

## XR-1 Race System Installation Guide PN-12665\*, 12667\*, 12668\*, 60537\*, 60538\*



**These instructions have been written to help you with the installation of your Borla Performance XR-1 Race System. Please read this document completely before beginning the installation of your system.**

**Please compare the parts in the box with the bill of materials provided to assure that you have all the parts necessary for this installation.**

**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 XR-1 Race System.**

**These Borla Performance Systems (12665, 60537) are designed for the 1990-93 Mazda Miata equipped with a 1.6L 4-cylinder engine, manual transmission.**

**These Borla Performance Systems (12668, 60537) are designed for the 1994-97 Mazda Miata equipped with a 1.8L 4-cylinder engine, manual transmission.**

**These Borla Performance Systems (12667, 60538) are designed for the 1998-05 Mazda Miata equipped with a 1.8L 4-cylinder engine, manual transmission.**

**\*THESE SYSTEMS HAVE BEEN DEVELOPED FOR RACING USE ONLY. NOT LEGAL FOR USE ON PUBLIC ROADS OR HIGHWAYS.**

Borla Performance Industries recommends that an exhaust shop or professional after market parts installer perform the installation of this system. However, if you decide to perform the installation on your own it is recommended that two people are used. This installation should not be performed by one person due to the risk of injury. Ensure the installers use all under car safety precautions including eye protection.

***Please take time to read and understand the following...***

By installing your Borla Performance XR-1 Race 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 XR-1 Race 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.

**Minimum Required Tool List:**

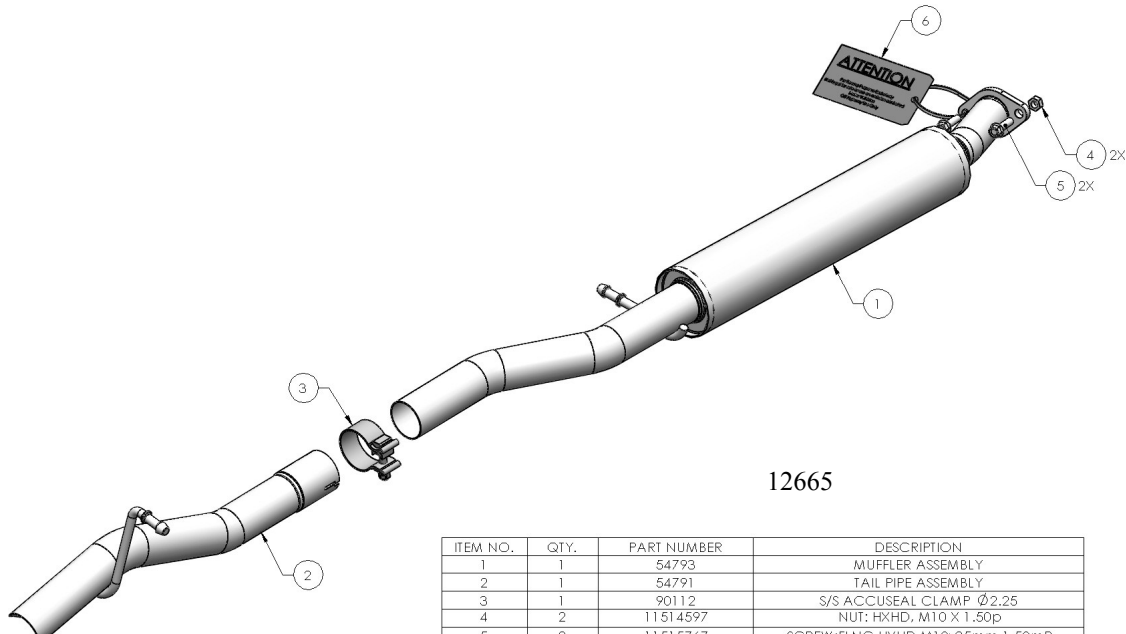
**TOOLS:**

1. 3/8" Drive Ratchet
2. 3/8" Drive Extension 3"
3. 15mm Deep Well Socket
4. Pry Bar
- 5.

