

18 Exhaust System

Model 318 i:		
18 00 020	Exhaust assembly – remove and install	18 - 1
18 12 031	Final muffler – replace	18 - 2
18 21 011	Pivot sleeves on exhaust carrier – replace	18 - 3
18 32 005	Catalytic converter – remove and install / replace	18 - 4
Models 325 ... 325 iX:		
18 00 020	Exhaust assembly – remove and install	18 - 5
18 12 031	Final muffler – replace	18 - 6
18 32 005	Catalytic converter – remove and install / replace	18 - 7
Model M 3:		
18 00 020	Exhaust assembly – remove and install	18 - 8
18 12 031	Final muffler – replace	18 - 8
	Exhaust suspension layout	18 - 9

18 00 020 REMOVING AND INSTALLING EXHAUST ASSEMBLY

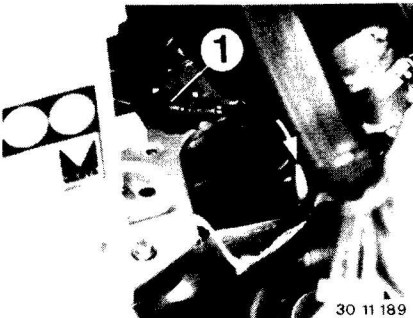
BMW 318 i:

Disconnect oxygen sensor plug (1).
Pull out plug downward through the protective tube.

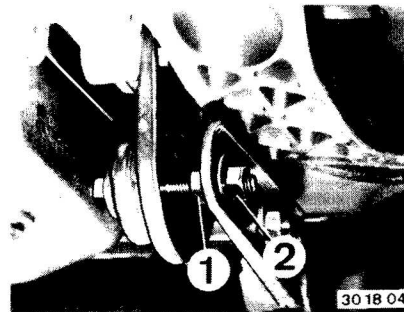
Caution!

Oxygen sensor must not be damaged.
Remove oxygen sensor if there is danger of damaging it.

Refer to 11 78 012.



30 11 189



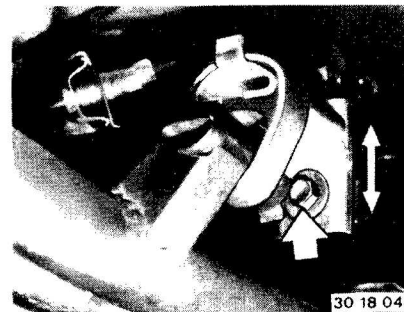
30 18 047

Cars with Automatic Transmission:

Unscrew nut (2).

Installation:

Mount the exhaust carrier without tension by adjusting nut (1).



30 18 048

Disconnect suspension on rear axle carrier if necessary.

Installation:

Move holder to adjust only after finishing installation of the exhaust assembly and then tighten to correct torque*.

Unscrew exhaust pipe on manifold.

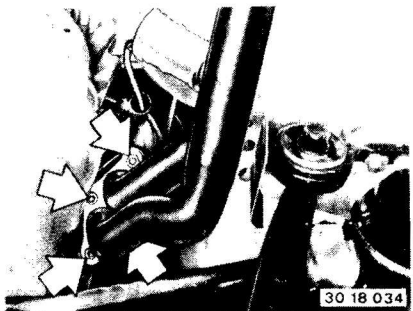
Installation:

Check gasket, replacing if necessary.

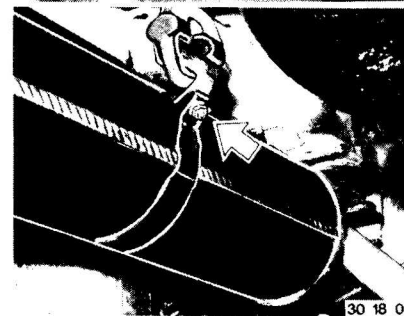
Replace self-locking nuts.

Coat threads with copper paste CRC**.

Tightening torque*.



30 18 034



30 18 003

Loosen holder for final muffler.

Installation:

Torque* holder in such a manner, that rubber ring is preloaded.

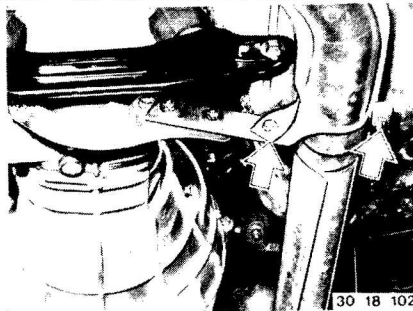
Preload: 6 mm (0.236").

