



# 2013+ Focus ST 2011 + Focus ROUSH Exhaust Kit

P/N: 421610 (1213-5E292)

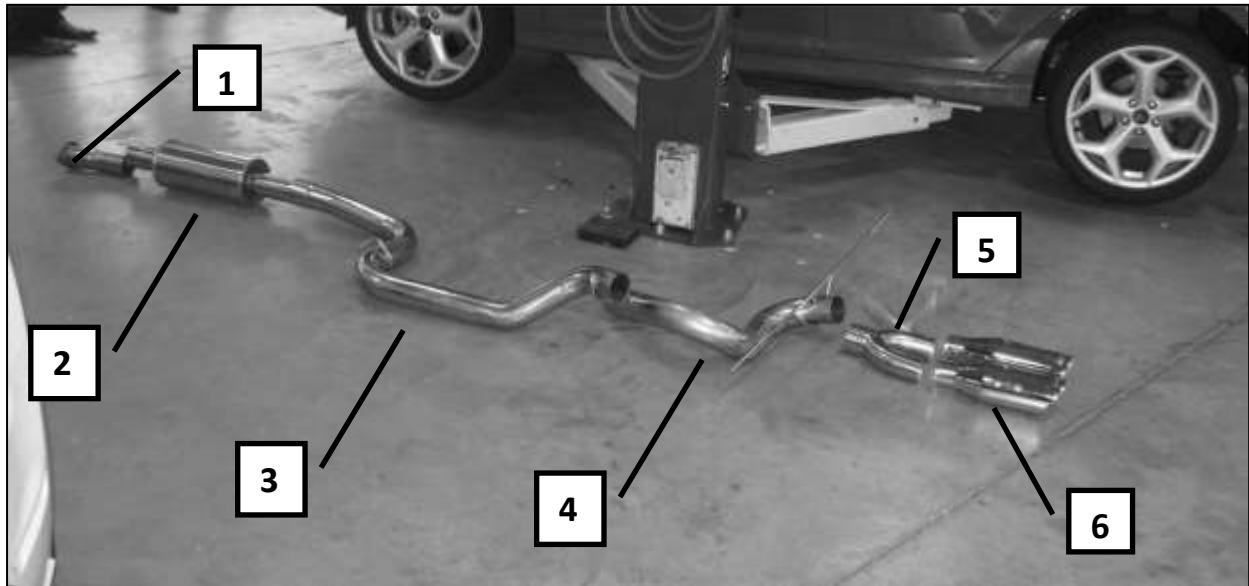
Application: 2013+ Ford Focus ST  
2011 + Ford Focus

## Installation Manual



Before installing your ROUSH Performance Product(s), read through the entire installation procedure and check to make sure all items are present. Contact ROUSH Customer Service at 1-800-59-ROUSH, weekdays from 9:00 AM to 5:00 PM EST, with any questions regarding fit, missing parts or instructions that are unclear to you.

## PACKAGING LIST (421610)



Part Ref	Part Description	Part Number	QTY
1	Inlet Pipe Adapter – ST Version	1213-5G267	1
2	ROUSH Muffler Assembly	1213-5230	1
3	Midpipe Assembly	1213-5246	1
4	Over-Axle Pipe Assembly	1213-5C262	1
5	Y-Pipe Assembly	1213-5255	1
6	ROUSH Exhaust Tip, 4"	13115230RTIP	2
Not Shown	Torca Clamp, 3"	R12060012	4
Not Shown	Torca Clamp, 2.5"	R12060014	2
Not Shown	Exhaust Flange Gasket	CV6Z-9450	1
Not Shown	Installation Manual	1213-5E292IM	1
Not Shown	Inlet Pipe Adapter – NA Focus	1213NA-5G267	1
Not Shown	Rear Valence Trim Template	1213-5E292TMP	1

## EQUIPMENT AND SUPPLIES REQUIRED

- 3/8" Drive Ratchets with Extensions
- Metric Socket Sets (deep recommended)
- 3/8" Drive Torque Wrench set to 48 Nm (35 lb-ft)
- Sawzall / Air saw - Cutting Tool



**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

## **LIMIT OF LIABILITY STATEMENT**

The information contained in this publication was accurate and in effect at the time the publication was approved for printing and is subject to change without notice or liability. ROUSH Performance Products (RPP) reserves the right to revise the information presented herein or to discontinue the production of parts described at any time.

## **SAFETY REQUIREMENTS**

**STOP!** READ IMPORTANT SAFETY CAUTIONS AND WARNINGS BEFORE PROCEEDING.

### **IMPORTANT SAFETY NOTICE**

Appropriate disassembly, assembly methods and procedures are essential to ensure the personal safety of the individual performing the kit installation. Improper installation due to the failure to correctly follow these instructions could cause personal injury or death. Read each step of the installation manual carefully before starting the actual installation.

