

Technical Information

911 Turbo

1/98

2635

2

Binder - Service Technical Bulletins

Installation of Dual Tailpipe

Vehicle Type: **911 Turbo (993)**

Model Year: **Model Years 1996 - 97**

Concern: **Installation of chrome plated dual tailpipe made of stainless steel.**

Information: The standard tailpipes can now be replaced with chrome plated dual tailpipes made with stainless steel. (New vehicle Exclusive option number XLB). Installation of the tailpipes does not have a negative effect on engine performance, emissions, or noise of the vehicle.

The **Porsche Trademark**  and the **EP 8110 identification** must be visible from below when the parts are installed.

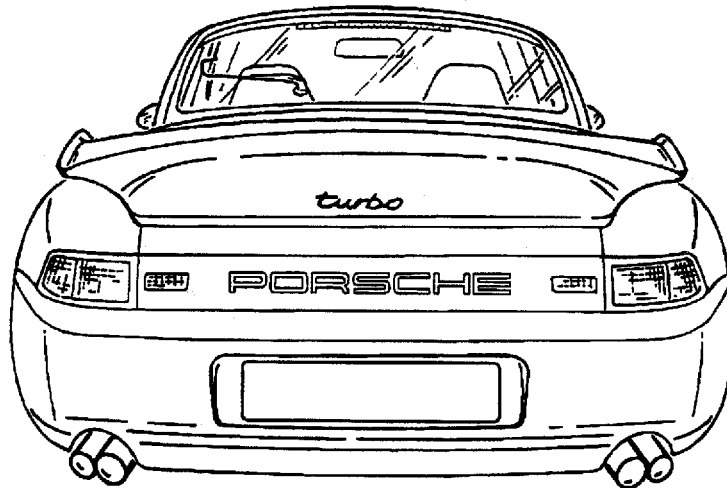


Figure 1

Parts Information:	Part Number	Description
	993 111 981 03	Dual Tailpipe, left
	993 111 982 03	Dual Tailpipe, right

- Required Tools:
- Ratchet with extension
 - 6mm allen wrench
 - 10mm & 13mm socket
 - 10mm & 13mm open end wrench
 - Sheet metal shears
 - File
 - Hammer
 - Pliers
 - Round file
 - 7mm drill bit
 - Phillips head screw driver
 - Plastic mallet
 - Hand held electric drill
 - Hack saw
 - Steel rule
 - Vise
 - Center punch

Installation Info: **1.0** Raise vehicle to working height

1.1 Remove both mufflers.

1.2 Remove standard tailpipes.

1.3 Detach rear spoiler at the sides and bottom. Remove mufflers, see 911 Carrera (993) Workshop Manual, Volume 1, page 26-1.

2.0 Pre-fit dual tailpipe tips.

2.1 Adapt mufflers to the dual tailpipe.

2.1.1 Remove heat shield and M6 nut holder from the mufflers.

2.1.2 Transfer dimension A = 130mm (figure 2) to the outlet pipe of the muffler. Using the hacksaw, vertically cut off the outlet pipe at the marking.

2.1.3 Deburr the cut edge.

2.2 Adapt heat shield to the muffler and to the dual tailpipe.

2.2.1 Starting from the first rib, symmetrically transfer the cut the edge (figure 3, dashed line) onto the heat shields.

2.2.2 Mark dimensions C = 10mm (figure 3) symmetrically between the longitudinal ribs as shown in figure 3.

2.2.4 Use a hammer to flatten the rib in the center of the heat shield (arrow in figure 4). Drill two 7mm holes at the markings (dimension C in figure 3) and make a slot between them.