See exhaust suspension layout drawing.

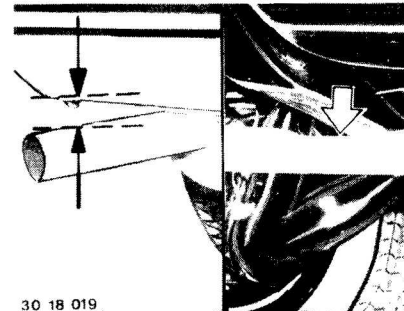
Loosen holder for exhaust.

Installation:

Torque* holder only after finishing installation of assembly (danger of tension).



30 18 102



30 18 019

Take off exhaust assembly.

Installation:

Check spacing to body and rear axle carrier, correcting if necessary.

* See Specifications

** Source of Supply: HWB

* See Specifications

18 12 031 REPLACING FINAL MUFFLER

BMW 318 i:
Disconnect catalytic converter on final muffler.

Installation:
Replace gasket and self-locking nuts.
Tightening torque*.

Disconnect suspension on rear axle carrier, if necessary.

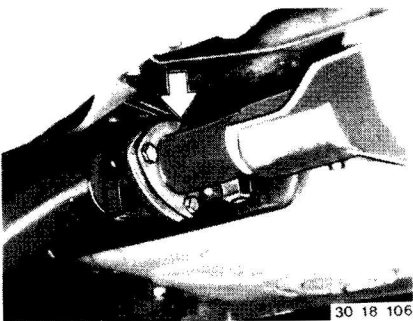
Installation:
Adjust holder by moving and torque* only after finishing installation of the exhaust assembly.

Loosen holder for final muffler.

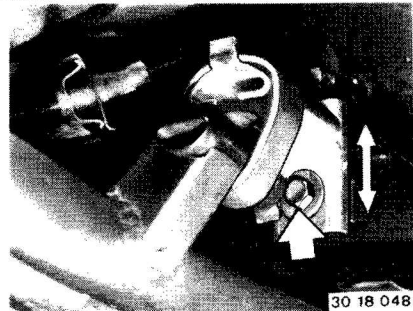
Installation:
Torque* holder in such a manner that rubber ring is preloaded.
Preload: 6 mm (0.236").
See exhaust suspension layout drawing.

Remove exhaust assembly.

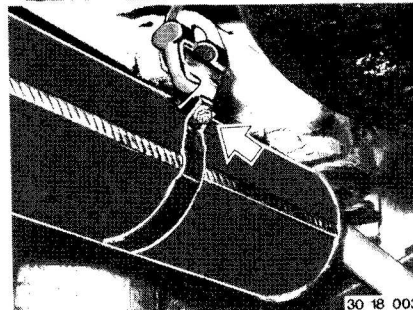
Installation:
Check spacing to body and rear axle carrier, correcting if necessary.



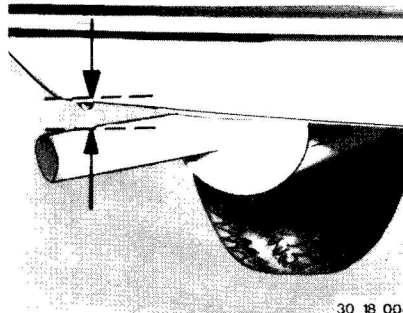
30 18 106



30 18 048



30 18 003



30 18 004

18 21 011 REPLACING PIVOT SLEEVES
ON EXHAUST CARRIER

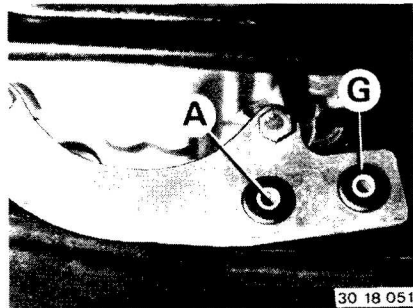
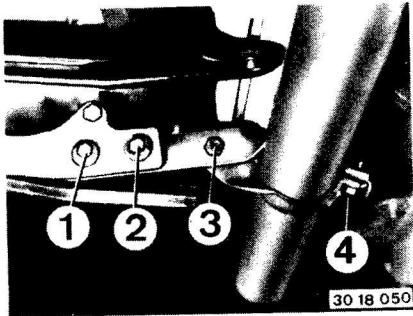
BMW 318 i:

Unscrew bolts (1 and 2).

