

CHEVY SSR

Exhaust System Installation

2004-06 Chevrolet SSR

PN 14254 / PN 14255



TOOLS NEEDED: Safety glasses, 15 mm wrench or deep socket, 1/2" wrench or deep socket, Torque wrench, saw or cutting wheel, chain-style pipe cutter, soapy water solution, ruler and black marking pen

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.

INSTALLATION NOTE:

Be sure to apply the provided anti-seize lubricant to all bolts, fasteners and clamps. A pouch 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.

CAUTION: 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.

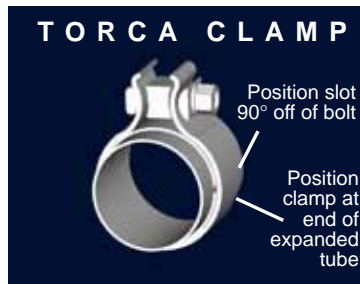


FIG. A



FIG. B



FIG. C

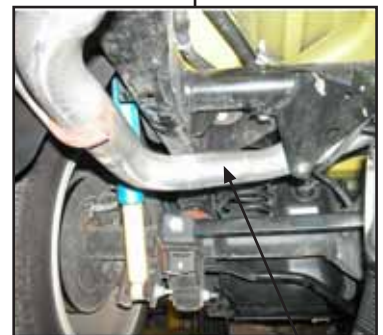


FIG. D



FIG. E

2004 Removal Instructions:

- 1) Scribe line approximately 2-3 inches down from frame brace (passenger side). **See Fig. A**
- 2) Cut pipe as far upward as possible toward the "Y" section (passenger side). **See Fig. B**
- 3) After cutting through pipe, remove passenger side segment as shown in **Fig. C**.
- 4) Cut the driver side stock pipe as close as possible to spot indicated by arrow in **Fig. D**.
- 5) Cut the driver side pipe as indicated in **Fig. E**.

6) After completely cutting pipe in previous step, remove the driver side segment from hanger grommet. Spray some soapy water in grommet to help. **See Fig. F**



7) Scribe a line 3 inches in front of stock muffler inlet. **See Fig. G**

8) Cut pipe approximately 3 inches in front of muffler inlet, as shown in **Fig. H**.

9) Loosen nuts at flange connection. Use a 15mm socket to remove flange nuts. **See Fig. I**

10) Remove Head Pipe section from grommet as shown. Spray some soapy water in grommet to help. **See Fig. J**

11) Remove cross bar bolts and cross bar from frame rails. **See Fig. K**
Be careful. The muffler is resting on the cross bar at this point.

12) Remove final section (muffler and "Y" pipe) from grommet as shown in **Fig. L**. Spray some soapy water in grommet to help. Carefully remove pipe from the rest of the vehicle.



FIG. F



FIG. G



FIG. H



FIG. I



FIG. J



FIG. K



FIG. L

Proceed to CORSA System
Install Instructions on page 3.

2005 Removal Instructions:



- 1) Cut Driver Side Tail Pipe using chain style cutting device. Remove the Driver Side Tail Pipe section from the vehicle. **See Fig.'s 1 & 2.**
- 2) Cut the 1/2" rod connecting the two tailpipes near the differential using a cut-off wheel or sawsall. **See Fig. 3.**
- 3) Cut the Passenger Side Tail Pipe approximately 3" past the muffler exit. Remove the Passenger Side Tail Pipe section from the vehicle. **See Fig. 4.**
- 4) Follow step 7 -12 on page 2 of instruction pamphlet to complete the removal of the stock exhaust system.



