



IMPORTANT WARRANTY & INSTALLATION  
INSTRUCTIONS ATTACHED

*Please Forward All Attached Information to Consumer  
Warranty Not Valid Unless Returned to CORSA Exhaust*



Please take time to read and understand these installation instructions.

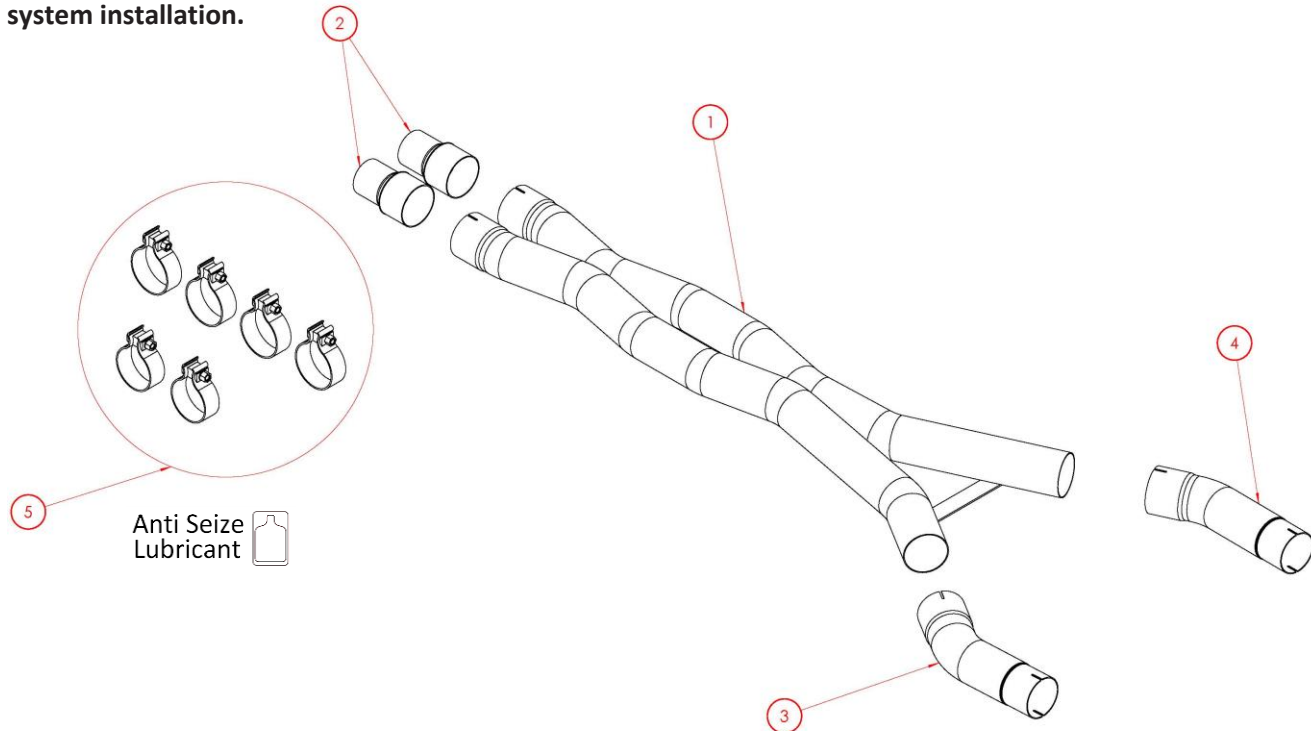
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

**CAUTION:** Never work on a hot exhaust system. Allow time for the vehicle to cool. Always wear eye protection when working under a vehicle.

