

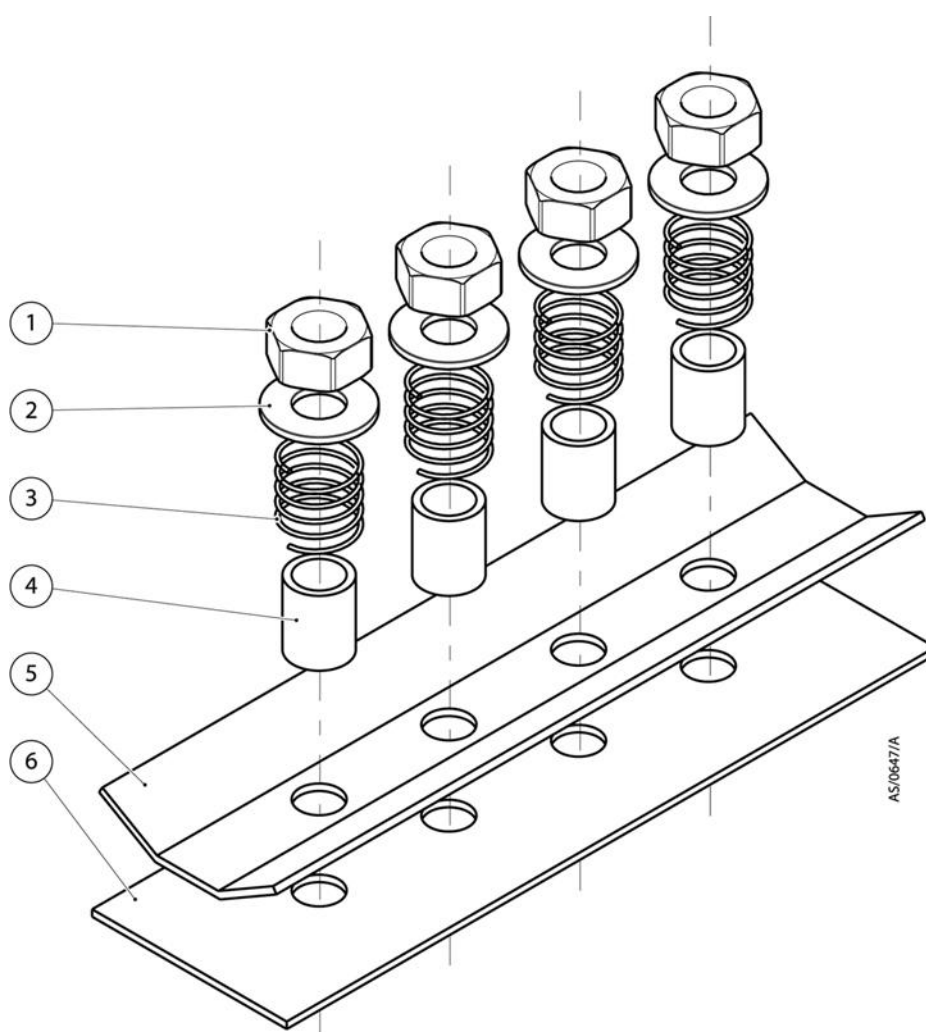
# Assembly Instructions

## E2M275 Spring Loaded Exhaust Valve

Follow the procedure below to correctly assemble the E2M275 spring loaded exhaust valve.

- Disassemble the HV exhaust valve.
- Discard the 4 off spacers (A278-04-004) and the clamp plate (A259-47-001).
- Rebuild the HV exhaust with the new kit items, replacing the valve plate (A259-60-003) with the modified plate from the kit. Refer to Figure 1.

Figure 1 - E2M275 Spring loaded exhaust valve assembly



1. M6 nut (existing item)
2. Washer 4 off 218980209 (new item)
3. Spring 4 off A271-02-077 (new item)
4. Spacer 4 off A278-04-040 (new item)
5. Modified exhaust valve plate A259-60-03 (new item)
6. Exhaust rubber (existing item)



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### CONTACT US

T: 1800 GO EZZI

E: [sales@ezzivision.com.au](mailto:sales@ezzivision.com.au)

W: [ezzivision.com.au](http://ezzivision.com.au)

**VIC:** 13/62 Ramset Drive, Chirnside Park,  
VIC 3116, Australia

**NSW:** Unit 1, 80 O'Riordan St, Alexandria,  
NSW 2015, Australia

**WA:** Unit 11, 24 Baile Road, Canning Vale,  
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