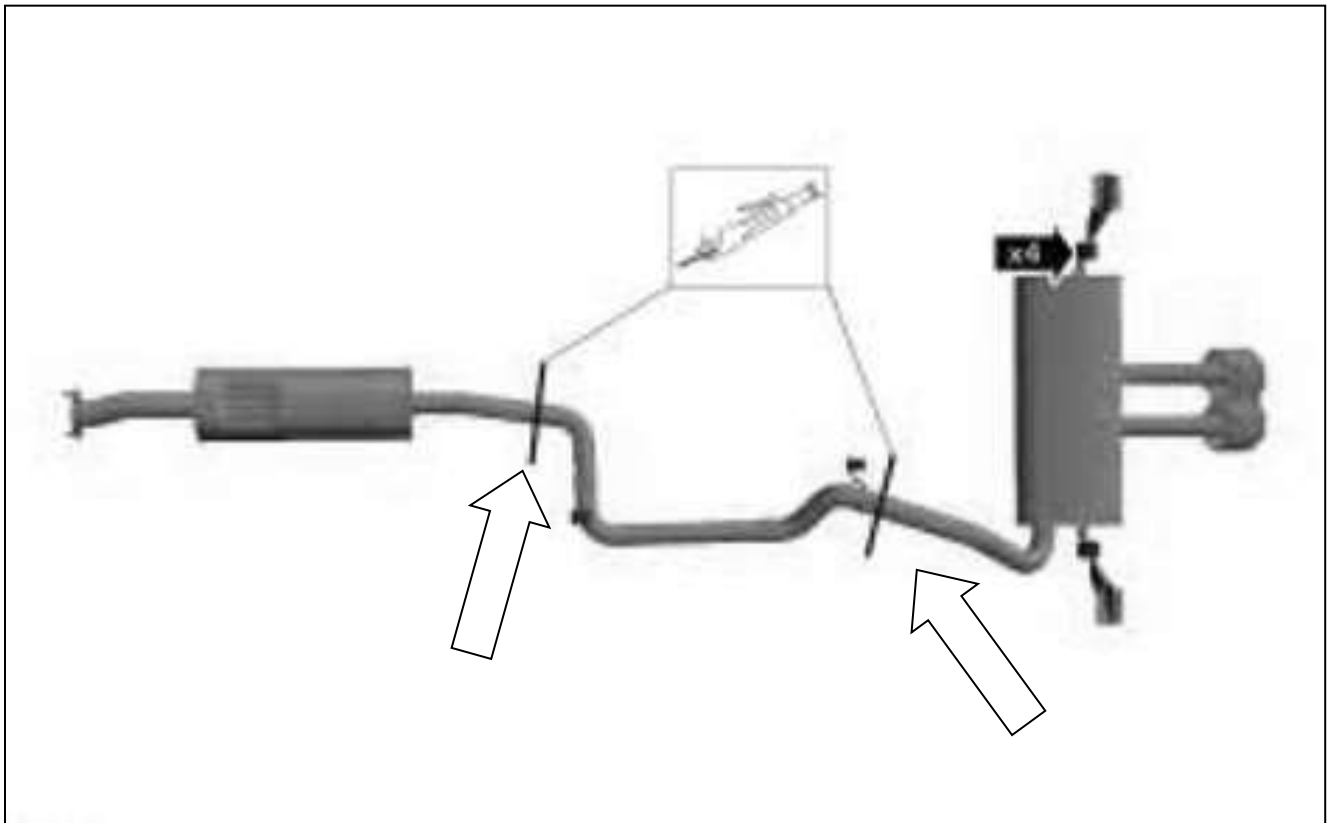
1. Always wear safety glasses for eye protection.
2. Place ignition switch in the OFF position.
3. Always apply the parking brake when working on a vehicle.
4. Chock the front and rear tires to prevent unexpected vehicle movement.
5. If working without a lift, always consult vehicle manual for correct lifting specifications.
6. Operate the engine only in well-ventilated areas to avoid exposure to carbon monoxide.
7. Do not smoke or use flammable items near or around the fuel system.
8. Use chemicals and cleaners in well-ventilated areas.
9. Batteries produce explosive gases, which can cause personal injury. Therefore, do not allow flames, sparks or flammable substances to come near the battery.
10. Keeps hands and any other objects away from the radiator fan blades.
11. Keep yourself and your clothing away from moving parts when the engine is running.
12. Do not wear loose clothing or jewelry that can get caught in rotating parts or scratch surface finishes.
13. Allow the engine, cooling system, brakes and exhaust to cool before working on a vehicle.