FIG. 1



FIG. 2



FIG. 3



FIG. 4

CORSA System Install Instructions:

- 1) Install CORSA Head Pipe shown in **Fig. M.**
- 2) Pre-tighten nuts using a 15mm socket as shown in **Fig. N.** Do not completely tighten nuts on Head Pipe until the rest of the CORSA system is in place.
- 3) Install muffler, ensuring drain hole is facing toward the ground. **See Figures O & P.**



FIG. M



FIG. N



FIG. O



FIG. P

- 4) After the muffler is assembled to the Head Pipe, swing the cross bar into place and tighten bolt as shown in **Fig. Q**. **Tighten bolt to a torque of 60 ft.-lbs.**
- 5) Next, assemble the Y-Pipe section of the CORSA exhaust system to the muffler exit. (**See Fig. R**)
- 6) Tighten the Y-Pipe section to the muffler exit using the 3" Torca clamp provided with your system. **See Fig. S**. When installing the Y-pipe hanger section to the factory grommet, make certain to rotate the grommet 180° so that the Y-Pipe hanger is above the factory hanger. Make sure the muffler is supported and level when installing the Y-Pipe. Do not tighten the clamp completely until the rest of the system is in place.
- 7) Slide the rubber grommet simultaneously onto the Y-Pipe hanger and the chassis hanger. Spray some soapy water in grommet to help. (**See Fig. T**)
- 8) After the grommet has been installed onto the Y-Pipe section of the assembly, your pipes should look similar to those in **Fig. U**.
- 9) Install the passenger side pipe assembly to the Y-Pipe section of the system. (**See Fig. V**)
- 10) Pre-tighten the passenger side section to the Y-Pipe section using a 2.5" Torca clamp (**See Fig. W**). Clamp is provided with your system. Do not tighten the clamp completely until the rest of the system is in place.
- 11) Install the driver side section of pipe (**See Fig. X**) to the Y-Pipe assembly.
- 12) Slide expanded end of driver side section onto driver side Y-Pipe. (**See Fig. Y**)



FIG. Q



FIG. R



FIG. S



FIG. V



FIG. T



FIG. U



FIG. W



FIG. X



FIG. Y



- 13) Place the grommet shown in **Fig. Z** onto the hanger of the driver side pipe assembly. Then tighten down the 2.5" Torca clamp at the Driver Side Tail Pipe to Y-Pipe connection. Do not tighten the clamp completely until the rest of the system is in place. Spray some soapy water in grommet to help.
- 14) At this point, your pipes should look similar to the SSR rear view shown in **Fig. AA**.
- 15) Begin to install the CORSA 4" Pro-Series tips on both the driver and passenger side tail pipes. **Continue to Step 16 on next page.**
16. Place the 4" Pro-Series tips onto both tailpipes. The tips should be recessed approximately 3/8" inside the tip pocket. The tabs on the clamps must be facing toward the center of the vehicle. At this time the clamps can be fully tightened. **(See FIG. BB)**
17. Install the tie bar with the side that has the hole thru the tab between the tabs on the passenger side clamp. Use the bolt and nut provided in the hardware kit to hold the tie-bar in place. **(See FIG. CC)**
18. Slide the Tie-Bar between the tabs on the driver side clamp.
NOTE: The tab attached to the Tie-Bar on the Driver Side is slotted. This is to give the installer adjustment when finalizing the tip alignment. **(See FIG. DD)**
19. Align the Driver side tip so that it is concentric with the opening in the bumper then tighten the nut and bolt through the clamp tabs and tie bar. **(See FIG. EE)**
20. See **FIG. FF** for a view of the Tie-Bar fully assembled to the driver and passenger side clamps.
21. The tips should be evenly spaced with the completion of the Tie-Bar assembly as shown in **FIG. GG**.

Now you may completely tighten ALL Torca clamps on the exhaust system to the **Torca torque specification of 45 ft.-lbs.**

Finally, finish tightening the nuts at the flange connection shown on page 3 in **Fig. N**. When tightening flange bolts, alternately tighten each bolt so the spacing is even all the way around the flange connection. Uneven tightening may result in an exhaust leak. **Torque the flange nuts to 60 ft.-lbs.**



FIG. Z



FIG. AA



FIG. BB



FIG. CC



FIG. DD



FIG. EE

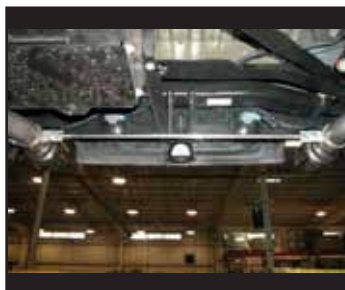


FIG. FF



FIG. GG

Adjustment Section

1) The alignment of the tips can be adjusted at two locations: The rear hanger sections of the Passenger and Driver Side Tail Pipe.



