



INSTRUCTIONS

BMW E90, E92 M3 2007 -

Active Autowerke Exhaust Stubbies

for fitment of BMW Catalysts with the Active X-PIPE

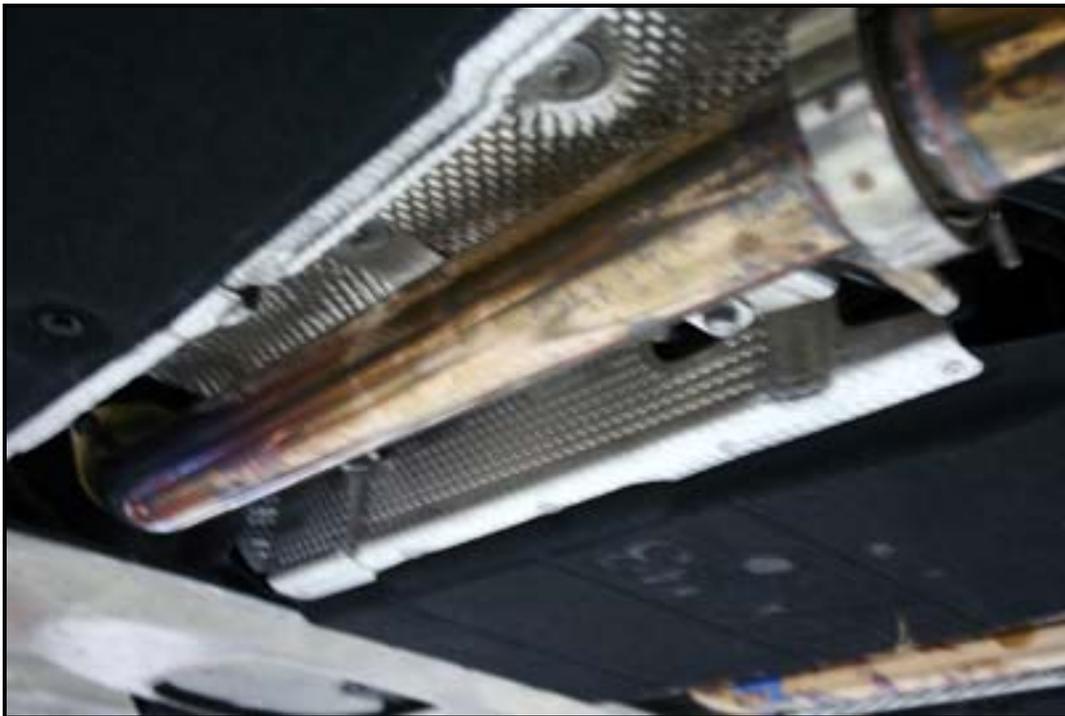
Tools Needed:

- A qualified technician that can weld
- Lift
- Mig/Tig Welding equipment
- Basic tools

The Active Autowerke STUBBIES is designed primarily as a cost effective means of utilizing your existing BMW Factory catalysts into something useable. If this can be done, then there's no need to purchase an additional set of catalysts to be OBD11 readiness compliant. Here are some instructions showing how to take advantage of your existing exhaust catalysts today.



Set of Active Autowerke exhaust Stubbies for BMW E9X M3. Stubbies are of different heights, the taller one goes on the drivers (LEFT) side, while the shorter one goes on the passenger (RIGHT) side.



FRONT section of the Active Autowerke X-PIPE installed for race prep



BMW Factory catalysts as a take-off.

QUESTION: How can one make this factory catalyst fit on the Active X-PIPE? See how this is done in a few pictures below.



Picture of the RIGHT side catalyst and the mark to be made for cutting off the catalyst



On the RIGHT catalyst, there is a weld mark made by the factory. Approximately 15mm after the weld, there is a depression. Using a felt tip marker, make a mark all-around as a guide mark.