Loosen bolts (3 and 4).

Installation:

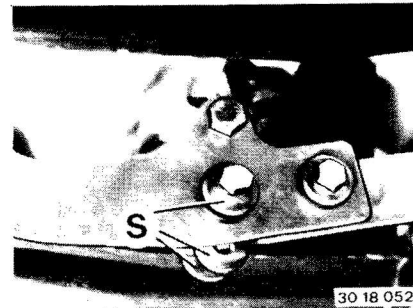
Tighten bolts and nuts in order of 1 to 4.



Push out spacers (A) and press out pivot sleeves (G).

Installation:

Coat pivot sleeves with a lubricant for installation of the spacers.



Install washers (S) as shown in the picture.
Tightening torque*.

* See Specifications

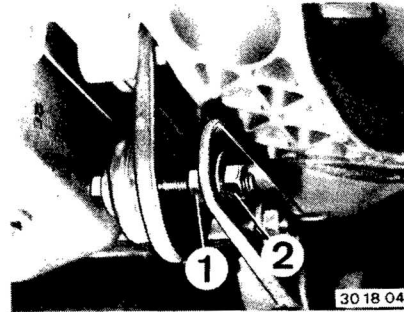
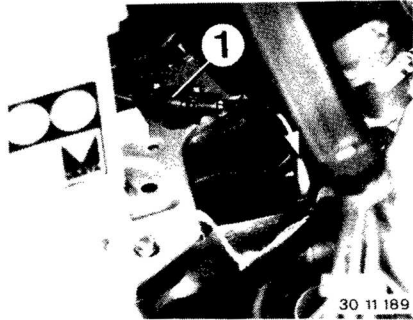
18 32 005 REMOVING AND INSTALLING OR REPLACING CATALYTIC CONVERTER

BMW 318 i:

Disconnect oxygen sensor plug (1).
Pull out plug downward through the protective tube.

Caution!

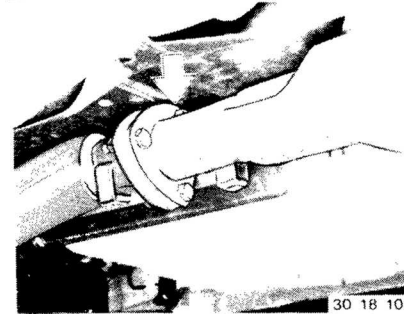
Oxygen sensor must not be damaged.
Remove oxygen sensor if there is danger of damaging it — see 11 78 012.



Cars with Automatic Transmission.
Unscrew nut (2).

Installation:

Mount the exhaust carrier without tension by adjusting nut (1).



Disconnect catalytic converter on final muffler.

Installation:

Replace gasket and self-locking nuts.
Tightening torque*.

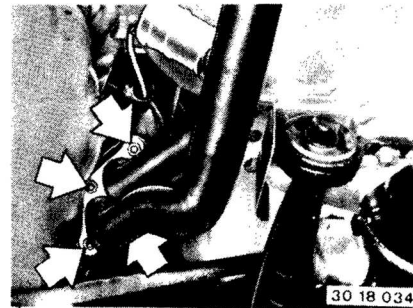
Scraping:

Used catalytic converters can be returned—
same process as for warranty parts***.

Unscrew exhaust pipe on manifold.

Installation:

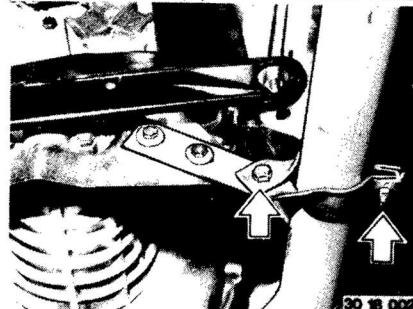
Check gasket, replacing if necessary.
Replace self-locking nuts.
Coat threads with copper paste CRC**.



Loosen holder for exhaust assembly.

Installation:

Torque* holder only after finishing
installation of exhaust assembly (danger of
tensioning).



