



*"Setting the World's  
Performance Standards!"*

**Starting Line  
Products, Inc.**

743 E. Iona Rd. Idaho Falls, ID 83401, (208)529-0244 Fax (208)529-9000

**SLP PART #09-872**

**ATTENTION DEALER**

**PLEASE PROVIDE YOUR CUSTOMER WITH THE  
INSTALLATION AND INSTRUCTION DATA THAT IS  
SUPPLIED IN THIS PACKET FOR THIS PRODUCT.**

**Before you begin, please read the following:**

The information contained in the instruction sheet supplied with this products is intended to provide complete setup and tuning specifications needed to have successful installation. It also acts as a reference guide for future tuning for altitude and temperature differentials. Varying from these standards can reduce performance and/or dependability.

Please read the following instructions for best results.

If you are experiencing difficulty after completely following the setup instructions, SLP technical assistance is available online at the SLP website:

**[www.startinglineproducts.com](http://www.startinglineproducts.com)**

**or by phone at 208-524-3397**





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## SLP Single Pipe Set for Arctic Cat M8/Crossfire/Crossfire R

**P.N. 09-872**

Effective Date:7/14/2008

### Kit Contents:

- |                             |  |                                 |
|-----------------------------|--|---------------------------------|
| 1 - Silencer (#09-282)      | 1 - Spring Tab (#090-697)              | 1 - Large Head Rivet (#090-42)  |
| 1 - Y-Pipe (#090-8721)      | 2 - Zip Tie (#090-45)                  | 1 - Anti-Seize (#090-0146)      |
| 1 - Single Pipe (#090-8722) | 1 - Rivet Washer(#090-44)              | 8 - Allen Head Bolts (#090-699) |
| 1 - Short Spring (#090-40)  | 1 - 30" Reflective Heat Tape (#090-31) |                                 |

**Read instructions carefully and completely before attempting installation.**

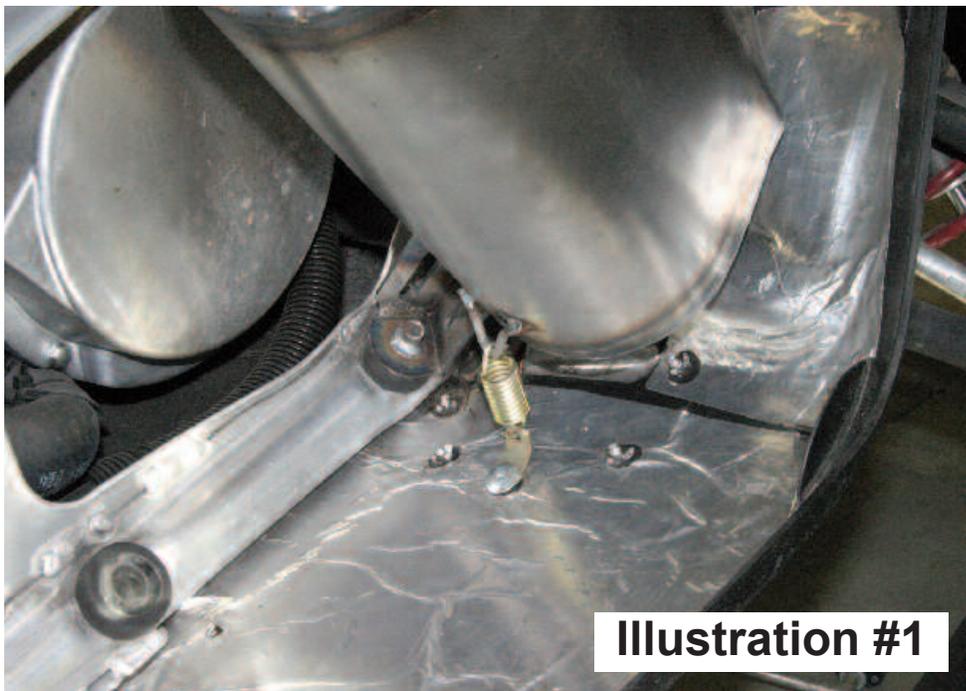
**Note:** Do not remove banding placed on the mid section of the pipe. It has been placed there to improve performance, reliability, and reduce noise emissions. Check tightness every 100 miles for the first 300 miles and periodically thereafter.

