

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

CORSA recommends that 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.

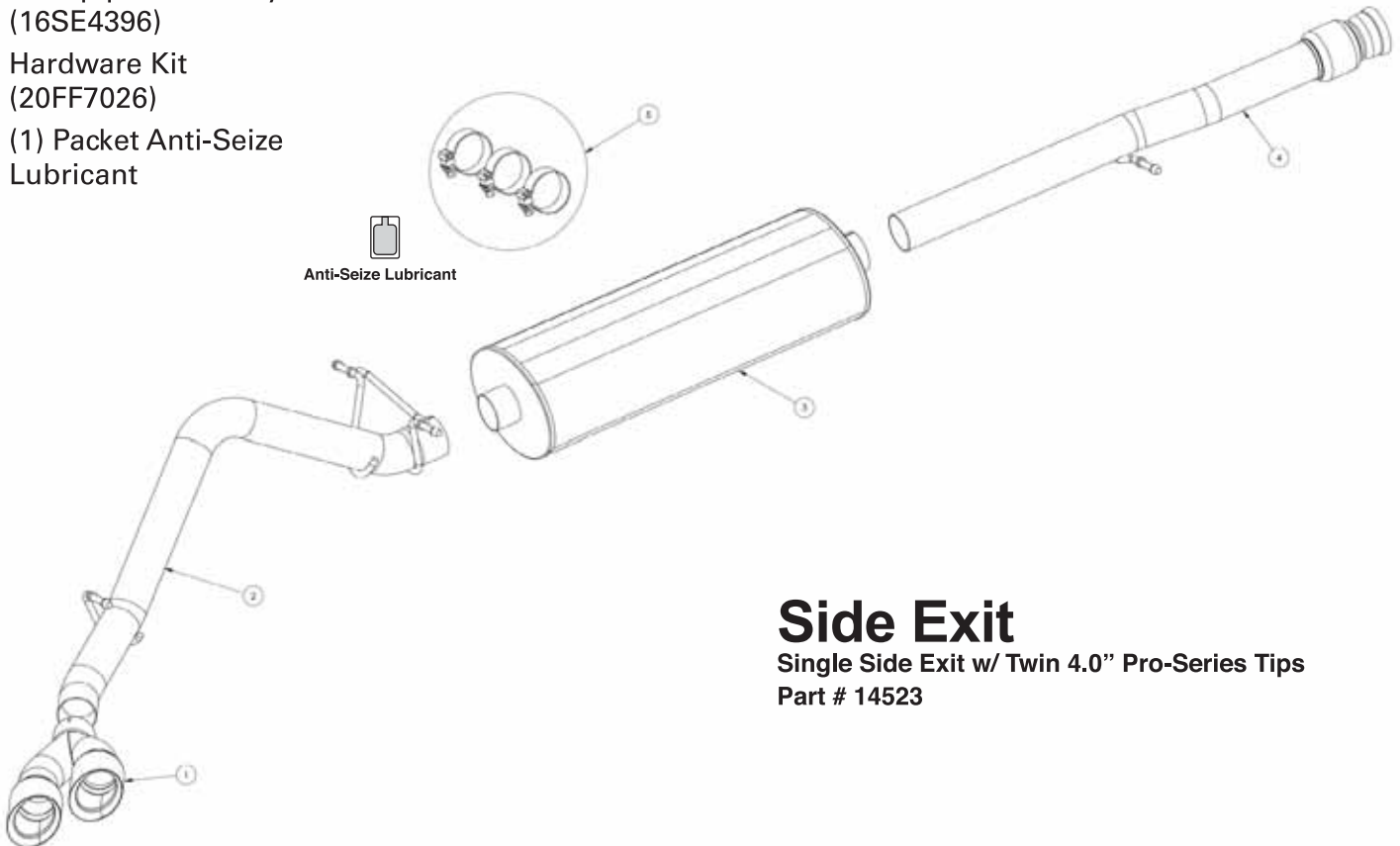
**Please confirm that all parts are present before beginning the factory exhaust system removal and CORSA exhaust system installation.**

