

Please take time to read and understand these installation instructions.

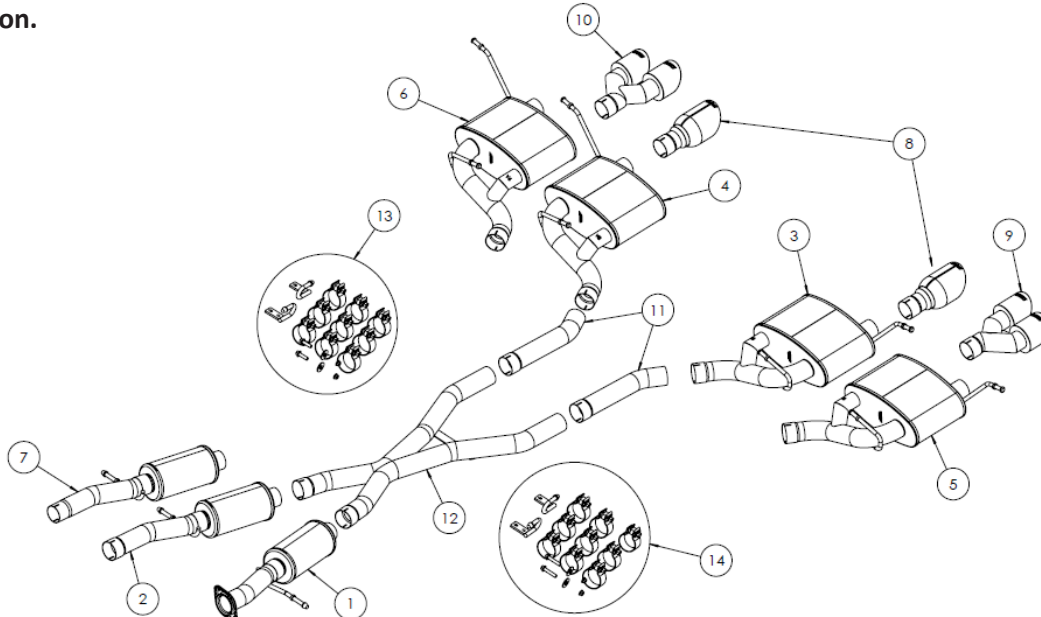
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a lift and an additional person will be required.

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 13mm deep socket
- 3/8" drive 14mm deep socket
- 3/8" drive 15mm deep socket
- 14mm wrench
- Rubber mallet and/or hammer
- Grommet pullers
- Soap and water solution
- Torque Wrench
- Safety glasses

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



14991(BLK) Bill of Materials

1. 17GC2021 – TUNNEL MUFFLER ASSEMBLY – DRIVER
2. 17GC2022 – TUNNEL MUFFLER ASSEMBLY – PASS (V8)
3. 17GC2023 – REAR MUFFLER ASSEMBLY DRIVER (V8)
4. 17GC2024 – REAR MUFFLER ASSEMBLY PASS (V8)
8. 17GC3000 – 4.5" TIP ASSEMBLY (2)
13. 17GC7023 – HARDWARE KIT (V8)

14980(BLK) Bill of Materials

1. 17GC2021 – TUNNEL MUFFLER ASSEMBLY – DRIVER
5. 17GC2053 – REAR MUFFLER ASSEMBLY DRIVER (V6)
6. 17GC2054 – REAR MUFFLER ASSEMBLY PASS (V6)
7. 17GC2056 – TUNNEL MUFFLER ASSEMBLY – PASS (V6)
8. 17GC3000 – 4.5" TIP ASSEMBLY (2)
14. 17GC7038 – HARDWARE KIT (V6)

14992(BLK) Bill of Materials

1. 17GC2021 – TUNNEL MUFFLER ASSEMBLY – DRIVER
2. 17GC2022 – TUNNEL MUFFLER ASSEMBLY – PASS (V8)
3. 17GC2023 – REAR MUFFLER ASSEMBLY DRIVER (V8)
4. 17GC2024 – REAR MUFFLER ASSEMBLY PASS (V8)
9. 17GC3001 – DUAL 4.0" TIP ASSEMBLY – DRIVER
10. 17GC3002 – DUAL 4.0" TIP ASSEMBLY – PASS
13. 17GC7023 – HARDWARE KIT (V8)