1. Carefully remove EGT probe from pipe. Remove stock pipe, silencer, y-pipe, and y-pipe cylinder studs. (Retain stock springs, silencer retaining clip and washer for pipe installation.)

**NOTE 2008-09 Models:** Remove aluminum heat shield that protects the injectors and oil bottle.

2. Using a 3/16" drill bit, remove the bottom rear rivet from the outlet plate (see illustration #1). Install the provided spring tab into the belly pan facing the front of the sled and rivet into place with the rivet washer on the outside of the belly pan.

3. Remove rubber insulator from stock silencer hanger. Install on SLP silencer (see illustration #2).



**Illustration #1**

4. Run a bead of high temp silicone such as Permatex® Ultra Black® (PX#82180) or Loctite® RTV Silicone 598™, around stock outlet hole (see illustration #3).

5. Install SLP silencer and mount into place using the stock washer and retaining clip. Using the supplied spring, spring from the spring tab to the silencer.

6. Apply heat tape to the throttle cable and exhaust valve cables. Apply heat tape to injector wire harness and zip tie to fuel rail (as shown in Illustration #4).

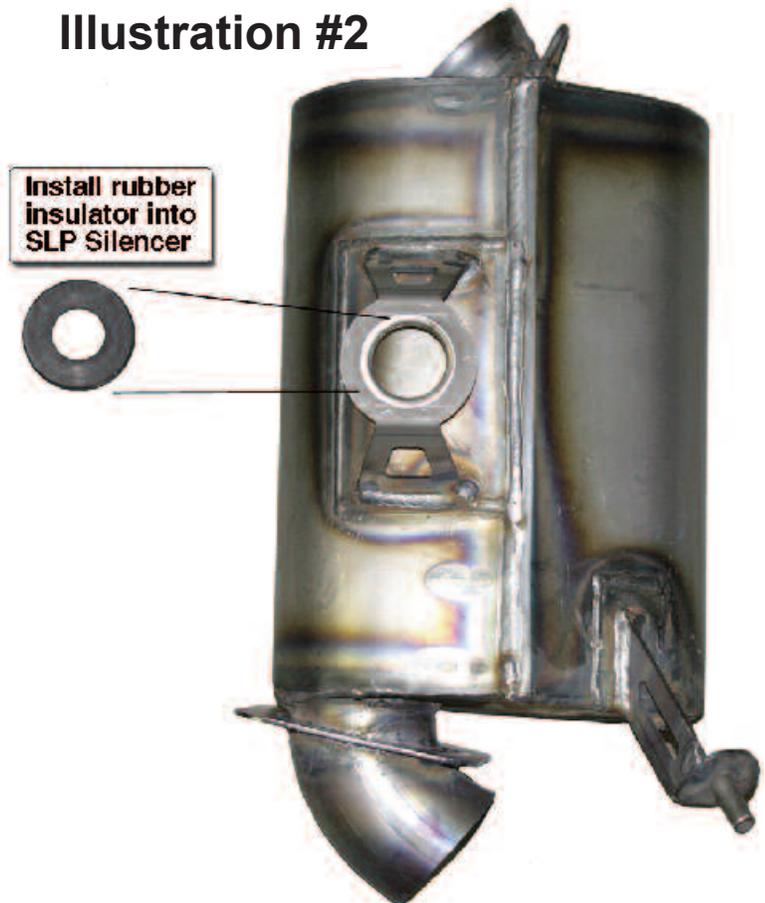
7. Reinstall aluminum heat shield removed in step 1 (**2008-09 Models only**), the shield will need to be bent down in the center for pipe clearance.

8. Install SLP y-pipe (with it angled downward). The stock metal shim gasket can normally be reused. Apply a light coating of high temp silicone sealer such as Permatex® Ultra Black® (PX#82180) or Loctite® RTV Silicone 598™ to both sides of the gasket to promote a good seal.