### **WORK SAFELY!**

Perform this installation on a good clean level surface for maximum safety and with the engine turned off.

## **SECTION A – REMOVAL OF STOCK EXHAUST**

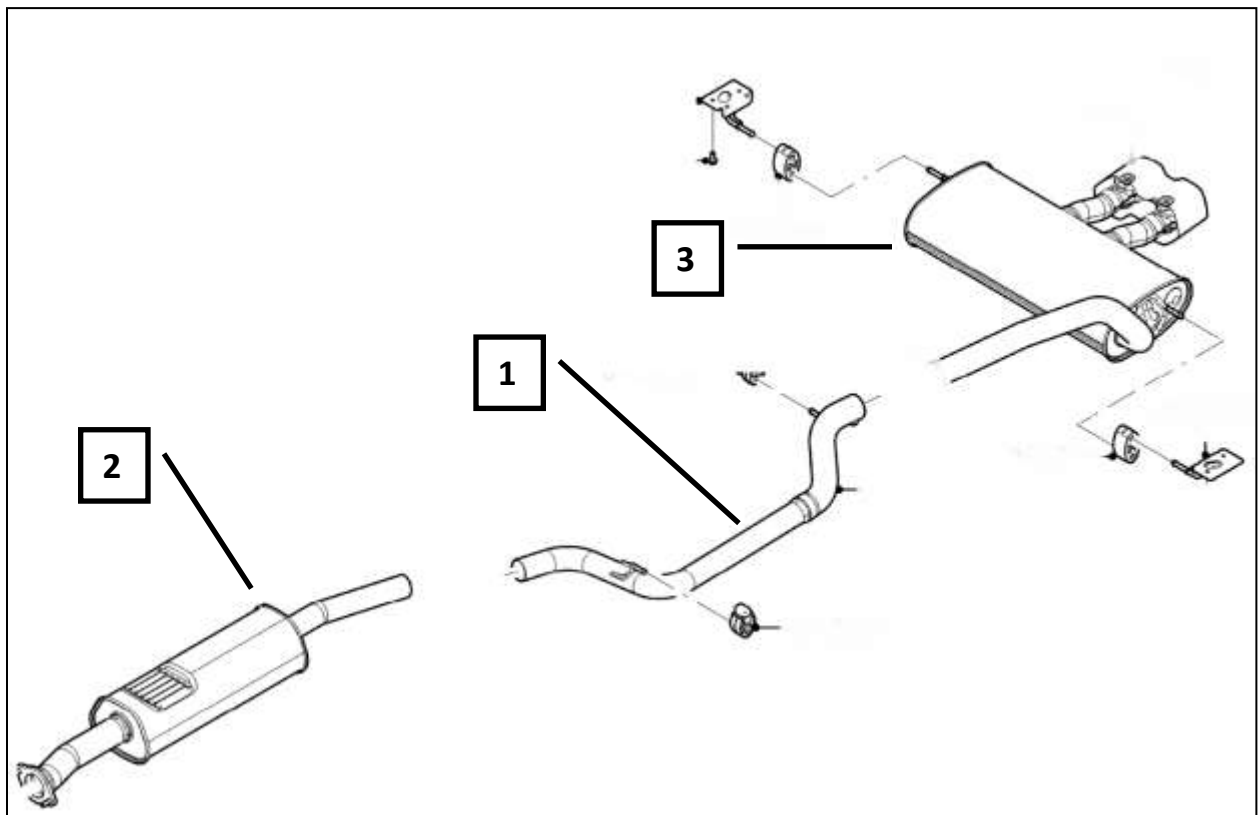
1. Secure the vehicle into the air using a lift.
2. Using a cutting tool, cut the stock exhaust system in the locations shown below.





**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

3. Remove the stock exhaust system by first sliding out the hangers on the middle section you just cut (1) from the rubber isolators holding it to the vehicle. Then, unbolt the resonator inlet from the catalytic converter outlet and remove the resonator (2) from the vehicle. (Set the nuts aside as they will be re-used). Remove the rear muffler (3) by sliding the exhaust hangers out of the rubber isolators attached to the vehicle. A few sprays of WD-40 on the hangers will make this step easier. Leave the isolators attached to the vehicle.

