

Please take time to read and understand these installation instructions.

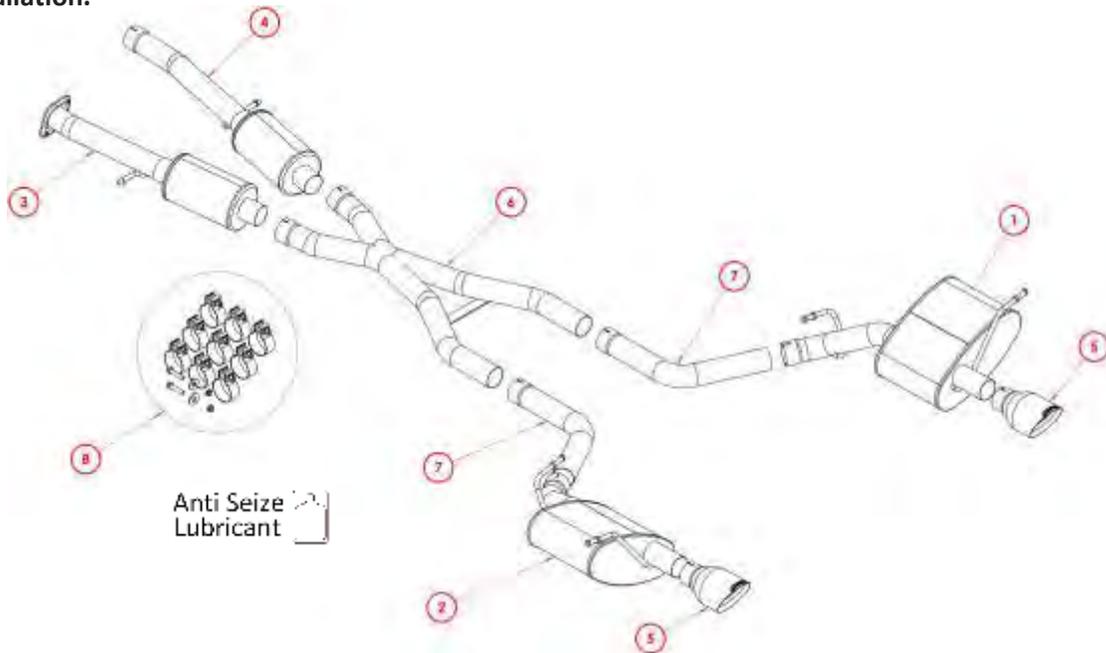
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

**CAUTION:** Never work on a hot exhaust system. Allow time for the vehicle to cool. Always wear eye protection when working under a vehicle.

### Recommended Tools:

- 3/8" drive ratchet
- 3/8" drive torque wrench
- 3/8" drive 13mm socket
- 3/8" drive 14mm socket
- 3/8" drive 15mm deep socket
- 13mm wrench
- 14mm wrench
- Grommet pullers
- Soap and water solution
- Torque Wrench
- Penetrating lubricant spray
- Safety glasses

Please confirm that all parts are present before beginning the factory exhaust system removal and CORSA exhaust system installation.



### Bill of Materials

1. 18DD2000 – Muffler Assembly – Passenger
2. 18DD2001 – Muffler Assembly – Driver
3. 18DD2009 – Tunnel Muffler Assembly – Driver
4. 18DD2010 – Tunnel Muffler Assembly – Passenger
5. 18DD3000 – Tip Assembly (2x)
6. 18DD4019 – X-Pipe Assembly
7. 18DD4026 – Axle Pipe (2x)

8. 18DD7009 – Hardware Kit

**Factory Exhaust System Removal:**

1. Using the 3/8" drive ratchet and 15mm deep socket, loosen the clamp in front of the passenger side flange joint. **(Fig. A)**
2. Using the 3/8" drive ratchet and 13mm socket, loosen the two nuts on the driver side flange. **(Fig. B)** Remove the stock mounting hardware from the flange. It will not be reused.
3. Using the 3/8" ratchet, 13mm socket and 3/8" extension, remove the two bolts from each driver and passenger side hanger bracket on the tunnel muffler. **(Fig. C & D)** Keep these four bolts for use during the Corsa system installation. Place a stand under the front section of the stock exhaust to help support it during the rest of the removal process. **(Fig. E)**

4. Using grommet pullers or a similar device, remove the front hanger grommets from both rear mufflers. **(Fig. F)**

**NOTE:** The use of a soap and water solution may aid in the removal of the hanger grommets.

5. Using the 3/8" ratchet and 15mm deep socket, loosen the two bolts connecting the driver side rear muffler. **(Fig. G)**
6. Remove the factory driver side muffler from the vehicle by pulling the rear hanger out of the rubber grommet. **(Fig. H & I)**
7. The rest of the factory system will come out in one piece. Pull the rear hanger on the passenger side rear muffler out of the rubber grommet. Disconnect the ground wire from the muffler hanger. **(Fig. J)** Slide the entire system down and towards the rear of the vehicle to remove it.

