

Please take time to read and understand these installation instructions.

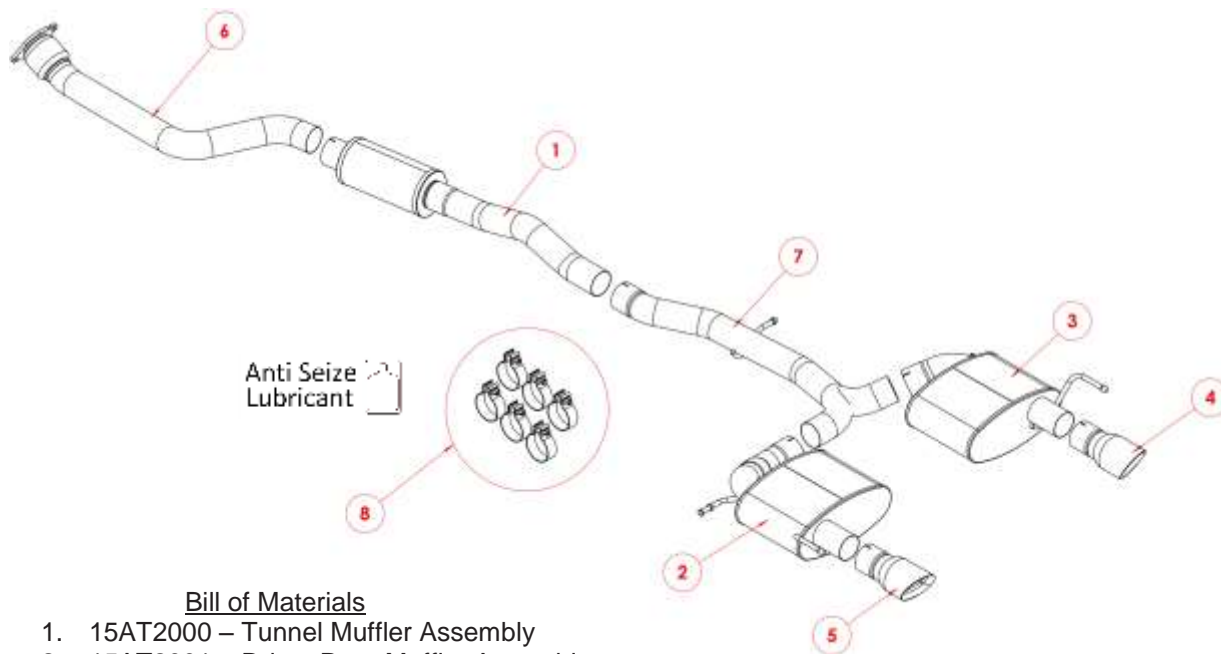
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

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

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



Bill of Materials

1. 15AT2000 – Tunnel Muffler Assembly
2. 15AT2001 – Driver Rear Muffler Assembly
3. 15AT2002 – Passenger Rear Muffler Assembly
4. 15AT3000(BLK) – Pass Side Tip Assembly
5. 15AT3001(BLK) – Driver Side Tip Assembly
6. 15AT4004 – Head Pipe Assembly
7. 15AT4010 – Axle Pipe Assembly
8. 15AT7007 – Hardware Kit

Factory Exhaust System Removal:

1. Remove the reinforcement brace located at the center of the car using 3/8" drive ratchet and 13mm socket. The brace is held in place by four (4) bolts. **(Fig A & B)**
2. Using a 3/8" ratchet and 14mm long socket, remove the two nuts securing the stock head pipe to the downpipe. Keep these bolts as they are needed to re-attach the new head pipe to the stock downpipe during installation of the Corsa exhaust. The front half of the exhaust will now be loose at this point. Do not let the exhaust fall as it may cause injury to and/or damage the car. Support the front of the exhaust using a jack stand or similar device. **(Fig. C & D)**

Note: Penetrating lubricant may make this step easier.

3. Using grommet pullers or a similar device, remove the driver side axle pipe hanger (attached to the exhaust piping), located just before the differential, from the rubber hanger grommet. **(Fig E)**

Note: The use of a soapy water solution may aid in the removal of hangers.

4. Using grommet pullers or a similar device, remove the passenger side axle pipe hanger (attached to the exhaust piping), located just before the differential, from the rubber hanger grommet. **(Fig F)**
5. Using grommet pullers or a similar device, remove the driver side hanger (attached to the rear muffler), located on the front of the rear muffler, from the rubber hanger grommet. **(Fig G)**
6. Using grommet pullers or a similar device, remove the passenger side hanger (attached to the rear muffler), located on the front of the rear muffler, from the rubber hanger grommet. **(Fig H)**
7. The rear section of the exhaust is now supported by two hangers located on the outer rear sections of the muffler. Slide the exhaust towards the rear of the car to create enough clearance to remove the head pipe off of the downpipe bolts. Once the head pipe is clear, slide the exhaust towards the front of the car to remove the remaining to hangers from the rubber grommets. **(Fig. I & J)**

Note: This operation will require the help of an additional person to support the rear section of the exhaust.

