

Test report no. : 11/0322-00
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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Test Report no. 11/0322-00

according to the Directive of the European Parliament
and of the Council relating to

**silencers as a separate technical unit
(replacement silencer)**

70/157/EEC of 06.02.1970

as last amended by

2007/34/EC of 14.06.2007

0. General Information

0.1. Make : MILLTEK SPORT

0.2. Type: MSSE137-129

0.4. Name and address of
manufacturer: MILLTEK SPORT LTD
Belfield Industrial Estate,
Ilkeston
Derbyshire DE7 8DU
United Kingdom

0.5. No. of information document: MSSE137-129/00
date: 11.04.2011

1. Description of the vehicle
the unit is used for: see enclosure 2

FAKT GmbH
Grüntensstraße 3-5
D-87751 Heimertingen

Technical Service
appointed by NSAI
Registration Number: 88.2

e24*70/157*1999/101*1474*00

Test report no. : 11/0322-00
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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2. Description of the test object:

2.1. Kind of replacement silencers:

Technical unit consisting of one middle silencer according to drawing no. A1546, round, Ø 127,3 x 200 mm long, absorption principle, with one inlet pipe Ø 63,5 mm and one outlet pipe Ø 63,5 mm and one rear silencer according to drawing no. A1545, oval, 130 x 215 x 450 mm long, absorption principle, with one inlet pipe Ø 63,5 mm, one outlet pipe Ø 70 mm with distributor and two tail pipes Ø 50,8 mm each with tail pipe cover.

2.2. Composition of the separate technical unit:

see enclosure 1

2.3. Position and direction of the tail pipes:

at the rear of the vehicle, centric, backwards

3. Test report:

The tests were carried out in one series of tests A on 07.04.2011 with following passenger car:

3.1 Vehicle:

3.1.1. Manufacturer: Seat S.A.
3.1.2. Type: 6J
3.1.2.1. Model: SCNCAVEX0
3.1.3. Type approval no.: e9*2001/116*0067*
3.1.3.1 Extension: 13
3.1.4. Vehicle identification no.: VSSZZZ6JZAR115536
3.1.5. Year of manufacture: 2010
3.1.6. kilometres: 10699

3.2. Engine:

3.2.1. Manufacturer: Volkswagen AG
3.2.2. Type: CAVE
3.2.3. Marking: CAV***
3.2.4. Rated maximum engine power: 132 kW at 6200 rpm
3.2.5. Engine capacity: 1390 cm³

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Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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3.3. Transmission:

3.3.1. Kind of transmission: 7 speed automatic transmission

The vehicle was equipped with a completely new replacement silencer system

Type: MSSE137-129

Assembly (positions see enclosure 1) no. 1)2)3)4)

3.4. Measuring of sound level values:

3.4.1. Type of sound level meter : 2235

3.4.2. Manufacturer of the sound level meter: Brüel & Kjaer

3.4.3. Sound level moving vehicle: according to the Council Directive no. 70/157/EEC at it's session 1999/101/EC

3.4.4. Sound level stationary vehicle: according to the Council Directive No. 70/157/EEC at it's session 1999/101/EC

3.5. Measuring of exhaust gas back pressure:

3.5.1. Type of the instrument: ALMEMO 2290-3

3.5.2. Manufacturer of the instrument: Ahlborn

3.5.3. Testing method: in 2nd speed

3.6. Conditioning of the silencers: by pressure vibrations

3.7. Test results:

3.7.1. The results of the tests are attached in the table of enclosure 3.

Based on a comparison between the above described technical unit with the original equipment system, they are observed to be acoustically equal.

3.7.2. Scope of application:

The described technical unit (replacement silencers) is suitable for an application at the vehicles mentioned in enclosure 2.

Test report no. : 11/0322-00
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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4. Enclosures:

- Enclosure 1 Composition of the separate technical unit
- Enclosure 2 Scope of application
- Enclosure 3 Results of tests

5. Summary:

The mentioned information document and the in it described type of the technical unit corresponds to the specified regulation.

There are no technical objections against granting an EC Type Approval.

This report includes pages 1 - 4 and the enclosures 1 - 3.

TEST LABORATORIUM FAKT-GMBH

Heimertingen, 2011-04-13

A handwritten signature in black ink, appearing to read "Fackler".



Dipl.-Ing. (FH) Fackler
The Expert

ENCLOSURE 1 Test report no.
Type:
Manufacturer:

11/0322-00
MSSE137-129
MILLTEK SPORT LTD



Composition of the separate technical unit

No.	Composition of the separate technical unit (Dimensions in mm)	Dimensions of the part in mm or original part / replacement part	Part number or homologation number
1)	Front pipe incl. catalytic converter	original part	-
2)	Front silencer	original part	-
3)	Middle silencer inlet pipe Ø 63,5 outlet pipe Ø 63,5	round, Ø 127,3 x 200	e24-03.....
4)	Rear silencer inlet pipe Ø 63,5 outlet pipe Ø 70 with distributor and two tail pipes Ø 50,8 each with tail pipe cover	oval, 130 x 215 x 450	e24-03.....