**NOTE:** The use of penetrating lubricant spray on the pipe joint may aid in removal.

8. With the factory system removed from the vehicle, use grommet pullers or a similar device to remove the rubber grommets and brackets from the factory tunnel muffler. **(Fig. K)** Keep the factory rubber grommets and brackets for use during the Corsa system installation. Make a note as to the orientation of the grommets and brackets, as they will be installed in original positions.

**NOTE:** The use of a soap and water solution may aid in the removal of the hanger grommets.

Factory Exhaust System Removal Pictures:



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

Factory Exhaust System Removal Pictures:

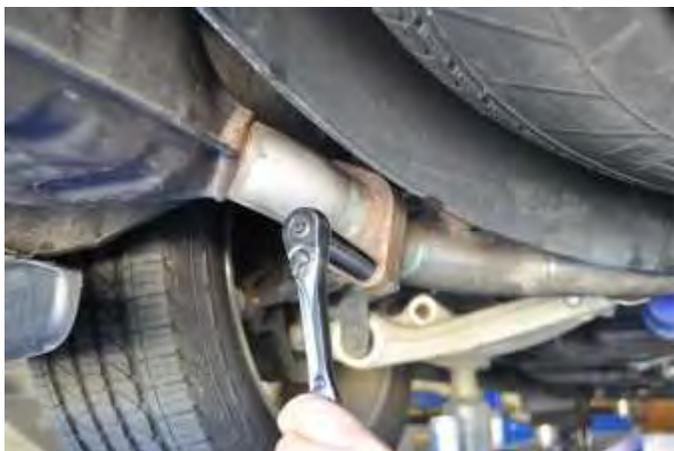


Fig. G



Fig. H



Fig. I



Fig. J

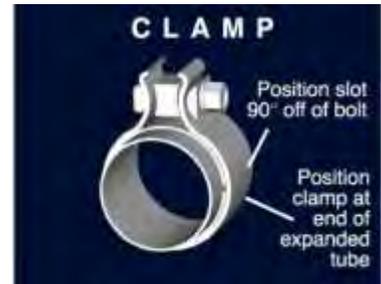


Fig. K

## Installation of CORSA Exhaust System:

**NOTE:** Apply the anti-seize lubricant (supplied) to the threads **ONLY** of all the clamps and flange bolts. Failure to follow this procedure can cause nuts to seize on clamps and potentially destroy threads. After applying anti-seize lubricant, be sure to thoroughly clean your hands, as lubricant will tarnish stainless steel. All clamps should be tightened using a properly calibrated Torque Wrench. Using an air impact gun will damage the clamp and reduce its ability to effectively seal the joint. It may also cause the joint to separate, thereby causing damage to your exhaust system and to your vehicle.

**NOTE:** Align all clamps so that the center of the clamp bolt is 90 degrees from the notch in the pipe. (See Fig. CLAMP)



