



*"Setting the World's  
Performance Standards"*

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

**SLP PART# 09-8018**

**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 product 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.**

**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 208-529-0244**

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## **SLP Single Pipe Set Part# 09-8018 for 2018-21 Arctic Cat 800 and 2021 Yamaha Mountain Max**

### **Parts List:**

1 - Silencer (#090-80003)	1 - Grafoil Seal (#090-747)	1 - Y-Pipe (#090-80180)
1 - Anti-Seize (#090-0146)	1 - Rivet Washer (#090-44)	1 - Single Pipe (#090-8017)
1 - 3/16” Rivets (#090-42)	4 - 30” Reflective Heat Tape (#090-31)	
1 - Short Spring (#090-40)	1 - 91 Octane Fuel Recommend Sticker (#60-38)	

**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. Remove hood and side panels from the sled. Carefully remove EGT probe from pipe. Remove stock pipe, silencer, y-pipe, aluminum heat shield and rubber support on clutch cover. (Retain stock springs, gaskets and rubber silencer supports for pipe installation.)

2. Apply heat tape to the concaved area on the bottom of the hood, then cover with reflective heat tape (see illustration #1).

4. Apply reflective heat tape to the upper portion of the gas tank that is not covered by OEM reflective tape (see illustration #2). Apply reflective heat tape to the upper front side shock tower (see illustration #3).

6. Install Power Commander V Fuel Control Box onto the top side of the air box.

7. Bend the OEM aluminum heat shield so that it is as close to the chassis cross bar as possible for y-pipe clearance. Bend the area around the wire loom up so that the aluminum heat shield will not pinch or cut wires. Then reinstall heat shield.

8. Install OEM rubber silencer supports onto SLP Silencer and install it into the snowmobile.

**NOTE:** Make sure the bottom of the silencer is not on the oil line. Spring into place using the SLP supplied short spring on the rear of silencer. The spring hook on the front of the silencer will not be used. (illustration #4)

9. Install SLP y-pipe. Use the SLP Exhaust Flange Gasket. 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 10mm swivel socket and a long extension.

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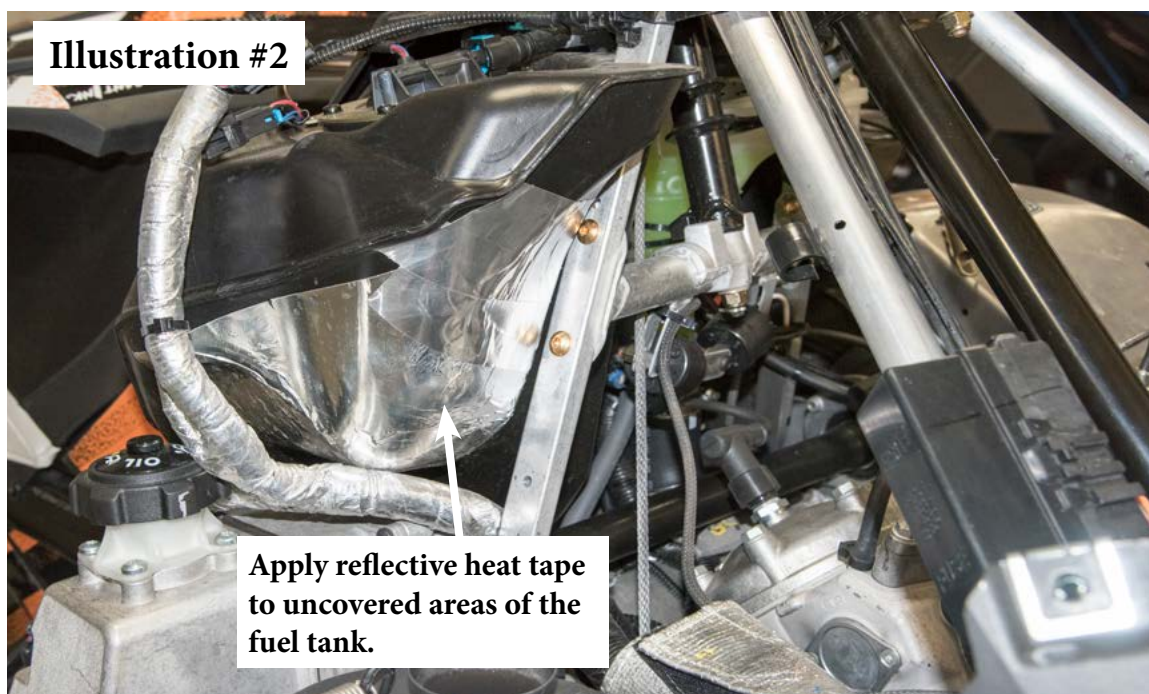
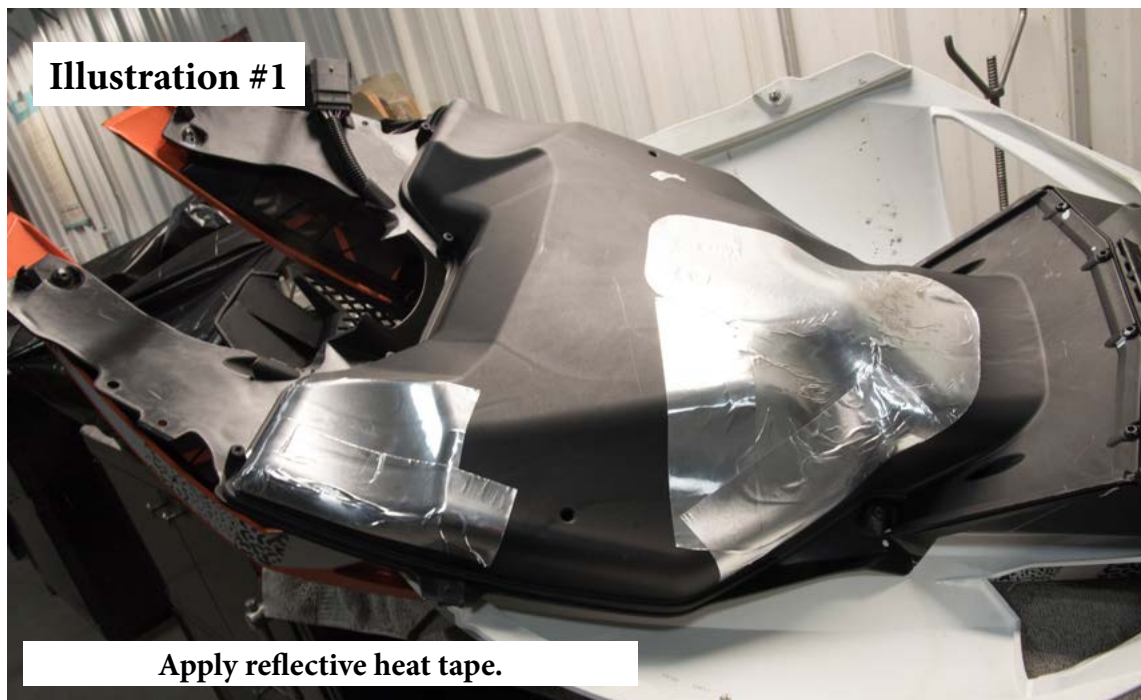
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10. Install SLP pipe using OEM grafoil seal for y-pipe to pipe and the supplied grafoil seal for pipe to silencer connection, and spring it into place using OEM springs. Using supplied packet of anti-seize, coat threads of the exhaust temperature probe 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.