14984(BLK) Bill of Materials

1. 17GC2021 – TUNNEL MUFFLER ASSEMBLY – DRIVER
5. 17GC2053 – REAR MUFFLER ASSEMBLY DRIVER (V6)
6. 17GC2054 – REAR MUFFLER ASSEMBLY PASS (V6)
7. 17GC2056 – TUNNEL MUFFLER ASSEMBLY – PASS (V6)
9. 17GC3001 – DUAL 4.0" TIP ASSEMBLY – DRIVER
10. 17GC3002 – DUAL 4.0" TIP ASSEMBLY – PASS
14. 17GC7038 – HARDWARE KIT (V6)

Common to all kits - Bill of Materials

11. 17GC4027 – AXLE PIPE (2)
12. 18DD4019 – X-PIPE ASSEMBLY

Factory Exhaust System Removal:

1. Beginning at the rear of the vehicle on the driver's side, use the 15mm socket and ratchet to loosen and remove the hardware securing the muffler. **(Fig. A)** By pulling up and rearward, separate the rear muffler from the axle pipe. **(Fig. B)**
2. At this point, remove the rear muffler from the factory rubber grommet. This rubber grommet is above the muffler towards the outside of the car vehicle, making access with grommet pullers difficult. It is possible to remove the muffler from the grommet by hand if grommet pullers will not fit into the cavity. **(Fig. C)** After removal, set the muffler aside.
Note: A soap and water solution will aid in removing hangers from rubber grommets.
3. Remove the driver's side axle pipe hanger from the factory grommet **(Fig. D)** Repeat on the passenger's side of the vehicle.
4. At the front of the vehicle, use the 13mm socket and ratchet to remove the two bolts securing the front driver's side hanger bracket to the chassis. Save the bolts for later use when installing the Corsa exhaust system. **(Fig. E)** Repeat on the passenger's side of the vehicle.
5. Using the 14mm socket and ratchet, remove the spring nuts from the factory studs on both the driver's and passenger's side of the vehicle. **(Fig. F)**
6. Carefully remove the factory exhaust system from the vehicle by first pushing the system towards the rear of the vehicle. Once the studs are free of the flanges at the front, slightly lower the front. At this point, remove the passenger's side rear hanger from the grommet above the muffler.
Note: There may be a ground strap between the vehicle frame and the muffler hanger. This strap clips in place and can be easily removed from the muffler.
7. Set the factory exhaust system to the side. Remove the rubber grommets from the sides of the factory tunnel muffler using the grommet pullers. Save the rubber grommets for later use when installing the Corsa exhaust system. **(Fig. G & H)**
Note: A second person helping is necessary during this step due to the size and weight of the factory exhaust.
8. Using the 15mm socket and ratchet, loosen the clamp on the passenger's side of the vehicle near the flange connection. Remove this short connector piece from the vehicle, leaving only a flange on the driver's side.
Note: A penetrating lubricant spray used at this expansion joint may make separating these pipes easier. The use of a rubber mallet or hammer to gently tap the flange rearward may also aid in removal.

This concludes the factory exhaust system removal process.