FIG. 5

2) Begin with Passenger Side Tail Pipe Hanger Assembly. If necessary, loosen the two 1/2" nuts shown in **Fig. 5**. Once the nuts have been loosened, the hanger assembly can slide sideways a 1/2" in either direction or 1" of total travel. Adjust to desired position and tighten the two nuts to lock the Passenger Side Tip into position.



FIG. 6

Torque the nuts to 15 ft.-lbs.

3) Adjusting the Driver Side Hanger Assembly requires movement in the vertical direction. If necessary, loosen the two 1/2" nuts shown in **Fig. 6**. Then move the tip up and or down until you reach the desired position.

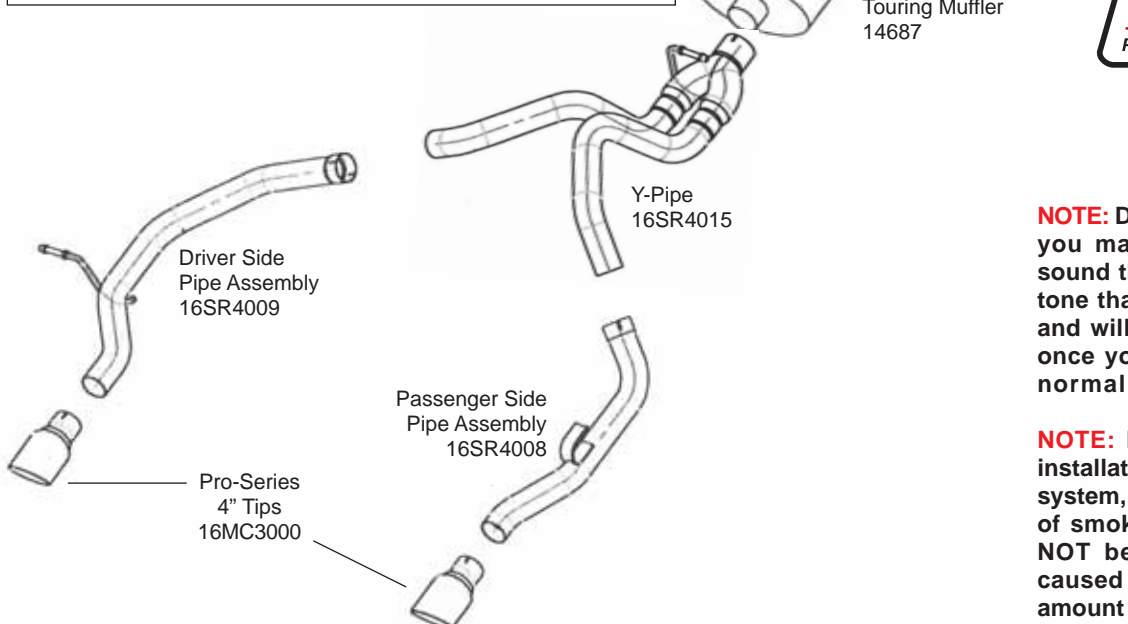
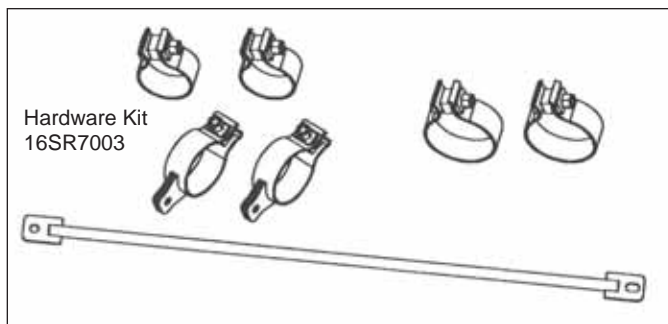
Torque the nuts to 15 ft.-lbs.

4) Once this process is complete, the tips should be perfectly centered as shown in **Fig. 7**.



FIG. 7

2004-05 Chevrolet SSR Exhaust System



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.