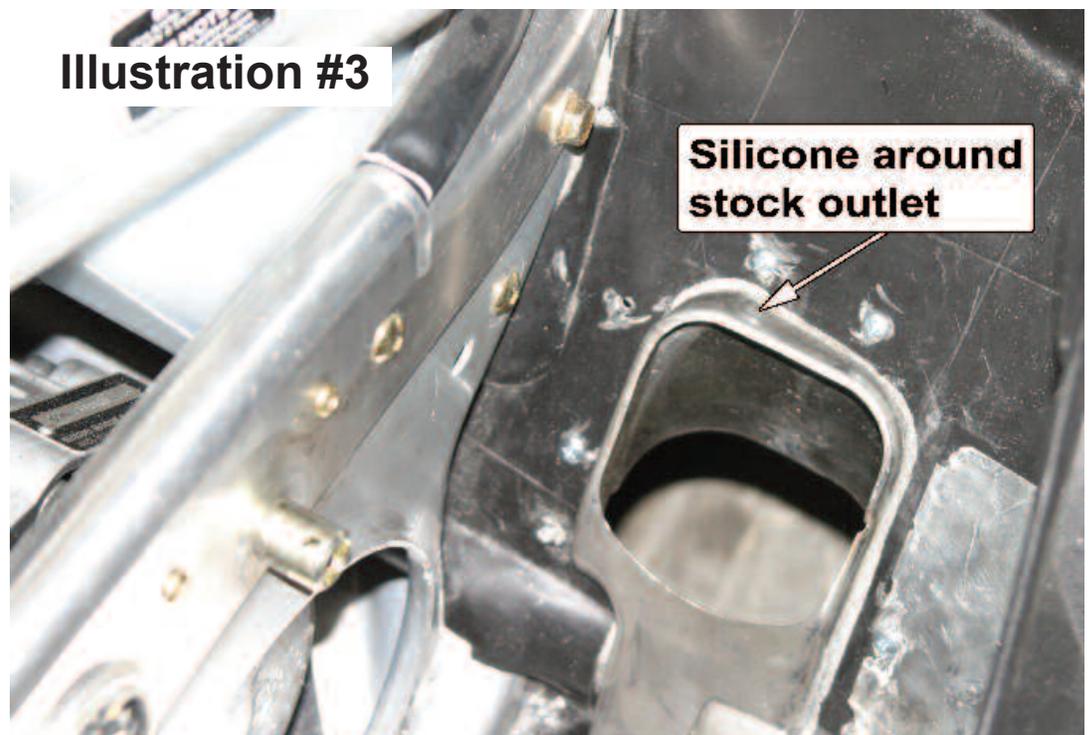
**Hint:** For easier installation of Y-pipe use a 6mm x 5" long 3/8" drive ball end allen wrench with a swivel and a long extension.

9. Install SLP pipe, and spring it into place. Using supplied packet of anti-seize, coat threads of the exhaust temperature probe and re-install, torquing to 12 - 15 ft/lbs. It is very important to use anti-seize, and make sure not to overtighten the probe nut. Failure to follow these guidelines can cause damage to the probe during installation.