REMOVAL PICTURES ON NEXT PAGE 

Factory Exhaust Removal Pictures



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E

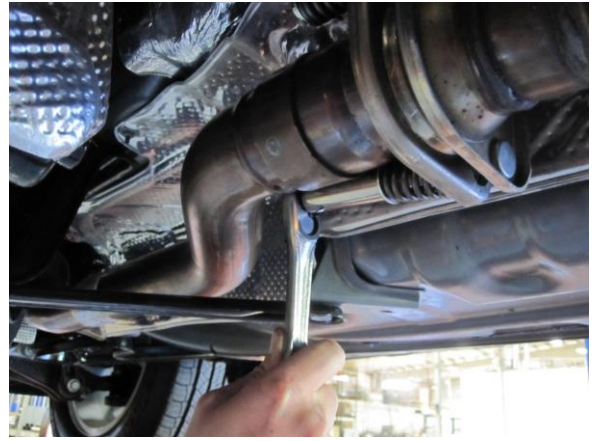


Fig. F

REMOVAL PICTURES CONTINUED ON NEXT PAGE 

Factory Exhaust Removal Pictures



Fig. G

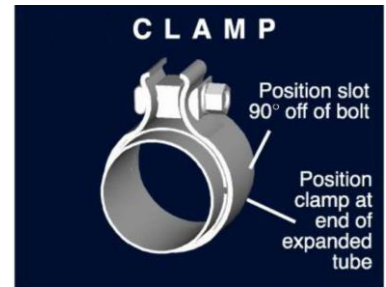


Fig. H

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 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. Begin by removing all exhaust components from the shipping container including the clamps.
2. Locate the two hanger brackets in the hardware kit. Install the rubber grommets saved from Step #7 of the removal process (**Fig. J**) and mount the brackets on the vehicle using the bolts saved from Step #3. (**Fig. K**)
Note: Ensure the U bent hanger is towards the front of the vehicle when mounting!
3. Locate the passenger side tunnel muffler and one of the supplied clamps (2.5" for V8 and 2.25" for V6). Slide a clamp over the expanded end of the muffler with the bolt opposite the hanger. Slide the expanded end of the muffler over the passenger side front exhaust pipe. (**Fig. L**) Insert the muffler hanger into the grommet. (**Fig. M**).
Note: The use of a soap and water solution may aid in working with the rubber grommets.
4. Locate the two bolts, two nuts, and two washers from the hardware kit along with the driver's side tunnel muffler. Begin by inserting the hanger into the rubber grommet. Slide the bolts into the holes of the flange on the tunnel muffler such that the bolt head is towards the rear of the vehicle, followed by a washer, then the nut on the front side of the factory flange. (**Fig. N**) Hand tighten both nuts and bolts.
5. Locate the XO pipe assembly and two more of the supplied 2.5" clamps. Slide the clamps over the expanded end of the XO pipe such that the bolts are towards the inside and then slide the expanded ends of the XO pipe over the outlets of the tunnel mufflers. (**Fig. P**) Ensure the flat bracket on the XO pipe is towards the ground. Snugly tighten the clamp on the passenger tunnel muffler and the two clamps on the XO pipe using the 15mm socket and ratchet.
Note: At this point, the XO pipe assembly needs supported using a suitable device.
6. Locate the two axle pipes and two more of the supplied 2.5" clamps. Slide the clamps over the expanded ends of the axle pipes and slide them over the outlet ends of the XO pipe. (**Fig. Q**) The plane of the bend on the axle pipe should be roughly parallel to the ground. Once the axle pipes are rotated correctly, snugly tighten them using the 15mm socket and ratchet.

INSTALLATION INSTRUCTION CONTINUED ON NEXT PAGE



Installation of CORSA Exhaust System:

7. Locate the passenger side rear muffler assembly and one of the 2.5" clamps. Slide the clamp over the expanded end of the muffler with the clamp bolt towards the hanger (**Fig. R**) and slip it over the outlet end of the axle pipe elbow. Insert the rear hanger into the grommet located up high and inside the bumper towards the outside of the vehicle (**Fig. S**) and then insert the hanger into the grommet at the front of the muffler. Snugly tighten the muffler using the 15mm socket and ratchet. Lastly, attach the ground strap to the rear hanger. Repeat this step for the driver side of the vehicle.
8. These installation instructions show the installation of the Summit Edition tips found with Corsa P/N's 14992 & 14984. For Corsa P/N's 14991 & 14980, the single tip assemblies are the same for both the driver's and passenger's side and the installation of the single tip assemblies is done by following the same process. Locate the remaining two clamps and the tip assemblies. Beginning on the passenger side, slide the 2.5" clamp over the tip such that the clamp is toward the outside of the vehicle and the bolt is vertical. Slide the expanded end of the tip over the muffler outlet and snugly tighten with the 15mm socket and ratchet. Repeat this step for the driver side of the vehicle.
9. Visually inspect and adjust the exhaust system position, tip alignment, and clamp orientation to maintain clearance to the undercarriage and heatshields. Once satisfied, tighten all clamps to 45lb-ft using the 15mm socket and torque wrench.
10. **It is strongly suggested** that all clamps be checked and the system be adjusted if necessary after initial road testing of the vehicle as thermal cycling has occurred on the system. Please wait until the system has fully cooled before performing this step.

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.

INSTALLATION PICTURES ON NEXT PAGE



CORSA Exhaust Installation Pictures



Fig. J



Fig. K



Fig. L



Fig. M



Fig. N



Fig. P

INSTALLATION PICTURES CONTINUED ON NEXT PAGE



CORSA Exhaust Installation Pictures



Fig. Q



Fig. R



Fig. S



Fig. T