* See Specifications

** Source of Supply: HWB

* See Specifications

*** See Service Information

18 00 020 REMOVING AND INSTALLING EXHAUST ASSEMBLY

BMW 325 ... 325 iX:

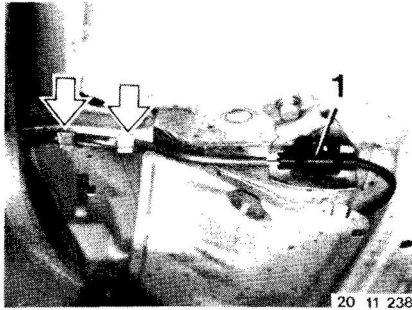
Disconnect oxygen sensor plug (1).

Lift out wire harness.

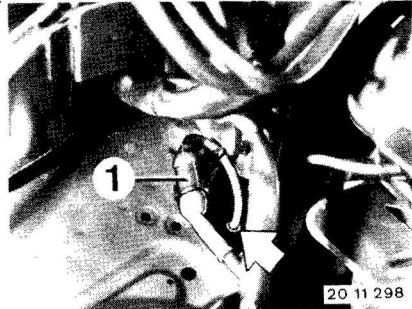
Floor assembly plug installation.

Installation:

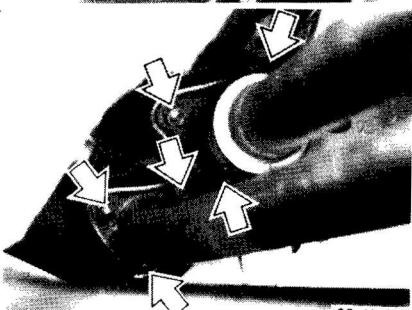
To avoid plug contact problems, seal off plug connection with Three Bond Silicone 1207**.



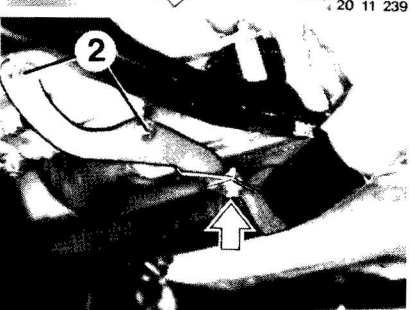
20 11 238



20 11 298



20 11 239



20 11 240

Disconnect oxygen sensor plug (1).

Lift out wire harness.

Right wheel house plug installation.

Caution!

Oxygen sensor must not be damaged.

Remove oxygen sensor if there is danger of damaging it – see 11 78 012.

Unscrew exhaust pipes on manifold.

Installation:

Check gaskets, replacing if necessary.

Replace self-locking nuts.

Coat threads with copper paste CRC**.

Tightening torque*.

Unscrew exhaust carrier.

Installation:

Loosen bolts (2) for installation without tension.

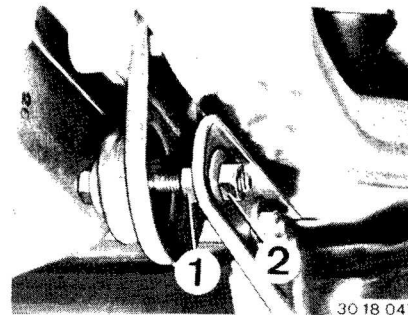
Installation:

Torque holder* only after finishing installation of the exhaust assembly. (Danger of tension.)

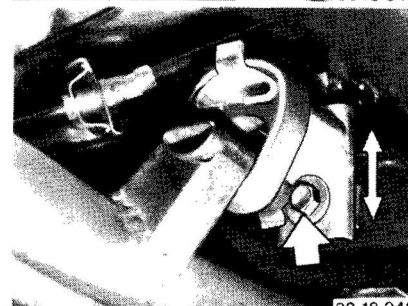
Tightening torque*.

* See Specifications

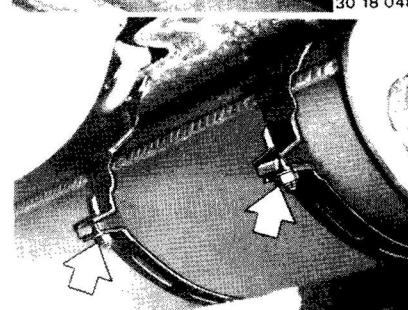
** Source of Supply: HWB



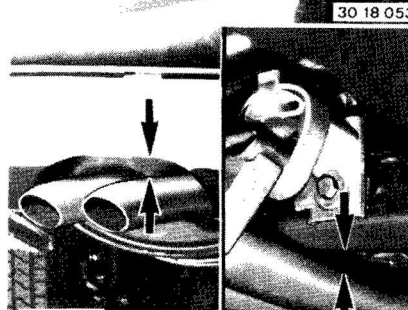
30 18 047



30 18 048



30 18 053



30 18 054

Cars with Automatic Transmission:

Unscrew nut (2).