8. Remove the stock exhaust from under the car as a complete system. Confirm that the metal flange gasket remained in place on the stock downpipe as it will be reused for the installation of the Corsa system. This concludes the removal process. **(Fig K & L)**

Factory Exhaust Removal Pictures



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

Factory Exhaust Removal Pictures



Fig. G



Fig. H



Fig. I



Fig. J



Fig. K

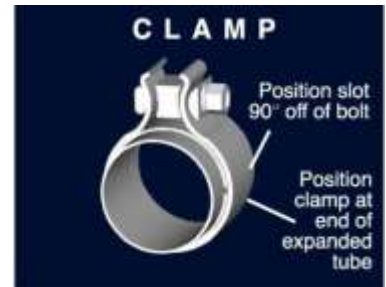


Fig. L

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 box, including all hardware.
2. Locate the head pipe assembly along with the two factory nuts retained from step 2 or the removal process. Place the head pipe flange onto the M12 x 1.75 studs from the stock downpipe, and secure with the two M12 nuts. Tighten the nuts using a 3/8" ratchet, 3/8" swivel extension, and 14mm deep socket. Place a jack stand or similar device to support the rear section of the head pipe. **(Fig. A & B)**
3. Locate a 3" Torca clamp and slide it over the expanded end of the tunnel muffler assembly. Install the clamp on the tunnel muffler assembly so that the bolt is vertical with the nut towards the ground and the bolt is towards the passenger side of the car. Slide the expanded end of the tunnel muffler assembly over the rear section of the head pipe. Rotate the tunnel muffler assembly until the outlet bend is positioned vertically. Tighten the clamp using a 3/8" ratchet and a 15mm deep socket until the tunnel muffler assembly is snug on the head pipe. Slide the jack stand downstream to support the rear section of the tunnel muffler. **(Fig. C & D)**
4. Locate the reinforcement brace and bolts removed during Step 1 of the stock exhaust removal procedure. Reinstall the brace and tighten the four (4) bolts in a cross-diagonal pattern use a 3/8" drive and 13mm socket. **(Fig. E)**
5. Locate the "Y" pipe. Insert the "Y" pipe hanger into the rubber hanger grommet located just before the differential. **(Fig. F)**

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

6. Locate a 3" Torca clamp and slide it onto the expanded end of the "Y" pipe. Install the clamp on the "Y" pipe so that the bolt is vertical with the nut towards the driver side of the car. Slide the expanded end of the "Y" pipe over the rear section of the tunnel muffler assembly. The "Y" pipe should be positioned so that the driver side outlet pipe is horizontal to ground. Tighten the clamp using a 3/8" ratchet and a 15mm deep socket until the "Y" pipe is snug on the tunnel muffler assembly. **(Fig. G & H)**
7. Locate the passenger side muffler assembly. Insert the rear hanger into the rear most rubber hanger grommet located directly behind the valance and to the right of the tip cut-out. Install a 3" Torca clamp onto the expanded end of the muffler assembly with the clamp positioned so that the bolt is facing the rear of the car. Next, insert the front muffler hanger into the rubber hanger grommet located rearward of the suspension assembly. Next slide the expanded end of the muffler inlet pipe over the passenger side "Y" outlet pipe. **(Fig. I, J & K)**
8. Locate the driver side muffler assembly. Insert the rear hanger into the rear most rubber hanger grommet located directly behind the valance to the left of the tip cut-out. Install a 3" Torca clamp onto the expanded end of the muffler assembly with the clap positioned so that the bolt is facing towards the front of the car. Next, insert the front muffler hanger into the rubber grommet located rearward of the suspensions assembly. Next, slide the expanded end of the muffler inlet pipe over the driver side "Y" outlet pipe. **(Fig. L, M & N)**
9. Tighten the driver and passenger side Torca clamps using a 3/8" ratchet and a 15mm deep socket until both driver and passenger muffler assemblies are snug onto the "Y" pipe. **(Fig. O & P)**
10. Locate a 3" Torca clamp and slide it onto the expanded end of the driver side tip assembly. Install the clamp on the tip assembly so that the bolt is vertical with the nut and bolt towards the outside of the car. Slide the expanded end of the tip assembly over the muffler outlet pipe and rotate the tip towards the center of the car until the Corsa etch is at the top of the tip. Repeat this process for the passenger side tip assembly. **(Fig. Q & R)**
Note: The muffler tips are designed to be rotated 18° towards the center of the car to match the valance profile.
11. Adjust the system accordingly to maximize chassis and heat shield clearance while positioning the tips within the bumper valance. Starting at the front and working backwards, tighten the clamps to 45ft-lb using the torque wrench and 15mm socket, ensuring that the tips are still in the desired position.
12. 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 as occurred on the system. Please wait until the 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 Exhaust Installation Pictures



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

CORSA Exhaust Installation Pictures:



Fig. G



Fig. H



Fig. I



Fig. J



Fig. K



Fig. L

CORSA Exhaust Installation Pictures:



Fig. M



Fig. N



Fig. O



Fig. P



Fig. Q



Fig. R