FAKT GmbH
Grüntenstraße 3-5
D-87751 Heimertingen

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ENCLOSURE 2 Test report no.
Type:
Manufacturer:

11/0322-00
MSSE137-129
MILLTEK SPORT LTD



Scope of application

No. of vehicle	Manufacturer	Make	Commercial description	Type and type approval no.	Engine code and type of combustion	Working principle	Cylinder capacity in cm ³	Engine power in kW/rpm	Assembly of the exhaust system (see enclosure 1)
		no. addendum to EC Type approval certificate							
		1.2.	1.3.	1.4.1.	1.4.2.	1.4.3.	1.4.4.		
1	Seat S.A.	Seat	Ibiza Cupra/ Bocanegra	6J (e9*...*0067*..)	CAVE (positive ignition)	four stroke	1390	132/6200	1)2)3)4)

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Registration Number: 88.2

e24*70/157*1999/101*1474*00

ENCLOSURE 3 Test report no.
 Type:
 Manufacturer:

11/0322-00
 MSSE137-129
 MILLTEK SPORT LTD



Test results

No. of vehicle	Number of gear ratios/ automatic	Gear ratios employed	Final drive	EC/ECE-homologation No. concerning sound level	Sound levels according to Council Directive 1999/101/EC in dB(A)									Variation in back pressure in %	
					moving vehicle					stationary vehicle					
					replacement measured	original measured	vehicle type approval	km/h	limit value*)	replacement measured	original measured	vehicle type approval	rpm		
No. addendum to EC Type approval certificate															
	1.5.	1.6.	1.7.	-	1.8.									1.9.	
1	-/7	D	3,227	e9*1999/101*9716*00	A: 73	73	72	50	74	80	80	80	80	3850 ^{a)}	-39

*) Limit value of directive which was valid by vehicle type homologation

a) limited

FAKT GmbH
 Grüntenstraße 3-5
 D-87751 Heimertingen

Technical Service
 appointed by NSAI
 Registration Number: 88.2

e24*70/157*1999/101*1474*00

0. General

- 0.1. Make : MILLTEK SPORT
- 0.2. Type: MSSE137-129
- 0.5. Name and address of manufacturer: MILLTEK SPORT LTD
Belfield Industrial Estate, Ilkeston
Derbyshire DE7 8DU
United Kingdom
- 0.7. Position of the EC approval mark on the components: at the bottom side of the silencer
- 0.8. Address of assembly plant: see 0.5
- 1. Description of the vehicles for which the device is intended:**
- 1.1. Make: see enclosure 2 of the test report
- 1.2. Type and general commercial description: see enclosure 2 of the test report
- 1.3. Means of identification of type, if marked on the vehicle: see enclosure 2 of the test report
- 1.4. Fahrzeugklasse: M1
- 1.5. EC type-approval number with regard to sound level: see enclosure 3 of the test report
- 1.6. All the information mentioned in items 1.1. to 1.5. of the type-approval certificate concerning the vehicle (Annex 1 appendix 2 to this directive): see enclosure 2 + 3 of the test report

2. Description of the device

2.1. A description of the replacement exhaust system indicating the relative position of each system component, together with mounting instructions: see item 2 of test report and enclosures of this information document

2.2. Detailed drawings of each component so that they can be easily located and reference to the materials used. These drawings must indicate the place provided for the compulsory affixing of the EC type-approval mark: see enclosures of this information document

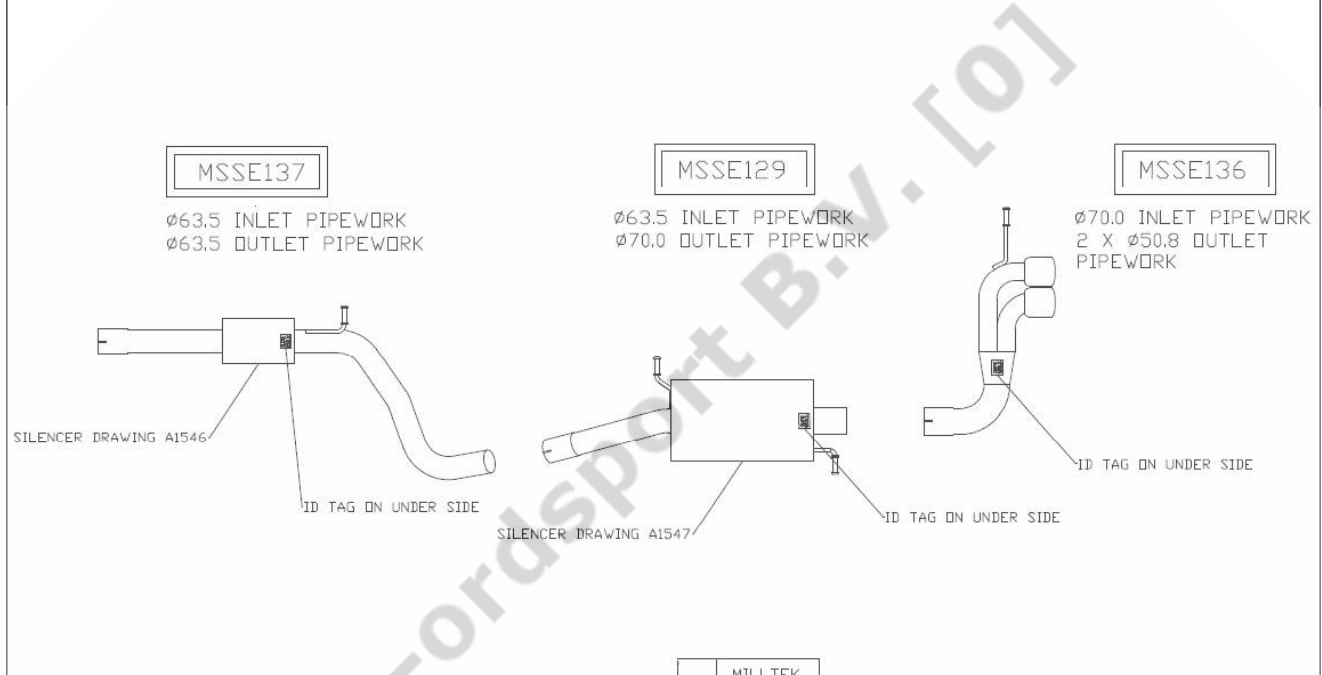
Enclosures:

