

## Installation Guide for Lexus RC F & IS 500 PNs 60738 & 60739



**\*\*\*\*\* Please compare the parts in the box with the bill of materials provided \*\*\*\*\*  
to ensure 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 exhaust 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 Mid-Section exhaust system.

Borla Performance Mid-Section exhaust system PN 60738 is designed to complement PN 11981/BC to create a custom Cat-Back™ for the Lexus RC F, equipped with a 5.0L V-8 normally aspirated engine and RWD automatic transmission.

Borla Performance Mid-Section exhaust system PN 60739 is designed to complement PN 11981/BC to create a custom Cat-Back™ for the Lexus IS 500, equipped with a 5.0L V-8 normally aspirated engine and RWD automatic transmission.

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:**

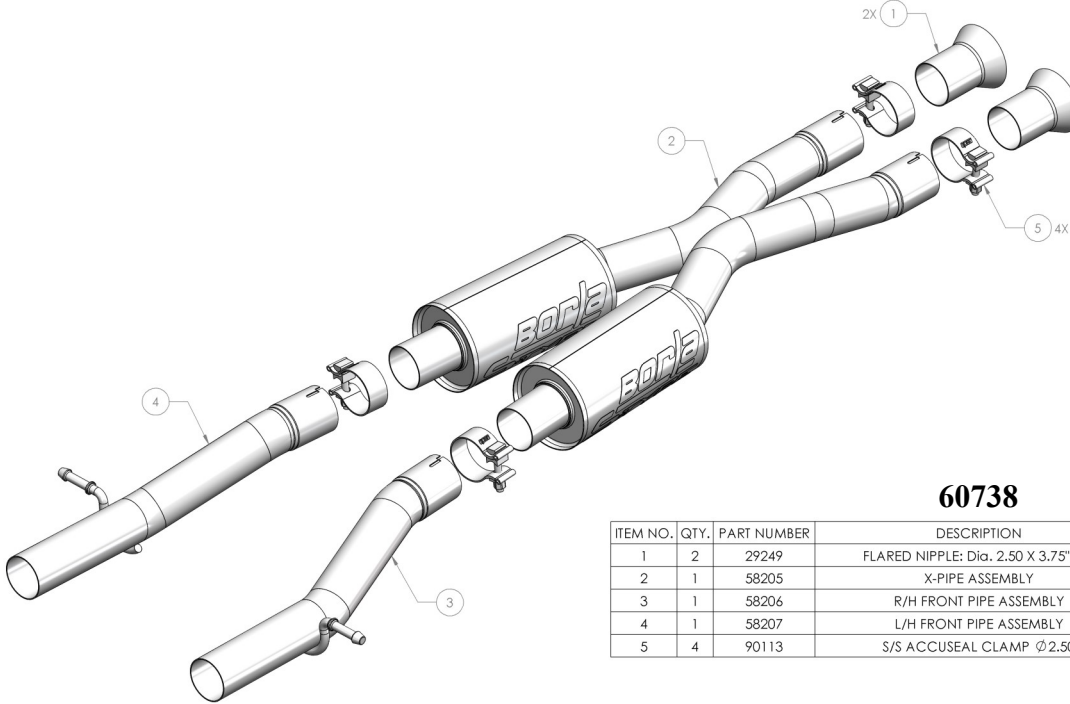
1. 3/8" drive ratchet
2. 3/8" drive extension 6"
3. 14mm deep well socket
4. 15mm deep well socket

5. Reciprocating Saw with metal cutting blade
6. MIG Welder

**SHOP SUPPLIES:**

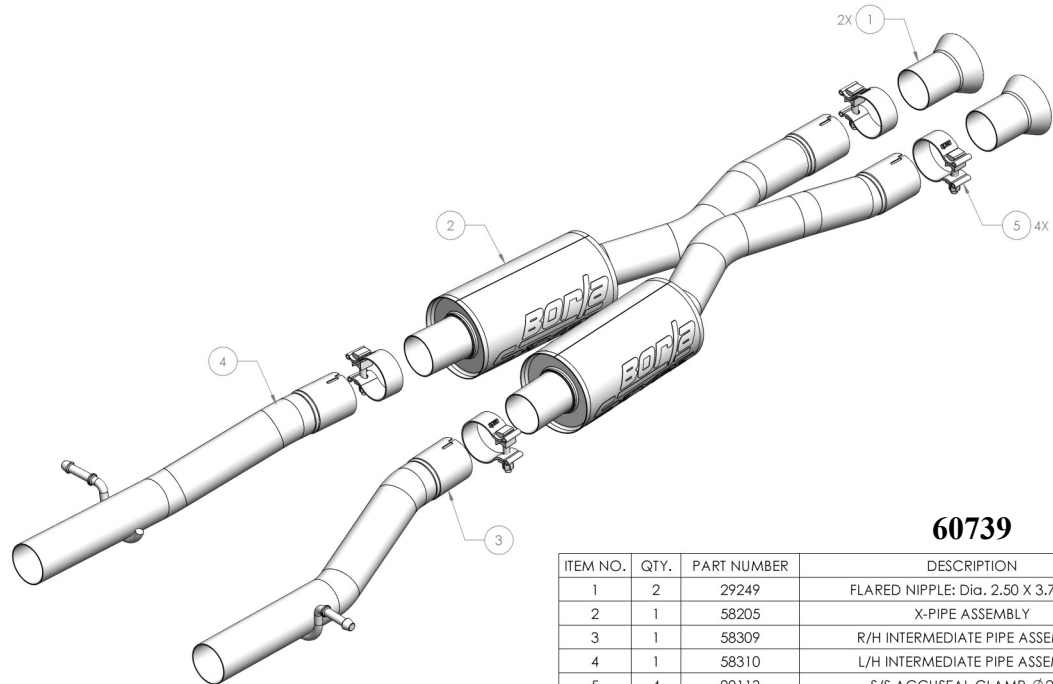
1. Spray lubricant

**Borla Performance - Bill of Materials**



**60738**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	29249	FLARED NIPPLE: Dia. 2.50 X 3.75" LG.
2	1	58205	X-PIPE ASSEMBLY
3	1	58206	R/H FRONT PIPE ASSEMBLY
4	1	58207	L/H FRONT PIPE ASSEMBLY
5	4	90113	S/S ACCUSEAL CLAMP Ø2.50



