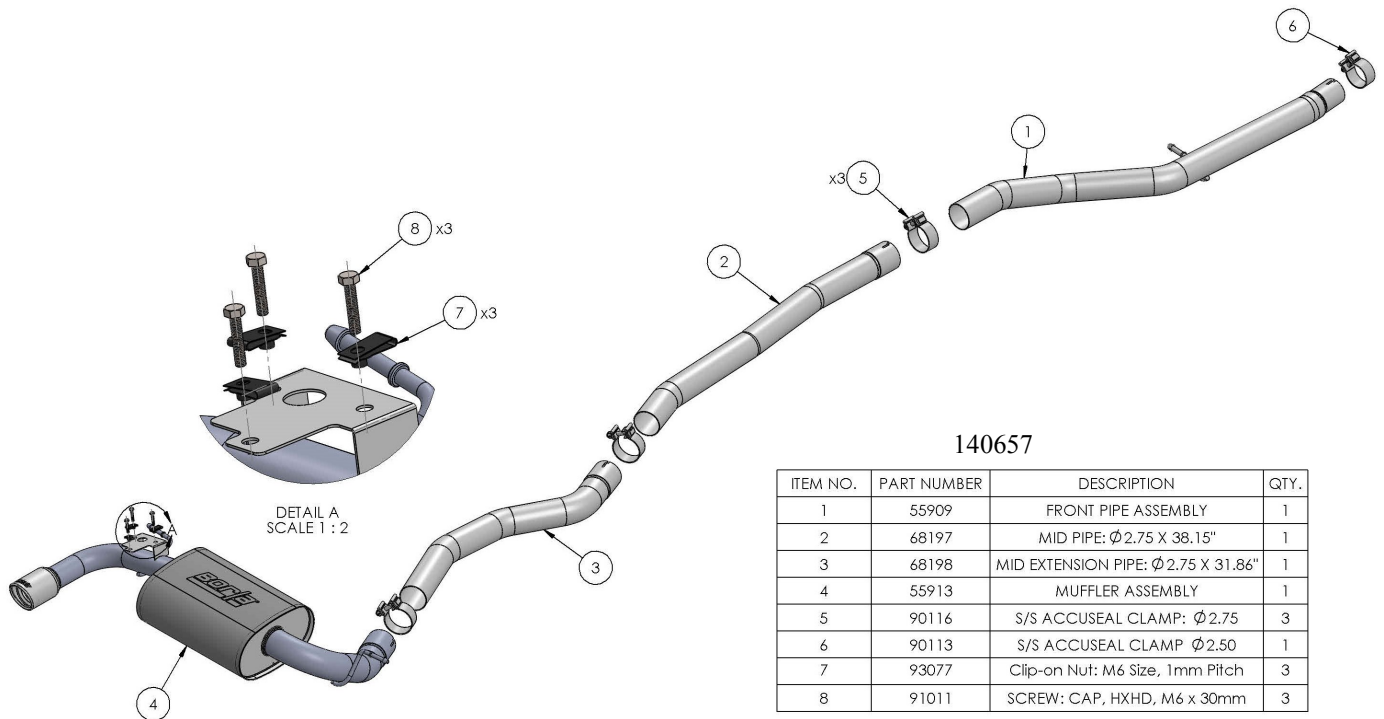
**TOOLS:**

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- 5 Pry Bar

**SHOP SUPPLIES:**

- 1 Spray Lubricant

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



140657

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	55909	FRONT PIPE ASSEMBLY	1
2	68197	MID PIPE: Ø2.75 X 38.15"	1
3	68198	MID EXTENSION PIPE: Ø2.75 X 31.86"	1
4	55913	MUFFLER ASSEMBLY	1
5	90116	S/S ACCUSEAL CLAMP: Ø2.75	3
6	90113	S/S ACCUSEAL CLAMP Ø2.50	1
7	93077	Clip-on Nut: M6 Size, 1mm Pitch	3
8	91011	SCREW: CAP, HXHD, M6 x 30mm	3