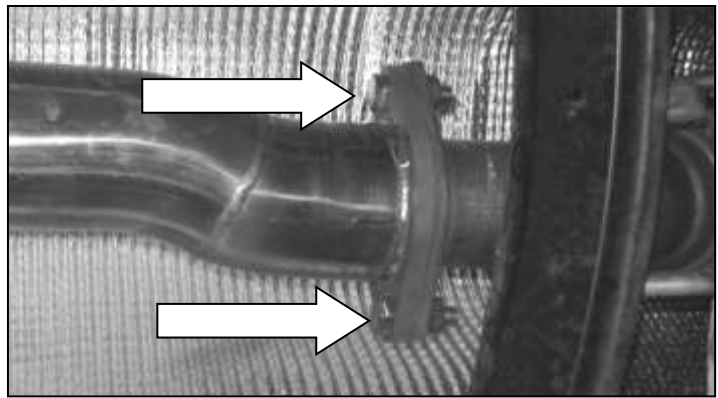
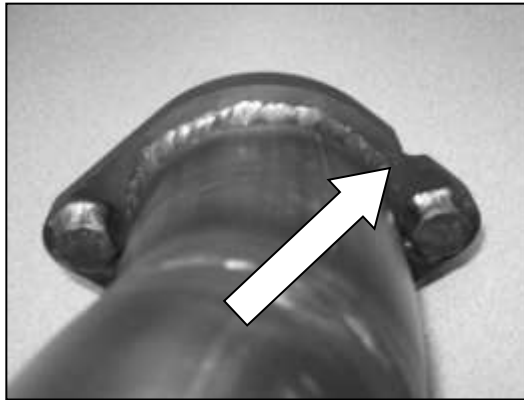




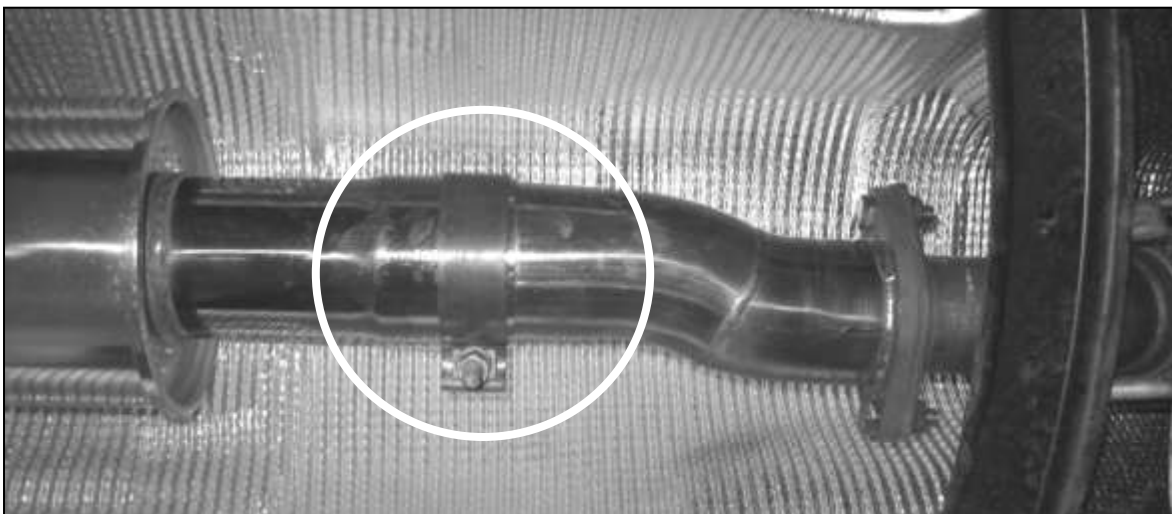
## **SECTION B – INSTALLATION OF ROUSH EXHAUST**

IF INSTALLING THIS EXHAUST ON A NON ST FOCUS, PLEASE REFER TO APPENDIX A AT THE END OF THIS MANUAL NOW.

1. Place the exhaust flange gasket (CV6Z-9450) onto the Inlet Pipe Adapter Assembly (1213-5G267) and fasten the adapter to the catalytic converter outlet using the factory nuts. Orient the Inlet Pipe with the small notch facing up, towards the bottom of the car. Tighten the nuts to 48 Nm (35 lb-ft).