## **Bill of Materials:**

- 1 Twin 4.0" Pro-Series Tip Assembly (16TA3000)
- 2 Tailpipe Assembly (side) (16SE4107)
- 3 Muffler (15CE2000)
- 4 Headpipe Assembly (16SE4396)
- 5 Hardware Kit (20FF7026)  
(1) Packet Anti-Seize Lubricant

## **Recommended Tools:**

- Safety Glasses
- Small flat head screw driver
- 15mm socket and ratchet
- Chain style pipe cutter
- or reciprocating saw
- Grommet pullers
- Spare tire removal kit
- Soapy water
- Torque wrench



## **Side Exit**

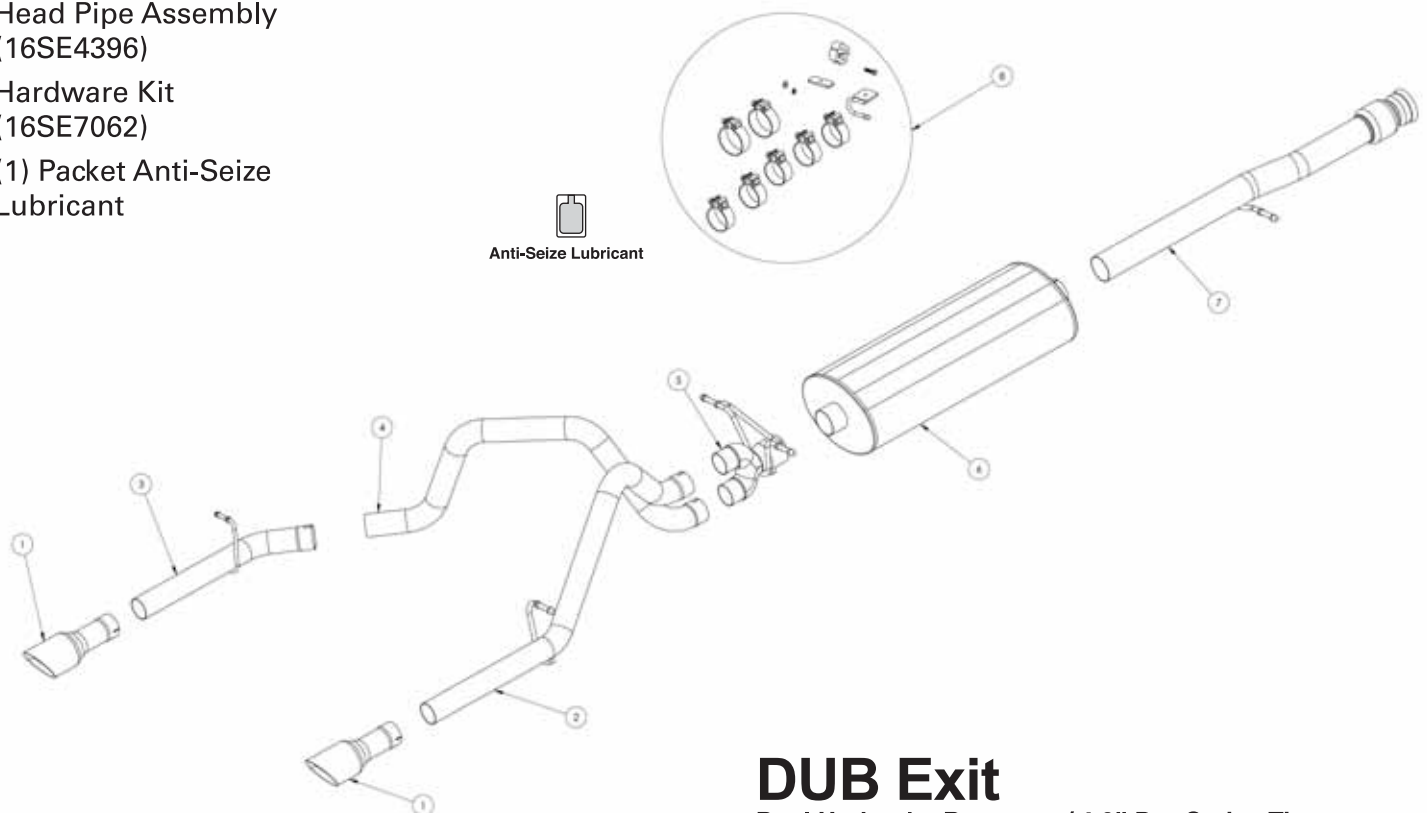
**Single Side Exit w/ Twin 4.0" Pro-Series Tips**  
**Part # 14523**