## Recommended Tools:

- 3/8" drive ratchet
- 3/8" drive torque wrench
- 3/8" drive 15mm deep socket
- Tape measure & Marker
- Saw or chain-style pipe cutter
- File or sanding device for de-burring
- Soap and water solution
- Torque Wrench
- Penetrating lubricant spray
- Safety glasses

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



### Bill of Materials

1. 20MU4078 – Double Helixx X-Pipe Assembly
2. 20MU4154 – X-Pipe Inlet Adapter – GT350
3. 20MU4156 – X-Pipe to Stock AB Adapter - Driver
4. 20MU4157 – X-Pipe to Stock AB Adapter – Pass
5. 20MU7036 – Hardware Kit

### **Factory Exhaust System Removal:**

1. Starting on the driver side, measure 14 ¼" away from the end of the tunnel resonator heat shield on the stock resonator, following the inside profile of the exhaust pipe, and mark the pipe. **(Fig. A & B)** The tape measure should follow the bend profile of the pipe. Next, on the passenger side, measure 14 ¼" away from the end of the tunnel resonator heat shield on the stock resonator following the inside profile of the exhaust pipe, and mark the pipe. **(Fig. C)** Again, the tape measure should follow the bend profile of the pipe. Using a chain cutter or similar device, cut both the driver and passenger side exhaust pipes at the marked locations. **(Fig. D)** Place an adjustable stand or similar device under the stock tunnel section of the exhaust for support. Once the axle pipes are cut, there are no additional stock hangers supporting the tunnel section.
  2. Slide the now cut rear muffler assemblies as far rearward as allowable. Using a 15mm deep socket and 3/8" drive ratchet loosen the two sleeve clamps at the cat-back connection point. **(Fig. E)** Both nuts must be loosened in order for the clamp to fully disengage. Slide the stock x-pipe rearward and remove it from the vehicle. **(Fig. F)**
- NOTE:** The use of a soap and water solution on the rear axle pipe and muffler hangers may aid in sliding the rear muffler assemblies rearward
3. **IMPORTANT:** Carefully and thoroughly de-burr the stock driver and passenger muffler inlet pipes from any burrs and sharp edges. This is important as any burrs will prevent the x-pipe outlet to stock adapters from sliding over the stock exhaust pipes.

This concludes the factory exhaust system removal.

**REMOVAL PICTURES ON NEXT PAGE** 

Factory Exhaust System Removal Pictures:



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E

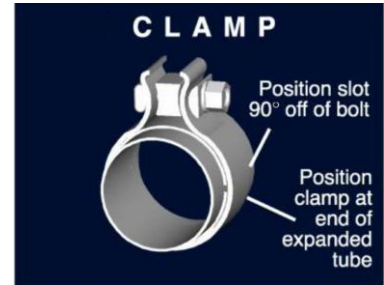


Fig. F

## 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. Remove all exhaust system components from the shipping boxes, including clamps and hardware.
2. Locate the two x-pipe inlet adapters. Confirm the factory sleeve clamps at the cat-back connection point are positioned correctly and slide the adapters into the factory sleeve clamps. **(Fig. G)** Tighten the clamps using the ratchet and 15mm deep socket, until the adapters are snug in the clamps.
3. Locate the double helixx x-pipe and two 3" clamps. Install the clamps on the driver and passenger inlets so that the bolts are vertical with the nut towards the ground and the bolts towards the outside of the vehicle. **(Fig. H)** Slide the x-pipe inlets over the x-pipe adapter outlets. **(Fig. I)** Position the x-pipe so that the x-pipe cross brace located at the rear of the x-pipe is facing down and is parallel with the ground, and the x-pipe outlets are centered around the differential. Tighten the clamps using a ratchet and 15mm deep socket, until the x-pipe is snug on the adapters. **(Fig. J)** Place a jack stand or similar device under the x-pipe for support. **(Fig. K)**
4. Using a permanent marker measure and mark 1-5/8" from both the driver and passenger side x-pipe outlets. **(Fig. L)** Locate the driver and passenger x-pipe outlet adapters, two 3" clamps and two 2 3/4" clamps. Install the 3" clamps on the expanded end of the adapter so that the bolts are vertical with the nuts towards the ground and both bolts are towards the center of the vehicle. Install the 2 3/4" clamps on the swaged outlet end of the adapters so that the bolts are vertical with the nuts towards the ground and the bolts towards the outside of the vehicle. Slide the expanded end of the adapters over the corresponding x-pipe outlet until the adapters bottom out with the adapter bend towards the ground. **(Fig. M)**

**NOTE:** The adapters need to be bottomed out to gain the necessary clearance for the following step #5. It is critical to slide the adapters to the previously marked location after step #5.

