

## SS SPORTS EXHAUST SYSTEM

### Range Rover Classic

Part Number: RA1069F

#### Kit includes:

- (6) Rubber spacer/washer (552818P)
- (4) Sports manifold gasket (AJM692SPORT)
- (3) Exhaust clamp 60MM (ECL15)
- (2) Exhaust clamp 54MM (GEX9010)
- (6) Steel nut 5/16"UNF (GHF201)
- (6) Plain washer 5/16"ID (GHF301)
- (6) Spring washer 8MM ID (GHF382)
- (3) Bolt 5/16"UNFX2" (HB816)
- (1) Stainless steel adaptor pipe (RA1011F)
- (1) Stainless steel sports silencer (RA1026F)
- (1) Stainless steel sports rear assembly (RA1027F)
- (1) Stainless steel sports auto "Y" section (RA1068F)
- (1) Stainless steel right hand sports manifold (RA1071RHF)
- (3) Setscrew 5/16" UNFX1.25" (SH605101)
- (1) Stainless steel sports manifold left hand short (RA1009LHFSHORT)
- (1) Exhaust warranty registration card (EWRC)
- (1) Milltek stainless steel sports exhaust 3.9 automatic 1990 onwards no lambda sensors (ZZRA1069F)



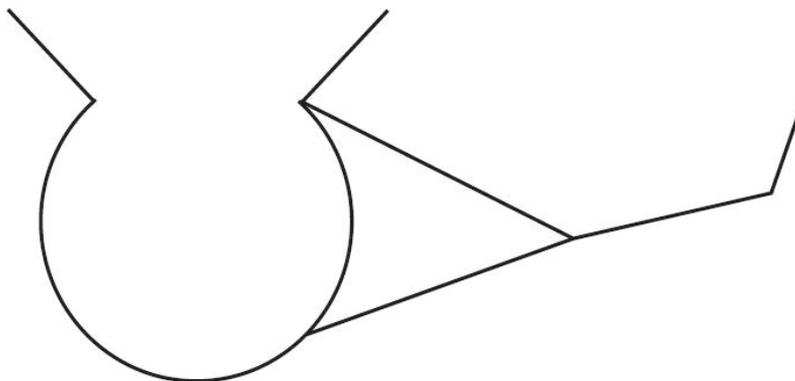
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- 1) It may be useful to pre-soak all nuts and bolts on the vehicle with penetrating oil several days before.
- 2) Obtain clear access to the underside of the vehicle using either a pit or a ramp.
- 3) Remove all of the old system including manifolds and fittings.
- 4) Fit the tubular manifolds and gaskets, it may be easier to tighten the lower securing studs/nuts before the upper.
- 5) Re-route the starter motor wiring as needed. On some models; to gain clearance for the manifolds you may need to reposition the coil or remove the cable securing studs from the chassis.
- 6) It may be necessary to cut a small amount from the manifold studs to gain clearance at the gearbox cross member. Make sure that enough of the stud is retained to form a seal with the "Y" pipe.
- 7) Secure the "Y" pipe to the manifolds with the clamps supplied and offer up the assembly to the cylinder heads.
- 8) Now fit the short extension pipe to the centre box and loosely fit to the "Y" piece with the bolts, nuts and washers supplied. This extension is designed to allow 4" of adjustment before and after to allow the remainder of the system to be correctly positioned.



- 9) Fit the bracket to the outlet pipe of the centre box using bolts and bushes supplied and loosely mount to the original mounting point on the chassis. It may be necessary to add or remove rubber washers to align the system later.
- 10) Offer up the rear tail pipe assembly into place, positioning to clear the chassis and axle, and slide into the rear of the centre box. You may need to alter the centre box position by sliding the front extension in or out and by adding or removing rubber washers/spaces on the mounting bracket.

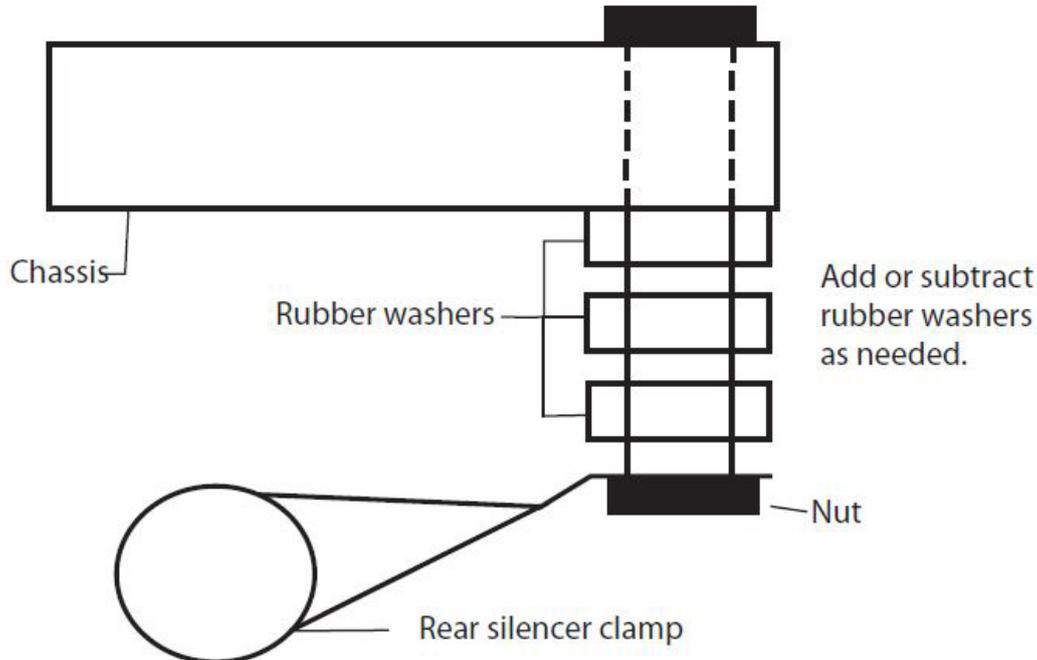
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- 11) Once you are happy with the systems position, fit the rear support bracket. On carb models use the bracket at the front of the rear box to mount the system to one of the original mounting holes on the chassis using the long bolt and rubber washers. Again you may find better clearance if you try each of the holes in the chasis mount; using whichever gives the best clearance. You can also add or subtract rubber washers as needed. On injection models, re-use the original system mounting fittings and fit up to the original position on the rear apron.
- 12) Once the system is in position and clear of all contact with the chassis and axles, tighten all clamps and fittings and make the final check that all wiring is clear of the manifolds and system. Since the engine is very firmly mounted in the Range Rover and has very little rocking or movement, the manifolds appear to be very close to the front chassis rails but this is normal and no actual contact takes place.
- 13) Please note that tuning may be required to suit the characteristics of the new sport exhaust systems.



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