## Bill of Materials:

- 1 4.0" Pro-Series  
Tip Assembly (16SE3000)
- 2 Passenger Tailpipe  
Assembly (16SE4115)
- 3 Driver Tailpipe Assembly  
(16SE4116)
- 4 Driver Over-the-Axle-Pipe  
(16SE4117)
- 5 Dual "Y" Assembly  
(16SE4109)
- 6 Muffler (15CE2000)
- 7 Head Pipe Assembly  
(16SE4396)
- 8 Hardware Kit  
(16SE7062)  
(1) Packet Anti-Seize  
Lubricant

## Recommended Tools:

- Tape measure
- Black marking pen
- 15mm socket and ratchet
- 1/2" socket
- Chain style pipe cutter
- Grommet pullers
- Soapy water
- Safety glasses
- Torque Wrench



## DUB Exit

Dual Under the Bumper w/ 4.0" Pro-Series Tips

Part # 14524

## Removal of Stock System:

- 1) Open cover next to rear license plate and use vehicle key to remove lock and access to spare tire removal shaft **(See Fig. A)**
- 2) Use the spare tire removal kit from your vehicle and place the square end into the spare tire removal shaft then turn the wrench counter clock wise to lower the spare tire.
- 3) Mark tailpipe 3.25" rearward of the 2nd hanger after main tunnel muffler. Place a chain style cutter around the tailpipe at mark and cut the tailpipe at this location. **(See Fig. B & C)**  
A reciprocating saw may also be used.
- 4) Remove the rearmost hanger from the grommet using grommet pullers or similar device. **(See Fig. D)**
- 5) Remove the tailpipe section from the vehicle by lifting the tailpipe over the rear axle and backwards under the rear bumper.
- 6) Use a 15mm socket to loosen the spherical clamp at the front of the headpipe, then remove the hanger at the headpipe location and the hangers after the muffler. Remove the tunnel muffler section away from the vehicle. This completes the removal of the stock system. **(See Fig's E, F, G & H)**



FIG. A



FIG. B



FIG. C



FIG. D



FIG. E



FIG. F



FIG. G



FIG. H

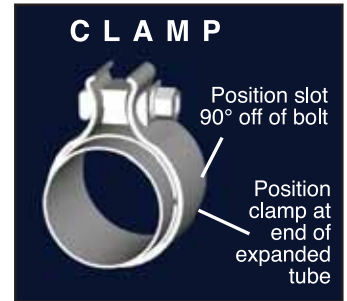
## Installation of CORSA Exhaust System:

**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 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 your vehicle.

- 1) Locate the CORSA headpipe assembly and slide the spherical joint onto the factory pipe. Reuse the factory spherical clamp and loosely snug the spherical joint. Insert the hanger into the factory grommet (**See Fig's J, K & L**)

**Note:** Using a soapy solution on the grommet hole will make the job easier.

- 2) Slide a supplied 3" TORCA clamp over the inlet of the CORSA muffler. Make sure the drain hole is facing down (See figure to the right). Slide the muffler onto the headpipe and pre-tighten the clamp. (**See Fig's M & N**)



**----- FOR DUAL UNDER THE BUMPER, SKIP TO STEP 3 ON PAGE 5. -----**

- 3) Slide a supplied 3" TORCA clamp over the inlet of the CORSA Tailpipe. From the rear of the vehicle slide the pipe over the axle while holding the rear differential vent hose out of the way. Insert the pipe over the muffler exit and place the hangers into the factory grommets. (**See Fig's O, P & Q**)

**Note:** Using a soapy solution on the grommet hole will make the job easier.



FIG. J



FIG. K



FIG. L



FIG. M



FIG. N



FIG. O



FIG. P



FIG. Q

- 4) Slide a 3" TORCA clamp over the tip assembly and place the tip onto the end of the tailpipe. Pre-tighten the clamp at this time. **(See Fig's R & S)**
- 5) Starting from the front of the CORSA exhaust system, tighten the factory spherical clamp to 21 ft-lbs and all TORCA clamps to 45 ft-lbs using a torque wrench.
- 6) Replace the spare tire to the pre-removal condition.
- 7) **It is strongly suggested that all clamps be checked and tightened after road testing the vehicle once the system has cooled.**

