

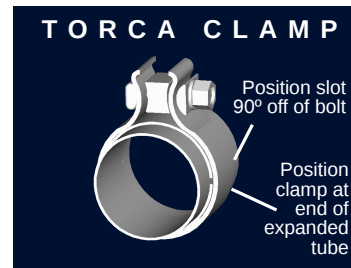
VIPER 3"

Exhaust System Installation

3" Exhaust System for the 1996-2002 RT/10 & GTS Dodge Viper

Tools: 15mm wrench and/or socket, 13mm wrench and/or socket, 1/2" wrench and/or socket, 1/4" Allen wrench, 9/16" wrench and/or socket, 8mm socket (for side cover removal), 22mm wrench (for oxygen sensor), Hammer, Torque Wrench and Safety Glasses

System Contents: (1) Rear Muffler Assembly, (1) Driver Side Under Axle Pipe (Labeled), (1) Passenger Side Under Axle Pipe, (1) Driver Side Side Muffler, (1) Passenger Side Side Muffler, (4) 3-inch TORCA clamps, (2) 2-1/2" TORCA clamps (for Side Mufflers), Anti-Seize Compound



C A U T I O N

Prior to installation, be sure your vehicle is parked on a level surface and the exhaust system is cool. For safety purposes and ease of installation, we urge you to take your vehicle to a qualified service center or muffler installer that employs the use of a lift. Be sure the exhaust system is cool before beginning the removal process. Safety glasses should be worn at all times.

INSTALLATION NOTE: Be sure to apply the anti-seize lubricant that has been provided to all bolts, fasteners and clamps. A pouch with anti-seize lubricant is included with the hardware kit. Apply the supplied anti-seize lubricant to the threads **ONLY** of all TORCA band clamps. Failure to follow this procedure can cause the nuts to seize on clamps and potentially damage threads. **WARNING:** Be sure to thoroughly clean hands after use. Anti-seize lubricant will tarnish stainless steel parts.

All Torca 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 your vehicle.

EXHAUST SYSTEM REMOVAL:

- 1) Remove the side muffler covers first. There is a total of ten (10) screws to remove for each side. There are four (4) small black round covers that are in the door sills covering the four (4) sheet metal screws holding each side cover in place. Use a screw driver to remove the round covers. There are two (2) screws that can be accessed by lifting the hood and four (4) more screws under the cover.

NOTE: Use a spray lubricant on all clamps and mounting hardware to facilitate the removal process.

- 2) Remove the oxygen sensor from each exhaust pipe using a 22mm wrench.
- 3) Loosen all clamps and remove the two bolts from the rubber insulator mount/hanger on each side muffler and keep bolts as they are needed for the installation of your new exhaust system.
- 4) Using a hammer, tap the intermediate pipe away from the inlet of the rear muffler. After the two pipes are separated, tap the side muffler to separate it from the catalytic converter and remove the entire side muffler/intermediate pipe assembly from the car.

- 5) Remove the rubber insulator mount/hanger from each side muffler hanger. Be sure to keep these as they are needed for the installation of your new exhaust system.
- 6) Next, remove the two fasteners from the rear muffler center mounting bracket. Be sure to keep these two (2) fasteners as they are needed for the installation of your new exhaust system. This will allow the front of the muffler to lower and be removed from the car.

INSTALLATION:

- 7) First, locate the REAR MUFFLER ASSEMBLY and LATERAL ADJUSTMENT BAR - both can be found in the same shipping carton. Attach LATERAL ADJUSTMENT BAR to the REAR MUFFLER and hand tighten (**See Fig. A**).
- 8) To begin the installation, insert the REAR MUFFLER ASSEMBLY into position as shown (**See Fig. B**) with LATERAL ADJUSTMENT BAR facing up. Push the REAR MUFFLER into place making sure that the adjustment bar "ends" fit into the factory rubber hangers. Let the REAR MUFFLER ASSEMBLY hang loose for now and DO NOT attempt to secure the rear muffler center mounting bracket to the frame hanger at this time.
- 9) Starting with the DRIVER SIDE, slide one of the two supplied 2-1/2" TORCA clamps over the inlet side of the SIDE MUFFLER (**See Fig. C**). Insert the SIDE MUFFLER dual wire hanger into the rubber insulator mounts/hanger (**See Fig. D**). Then slide SIDE MUFFLER over catalytic converter outlet (**See Fig. E**) with clamp in place and hand tighten.
- 10) Next, position rubber insulator mount/hanger (with dual wire hanger already inserted in rubber mount) to frame (located just forward of rear tires) and insert mounting bolts. DO NOT tighten clamps or bolts at this time (**See Fig. F**).
- 11) Slide the DRIVER SIDE UNDER-AXLE PIPE (labeled) (**See Fig. G**) through the frame with expanded end towards the SIDE MUFFLER outlet.