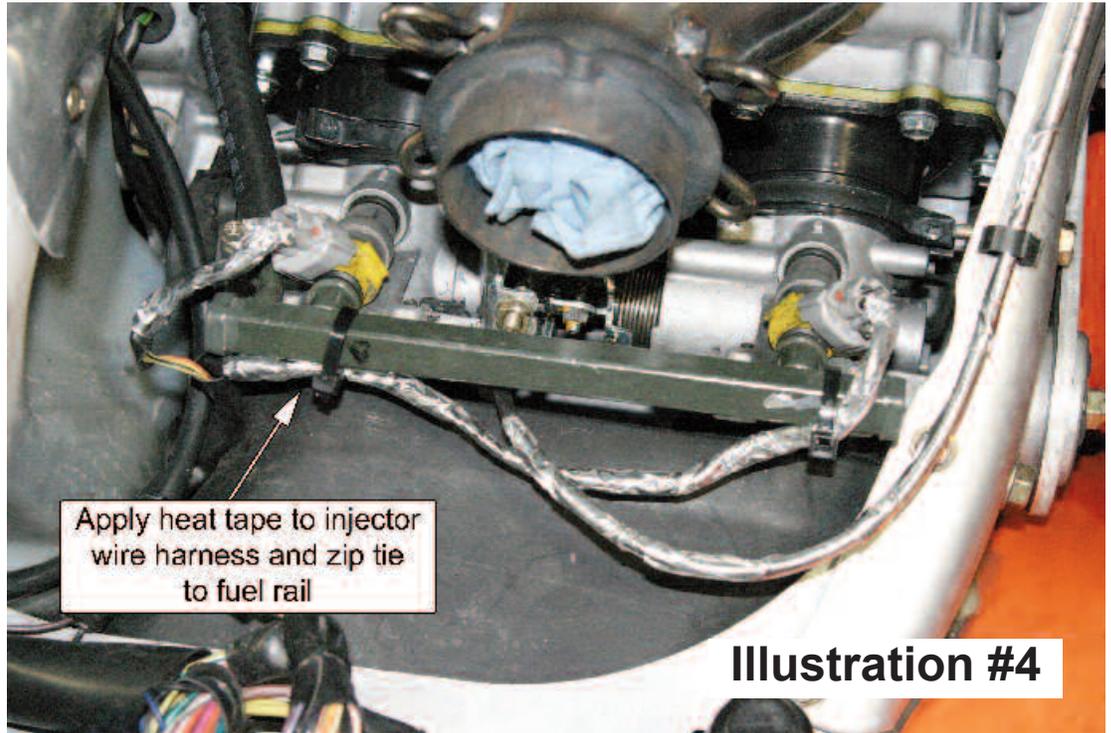
## Illustration #2



## Illustration #3



9. The two inner lower (front) tabs on the left hood screen must be removed. Relocate screen clip to center screen tab (see illustration #5). Cut the inner lower hood tabs flush with the hood. Using a razor knife cut the hood insulation from the lower left hood tab down 5" and over 4". Then cover this area with reflective heat tape. Check for hood clearance of at least 1/8" before operation.



**Illustration #4**

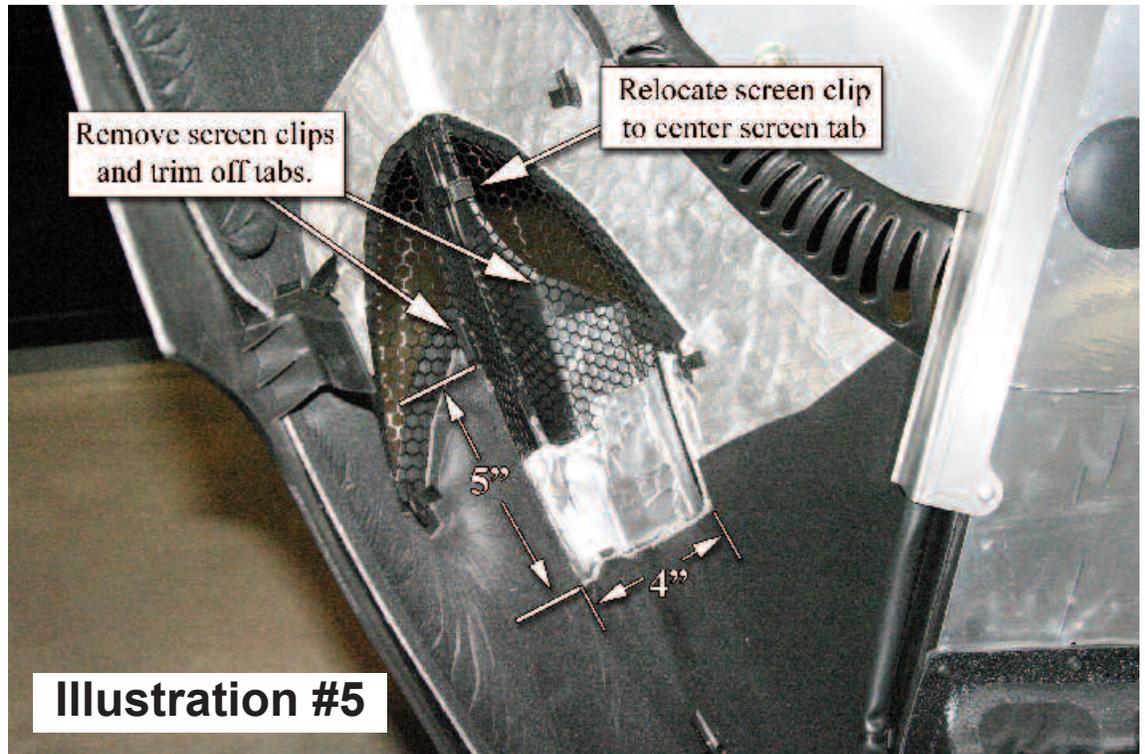
**Spring Tension Adjustment:**

Spring loop adjustment is suggested for proper spring tension to prevent leakage and wear (low tension), allow adequate flex (proper tension) and prevent spring breakage (excessive tension).