**SIDE EXIT INSTALLATION IS COMPLETE.**

**DUAL UNDER THE BUMPER INSTRUCTIONS CONTINUED...**

- 3) Slide a supplied 3" TORCA clamp over the inlet of the CORSA Dual "Y" Assembly and insert over the muffler exit and place the hangers into the factory grommets. Pre-tighten the clamp. **(See Fig's T, U, V & W)**  
**Note: Using a soapy solution on the grommet hole will make the job easier.**



FIG. T



FIG. U



FIG. V



FIG. W

- 4) Slide a 2.5" TORCA clamp over the passenger side tailpipe assembly and place the pipe onto the upper end of the Dual "Y" Assembly and insert the hanger into the factory grommet. Pre-tighten the clamp at this time. **(See Fig's X, Y, Z, & AA)**  
**Note: Using a soapy solution on the grommet hole will make the job easier.**



FIG. X



FIG. Y



FIG. Z



FIG. AA



FIG. R



FIG. S

- 5) Slide a 2.5" TORCA clamp over the "Driver over the axle Pipe" and place the pipe onto the lower end of the Dual "Y" Assembly. Leave the pipe loose at this time for adjustment when placing the driver side tailpipe onto the over the axle pipe. (See Fig's BB, CC, & DD)
- 6) Locate Driver Side tail pipe hanger assembly ("U" shaped Wire Loop & Plate) and hardware (threaded Mounting Plate, bolt and washers) (See Fig. EE). On the driver side of the vehicle, position the threaded rectangular-shaped mounting plate on top of the frame rail over the hole located furthest forward from the rear of the frame rail. (See Fig. FF & GG)
- 7) Insert the supplied 5/16"-18 bolt through the tail pipe Wire Loop & Plate hanger and thread it into the threaded Mounting Plate on top of the frame. **Note: Position the driver side hanger so that it faces toward the spare tire (See Fig. HH)**
- 8) Slide a 2.5" TORCA clamp over the inlet of the drivers side tailpipe and install tail pipe onto the over the axle pipe (See Fig's II, JJ & KK). Insert tail pipe hanger into provided rubber grommet and pre-tighten clamp at this time. **Note: Using a soapy solution on the grommet hole will make the job easier.**
- 9) Locate exhaust tip assemblies and slide 2.5" TORCA clamp over expanded end of tip assembly. With the bolt and nut facing up, snug fit the clamps on each tip assembly. Do not tighten at this time. (See Fig's LL & MM)



FIG. BB



FIG. CC



FIG. DD



FIG. EE



FIG. FF



FIG. GG



FIG. HH



FIG. II



FIG. JJ



FIG. KK



FIG. LL



FIG. MM

- 10) Check the alignment of tail pipes and tips. (See Fig. NN) Make sure there is at least 1.5" clearance between the tips and bottom of the bumper. Align tail pipes if necessary by making adjustments at the slip joints.



FIG. NN

**Recommended Minimum Clearance to Components:**

Distance from Pipe to Fuel Pump Control Module (Fig. OO):	1.6 in. / 40 mm.
Distance from Pipe to Spare Tire (Fig. PP):	2.4 in. / 60 mm.
Distance from Pipe to Shock Absorber Boot (Fig. QQ):	2.4 in. / 60 mm.
Distance from Pipe to Brake Line Sleeve (Fig. RR):	2.4 in. / 60 mm.



FIG. OO



FIG. PP



FIG. QQ



FIG. RR

- 11) Starting from the front of the CORSA exhaust system, tighten the factory spherical clamp to 21 ft-lbs and all TORCA clamps to 45 ft-lbs using a torque wrench. Make sure clamps are positioned and tightened as shown. (See Fig. SS)

- 12) It is strongly suggested that all clamps be checked and tightened if necessary after road testing the vehicle and after the system has cooled.



FIG. SS

**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.