

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

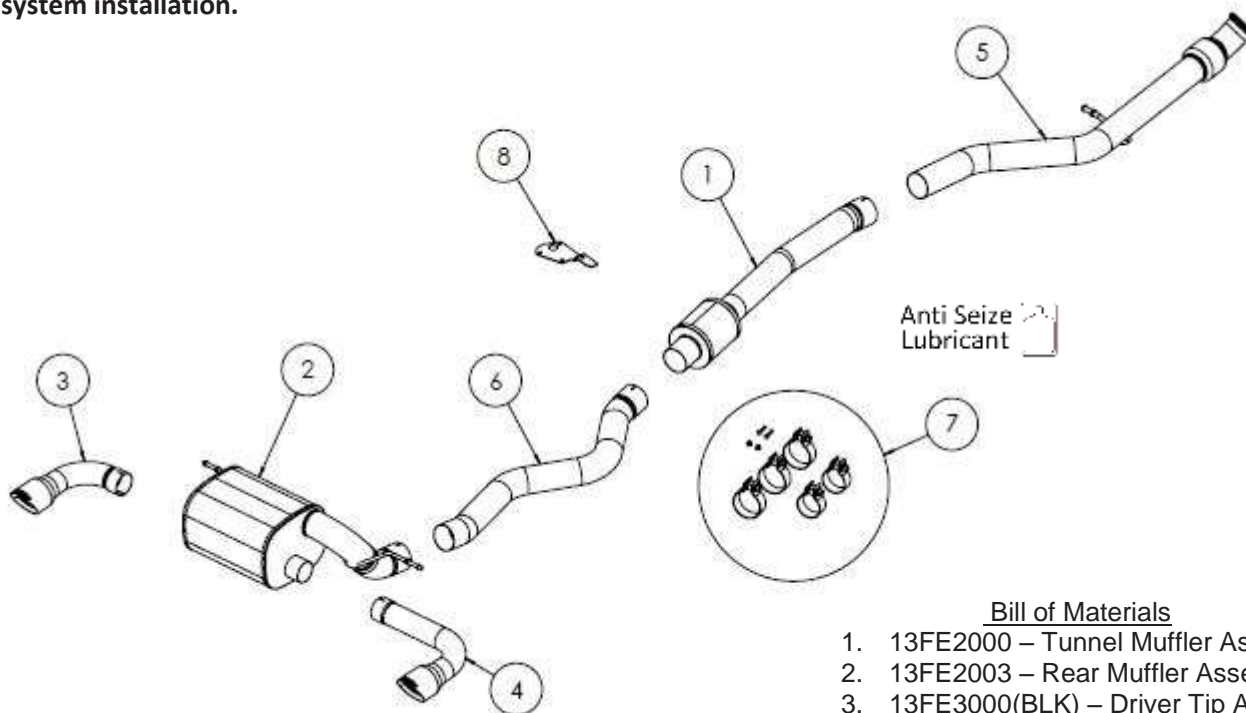
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

**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 10mm deep socket
- 3/8" drive 13mm shallow socket
- 3/8" drive 15mm deep socket
- 3/8" drive 16mm deep socket
- 3/8" drive E10 Torx
- 3/8" drive T50 Torx
- 10mm wrench
- 10" 3/8" ratchet extension
- 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. 13FE2000 – Tunnel Muffler Assembly
2. 13FE2003 – Rear Muffler Assembly
3. 13FE3000(BLK) – Driver Tip Assembly
4. 13FE3001(BLK) – Passenger Tip Assembly
5. 13FE4000 – Head Pipe Assembly
6. 13FE4005 – Axle Pipe
7. 13FE7007 – Hardware Kit
8. 13FE7002 – Valve Relocation Bracket

## Factory Exhaust System Removal:

1. Beginning on the driver's side of the car near the tip, disconnect the stock exhaust valve wires. **(Fig A & B)**
2. In the middle of the car, there is a brace held on with six (6) bolts. Remove the bolts and the brace using the ratchet and T50 Torx bit. **(Fig C)**
3. At the front of the exhaust, use the 16mm socket and ratchet to loosen the V-band clamp joining the catback to the downpipe. **(Fig D)** It may be easier to separate this joint if the bolt and nut are removed from the clamp temporarily.  
**Note:** Penetrating lubricant may make this step easier.
4. Using the ratchet and E10 Torx bit, remove the two bolts securing the front exhaust hanger. **(Fig E)** Keep these bolts as they are needed to re-attach the hanger to the car during installation of the Corsa exhaust.  
**Note:** The front half of the exhaust will now be loose at this point. Do not let the exhaust fall as it cause injury to and/or damage the car. Support the front of the exhaust using a jack stand or similar device.
5. Starting on the passenger side near the tip, use the ratchet, extension, and 13mm socket to remove the nut securing the hanger bracket to the frame. **(Fig F)** Keep the nut for later use during installation of the Corsa exhaust.  
**Note:** Only the hanger on the driver's side and the jack stand from Step #4 are supporting the exhaust at this point. Use a jack stand or similar device to support the passenger's side of the stock exhaust.
6. Repeat Step #5 on the driver's side. Keep the nut removed in this step for later use during installation of the Corsa exhaust.
7. Carefully remove the exhaust from the vehicle.
8. Using the 10mm wrench, remove the three (3) bolts securing the black stepper motor to the exhaust valve. **(Fig G)** These bolts are not reused during Corsa exhaust installation.
9. Using grommet pullers or a similar device, remove the hanger bracket near the front of the stock catback exhaust. **(Fig H & J)**  
**Note:** The use of a soapy water solution may aid in the removal of hangers.
10. Using grommet pullers or a similar device, remove the rubber hanger grommet on the passenger's side of the stock rear muffler. **(Fig K)**  
**Note:** The bracket may be left attached to the rubber grommet as an assembly.
11. Repeat Step #10 on the driver's side of the rear muffler. This concludes the removal process.