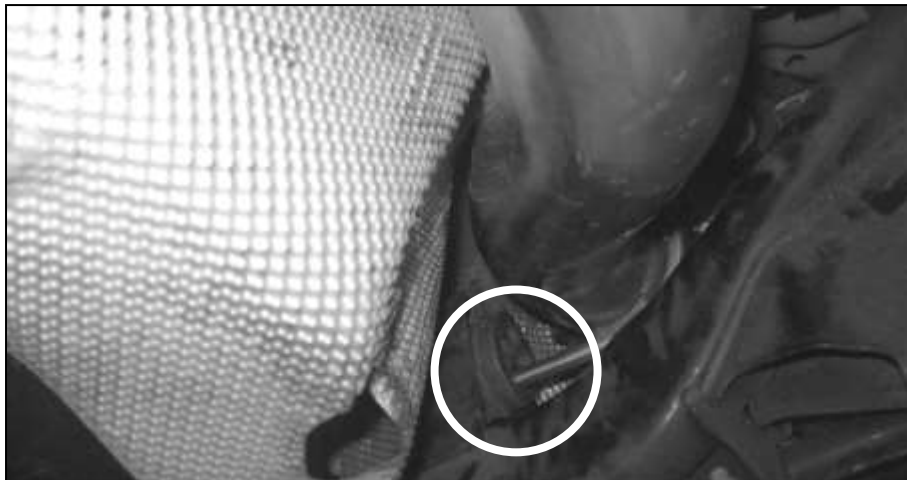
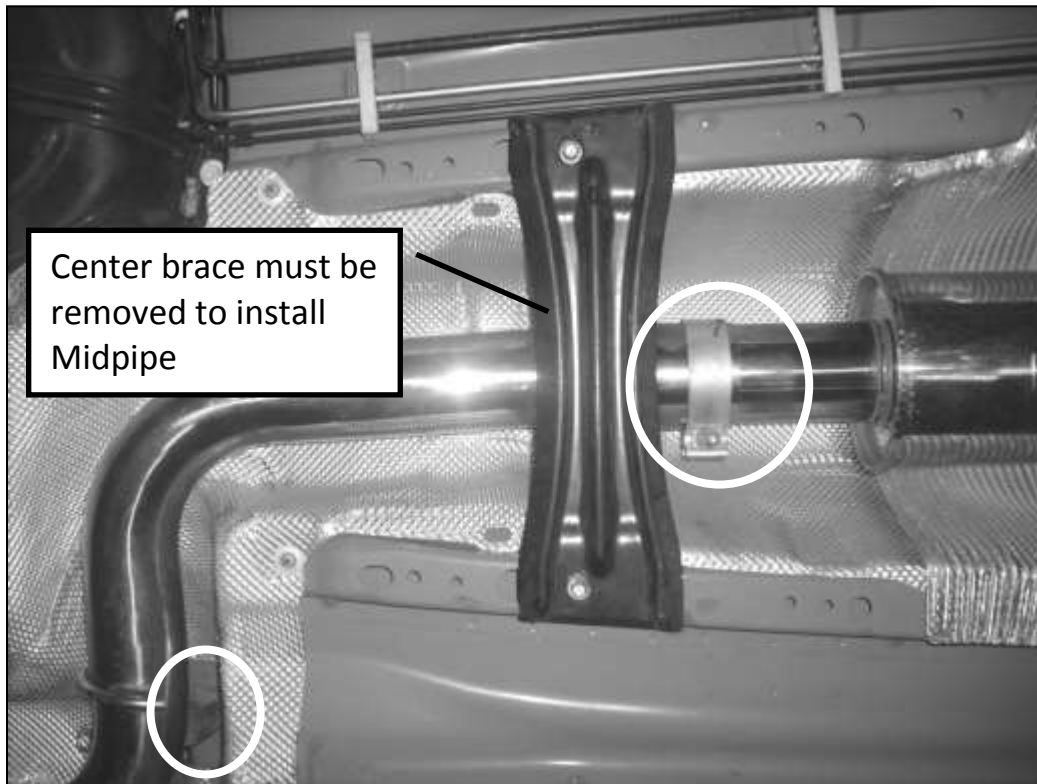
2. Place a 3" Torca Clamp (R12060012) over the flared end of the ROUSH Muffler (1213-5230). Install the flared end of the muffler over the end of the Inlet Pipe Adapter Assembly and loosely tighten the clamp.





