

Please take time to read and understand these installation instructions.

CORSA recommends that installation of this system be performed by an authorized CORSA 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.

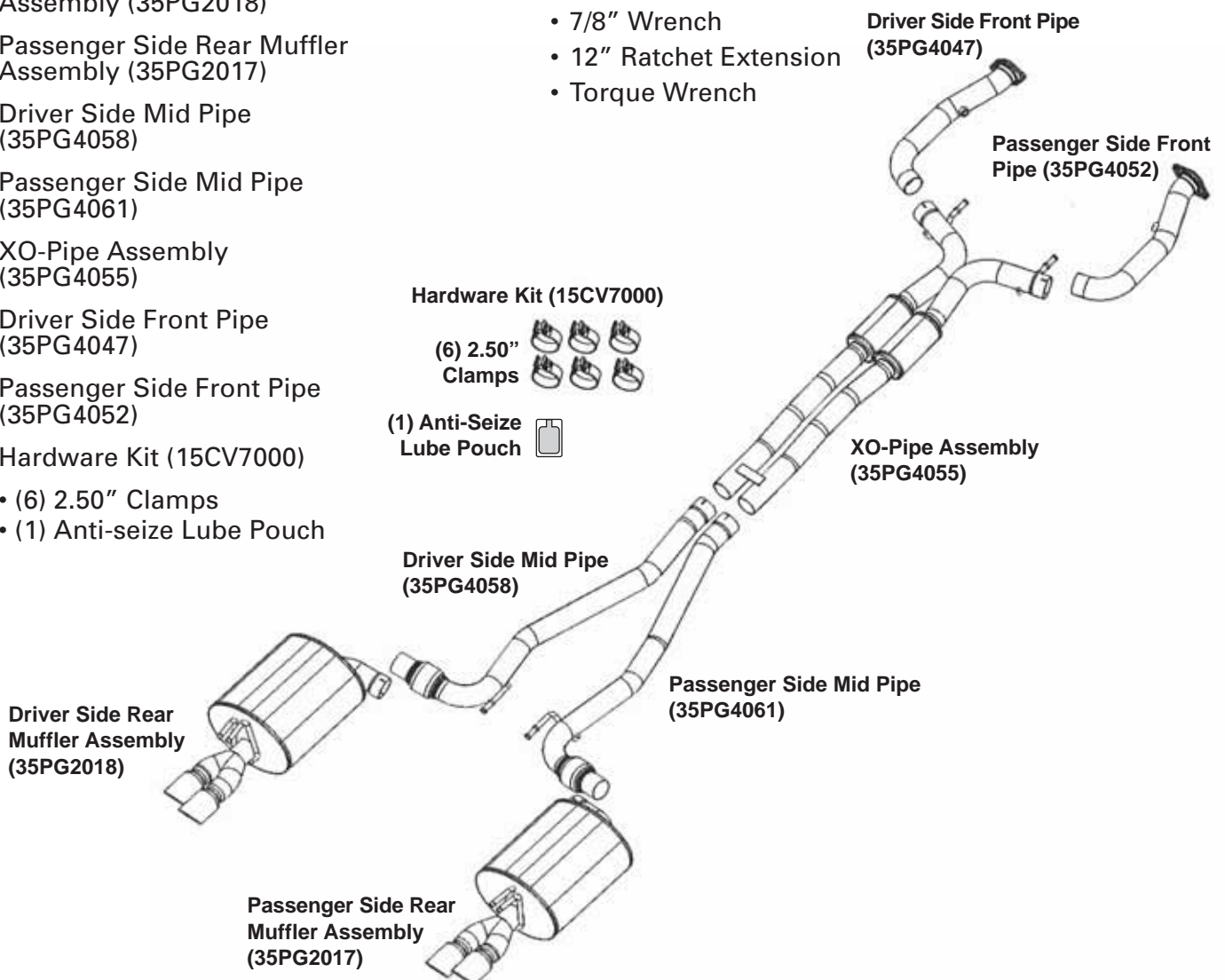
Please confirm that all parts are present before beginning the factory exhaust system removal and CORSA exhaust system installation.