11. Reinstall hood and side panels.

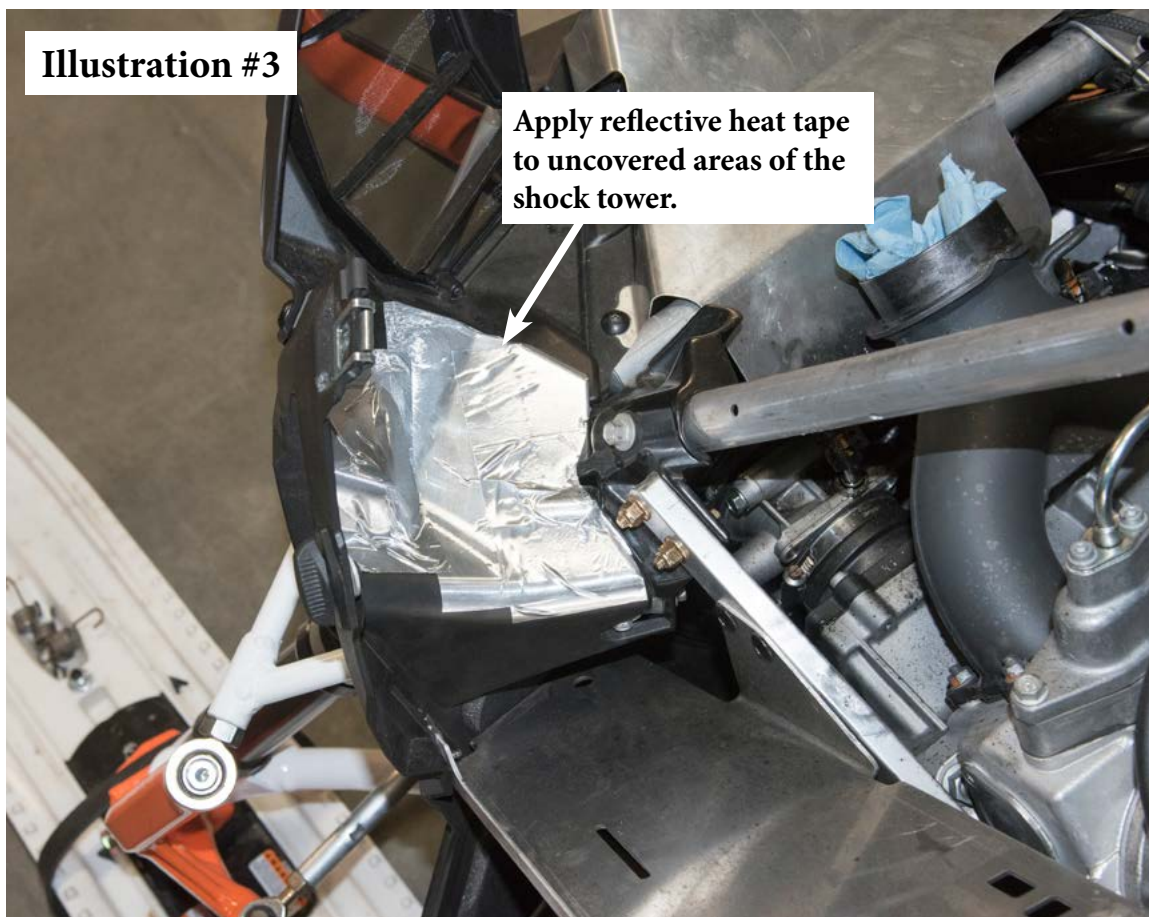
**NOTE:** Check for pipe to hood clearance, there should be at least 1/8" of clearance.