	drawing no.	date
Drawing complete exhaust system	T0024	11.04.11
Drawing middle silencer	A1546	08.04.11
Drawing rear silencer	A1545	28.01.11
Fitting instruction		
Photo		

date: 11.04.2011

MILLTEK SPORT LTD

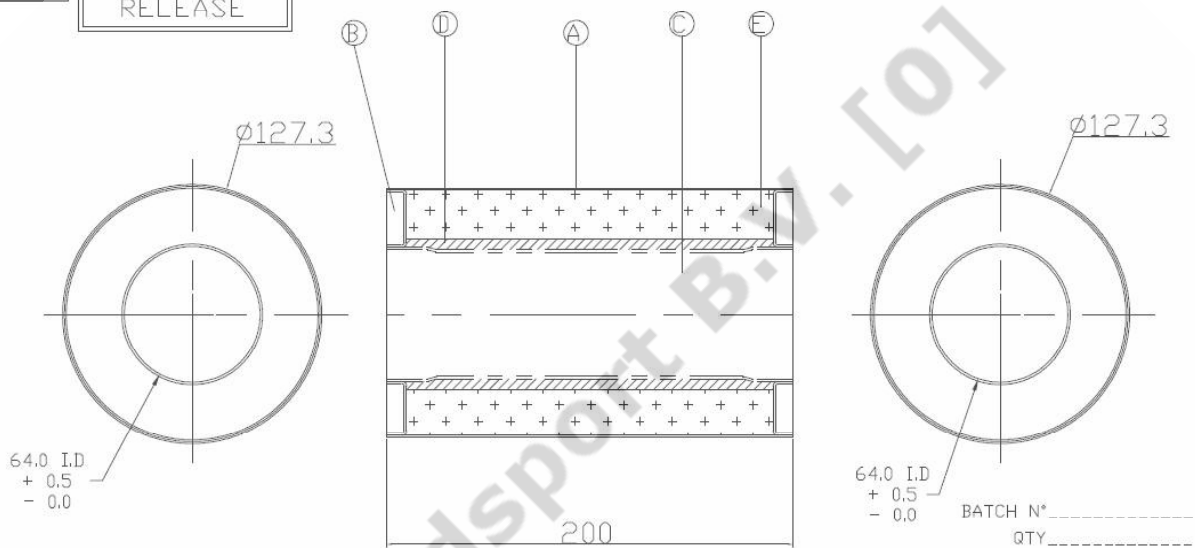
DRAWING No. T0024	REV	DATE	REVISION DETAILS	SIGN
	A	11/04/2011	SYSTEM DRAWING PRODUCED ON CAD	DJM



© This drawing is the property of Milltek Sport Ltd may only be used with permission. MILLTEK SPORT LTD BELFIELD INDUSTRIAL ESTATE ILKESTON, DERBYSHIRE, DE7 8DU TEL-0115 8508690 FAXI-0115 9440366	MILLTEK PART N° BATCH N° MADE IN ENGLAND	ALL DIMENSIONS IN MM U. O. S. 30.0 40.0	TOLERANCES OPENI- ±0.4 0.0:- ±0.25 0.00:- ±0.1	SCALE 1:1 THIRD ANGLE	DRAWN DJM DATE 11/04/11	DRAWING No. T0024
	GENERAL EXHAUST ARRANGEMENT USED ON- SEAT IBIZA 1.4TSI CUPRA / BOCANEGRA					

e24*70/157*1999/101*1474*00

DRAWING No. A1546	PRODUCTION RELEASE	REV	DATE	REVISION DETAILS	SIGN
		A	08/04/2011	SILENCER DRAWING PRODUCED ON CAD	DJM



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MILLTEK SPORT LIMITED
BELFIELD INDUSTRIAL ESTATE
ILKESTON, DERBYSHIRE. DE7 8DU
TEL:-0115 8508690 FAX:-0115 9440366