Bill of Materials:

- Driver Side Rear Muffler Assembly (35PG2018)
- Passenger Side Rear Muffler Assembly (35PG2017)
- Driver Side Mid Pipe (35PG4058)
- Passenger Side Mid Pipe (35PG4061)
- XO-Pipe Assembly (35PG4055)
- Driver Side Front Pipe (35PG4047)
- Passenger Side Front Pipe (35PG4052)
- Hardware Kit (15CV7000)
 - (6) 2.50" Clamps
 - (1) Anti-seize Lube Pouch

Recommended Tools:

- Safety Glasses
- 13mm Socket
- 15mm Socket
- Grommet Pullers
- 7/8" Wrench
- 12" Ratchet Extension
- Torque Wrench



Factory Exhaust System Removal:

1. Using a 15mm socket, remove and save the nuts from the driver and passenger flanges near the O2 sensors. **(See Fig. A)**
2. Remove the driver and passenger O2 sensors from the stock pipes with a 7/8" wrench. **(See Fig. B)**
3. Remove and save the four bolts securing the cross brace using a 15mm socket, and set brace aside **(See Fig. C)**. The brace and the bolts will be reinstalled.
4. Remove the flange bolts on the driver and passenger rear mufflers with a 15mm socket. **(See Fig. D)**
5. Using a grommet puller or similar device, remove the hangers beneath the rear sway bar. **(See Fig. E)**

Note: The use of a soapy water solution may aid in the removal and later installation of the hangers in the rubber isolators.

6. While preventing the tips from hitting the rear fascia, lower the flanged end of the rear muffler and remove the hangers from the double grommet **(See Fig. F)**. Repeat on the opposite side and remove the rear mufflers **(See Fig. G)**.
7. The front section of the stock exhaust can be removed after the hangers are pulled from the rubber grommets near the O2 sensors **(See Fig. H)**. The removal of the factory system is complete.



FIG. A



FIG. B



FIG. C



FIG. D



FIG. E



FIG. F



FIG. G



FIG. H

CORSA Exhaust System Installation:

1. Install the xo-pipe section of the Corsa exhaust into the two front hangers (**See Fig. I**), then install the cross brace and torque the bolts to 18 ft-lbs. (**See Fig. J**). This will temporarily support the xo-pipe while you continue the install.
2. Slide a clamp over the inlet expansion of the xo-pipe (**See Fig. K**) and slide the front pipe into the expansion. Do not torque anything yet, but the flange nuts and clamp can be loosely tightened. Repeat step by installing the clamp and front pipe on the other side.
3. Slide clamps over the outlet end of the xo-pipe (**See Fig. L**) and slide the expanded end of the mid-pipe over the xo-pipe, then slide the hanger near the flex coupler into the rubber grommet (**See Fig. M**). Repeat on the other side.
4. Using a 13mm socket on an extension, remove the two bolts to free the rubber grommet that holds the rear mufflers (**See Fig. N**). Paying attention to the orientation (the long tab goes towards the inside of the vehicle), install the grommets onto the hangers of the Corsa rear mufflers (**See Fig. O**).
5. Slide a clamp over the expanded inlet of the rear muffler (**See Fig. P**), and tighten the bolts on the rubber grommet (**See Fig. Q**). Repeat on the other side.



FIG. I



FIG. J



FIG. K



FIG. L



FIG. M



FIG. N



FIG. O



FIG. P



FIG. Q

6. Starting at the front of the vehicle, tightening all the connections while holding the xo-pipe at least 1" off the cross brace. If working alone, a wood block or similar item can be used to hold this distance. Once the system is roughly aligned, torque the front flange bolts to 30ft-lbs. (See Fig. R), reinstall and tighten the O2 sensors (See Fig. S), and torque all clamps to 45ft-lbs (See Fig. T, U, and V).
7. Check clearance around the rear muffler and make adjustments at the clamp joints to properly align.
8. It is **STRONGLY SUGGESTED** that all clamps be checked and tightened if needed after road testing the vehicle once the system has cooled.



FIG. R



FIG. S



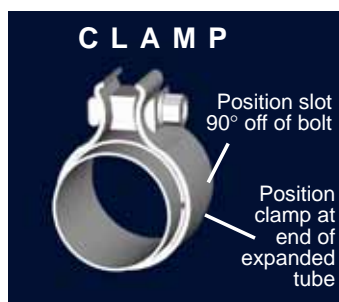
FIG. T



FIG. U



FIG. V



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.