NOTE: Make sure that the oxygen sensor threaded sleeves are pointing up towards the floor of the vehicle.

- 12) Slide a clamp over the SIDE MUFFLER outlet (**See Fig. H**) and fully insert the UNDER-AXLE PIPE into SIDE MUFFLER. Position clamp and hand tighten - DO NOT tighten clamps at this time. DRIVER SIDE UNDER-AXLE PIPE should be positioned as shown in **Fig I**.

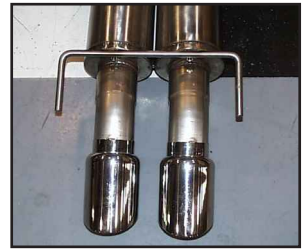


Fig. A

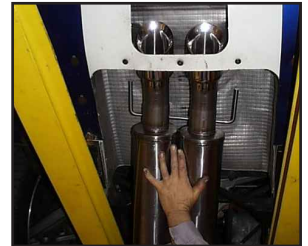


Fig. B



Fig. C



Fig. D



Fig. E

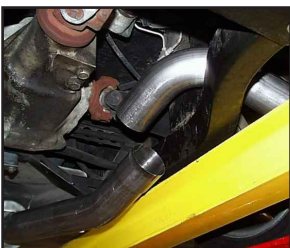


Fig. I

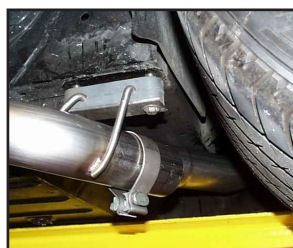


Fig. H



Fig. G



Fig. F

- 13) Repeat process for PASSENGER SIDE.
- 14) Slide a clamp over each REAR MUFFLER inlet. Insert UNDER-AXLE PIPES into each REAR MUFFLER inlet (**See Fig. J**). Work each pipe into the REAR MUFFLER ASSEMBLY alternating between pulling the REAR MUFFLER toward the front of the vehicle and sliding UNDER-AXLE PIPES into REAR MUFFLER. Position clamps and hand tighten - DO NOT tighten clamps at this time.
- 15) When each UNDER-AXLE PIPE is fully inserted into REAR MUFFLER outlets, the center mounting bracket on the REAR MUFFLER ASSEMBLY should line up with the frame hanger bracket (**See Fig. K**). Install the two (2) fasteners for the center mounting bracket and tighten securely with 13mm socket or wrench.
- 16) To complete the installation, check that all of the slip-fit connections are inserted fully and that there is at least 1/4-inch clearance between the pipes and frame, body, etc...
- 17) Next, make adjustment to exhaust tips ensuring they are centered in the fascia opening. Once aligned, use a 13mm open-end wrench and tighten lateral adjustment bar bolts (**See fig. L**).
- 18) Now tighten all clamps with 15mm socket or wrench making sure that they are aligned as shown in the box on page one of this instruction sheet, entitled TORCA CLAMP. Tighten the bolts on the side muffler rubber insulator mounts/hangers. **Torque setting: 45 ft.-lbs.**
- 19) Reinstall both oxygen sensors into each UNDER-AXLE PIPE using a 22mm open-end wrench. Before inserting sensor into threaded sleeve, turn it counterclockwise several times so that when it is tightened and in place, the wires are not twisted.
- 20) Reinstall the SIDE MUFFLER covers by reversing the procedure in Step 1 using original mounting hardware with 8mm socket (**See Fig. M**). Lower the car and enjoy the sound of your new CORSA Performance 3-inch Viper exhaust system.
- 21) It is MANDATORY that all clamps be checked and tightened if necessary AFTER road-testing the vehicle and AFTER system has cooled.

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 CORSA 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.

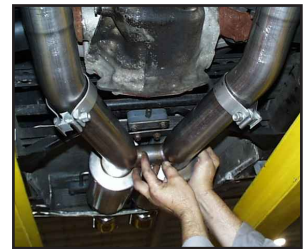


Fig. J



Fig. K



Fig. L



Fig. M



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