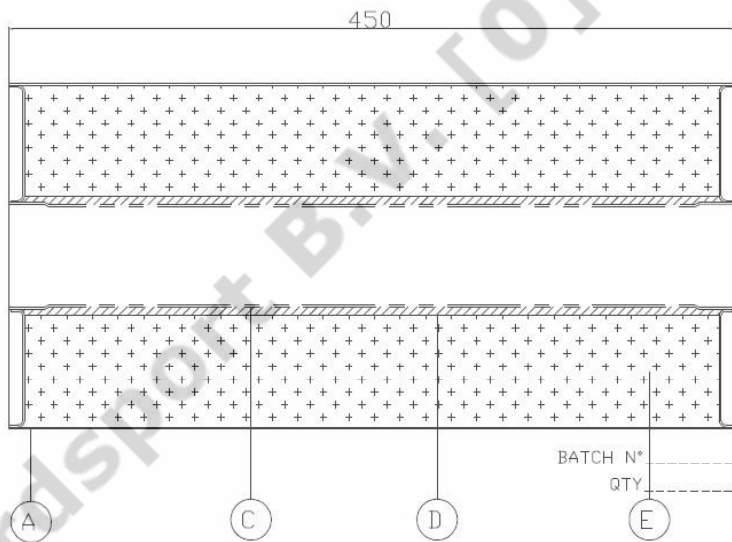
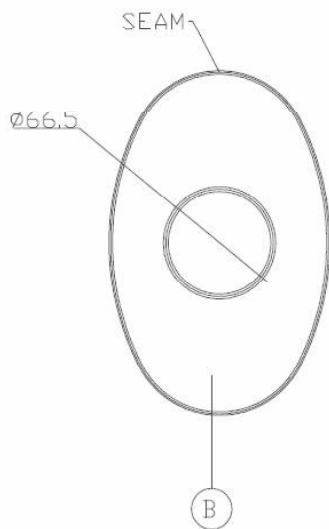
ITEM	DESCRIPTION	PART No	QTY	MATL	SIZE	FORM
E	FILLING	E GLASS	1	-	MAXIMUM 500G	FILL CHAMBER WITH MIN 400G / MAX 500G
D	WIREWOOL	SSWIREWOOL	2	304	AS REQUIRED	WRAP AROUND PERF TUBE & SPOTWELD IN PLACE
C	PERF	250012304P	1	304	Ø63.5 X 200 X 1.2	SIZE UP BOTH ENDS TO Ø63.5 I.D. X 20MM LONG
B	ENDPLATES	B34R4875	2	304	Ø127 X 1.5	PUNCH & RAISE AS DETAIL
A	SILENCER BODY	25120934BA	1	304	410 X 200 X 0.9	NOTCH, ROLL & SEAM

PART NUMBER: MSSE137		ALL DIMENSIONS IN MM U. D. S.	
CENTRE SILENCER ASSEMBLY		TOLERANCES	SCALE
USED ON:- SEAT IBIZA 1.4 TSI CUPRA / BOCANEGRA		OPEN:- ±0,4	1 : 1
		0,0:- ±0,25	THIRD ANGLE
		0,00:- ±0,1	DATE
			08/04/11

DRAWING No.
A1546

e24*70/157*1999/101*1474*00

DRAWING No. A1545	PRODUCTION RELEASE	REV	DATE	REVISION DETAILS	SIGN
		A	11/04/2011	SILENCER DRAWING PRODUCED ON CAD	DJM



BATCH N° _____
QTY. _____

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BELFIELD INDUSTRIAL ESTATE
ILKESTON, DERBYSHIRE. DE7 8DU
TEL:-0115 8508690 FAX:-0115 9440366

ITEM	DESCRIPTION	PART No	QTY	MATL	SIZE	FORM
E	FILLING	E GLASS	1	-	MAXIMUM 1010G	FILL CHAMBER WITH MIN 920G / MAX 1010G
D	WIREWOOD	SSWIREWOOD	2	304	AS REQUIRED	WRAP AROUND PERF TUBE & SPOTWELD IN PLACE
C	PERF	250012304P	1	304	Ø63.5 X 450 X 1.2	SIZE UP BOTH ENDS TO Ø63.5 I.D. X 20MM LONG
B	ENDPLATES	B34D8X5	2	304	215 X 130 X 1.2	PUNCH & RAISE AS DETAIL
A	SILENCER BODY	25120934BA	1	304	450 X 575 X 0.9	NOTCH, ROLL & SEAM

PART NUMBER: MSSE129		ALL DIMENSIONS IN MM U. D. S.	
REAR SILENCER ASSEMBLY		TOLERANCES	SCALE
		OPEN:- ±0.4	1:1
		0.0:- ±0.25	THIRD ANGLE
USED DN:- SEAT IBIZA 1.4TSI CUPRA / BOCANEGRA		DATE	DRAWING No.
		28/01/11	A1545

e24*70/157*1999/101*1474*00

Montageanleitung

1. Genau prüfen, welche Teile der gesamten Abgasanlage schadhaft sind. Häufig sind neben den eigentlichen Schalldämpfern auch die Abgasrohre erneuerungsbedürftig.
2. Dabei auch den Zustand der Anbauteile, wie Dichtungen, Schrauben, Muttern usw. beachten.
3. Steckverbindungen, Schrauben und Muttern sind oft festgebrannt. Deshalb vor Ausbau mit rostlösendem Mittel einsprühen.
4. Dieselben Stellen der neuen Teile einfetten, z. B. mit einem Gemisch aus Graphit und Öl.
5. Befestigungsschrauben an den Eintrittsrohren der originalen Schalldämpfer lösen, dann die originalen Schalldämpfer aus den Aufhängungsgummis aushängen und abnehmen.
6. Austauschteile am Fahrzeug zunächst lose und spannungsfrei montieren und ausrichten, dann erst Verbindungen und Aufhängungen fest anziehen.
7. Verbindungsstellen auf Dichtheit prüfen.
8. Auf ausreichenden Abstand der Endrohre zur Heckschürze ist zu achten, ggf. ist ein ausreichender Ausschnitt für die Endrohre zu schaffen.