**SHOP SUPPLIES:**

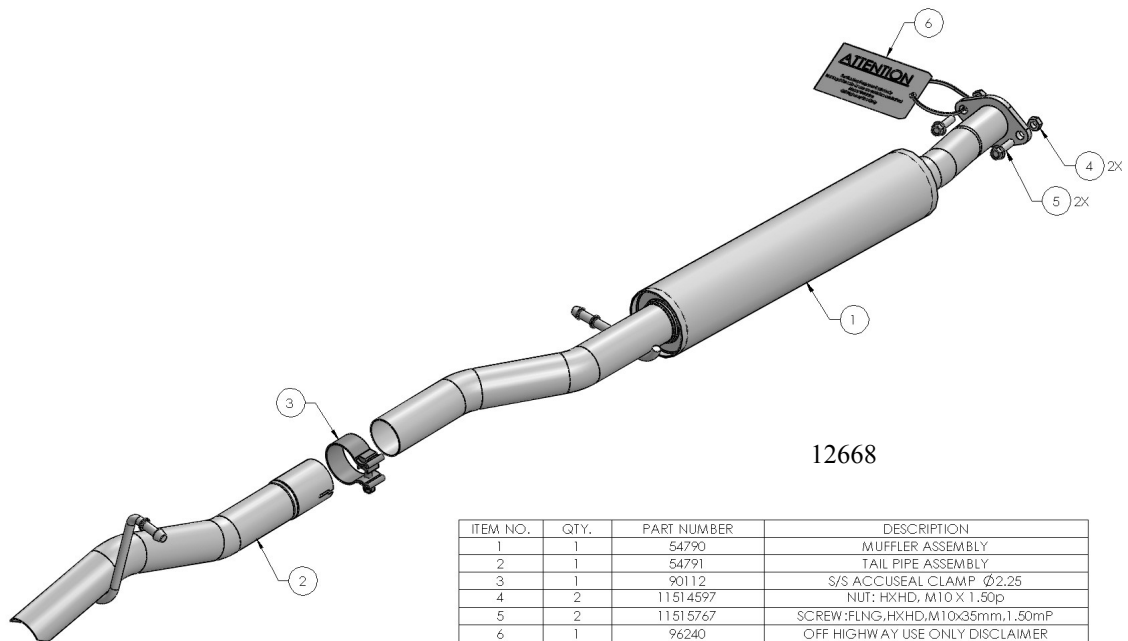
- 1 Spray Lubricant

**Borla Performance - Bill of Materials**



12665

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54793	MUFFLER ASSEMBLY
2	1	54791	TAIL PIPE ASSEMBLY
3	1	90112	S/S ACCUSEAL CLAMP Ø2.25
4	2	11514597	NUT: HXHD, M10 X 1.50p
5	2	11515767	SCREW: FLNG, HXHD, M10x35mm, 1.50mP
6	1	96240	OFF HIGHWAY USE ONLY DISCLAIMER



12668

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54790	MUFFLER ASSEMBLY
2	1	54791	TAIL PIPE ASSEMBLY
3	1	90112	S/S ACCUSEAL CLAMP Ø2.25
4	2	11514597	NUT: HXHD, M10 X 1.50p
5	2	11515767	SCREW: FLNG, HXHD, M10x35mm, 1.50mP
6	1	96240	OFF HIGHWAY USE ONLY DISCLAIMER

**Minimum Required Tool List:**

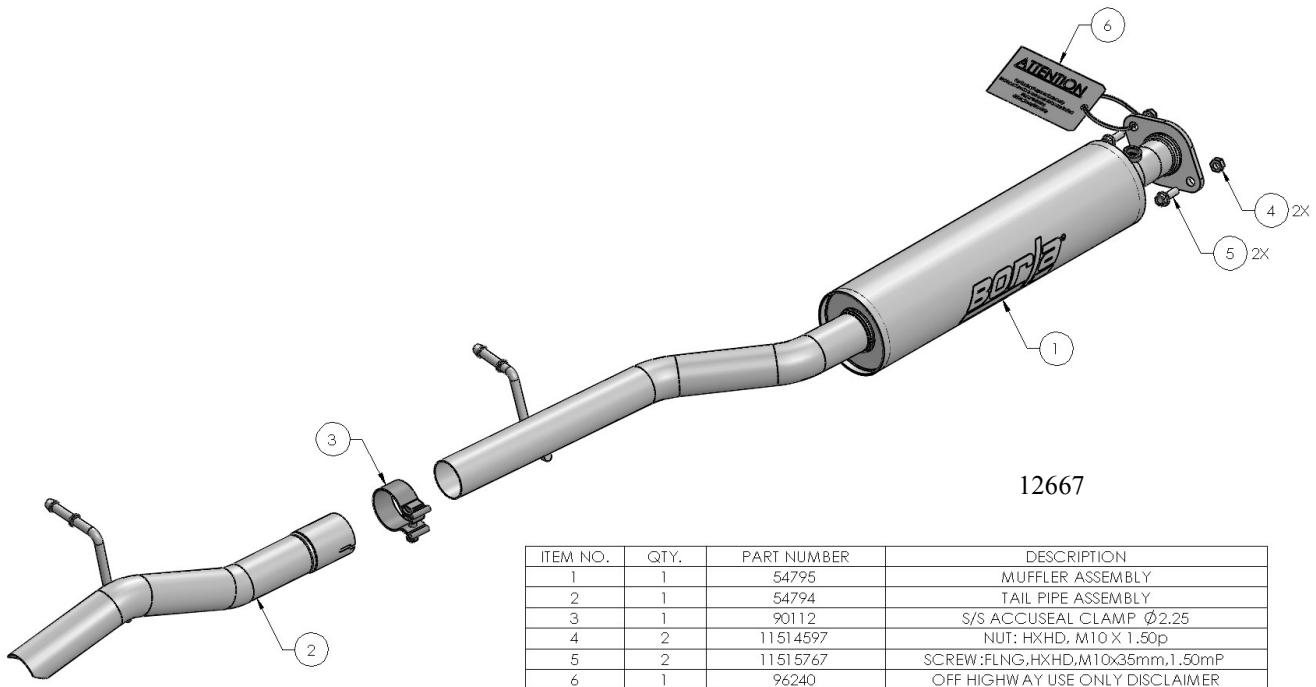
**TOOLS:**

1. 3/8" Drive Ratchet
2. 3/8" Drive Extension 3"
3. 15mm Deep Well Socket
4. Pry Bar
- 5.