Installation:

Mount the exhaust carrier without tension by adjusting nut (1).

Tightening torque*.

Loosen holder on rear axle carrier, if necessary.

Installation:

Adjust holder by moving and torque* only after finishing installation of the exhaust assembly.

Loosen holder for final muffler.

Installation:

Torque* holder in such a manner, that rubber ring is preloaded.

Preload: 6 mm (0.236").

See exhaust suspension layout drawing.

Take off exhaust assembly.

Check installed location.

Provide sufficient spacing to body and rear axle carrier.

* See Specifications

18 12 031 REPLACING FINAL MUFFLER

Unscrew catalytic converter on final muffler.

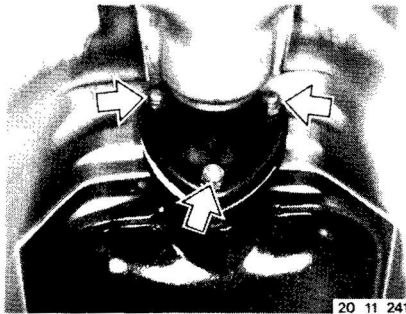
Installation:

Check seals, replacing if necessary.

Replace self-locking nuts.

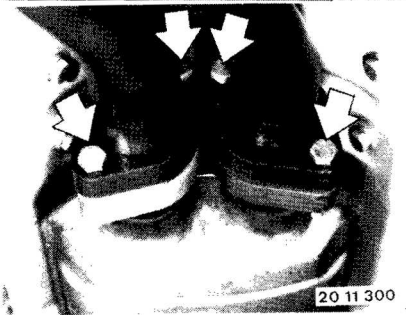
Tightening torque*.

Three Hole Flange Version



20 11 241

Two Hole Flange Version

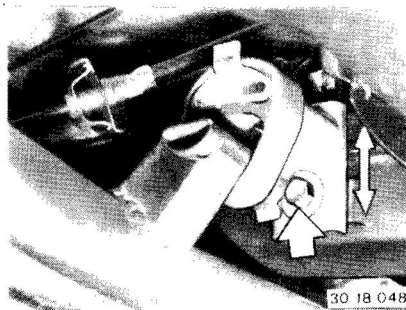


20 11 300

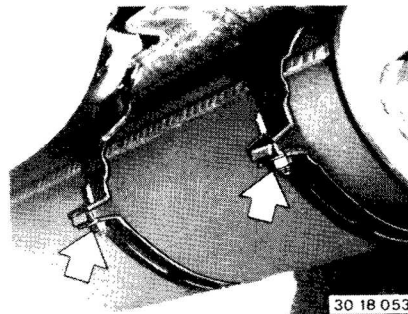
Loosen holder on rear axle carrier, if necessary.

Installation:

Adjust holder by moving and torque* only after finishing installation of the exhaust assembly.



30 18 048



30 18 053

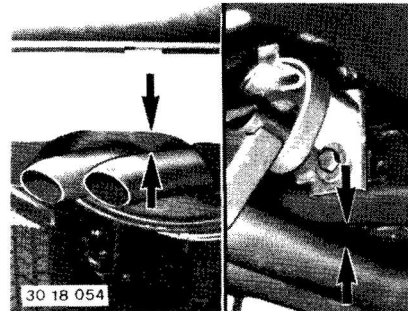
Loosen holder for final muffler.

Installation:

Torque* holder in such a manner, that rubber ring is preloaded.

Preload: 6 mm (0.236").

See exhaust suspension layout drawing.



30 18 054

Take off exhaust assembly.

Check installed position.

Provide sufficient spacing to body and rear axle carrier.

18 32 005 REMOVING AND INSTALLING OR REPLACING CATALYTIC CONVERTER

6 Cylinder M 20:
Disconnect oxygen sensor plug (1).
Lift out wire harness.

Installation:
To avoid plug contact problems, seal off the plug connection with Three Bond Silicone 1207**.

Floor Assembly Plug Installation

Disconnect oxygen sensor plug (1).
Lift out wire harness.
Right Wheel House Plug Installation

Unscrew exhaust pipes on manifold .