**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

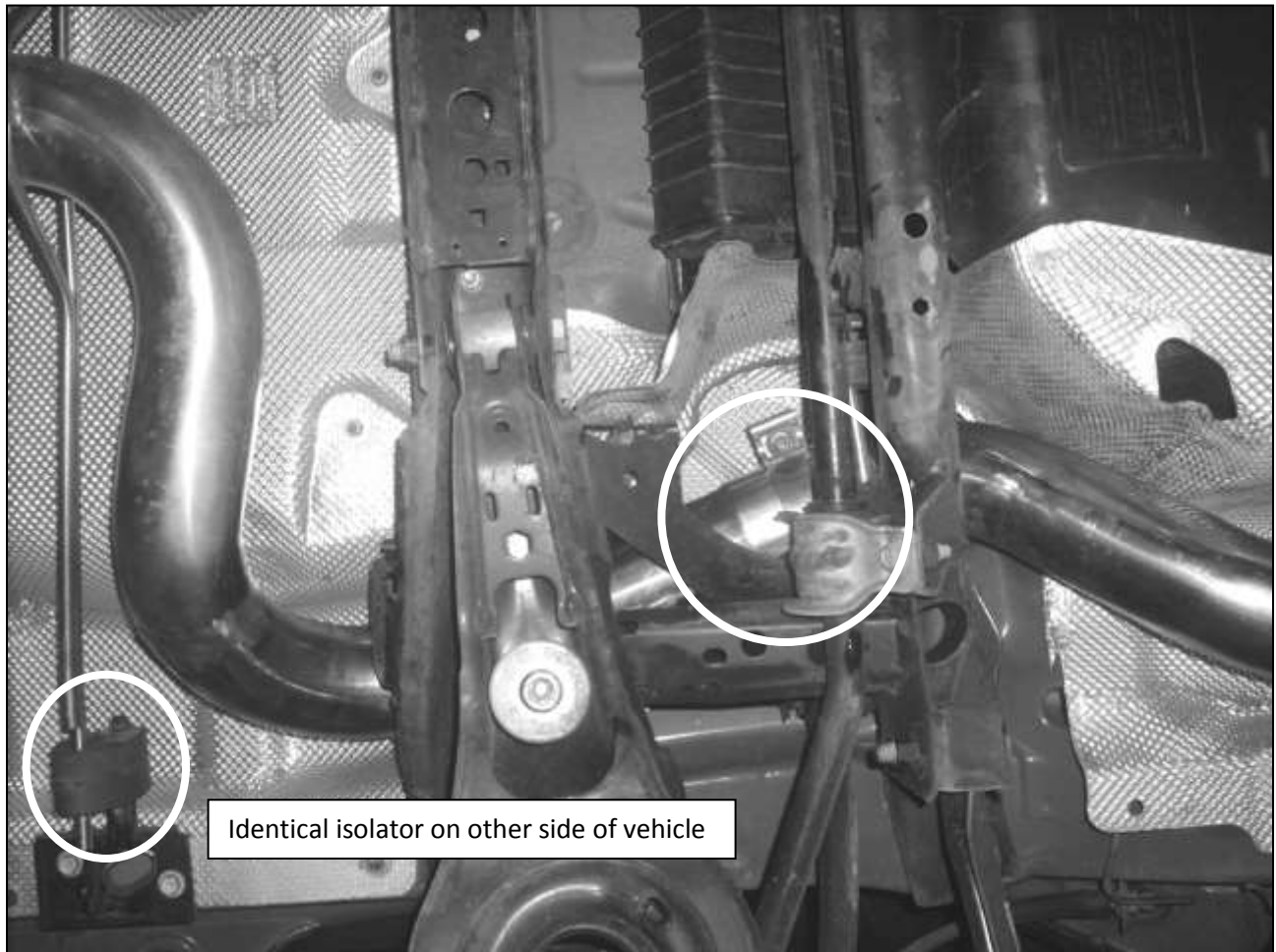
3. Remove the black center brace directly after the muffler and set aside the fasteners and bracket. Place a 3" Torca Clamp (R12060012) over the flared end of the ROUSH Midpipe (1213-5246). Install the flared end of the Midpipe over the end of the ROUSH Muffler and insert the hangers near the middle and rear end (directly above rear suspension arm) of the pipe into the factory rubber isolators. Loosely tighten the clamp. Re-install the center brace. Torque the bolts to 25 Nm.





**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

4. Insert the handle bar hangers on the ROUSH Over-Axle Pipe (1213-5C262) into the factory rubber isolators near the rear of the vehicle. Place a 3" Torca Clamp (R12060012) over the flared end of the Over-Axle Pipe. Install the flared end of the Over-Axle Pipe onto the end of the Midpipe (directly over the rear suspension) and loosely tighten the clamp. Position clamp so it is accessible for run down.