1. Remove all exhaust system components from the shipping boxes, including clamps and hardware.
2. Locate the four bolts that were removed during step #3 of the removal process, and the two rubber grommets retained during step #8 of the removal process. Using a ratchet and 13mm deep socket, install the driver side hanger assembly with the two bolts. **(Fig. L)** Repeat on the passenger side.
3. Locate the passenger tunnel muffler assembly and one of the 2.50" clamps. Insert the tunnel muffler hanger into the rubber grommet. **(Fig. M)** Install the clamp on the tunnel muffler so that the bolt is vertical with the nut towards the ground and bolt is towards the inside of the vehicle. Slide the tunnel muffler inlet over the factory outlet, and tighten the clamp using the ratchet and 15mm deep socket, until the tunnel muffler inlet pipe is snug on the factory exhaust pipe. **(Fig N)** Ensure the tunnel muffler hanger is horizontal while tightening the clamp.  
**NOTE:** The use of a soap and water solution may make it easier to install the hangers.
4. Locate the driver side tunnel muffler, the two M10-1.25X50mm bolts and nuts included in the hardware kit. Insert the tunnel muffler hanger into the rubber grommet. Inspect the donut gasket at the flange to insure it is seated properly. **(Fig. O)** Align the muffler inlet pipe with the stock outlet while positioning the flanges together. Insert the bolts from the rear through the tunnel muffler flange first, then into the stock flange. Start threading the nuts onto the bolts by hand. Snug the bolts using a 14MM socket, ratchet and 14mm wrench. Do not fully tighten time at this time. **(Fig. P)**  
**NOTE:** The use of a soap and water solution may make it easier to install the hangers.
5. Locate the x-pipe assembly and two of the 2.5" clamps. The x-pipe is installed with the reinforcement brace towards the ground and favoring the rear of the vehicle. Install the clamps on the x-pipe so that the bolts are vertical, with the nut towards the ground and the bolts are towards the inside of the car. **(Fig. Q)** Insert the x-pipe inlets onto both tunnel muffler outlet pipes before tightening the clamps. **(Fig. R)** Tighten the clamps using the ratchet and 15mm deep socket until the x-pipe is snug on the tunnel muffler outlets. **(Fig. S)**

6. Locate the passenger side axle pipe along with one 2.5" clamp. Install the clamp on the axle pipe so the bolts are vertical with the nut towards the ground and the bolts are towards the inside of the car. **(Fig. T)** Tighten the clamp using the ratchet and 15mm deep socket until the axle pipe is snug on the x-pipe. **(Fig. U)**
7. Repeat step #6 on the driver side of the vehicle.
8. Check that the clearance to the suspension mounts are the same on both sides. Adjust the position of the x-pipe and tunnel mufflers as needed to create equal and adequate clearance of the axle pipes and the spare tire plastic guard. Make sure that the x-pipe is level and not rotated to one side. The reinforcement brace should be parallel to the ground.
9. Locate the passenger rear muffler assembly and one 2.5" clamp. Insert the rear hanger into the rear rubber grommet. **(Fig. V)** Install the clamp on the rear muffler inlet pipe so the bolt is vertical with the nut towards the ground and bolt towards the outside of the vehicle. Slide the muffler inlet pipe over the axle pipe. **(Fig. W)** Next, insert the front muffler hanger into the front grommet. **(Fig. X)** Tighten the clamp until the muffler inlet pipe is snug against the axle pipe. **(Fig. Y)**  
**Note:** The use of a soap and water solution may make it easier to install hangers.
10. Repeat Step #8 on the driver side of the vehicle. When installing the rear muffler hanger into the grommet, reinstall the ground wire onto the rear hanger. **(Fig. Z)**  
**Note:** You may need to lightly pinch the ground wire clamp to ensure it will be snug on the hanger.
11. Locate the rear tip assembly and one 2.5" clamp. Install the clamp on the tip inlet pipe so that the bolt is vertical with the nut towards the ground and the bolt is towards the outside of the vehicle. Slide the tip assembly over the muffler outlet pipe and tighten the clamp until snug. **(Fig. AA & BB)**
12. Adjust the system accordingly, including the rear muffler depth and rotation, so that the tips are centered in the bumper valence. **(Fig. CC)** Check clearance between the system components and chassis. At this time, tighten all clamps to 45ft-lbs using the torque wrench and 15mm socket and all flange bolts to 28 ft-lbs using the torque wrench and 14mm wrench.

**NOTE:** During cold weather start-ups, you may experience an exhaust sound that is deeper and louder in tone than usual. This is temporary and will diminish to normal levels once your engine has reached its normal operating temperature.

**NOTE:** Immediately following the installation of your exhaust system, you may experience a trace of smoke after initial start-up. DO NOT be alarmed. The smoke is caused by the burning of a small amount of forming oil residue used in the manufacturing process.

**CORSA Installation Pictures**



**Fig. L**



**Fig. M**



**Fig. N**



**Fig. O**



**Fig. P**



**Fig. Q**

**CORSA Installation Pictures**



**Fig. R**



**Fig. S**



**Fig. T**



**Fig. U**



**Fig. V**



**Fig. W**

**CORSA Installation Pictures**



**Fig. X**



**Fig. Y**



**Fig. Z**



**Fig. AA**



**Fig. BB**



**Fig. CC**