**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.*

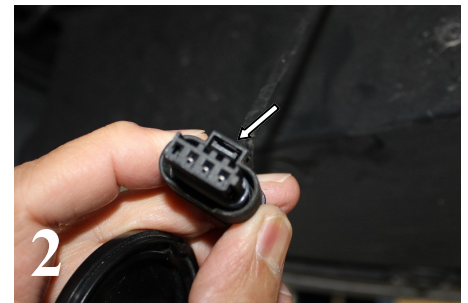
*Taking all under car safety precautions, lift the vehicle using a hoist or hydraulic lift. Once this has been done, you may begin the removal of your old exhaust system from your vehicle.*

**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. Stock exhaust removes in 1-piece and no cutting is required. *Note arrow indicating factory valve on factory exhaust. This valve assembly will be unbolted and transferred to your new Borla cat-back.* (See Fig. 1)
2. Carefully disconnect wire harness from factory exhaust valve. **NOTE:** *Your new cat-back includes mounting provisions for this valve and harness connection. The valve will not be operative with your new Borla cat-back.* (See Fig. 2)
3. Remove cross-brace and keep hardware for re-installation with your new cat-back.
4. Loosen front muffler clamp. (See Fig. 3)
5. Using a muffler stand or an additional person to hold the muffler assembly up into position, slide the (3) hangers out of the rubber isolators and remove the system from the rear. Original rubber isolators are used in the installation of your new exhaust system.
6. Reinstall cross-brace and tighten hardware.

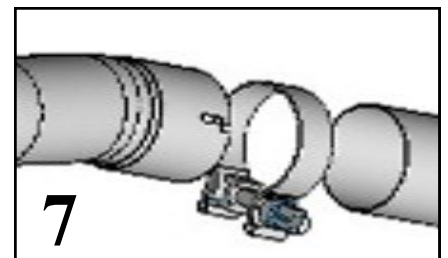
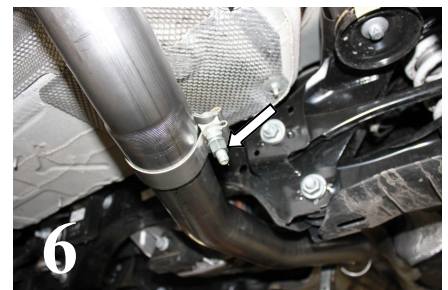
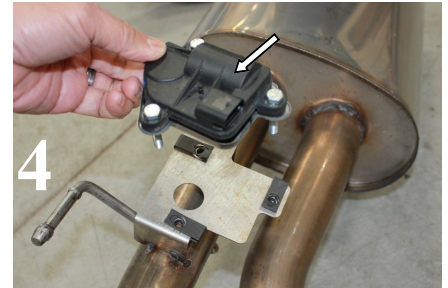


**WARNING:** *Use extreme caution during installation. Torque all fasteners according to manufacturer's torque values and tightening sequence. **DO NOT** use air impact tools to tighten fasteners on Borla Performance Exhaust Systems. Use of such tools may result in bent flanges or gasket contact areas 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. Reference Page 2 and 3 drawing when installing. Use hardware provided to install valve to **Muffler Assembly**. Tighten hardware 18-20 ft.lbs. (See Fig. 4)
2. Place a clamp over the **Front Pipe Assembly** and place inlet over factory cat-pipe. LIGHTLY TIGHTEN CLAMP BOLT.
3. Place a clamp over the **Mid-Pipe Assembly** and place over Front **Pipe Assembly**. LIGHTLY TIGHTEN CLAMP BOLT.
4. Place a clamp over the **Muffler Assembly** and place pipe inlet over **Mid-Pipe Assembly**. Carefully insert hangars into rubber isolators. LIGHTLY TIGHTEN CLAMP BOLT. (See Fig. 5 & 6)
5. Check your exhaust system for proper clearance under the vehicle and also for tip alignment. Once position has been determined to be correct, tighten the Accuseal™ clamp 32-35 ft. lbs. Tighten the OE clamp bolts. **NOTE: When properly clamped, the Accuseal pipe closes with interlocking notches creating a proper seal.** (See Fig. 7)
6. *Reconnect wire to harness.*
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 or incorrectly positioned clamp) and repair as necessary.



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