Using a hack-saw, cut off the RIGHT catalyst



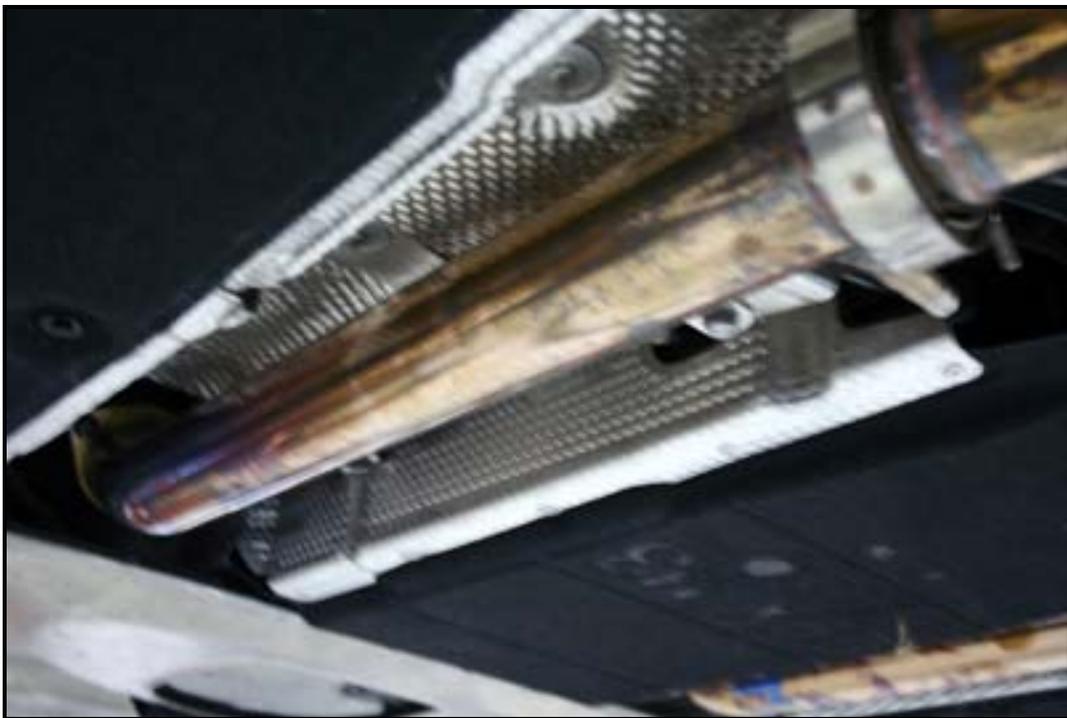
Picture of the LEFT side catalyst and the mark to be made for cutting off the catalyst



On the LEFT catalyst, there is a weld mark made by the factory. Approximately 10mm after the weld, there is a depression. Using a felt tip marker, make a mark all-around as a guide mark.



Using a hack-saw, cut off the LEFT catalyst



Remove the front pipes of the X-PIPE and install the cut off factory catalyst.



Position the STUBBIE between the factory catalyst and the Active X-PIPE and secure with the V-BAND clamp and other mounting hardware. The Stubbies have a sleeve making the pipes slide on for a partial fit.

Using a mig welder, make TACK WELD ONLY to secure the STUBBIE in the proper position.

DO NOT COMPLETE WELD the STUBBIES at this time.

After the tack welds are placed all around, the catalyst with STUBBIE can be removed and properly welded all around on a bench



Completed STUBBIES to the BMW factory catalysts ready to be installed for street use



Short and compact primary catalysts for easy installation or easy storage

- Check all clearance and tightness of all clamps and related hardware
- Make adjustment as needed then tighten all bolts and clamps
- Perform road test

Thanks for purchasing and installing a Active Autowerke STUBBIE exhaust component. Now you can perform on the street or on the track in a simple, easy installation that requires no gasket replacement for multiple re-installs.

If you have any questions, please contact anyone at Active Autowerke:

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