2.3 Pre-fit the dual tailpipe and heat shield.

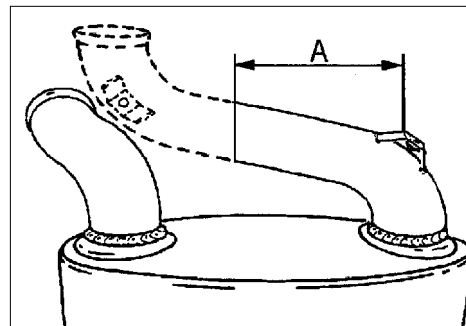


Figure 2

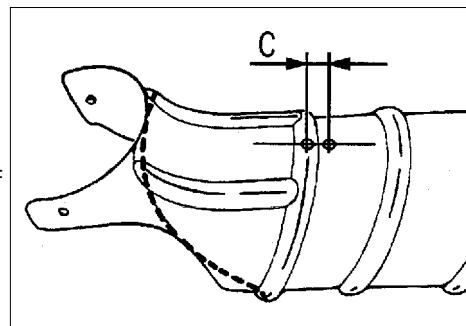


Figure 3

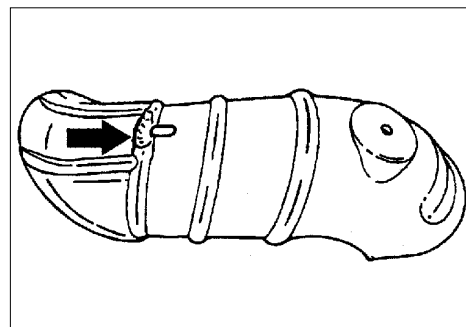


Figure 4

Installation Info:
(cont'd)

- 2.3.1** Put dual tailpipe onto the outgoing pipe of the muffler. When doing this, align the clamp so that the tensioning screw points toward the exhaust pipe.
- 2.3.2** Put M6 nut holders onto the mounts on the dual tailpipe and muffler. Firmly screw heat shield onto the muffler mount. The screw for the second fastening point of the heat shield (dual tailpipe) must be screwed in only hand tight.
- 2.3.3** Align the dual tailpipe as described below:
- Vertical alignment with muffler on edge;
 - gap D = 3 to 5mm (figure 5) from the inlet pipe;
 - clearance between heat shield and dual tailpipe; if necessary, the radius of the cut edge on the heat shield must be reworked.

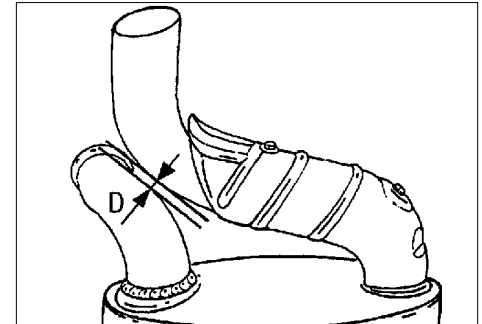


Figure 5

- 3.0** Install muffler with dual tailpipe.
- 3.1** Fit muffler in the mounting point and hand tighten screw in the restraining strap.
- 3.2** Position clamp on the catalytic converter and tighten slightly. Roughly align the muffler with the dual tailpipe with to the rear spoiler.
- 3.3** Firmly tighten the restraining strap screw (muffler) and clamp screw (catalytic converter).
- 3.4** Align dual tailpipe with respect to the rear spoiler, observing the points below:
- Perform visual inspection to determine whether gap D = 3 to 5mm (figure 5), distance E = 60mm (figure 6), and whether the dual tailpipe is symmetrically positioned in the rear spoiler cut-out;
 - the heat shield must not rub against the dual tailpipe or the adjacent components.

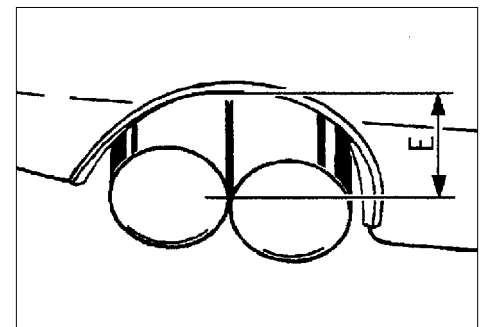


Figure 6

- 3.5** Firmly tighten clamp of the dual tailpipe and the heat shield.



Danger

Sharp edge on heat shield.
Danger of lacerations during work in the area of the dual tailpipes.
Take particular care when working in this area, or deburr the edge again.

- 3.6** Fasten sides of the rear spoiler.

Labor Info:	Labor Operation	Description	Time Units
	26 35 24 00	Dual tailpipes (2x) installed Includes: Removing standard tailpipes, removing and reworking mufflers and heat shields. Muffler with dual tailpipes installed.	210
Literature:	911 Carrera (993) Workshop Manual, - Repair 26 01 55 - Replacing exhaust system 63 55 19 - Removing and installing rear spoiler		

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