When system is installed the spring can be judged for proper tension. The winding spacing at the center of the spring will indicate tension.

When proper the two center windings will have .040" to .050" clearance between them. This is easily tested with a feeler gage.

If tension is incorrect, the loop on the pipe or silencer can be bent in the direction needed to increase or decrease tension. Attach a vise grip firmly to the loop and bend.



**Illustration #5**

## Arctic Cat M-8 EFI with SLP Single Pipe Set

**Fuel Requirement:** This pipe is compatible with the stock ECU on 2007-09 models. It is also compatible with the stock ECU when used in combination with SLP High Flow™ Intake Kit (part #14-305) and V-Force 3 Reed Valves (part #22-103). Other modifications including but not limited to: head modifications, increased timing, cylinder porting or intake modifications other than the SLP High Flow™ Intake Kit in addition to the pipe may require the use of an EFI control box.

**Fuel Requirement:** Minimum 91 octane pump fuel.

## Clutching for 2007-09 Arctic Cat 800 with SLP SLP Single Pipe Set

Altitude (feet)	Drive Clutch		Driven Clutch		
	Clutch Spring	Shift Weight	Clutch Spring	Driven Helix (Good)	Driven Helix (Best)
0-3000 ft	Yellow / White #0646-229(Steel) #0646-379T (Titanium) (Stock)	77g MTX (#40-118) 1g rivet outer hole	Orange #0648-774 (Steel) #0648-776T (Titanium) (Stock)	36° (Stock) #0648-765	40/36 #52-40/36
3000-6000 ft	Yellow / White #0646-229(Steel) #0646-379T (Titanium) (Stock)	71g MTX (#40-96) 3g rivet outer hole 3g inner hole	Orange #0648-774 (Steel) #0648-776T (Titanium) (Stock)	36° (Stock) #0648-765	40/36 #52-40/36
6000-8000 ft	Yellow / White #0646-229(Steel) #0646-379T (Titanium) (Stock)	71g MTX (#40-96) 3g rivet outer hole 1g inner hole	Orange #0648-774 (Steel) #0648-776T (Titanium) (Stock)	36° (Stock) #0648-765	40/36 #52-40/36
8000-10000 ft	Yellow / White #0646-229(Steel) #0646-379T (Titanium) (Stock)	71g MTX (#40-96) 2g rivet outer hole	Orange #0648-774 (Steel) #0648-776T (Titanium) (Stock)	36° (Stock) #0648-765	40/36 #52-40/36

## Running RPM 8000-8100

## **Caring for your ceramic coated pipes and/or silencer:**

Ceramic Coating is an aluminum matrix applied to your exhaust system to provide a thermal barrier for more consistent performance. It is a coating which requires little maintenance to keep your pipes and/or silencer looking like new.

Upon completion of new installation, wipe the ceramic coated parts of the exhaust system down with brake cleaner. This will prevent oils and grease (usually in the form of fingerprints) from burning on and staining the exhaust during first initial startup.

To maintain your ceramic coated system, wash it with soap and water periodically (especially necessary after trailering it to and from your riding area on roads that have been treated with salt and other ice removing chemicals). Salt and other ice removing chemicals will attack and eat away at the ceramic coating. This will result in rust coming through the coating. Typically you will notice this rusting after your snowmobile has set for a period of time without the exhaust system being brought up to running temperature.

Periodically polish your ceramic coated pipes and/or silencer after each washing with an aluminum polish such as Mothers, Maas or Blue Magic aluminum polish that can be found at any automotive parts store. Do not use any acidic cleaners! For stubborn stains use fine 000 steel wool, then use a soft cloth with polish. Failure to maintain your ceramic coated pipes or silencer can result in damage to the ceramic coating for which there is no warranty coverage. A little care will insure that your pipes and/or silencer will continue looking like new for many years.

Note: In areas of the ceramic coated system where skin temperatures exceed 1300 degrees F, it is normal for the coating to turn dull gray. These areas should also be washed and polished periodically.