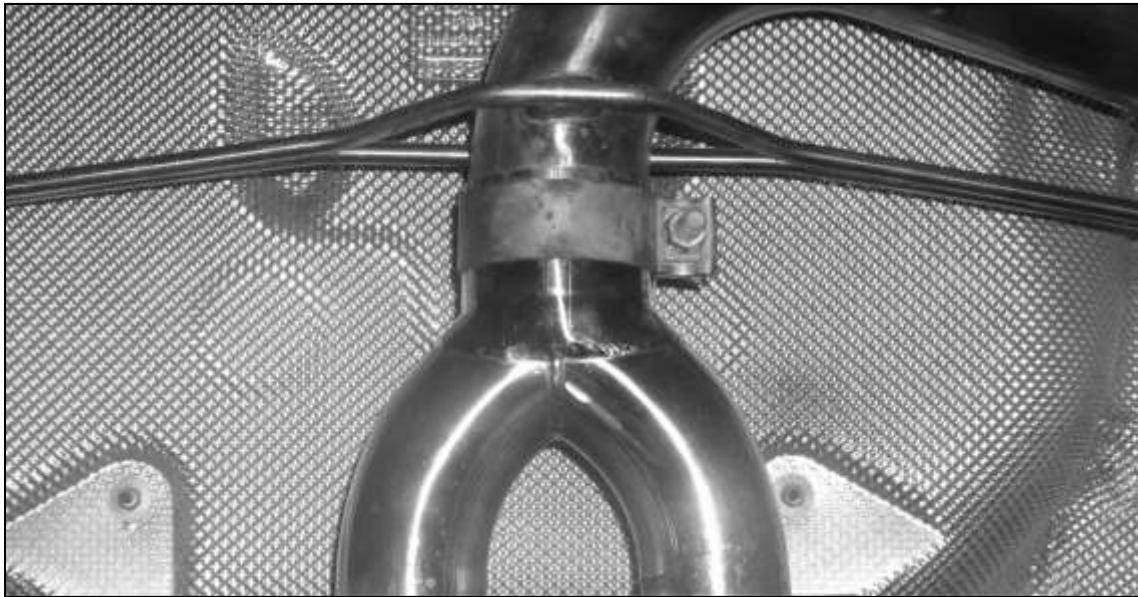




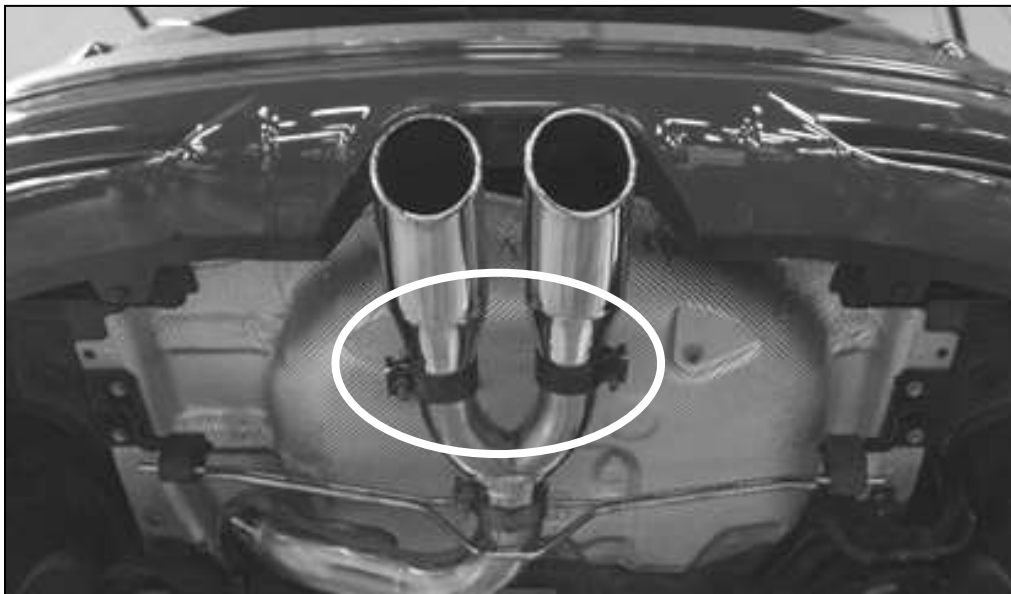


**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

5. Place a 3" Torca Clamp (R12060012) over the flared end of the ROUSH Y-Pipe (1213-5255). Install the flared end of the Y-Pipe onto the end of the Over-Axle Pipe and loosely tighten the clamp.