**60739**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	29249	FLARED NIPPLE: Dia. 2.50 X 3.75" LG.
2	1	58205	X-PIPE ASSEMBLY
3	1	58309	R/H INTERMEDIATE PIPE ASSEMBLY
4	1	58310	L/H INTERMEDIATE PIPE ASSEMBLY
5	4	90113	S/S ACCUSEAL CLAMP Ø2.50

**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.*

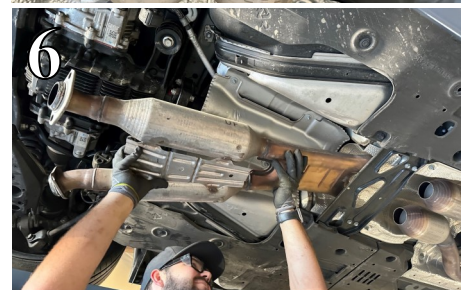
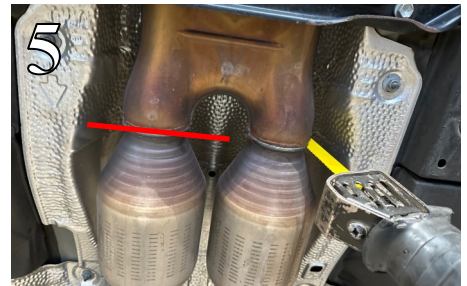
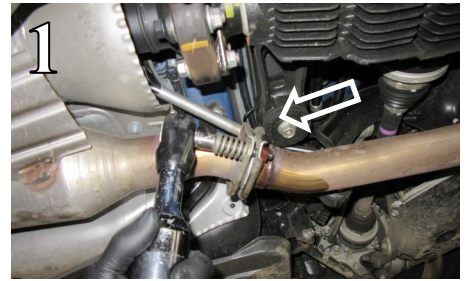
**Taking all under car safety precautions, lift the vehicle using a hoist or hydraulic lift. Once this has been done, you may begin the removal of your old exhaust system from your vehicle.**

**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

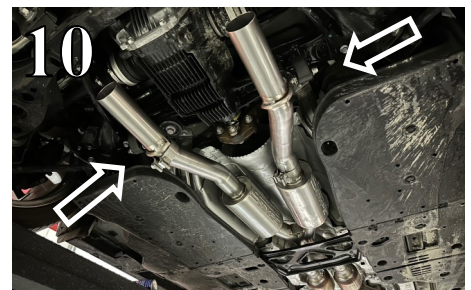
1. Lubricate all hangers, rubber isolators, bolts and nuts.
2. Loosen and remove the hardware on the rear muffler assembly flange (Fig. 1).
3. Using a flathead screwdriver or a prybar, remove the rear muffler assembly hangers from their rubber isolators on the vehicle and remove the rear muffler assembly from the vehicle (Figs. 2-4).
4. Cut with a reciprocating saw at the weld connecting the cross over to the rest of the exhaust system (Fig. 5).
5. Remove the mid section assembly from the vehicle by sliding it away from the front of the vehicle and lower the flange side downward (Fig. 6).
6. Original exhaust removed.





## Borla Performance Mid-Section Exhaust System Installation

1. Orient the components on shop floor according to Borla bill of materials drawing on page 2.
2. Start the installation by dry fitting the **Flared Nipples** and **X-Pipe Assembly** to the vehicle. Once fitment is correct and everything is centered, place tack welds attaching the **Flared Nipples** to the original exhaust system (Fig. 7).
3. With the tacks placed, remove the **X-Pipe Assembly** from the vehicle as well as the original exhaust where the **Flared Nipples** were tacked in place. Fully weld the **Flared Nipples** to the original exhaust and reinstall the original exhaust onto the vehicle (Fig. 9).
4. Place clamps over the expanded ends of the **X-Pipe Assembly** and insert the inlets to the **Flared Nipples** (Fig. 7). Do not tighten the clamps.
5. Place a clamp over the expanded end of the **R/H Intermediate Pipe Assembly** and insert the inlet to the **X-Pipe Assembly**. Insert the hanger into the original rubber isolator (Fig. 10). Do not tighten the clamp.
6. Repeat Step 5 for the installation of the **L/H Intermediate Pipe Assembly**.
7. Place a clamp over the expanded end of the **R/H Muffler Assembly** and insert the inlet to the **R/H Intermediate Pipe Assembly**. Insert the hangers into their original rubber isolators (Fig. 11). Do not tighten the clamp.
8. Repeat Step 7 for the installation of the **L/H Muffler Assembly**.
9. Once position has been determined to be correct, tighten the Accuseal clamps to 32-35 ft. lbs.
10. Before starting your vehicle, make sure to check all wires, hoses, brake lines, body parts and tires for safe clearance from the exhaust system (Fig. 12).
11. Start the vehicle and check for any leaks. If any leaks are found, determine cause (such as loose or incorrectly positioned clamp) and repair as necessary.



**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.