

**Please take time to read and understand these installation instructions.**

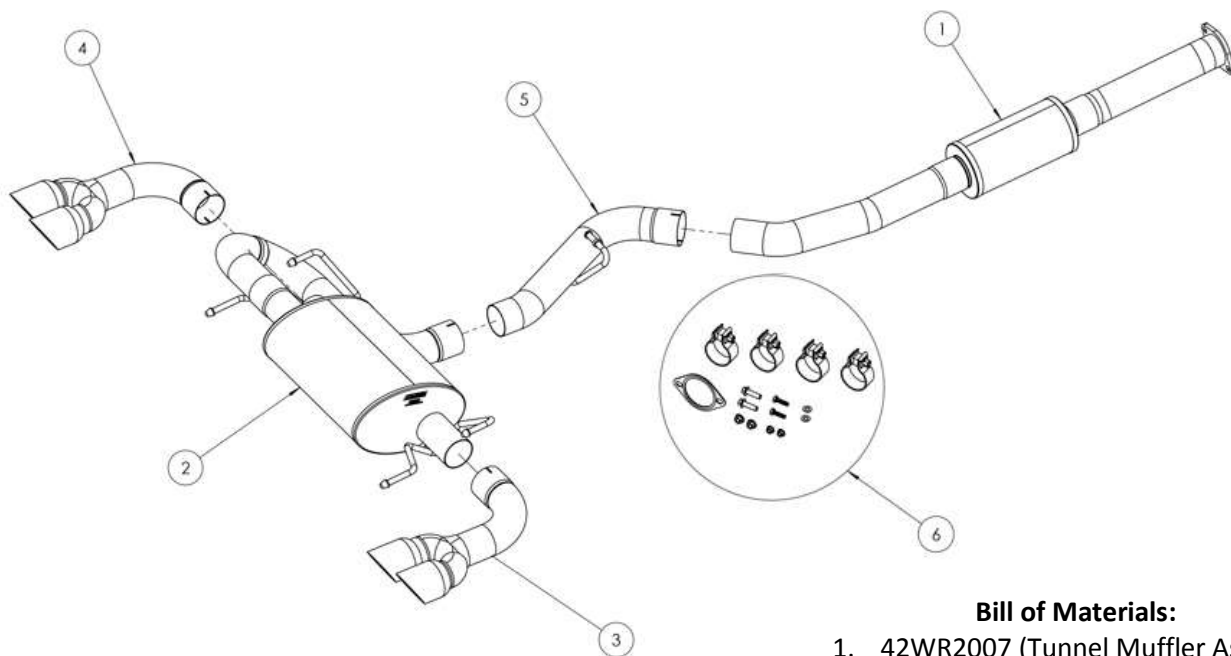
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

**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 14mm socket
- 3/8" drive 15mm deep socket
- 3/8" drive 13mm socket
- 12mm wrench
- 13mm wrench
- Small flat head screwdriver
- Soap and water solution
- Torque wrench
- Penetrating lubricant spray
- Safety glasses
- Grommet Pullers

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



### **Bill of Materials:**

1. 42WR2007 (Tunnel Muffler Assembly)
2. 42WR2008 (Rear Muffler Assembly)
3. 42WR3000 (Tip Assembly – Passenger)
4. 42WR3001 (Tip Assembly – Driver)
5. 42WR4011 (Axle Pipe Assembly)
6. 42WR7010 (Hardware Kit)

## Factory Exhaust System Removal:

1. Remove both sets of hardware that secure the catback to downpipe flange connection on the factory center pipe using a 14mm socket and a 12mm wrench. **(Fig A)**
2. Place a support under the front of the system to ensure it doesn't fall during removal. Using grommet pullers or similar device, remove the front hanger grommet from the axle pipe. **(Fig B)**

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

3. Remove both hanger grommets from the rear muffler on the driver's side using grommet pullers or similar device. **(Fig C & D)** Repeat on passenger side.
4. Carefully remove the factory exhaust by moving it down and towards the rear of the vehicle.
5. Remove the donut gasket at the flange on the factory downpipe. **(Fig E)** It may be helpful to use a small flathead screwdriver to free the donut gasket from the lip on the downpipe. The donut gasket will not be reused. This completes the removal process.