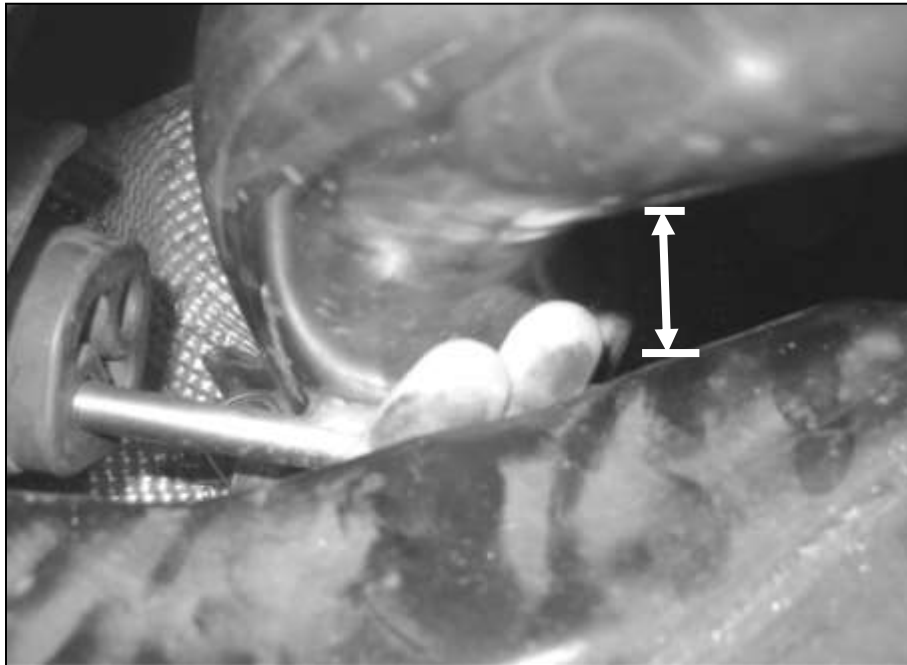
6. Place a 2.5" Torca Clamp (R12060014) over the flared ends of each ROUSH Exhaust Tip (13115230RTIP). Install the Tips onto the ends of the Y-Pipe and loosely tighten the clamps.





**ROUSH**<sup>®</sup>  
P E R F O R M A N C E

7. Adjust the entire system until the Exhaust Tips are centered in the rear valance. Ensure that there is adequate clearance between the rear suspension arm and the Over-Axle Pipe. Tighten all clamps to 48 Nm (35 lb-ft). You may need to bend the hangers on the over-axle pipe to achieve the desired position due to vehicle and install variances.



Congratulations!!! You have completed the installation of your ROUSH Performance Parts Exhaust System. It is recommended you save all parts removed from your vehicle during the installation of this kit.



## APPENDIX A – REAR VALENCE TRIM

### - NON ST ONLY -

Before installing the Roush Exhaust on your naturally aspirated Focus (Non ST Versions), the rear valence needs to be trimmed using the provided template (1213-5E292TMP) for the center exit exhaust.

- 1) With the factory exhaust system removed, cut the ROUSH template out and tape it to the outside inside edge of the rear valence. Line up the body line and the lower edges to the edge of the valence.



- 2) Cut / Trim out the center section around the bottom portion of the template and file down the edges to clean up any burrs.
- 3) Return to Section B – Exhaust Installation with the **following exception in step 1 (Section B), use the Straight Inlet Pipe Adapter (1213NA-5G297)** rather than the ST Inlet adapter for proper exhaust system clearance.



## **WARRANTY**

All retail parts carry a 90-day warranty from the date of purchase. This warranty covers defects in materials or workmanship, and does not include (i) normal wear and tear, environmental conditions, improper installation; (ii) road hazards, misuse, abuse, neglect, accidents, collision, fire, theft, freezing, vandalism, riot, explosion, or objects striking the vehicle; (iii) misusing the vehicle, such as driving over curbs, overloading, racing, or using the vehicle as a stationary power source; (iv) altering, disassembling or modifying the parts; (v) defects caused or induced by failures, breakdowns, or damage by other parts, components or the vehicle; (vi) subjecting the parts to excessive moisture or water or any motor vehicle fluids (e.g.: oil, anti-freeze, battery acid, brake fluid, etc.); (vii) acts of God, natural disasters and other similar causes beyond the reasonable control of ROUSH; or (viii) application of chemicals that affect the parts. This Limited Warranty does not cover surface deterioration of paint, trim, and appearance items that result from use and/or exposure to the elements, such as stone chips, scratches, bird droppings, lightning, hail, windstorm, dings, dents, earthquake, road salt, tree sap, water or flood.

ROUSH SHALL NOT BE LIABLE TO REIMBURSE CUSTOMER/DEALER FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES RESULTING FROM THE INSTALLATION OR USE OF ANY PRODUCT SOLD THROUGH THIS CATALOG OR ARISING OUT OF ANY BREACH OF WARRANTY. EXCEPT AS MAY BE STATED IN THIS CATALOG, ROUSH DISCLAIMS ALL EXPRESS AND IMPLIED WARRANTIES, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. IN NO EVENT SHALL ROUSH'S LIABILITY EXCEED THE PRICE PAID BY CUSTOMER/DEALER FOR PRODUCTS SOLD REGARDLESS IF ROUSH HAS BEEN ADVISED IN ADVANCE OF ANY POTENTIAL PROBLEM OR IF A CLAIM IS BASED ON CONTRACT, TORT, STRICT LIABILITY, PRODUCT LIABILITY OR OTHERWISE. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF IMPLIED WARRANTIES OR THEIR DURATION, OR LIABILITY FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE EXCLUSIONS OR LIMITATIONS MAY NOT APPLY.