Installation:
Check gaskets, replacing if necessary.
Replace self-locking nuts.
Coat threads with copper paste CRC**.
Tightening torque*.

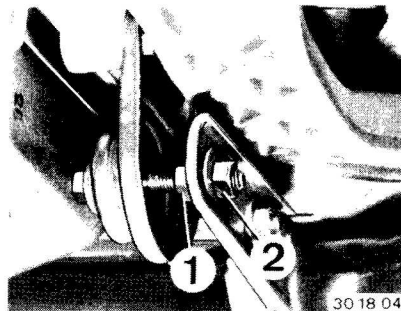
Unscrew exhaust carrier.

Installation:
Loosen bolts (2) for installation without tension.

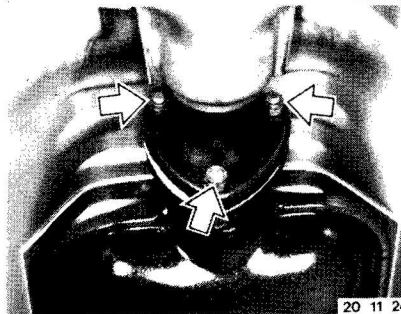
Installation:
Torque holder to correct torque* **only** after finishing installation of the exhaust assembly.
(danger of tension)
Tightening torque*.

* See Specifications

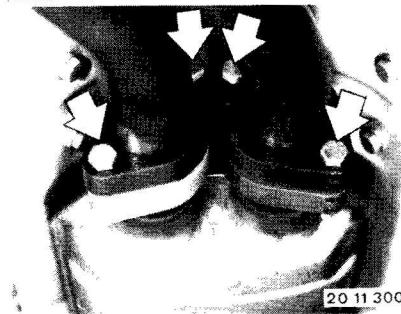
** Source of Supply: HWB



30 18 047



20 11 241



20 11 300

Cars with Automatic Transmission:

Unscrew nut (2).

Installation:

Mount the exhaust carrier without tension by adjusting nut (1).

Tightening torque*.

Unscrew catalytic converter on final muffler.

Installation:

Check seals, replacing if necessary.

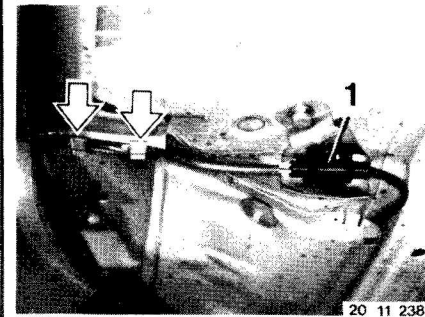
Replace self-locking nuts.

Tightening torque*.

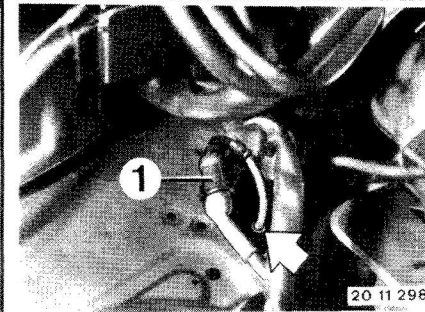
Three Hole Flange Version

Two Hole Flange Version

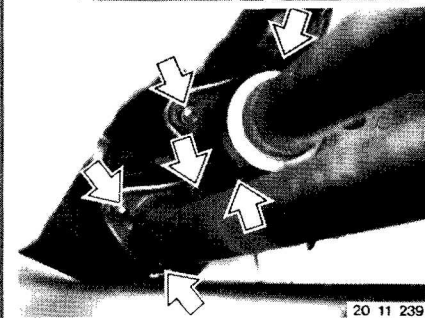
* See Specifications



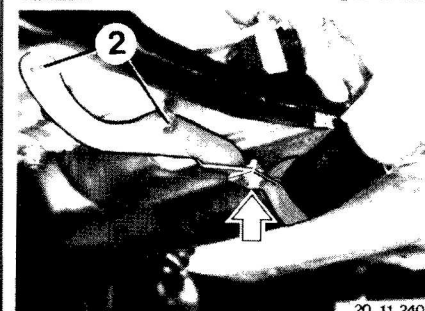
20 11 238



20 11 298



20 11 239



20 11 240

18 00 020 REMOVING AND INSTALLING EXHAUST ASSEMBLY

BMW M 3:

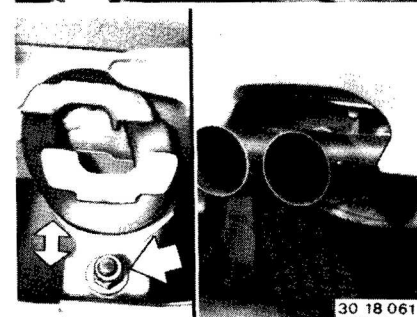
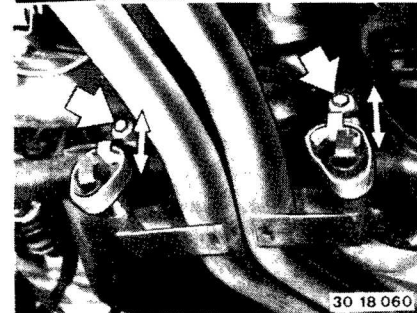
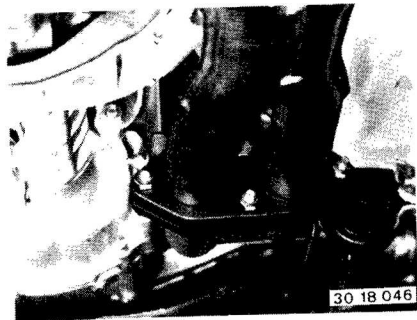
Unscrew exhaust on flange.

Installation:

Check gasket, replacing if necessary.

Coat threads with copper paste CRC**.

Tightening torque*.



Loosen holder on rear axle carrier.

Installation:

Adjust holder by moving and tighten only after finishing installation of the exhaust assembly.

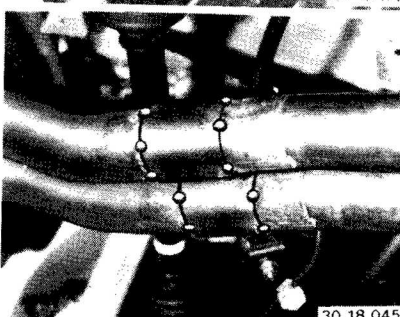
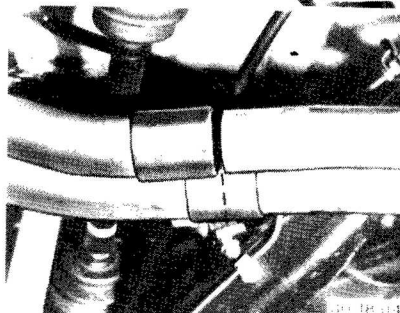
Tightening torque*.

Loosen holder for final muffler.

Installation:

Provide spacing to body by adjusting the holder.

Tightening torque*.



18 12 031 REPLACING FINAL MUFFLER

BMW M 3:

Remove exhaust assembly – see 18 00 020.

Disconnect clamping sleeves at clamping points.

Position clamping sleeves in one direction.

Slide on new sleeves.

Adjust exhaust assembly to installed position.

Center sleeves.

Tack weld sleeves with several welding spots.

Remove primary and final mufflers again.

Weld sleeves all around.

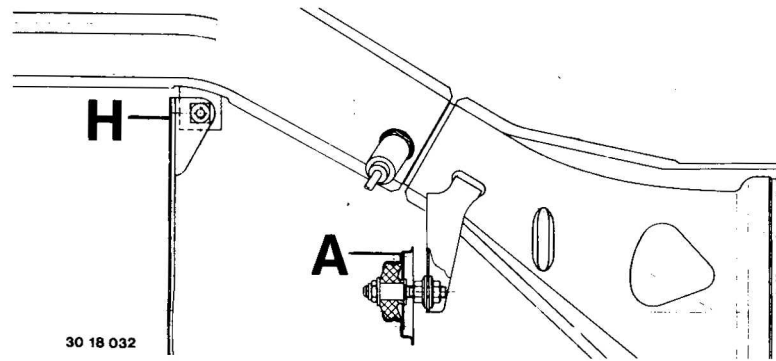
EXHAUST SUSPENSION LAYOUT DRAWINGS

Installation:

Tighten the exhaust carrier (H or A) only after the exhaust assembly is in correct installed position (danger of tension).

H = Version with manual transmission

A = Version with automatic transmission



Tighten clamps (1) for the final muffler in such a manner, that rubber suspension parts are preloaded.

Preload A = 6 mm (0.236").