Photo



e24*70/157*1999/101*1474*00

Test report no. : 11/0322-01
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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Extension 01

Test Report

no. 11/0322-01

according to the Directive of the European Parliament
and of the Council relating to

**silencers as a separate technical unit
(replacement silencer)**

70/157/EEC of 06.02.1970

as last amended by

2007/34/EC of 14.06.2007

Changes:

- scope of application is extended
- further variants of silencer / tail pipes are extended

0. General Information

0.1. Make : MILLTEK SPORT

0.2. Type: MSSE137-129

0.4. Name and address of manufacturer:

MILLTEK SPORT LTD
Belfield Industrial Estate,
Ilkeston
Derbyshire DE7 8DU
United Kingdom

0.5. No. of information document: MSSE137-129/01
date: 21.08.2012

1. Description of the vehicle
the unit is used for: see enclosure 2/01

Test report no. : 11/0322-01
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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2. Description of the test object:

2.1. Kind of replacement silencers:

Technical unit consisting of one middle silencer according to drawing no. A1546, round, Ø 127,3 x 200 mm long, absorption principle, with one inlet pipe Ø 63,5 mm and one outlet pipe Ø 63,5 mm and one rear silencer according to drawing no. A1545, oval, 130 x 215 x 450 mm long, absorption principle, with one inlet pipe Ø 63,5 mm, one outlet pipe Ø 70 mm with distributor and two tail pipes Ø 50,8 mm each with tail pipe cover.

2.2. Composition of the separate technical unit:

see enclosure 1/01

2.3. Position and direction of the tail pipes: at the rear of the vehicle, centric or left hand side, backwards

3. Test report:

The tests were carried out in one series of tests A on 07.04.2011 with following passenger car:

3.1 Vehicle:

3.1.1. Manufacturer: Seat S.A.
3.1.2. Type: 6J
3.1.2.1. Model: SCNCAVEX0
3.1.3. Type approval no.: e9*2001/116*0067*
3.1.3.1. Extension: 13
3.1.4. Vehicle identification no.: VSSZZZ6JZAR115536
3.1.5. Year of manufacture: 2010
3.1.6. Kilometers: 10699

3.2. Engine:

3.2.1. Manufacturer: Volkswagen AG
3.2.2. Type: CAVE
3.2.3. Marking: CAV***
3.2.4. Rated maximum engine power: 132 kW at 6200 rpm
3.2.5. Engine capacity: 1390 cm³

Test report no. : 11/0322-01
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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3.3. Transmission:

3.3.1. Kind of transmission: 7 speed automatic transmission

The vehicle was equipped with a completely new replacement silencer system

Type: MSSE137-129

Assembly (positions see enclosure 1/01) no. 1)2)3)4)

3.4. Measuring of sound level values:

3.4.1. Type of sound level meter : 2235

3.4.2. Manufacturer of the sound level meter: Brüel & Kjaer

3.4.3. Sound level moving vehicle: according to the Council Directive no. 70/157/EEC at it's session 1999/101/EC

3.4.4. Sound level stationary vehicle: according to the Council Directive no. 70/157/EEC at it's session 1999/101/EC

3.5. Measuring of exhaust gas back pressure:

3.5.1. Type of the instrument: ALMEMO 2290-3

3.5.2. Manufacturer of the instrument: Ahlborn

3.5.3. Testing method: in 2nd speed

3.6. Conditioning of the silencers: by pressure vibrations

3.7. Test results:

3.7.1. The results of the tests are attached in the table of enclosure 3/01.

Based on a comparison between the above described technical unit with the original equipment system, they are observed to be acoustically equal.

The different variants of tail pipes let no appreciable influence expect on the noise and the exhaust gas back pressure of the vehicles.

Test report no. : 11/0322-01
Manufacturer: MILLTEK SPORT LTD
Type: MSSE137-129



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3.7.2. Scope of application:

The described technical unit (replacement silencers) is suitable for an application at the vehicles mentioned in enclosure 2/01.

4. Enclosures:

Enclosure 1/01 Composition of the separate technical unit
Enclosure 2/01 Scope of application
Enclosure 3/01 Results of tests

5. Summary:

The mentioned information document and the in it described type of the technical unit corresponds to the specified regulation.

There are no technical objections against granting an extension 01 for EC Type Approval no. e24*70/157*1999/101*1474*00.

This report includes pages 1 - 5 and the enclosures 1/01 – 3/01.

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TEST LABORATORIUM FAKT-GMBH

Heimertingen, 2012-08-21

A handwritten signature in black ink, appearing to read 'Fackler', written over a large, faint watermark that says 'Copyright Sport 101'.



Dipl.-Ing. (FH) Fackler
The Expert

ENCLOSURE 1/01 Test report no.
Type:
Manufacturer:

11/0322-01
MSSE137-129
MILLTEK SPORT LTD



page 1/2

Composition of the separate technical unit

No.	Composition of the separate technical unit (Dimensions in mm)	Dimensions of the part in mm or original part / replacement part	Part number or homologation number
1)	Front pipe incl. catalytic converter	original part	-
2)	Front silencer	original part	-
3)	Middle silencer inlet pipe \varnothing 63,5 outlet pipe \varnothing 63,5	round, \varnothing 127,3 x 200	e24-031474
4)	Rear silencer inlet pipe \varnothing 63,5 outlet pipe \varnothing 70 with distributor and two tail pipes \varnothing 50,8 each with tail pipe cover (according to drawing T0024, rev. B, 13.08.2012)	oval, 130 x 215 x 450	e24-031474

page 2/2

FAKT GmbH
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DE-87751 Heimertingen

Technical Service
appointed by NSAI
Registration Number: 88,2

e24*70/157*1999/101*1474*01

ENCLOSURE 2/01 Test report no.
Type:
Manufacturer:

11/0322-01
MSSE137-129
MILLTEK SPORT LTD



Scope of application: Vehicle category M1

No. of vehicle	Manufacturer	Make	Commercial description	Type and type approval no.	Engine code and type of combustion	Working principle	Cylinder capacity in cm ³	Engine power in kW/rpm	Assembly of the exhaust system (see enclosure 1/01)
no. addendum to EC Type approval certificate									
			1.2.	1.3.	1.4.1.	1.4.2.	1.4.3.	1.4.4.	
1	Seat S.A.	Seat	Ibiza Cupra/ Bocanegra	6J (e9*2001/116*0067*..)	CAVE (positive ignition)	four stroke	1390	132/6200	1)2)3)4)
2	Audi AG	Audi	A1	8X (e1*2007/46*0414*..)	CAVG (positive ignition)			136/6200	
3	Volkswagen AG	Volkswagen	Polo	6R (e1*2001/116*0510*..)	CAVE (positive ignition)			132/6200	
4	Skoda Auto a.s.	Skoda	Fabia RS	5J (e11*2001/116*0291*..)	CAVE (positive ignition)			132/6200	

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Registration Number: 88,2

e24*70/157*1999/101*1474*01

ENCLOSURE 3/01 Test report no.
 Type:
 Manufacturer:

11/0322-01
 MSSE137-129
 MILLTEK SPORT LTD



Test results

No. of vehicle	Number of gear ratios/ automatic	Gear ratios employed	Final drive	EC/ECE-homologation No. concerning sound level	Sound levels according to Council Directive 1999/101/EC in dB(A)									Variation in back pressure in %
					moving vehicle					stationary vehicle				
					replacement measured	original measured	vehicle type approval	km/h	limit value*)	replacement measured	original measured	vehicle type approval	rpm	
No. addendum to EC Type approval certificate														
	1.5.	1.6.	1.7.	-	1.8.									1.9.
1	-/7	D	3,227	e9*1999/101*9716*00	A: 73	73	72	50	74	80	80	80	3850 ^{a)}	-39

*) Limit value of directive which was valid by vehicle type homologation

a) limited

FAKT GmbH
 Grüntenstraße 3-5
 DE-87751 Heimertingen

Technical Service
 appointed by NSAI
 Registration Number: 88.2

e24*70/157*1999/101*1474*01

0. General

- 0.1. Make : MILLTEK SPORT
- 0.2. Type: MSSE137-129
- 0.5. Name and address of manufacturer: MILLTEK SPORT LTD
Belfield Industrial Estate, Ilkeston
Derbyshire DE7 8DU
United Kingdom
- 0.7. Position of the EC approval mark on the components: at the bottom side of the silencer
- 0.8. Address of assembly plant: see 0.5
- 1. Description of the vehicles for which the device is intended:**
- 1.1. Make: see enclosure 2/01 of the test report
- 1.2. Type and general commercial description see enclosure 2/01 of the test report
- 1.3. Means of identification of type, if marked on the vehicle: see enclosure 2/01 of the test report
- 1.4. Vehicle category: M1
- 1.5. EC type-approval number with regard to sound level: see enclosure 3/01 of the test report
- 1.6. All the information mentioned in items 1.1. to 1.5. of the type-approval certificate concerning the vehicle (Annex 1 appendix 2 to this directive): see enclosure 2/01 + 3/01 of the test report

2. Description of the device

2.1. A description of the replacement exhaust system indicating the relative position of each system component, together with mounting instructions: see item 2 of test report and enclosures of this information document

2.2. Detailed drawings of each component so that they can be easily located and reference to the materials used. These drawings must indicate the place provided for the compulsory affixing of the EC type-approval mark: see enclosures of this information document

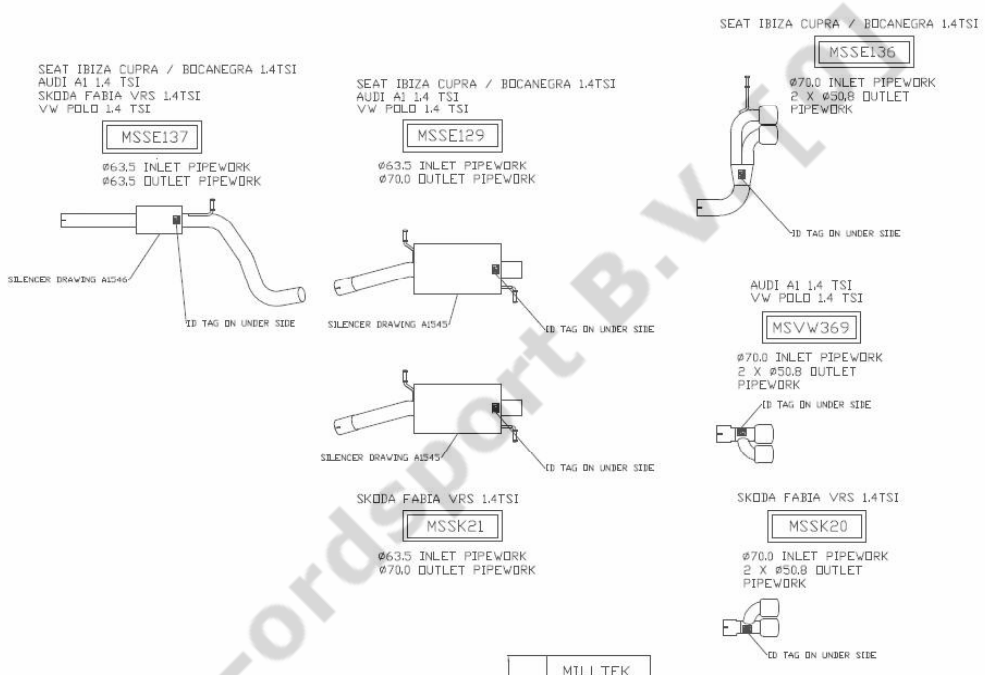
Enclosures:

	drawing no.	date
Drawing complete exhaust system	T0024, Rev. A	11.04.11
	Rev. B	13.08.12
Drawing middle silencer	A1546, Rev. A	08.04.11
Drawing rear silencer	A1545, Rev. A	11.04.11
Fitting instruction		
photograph		

date: 21.08.2012

MILLTEK SPORT LTD

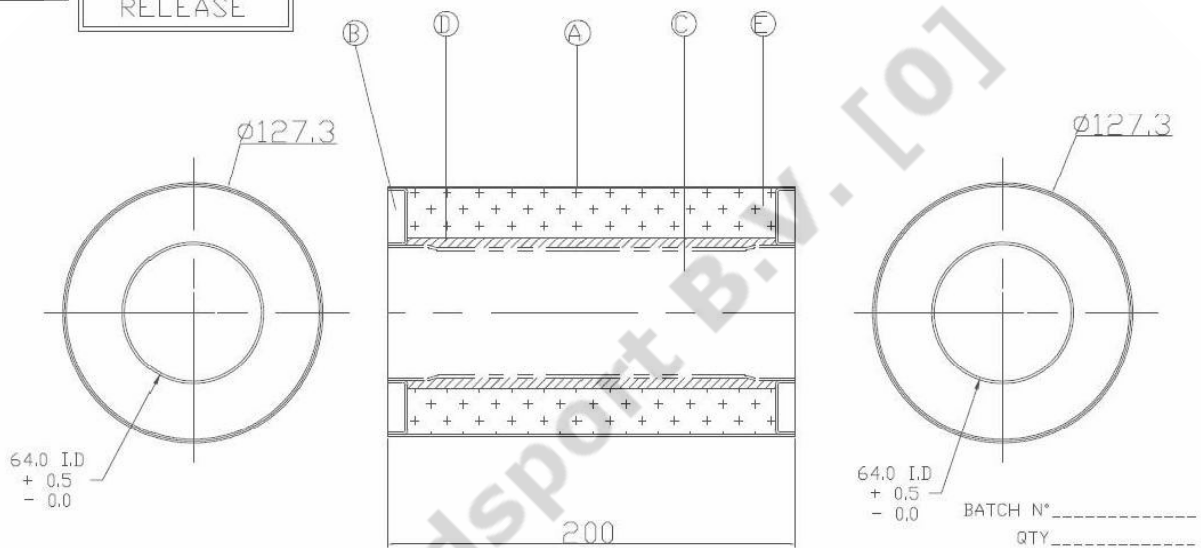
DRAWING No. T0024	REV	DATE	REVISION DETAILS	SIGN
	A	11/04/2011	SYSTEM DRAWING PRODUCED ON CAD	DJM
	B	13/08/2012	ADDITIONAL MODEL INFORMATION ADDED	DJM



© This drawing is the property of Milltek Sport Ltd may only be used with permission. MILLTEK SPORT LTD BELFIELD INDUSTRIAL ESTATE ILKESTON, DERBYSHIRE, DE7 8DU TEL:-0115 8508690 FAX:-0115 9440366	30.0 MILLTEK PART N° BATCH N° MADE IN ENGLAND	40.0	ALL DIMENSIONS IN MM U. O. S.	TOLERANCES OPEN:- ±0.4 0.0:- ±0.25 0.00:- ±0.1	SCALE 1 : 1 THIRD ANGLE	DRAWN DJM DATE 11/04/11	DRAWING No. T0024
	GENERAL EXHAUST ARRANGEMENT USED ON:- V.A.G 1.4 TSI MODELS						

e24*70/157*1999/101*1474*01

DRAWING No. A1546	PRODUCTION RELEASE	REV	DATE	REVISION DETAILS	SIGN
		A	08/04/2011	SILENCER DRAWING PRODUCED ON CAD	DJM



APPROVED FOR PROD BY.....