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**Illustration #3**



**Illustration #4**



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# Clutching for 2018-21 Arctic Cat F8, XF-8 and 7/15/20 AW

## ZR8000 EFI with SLP Single Pipe Set

Clutching not yet available for this model. Information will be released as soon as it is available. For more information contact Starting Line Products at (208)529-0244 or email [slptech@slp.cc](mailto:slptech@slp.cc).

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## Clutching for 2018-21 Arctic Cat M-8 and 2021 Yamaha Mountain Max with SLP Single Pipe Set using TEAM BOSS Secondary Clutch and SLP Magnum Force™ Clutch Weights

Altitude (feet)	Drive Clutch		Driven Clutch		
	Clutch Spring	SLP Magnum Force™ Shift Weight	Clutch Spring	Driven Helix	
				Good	Better
<b>0-2000'</b>	SLP Green / Silver SLP# 40-72	SLP Magnum Force™ SLP #40-152 7 set screws 1 lock set	Stock 180/240	48° Straight (Stock)	N / A
<b>2000-4000'</b>	SLP Green / Silver SLP# 40-72	SLP Magnum Force™ SLP #40-152 6 set screws 1 lock set	Stock 180/240	48° Straight (Stock)	N / A
<b>4000-6000'</b>	SLP Green / Silver SLP# 40-72	SLP Magnum Force™ SLP #40-152 5 set screws 1 lock set	Stock 180/240	48° Straight (Stock)	N / A
<b>6000-8000'</b>	SLP Green / Pink SLP# 40-77	SLP Magnum Force™ SLP #40-152 2 set screws 1 lock set	SLP #50-138 200/280	48° Straight (Stock)	46° SLP #52-102
<b>8000-10000'</b>	SLP Green / Pink SLP# 40-77	SLP Magnum Force™ SLP #40-152 1 set screws 1 lock set	SLP #50-138 200/280	48° Straight (Stock)	46° SLP #52-102
<b>10000 ft</b>	SLP Green / Pink SLP# 40-77	SLP Magnum Force™ SLP #40-152 Empty	SLP #50-138 200/280	48° Straight (Stock)	46° SLP #52-102

### Running RPM 8250-8450

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## **2018-21 Arctic Cat 800 and 2021 Yamaha Mtn. Max with SLP Single Pipe Set**

Fuel Control Box Requirement: Must use SLP pre-programmed Power Commander V. SLP Part #70-199 with SLP fuel map (see below). This fuel map is compatible with the SLP Single Pipe. Other modifications including but not limited to: head modifications, increased timing, cylinder porting or intake modifications other than SLP High Flow™ Intake Kit in addition to the pipe may require a different fuel map.

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

**2018-19 Models:**

**-Non-Ethanol Fuels: Use SLP Map Part #70-296**

**-Ethenol Fuels: Use SLP Map Part# 70-297**

**2020-21 Models:**

**-Non-Ethanol Fuels: Use SLP Map Part #70-318**

**NOTE:** Within the parts kit of this pipe set you will find a “Minimum 91 Octane Recommended” sticker. We recommend placing this sticker on or around the fuel cap as a friendly reminder.

### **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). After system installation, inspect center winding spring for proper tension. .040” to .050” clearance between windings is proper. Test with a feeler gauge. To adjust, 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.

## **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

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