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. J

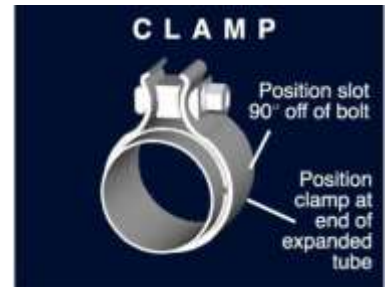


Fig. K

## 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. Using the ratchet, 10mm socket, and 10mm wrench, M6 nuts and M6 bolts, secure the factory exhaust's stepper motor to the Corsa supplied relocation bracket. **(Fig A)**
2. Locate the nut removed during Step #6 along with the driver's side hanger bracket and grommet removed during Step #11 of the removal process, and the bracket and stepper motor assembly from Step #1 of the installation process. Using the ratchet, extension and 13mm socket, secure the hanger bracket with the grommet and the valve relocation bracket as shown. **(Fig B)**  
**Note:** The stepper motor is towards the front of the car with the rubber grommet sitting inboard.
3. Repeat Step #2 on the passenger side. The passenger's side only has the hanger bracket and grommet to reinstall. If needed, refer to **Fig F** of the removal process for bracket orientation.
4. Plug the control wires into the stepper motor. **(Fig C)**
5. Using the bolts removed during Step #4 of the removal process, reinstall the front exhaust hanger removed during Step #9 of the removal process. The arrow on the bottom of the bracket points towards the passenger's side of the vehicle. Use the ratchet and E10 Torx bit to tighten the bolts.
6. Locate the V-band clamp and its hardware if removed during Step #3 of the removal process. Reinstall the clamp onto the factory downpipe, with the bolt on the passenger's side of the vehicle and the nut towards the ground. Insert the Corsa headpipe into the clamp, making sure the V-band clamp captures the flare of the downpipe and the machined hump of the flange. **(Fig D)**
7. Insert the hanger into the grommet installed during Step #5. **(Fig E)** To ensure proper fitment of the remaining Corsa catback components, note the angle at which the bent hanger enters the rubber grommet. The hanger head's central axis should run parallel to the ground as seen in **(Fig F)**. An improperly adjusted headpipe will allow the hanger to sit at an angle similar to what is seen in **(Fig G)**.

8. Tighten the V-band clamp using the 16mm socket and ratchet. **(Fig H)**
9. Locate the tunnel muffler assembly. While holding the assembly with the muffler case's seam pointed up, position one of the 3" clamps such that the bolt is on the left of the expansion and the nut is towards the ground. **(Fig J)** Slide the expansion over the headpipe and snugly tighten the clamp using the ratchet and 15mm socket. **(Fig K)**
10. Locate the axle pipe. While holding the axle pipe with the expansion towards the front of the car and the first bend pointing towards the passenger's side, position a 3" clamp on the expansion such that the bolt is on the passenger's side with the nut towards the ground and slide the axle pipe over the outlet of the tunnel muffler. **(Fig L)** Snugly tighten the clamp using the 15mm socket and ratchet. **(Fig M)**
11. Locate the rear muffler assembly. Position the muffler such that the inlet side of the muffler with the bent pipes is towards the passenger's side of the vehicle. Insert the driver's side hanger into the rubber grommet. **(Fig N & P)**  
**Note:** The use of a soap and water solution may make working with rubber grommets easier.
12. Repeat Step #11 on the passenger's side of the vehicle.
13. Position a 3" clamp on the inlet of the rear muffler such that the bolt is on the driver's side with the nut towards the ground. Slide the expansion on the muffler inlet over the outlet of the axle pipe and snugly tighten the clamp with the 15mm socket and ratchet. **(Fig Q)**
14. Locate the driver's side tip assembly and one of the 2.5" clamps. Position the clamp on the expansion such that the bolt is towards the tip and the nut is towards the ground. Slide the expansion over the outlet of the muffler and snugly tighten the clamp. **(Fig R)**
15. Repeat Step #14 on the passenger's side.
16. Locate the six (6) bolts and the brace removed during Step #2 of the removal process. Reinstall the brace and bolts using the ratchet and T50 Torx bit. **(Fig S)**
17. Adjust the system accordingly to maximize chassis and heat shield clearance while positioning the tips within the bumper valence. 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.

**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. J



Fig. K



Fig. L



Fig. M



**CORSA Exhaust Installation Pictures:**



Fig. N



Fig. P



Fig. Q



Fig. R



Fig. S