



# Slip On Exhaust Instructions

**For Models:** Scrambler® XP 1000 S (2020-2023), Sportsman® XP 1000 S (2020-2022)

## Removal

**!!! WARNING !!!** Before working on your machine, make sure it is parked on a level surface with the transmission in park and/or the parking brake engaged.

Do not work on any machine with a hot engine or exhaust. Allow time for all parts to cool in order to reduce the risk of burns.

Blackout Exhausts: Take care not to get grease or oils on the exhaust. Cleaning our Blackout exhaust with harsh solvents, abrasives, or pressure washers will remove the coating and is not covered under warranty.

1. Using a spring puller, rope, or wire remove the (2) springs between the stock silencer and headpipe. *(See Figure #1)*
2. Carefully pull the silencer rearward and remove it from the vehicle.
3. Inspect the mounting posts on the silencer. If any of the rubber grommets pulled out of the mounts on the vehicle remove them from the silencer, and put them back in the mounts on the vehicle.
4. Inspect the donut gasket on the headpipe. If worn or damaged, replace with a new OEM gasket. This gasket is **NOT** included with the HMF slip on exhaust. *(See Figure #2)*

## Installation

1. Carefully install the silencer making sure to align the mounting rods with the original rubber grommets on the vehicle. *(See Figure #3)*

**Tip:** It will be easier to install the mounting rods through the grommets if lightly lubricated with silicone spray.

2. Check that the HMF silencer is properly fitted to the original headpipe and donut gasket. Adjust as needed. *(See Figure #4)*

3. Install the provided **(2) Long Neck Springs** between the HMF silencer and original headpipe. *(See Figure #5)*

Wipe off any fingerprints or markings using a soft cloth and mild detergent such as soap and water or glass cleaner without ammonia. Once the exhaust heat cycles any oils left on the exhaust may permanently imprint.

If you received a stainless steel exhaust without the Blackout coating it is normal for the pipes to change color as they heat cycle.

The HMF Blackout exhaust will smoke and put out an odor for the first full heat cycle as the coating goes through its final curing process. It is recommended to allow this process to happen in a well ventilated area.

All systems will produce a smoke out the end cap after a short initial heat cycle, this is the packing material bedding in

and is completely normal.

Until the exhaust has been heat cycled a few times small exhaust leaks may be noted at any of the connection points or from the rivets on the silencer. This is normal and usually goes away after a few hours of run time. (See Figure #6)

## Hardware



(2) 400076 - Spring(s) - Long Neck

\*Click thumbnails to enlarge

Figure #1



Figure #2



Figure #3



Figure #4



Figure #5



Figure #6



(2) Spring(s) - Long Neck