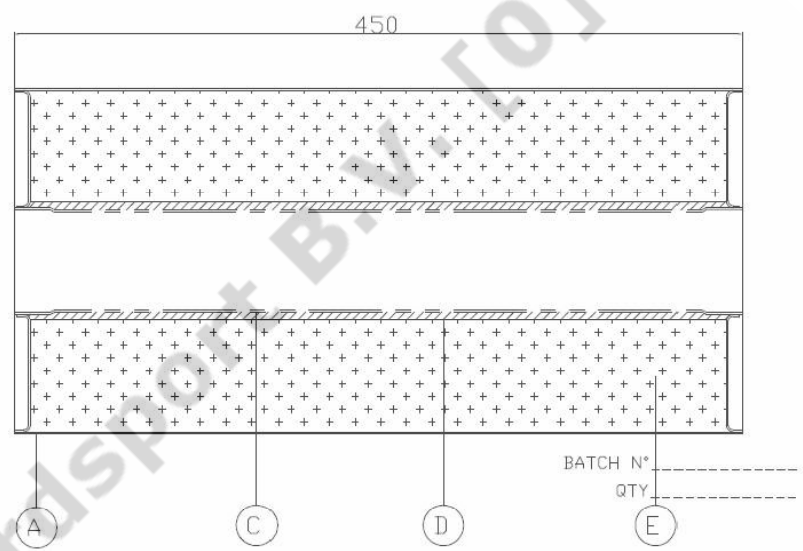
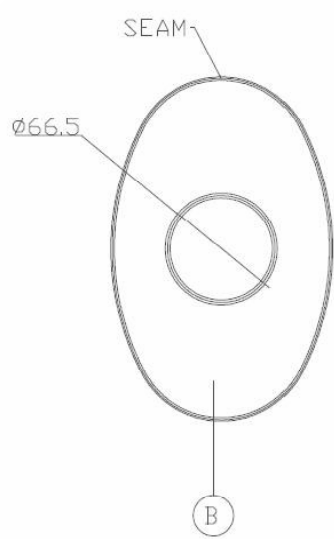
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MILLTEK SPORT LIMITED
BELFIELD INDUSTRIAL ESTATE
ILKESTON, DERBYSHIRE. DE7 8DU
TEL:-0115 8508690 FAX:-0115 9440366

E	FILLING	E GLASS	1	-	MAXIMUM 500G	FILL CHAMBER WITH MIN 400G / MAX 500G
D	WIREWOOL	SSWIREWOOL	2	304	AS REQUIRED	WRAP AROUND PERF TUBE & SPOTWELD IN PLACE
C	PERF	250012304P	1	304	Ø63.5 X 200 X 1.2	SIZE UP BOTH ENDS TO Ø63.5 I.D. X 20MM LONG
B	ENDPLATES	B34R4875	2	304	Ø127 X 1.5	PUNCH & RAISE AS DETAIL
A	SILENCER BODY	25120934BA	1	304	410 X 200 X 0.9	NOTCH, ROLL & SEAM
ITEM	DESCRIPTION	PART No	QTY	MATL	SIZE	FORM
PART NUMBER:MSSE137						ALL DIMENSIONS IN MM U. O. S.
CENTRE SILENCER ASSEMBLY						TOLERANCES
USED ON:- SEAT IBIZA 1.4 TSI CUPRA / BOCANEGRA						OPEN:- ±0.4
						0.0:- ±0.25
						0.00:- ±0.1
						SCALE 1:1
						THIRD ANGLE
						DRAWN DJM
						DATE 08/04/11
						DRAWING No. A1546

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DRAWING No. A1545	PRODUCTION RELEASE	REV	DATE	REVISION DETAILS	SIGN
		A	11/04/2011	SILENCER DRAWING PRODUCED ON CAD	DJM



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 ILKESTON, DERBYSHIRE. DE7 8DU
 TEL:-0115 8508690 FAX:-0115 9440366

E	FILLING	E GLASS	1	-	MAXIMUM 1010G	FILL CHAMBER WITH MIN 920G / MAX 1010G			
D	WIREWOOL	SSWIREWOOL	2	304	AS REQUIRED	WRAP AROUND PERF TUBE & SPOTWELD IN PLACE			
C	PERF	250012304P	1	304	Ø63.5 X 450 X 1.2	SIZE UP BOTH ENDS TO Ø63.5 I.D. X 20MM LONG			
B	ENDPLATES	B3408X5	2	304	215 X 130 X 1.2	PUNCH & RAISE AS DETAIL			
A	SILENCER BODY	25120934BA	1	304	450 X 575 X 0.9	NOTCH, ROLL & SEAM			
ITEM	DESCRIPTION	PART No	QTY	MATL	SIZE	FORM			
PART NUMBER:MSSE129						ALL DIMENSIONS IN MM U. O. S.			
REAR SILENCER ASSEMBLY						TOLERANCES			
USED ON:- SEAT IBIZA 1.4TSI CUPRA / BOCANEGRA						OPEN:- ±0.4	SCALE 1:1	DRAWN DJM	DRAWING No. A1545
						0.0:- ±0.25	THIRD ANGLE	DATE 28/01/11	
						0.00:- ±0.1			

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Montageanleitung

1. Genau prüfen, welche Teile der gesamten Abgasanlage schadhaft sind. Häufig sind neben den eigentlichen Schalldämpfern auch die Abgasrohre erneuerungsbedürftig.
2. Dabei auch den Zustand der Anbauteile, wie Dichtungen, Schrauben, Muttern usw. beachten.
3. Steckverbindungen, Schrauben und Muttern sind oft festgebrannt. Deshalb vor Ausbau mit rostlösendem Mittel einsprühen.
4. Dieselben Stellen der neuen Teile einfetten, z. B. mit einem Gemisch aus Graphit und Öl.
5. Befestigungsschrauben an den Eintrittsrohren der originalen Schalldämpfer lösen, dann die originalen Schalldämpfer aus den Aufhängungsgummis aushängen und abnehmen.
6. Austauschteile am Fahrzeug zunächst lose und spannungsfrei montieren und ausrichten, dann erst Verbindungen und Aufhängungen fest anziehen.
7. Verbindungsstellen auf Dichtheit prüfen.
8. Auf ausreichenden Abstand der Endrohre zur Heckschürze ist zu achten, ggf. ist ein ausreichender Ausschnitt für die Endrohre zu schaffen.

Photograph (example)



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