## Factory Exhaust System Removal Pictures:



Fig A



Fig B



Fig C



Fig D

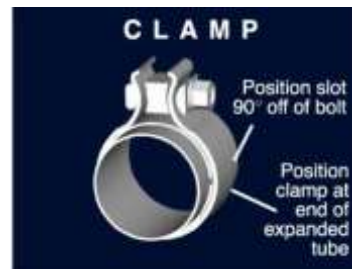


Fig E

## 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. (Fig. CLAMP)



1. Remove all exhaust system components from the shipping boxes, including the clamps, gasket and hardware.

**When connecting to factory downpipe; continue to step 2. If you're connecting to an aftermarket 3" downpipe, skip to step 3:**

2. Locate the M8 x 1.25 bolts and slide them into downpipe flange. **(Fig F)** Place the flange gasket onto the M8 bolts on the downpipe flange, followed by the tunnel muffler assembly, washers and finally the nuts. Hand-tighten the nuts. Continue to step 4
3. Any aftermarket downpipe used needs to maintain the OEM flange position and orientation to allow the Corsa system to fit properly. Locate the M10 x 1.25 bolts and slide them into downpipe flange. Place the flange gasket onto the M10 bolts on the downpipe flange, followed by the tunnel muffler assembly, washers and finally the nuts. Hand-tighten the nuts. Continue to step 4.
4. Locate a 3" Torca clamp and slide it over the expanded end of the axle pipe assembly. Install the clamp on the axle pipe so that the bolts are vertical with the nut towards the ground and the bolt is towards the inside of the car. Insert the axle pipe hangers into the factory grommet. **(Fig G)** Adjust the position and rotation of the axle pipe until the outlet is parallel to the ground and has at least a finger width gap to the rear differential. **(Fig H)** Tighten the clamp using the ratchet and the 15mm deep socket until the axle pipe is snug on the tunnel muffler. **(Fig I)** Center the gasket on the flange, and then tighten the flange nuts using a 13mm socket and a 13mm wrench (for the M8 hardware) or a 15mm socket and a 15mm socket (for the M10 hardware). **(Fig J)**

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

5. Locate a 3" Torca clamp and slide it onto the expanded inlet of the rear muffler assembly. **(Fig K)** Insert the rear muffler hangers into the rubber grommets. **(Fig L & M)** Slide muffler inlet onto axle pipe. Tighten the clamp using the 15mm deep socket until the rear muffler inlet is snug on the axle pipe.
6. Locate a 3" Torca clamp and slide it over the expanded end of the passenger's side tip assembly. **(Fig N)** Slide the tip assembly over the passenger outlet of the rear muffler assembly. Adjust the depth and rotation to center the tips in the cutout in the rear valence. Tighten the clamp using the ratchet and the 15mm deep socket until the tip assembly is snug on the rear muffler assembly. **(Fig O)**
7. Repeat step 6 for the driver's side tip assembly. **(Fig P & Q)**
8. Visually inspect and adjust the exhaust system position, tip alignment, clamp orientation and exhaust pipe clearance.
9. When the exhaust system is in the desired location, tighten the nuts on the clamps. Torque nuts to 45 ft-lbs (61 N-m)
10. It is **STRONGLY SUGGESTED** that all clamps be checked and re-tightened (if necessary) to the recommended torque after initial road testing of the vehicle, as thermal cycling has occurred on the system. Please wait until system has fully cooled to perform this step.

**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 F



Fig G



Fig H



Fig I



Fig J



Fig K



Fig L



Fig M



Fig N



Fig O



Fig P



Fig Q