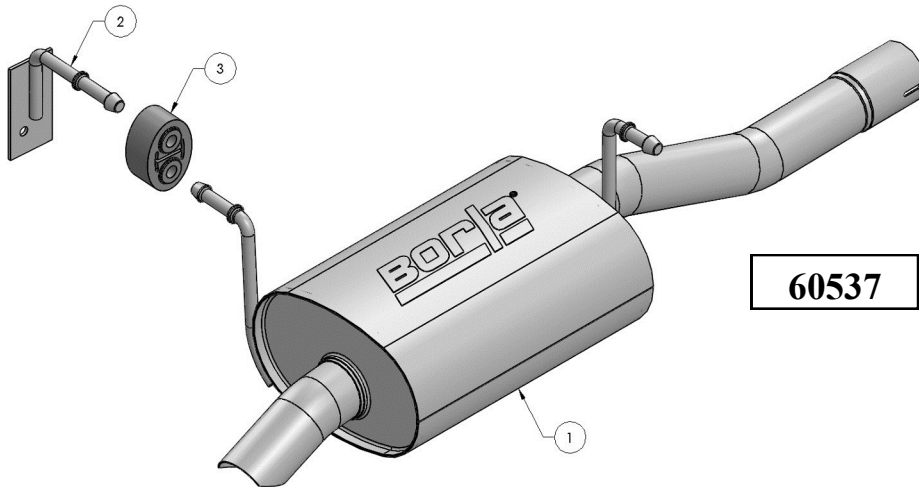
**SHOP SUPPLIES:**

- 1 Spray Lubricant

**Borla Performance - Bill of Materials**



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54795	MUFFLER ASSEMBLY
2	1	54794	TAIL PIPE ASSEMBLY
3	1	90112	S/S ACCUSEAL CLAMP Ø2.25
4	2	11514597	NUT: HXHD, M10 X 1.50p
5	2	11515767	SCREW: FLNG, HXHD, M10x35mm, 1.50mP
6	1	96240	OFF HIGHWAY USE ONLY DISCLAIMER



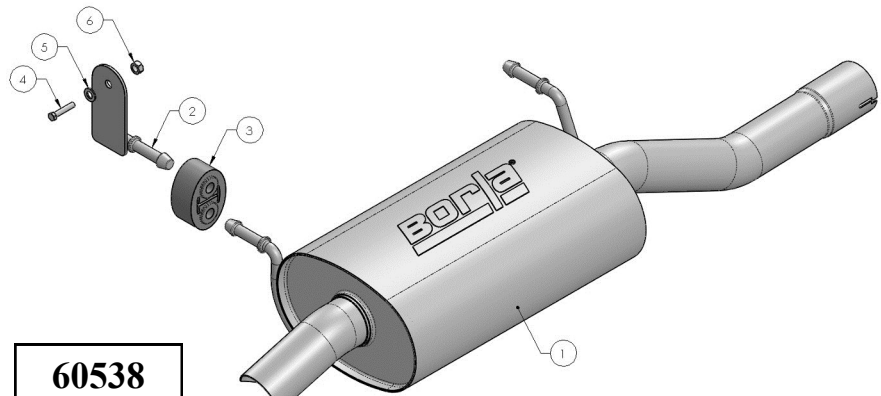
**60537**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54797	MUFFLER ASSEMBLY
2	1	54792	HANGER/BRACKET ASSEMBLY
3	1	44485	RUBBER BRACKET: 3.00 X 1.40 X 2.12"

60537 is designed to compliment Borla 12665 & 12668. Bracket hardware should be pre-installed to vehicle to save install/removal at the track.



60538 is designed to compliment Borla 12667. Bracket hardware should be pre-installed to vehicle to save install/removal at the track.



**60538**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	54798	MUFFLER ASSEMBLY
2	1	54796	HANGER/BRACKET ASSEMBLY
3	1	44485	RUBBER BRACKET: 3.00 X 1.40 X 2.12"
4	1	91123	HEXHD SCREW: 8MM X 30MM
5	1	92009	8MM FLAT WASHER
6	1	93005	HEXNUT: 8MM X 1.25 PITCH

**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 XR-1 Race 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 XR-1 Race System.*

**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.