INSTALLATION INSTRUCTIONS CONTINUED ON NEXT PAGE



5. **THE HELP OF A SECOND PERSON MAY BE NEEDED FOR THIS STEP.** Rotate the driver and passenger side adapters so that the straight after the bend is in the same plane as the last straight of the corresponding driver and passenger side x-pipe outlets. Slide the stock axle pipes into the rear adapter outlets. **(Fig. N)**
6. Slide the driver side and passenger side adapters up to point marked in step #4. Snug the 3" clamps on the adapter inlets using a 15mm deep socket and ratchet. **(Fig. O)**
7. Adjust the depth of the rear muffler assemblies by sliding the stock axle pipes further into the adapter outlet until a 1-7/8" overlap is achieved. Using a 15mm deep socket and 3/8" drive ratchet snug the 2 3/4" clamps at the adapter outlet end.
8. Adjust the system accordingly. The depth of the system can be adjusted slightly at the stock to double x-pipe adapter and x-pipe inlet connection point; as well as at the rear adapter and stock axle pipe connection point. The connection point at the x-pipe outlet and rear adapters will control the toe of the rear mufflers and will help center the muffler outlet pipes with the valance bezel. Verify the exhaust tips are centered in the bumper valance bezels after all adjustments are made. Check clearances between the system components and chassis. **(Fig. P & Q)** At this time, tighten all clamps to 45ft-lbs using the torque wrench and 15mm socket.

**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 Installation Pictures

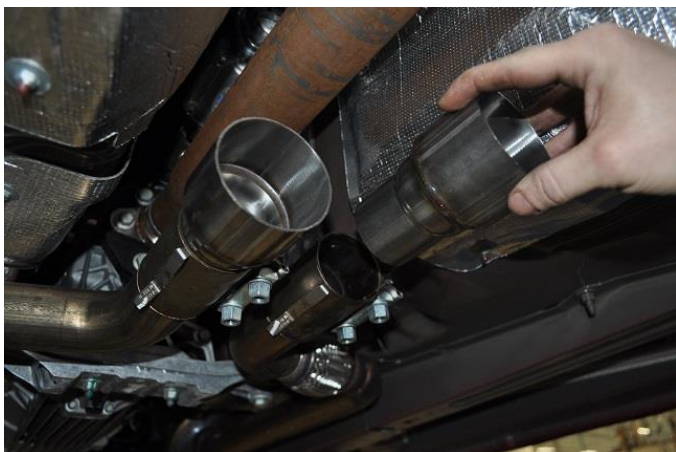


Fig. G



Fig. H



Fig. I

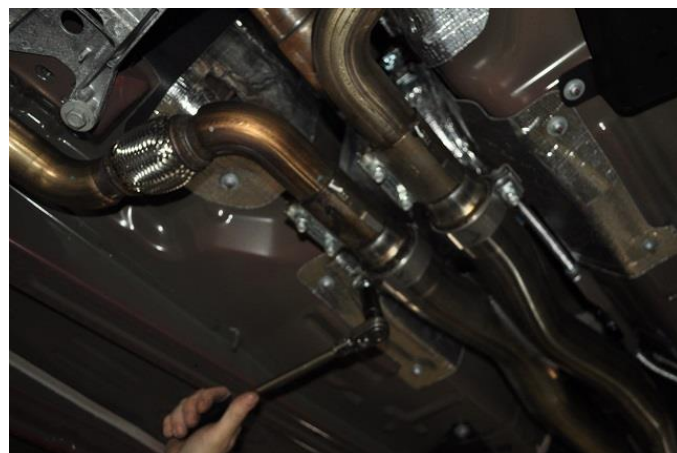


Fig. J



Fig. K

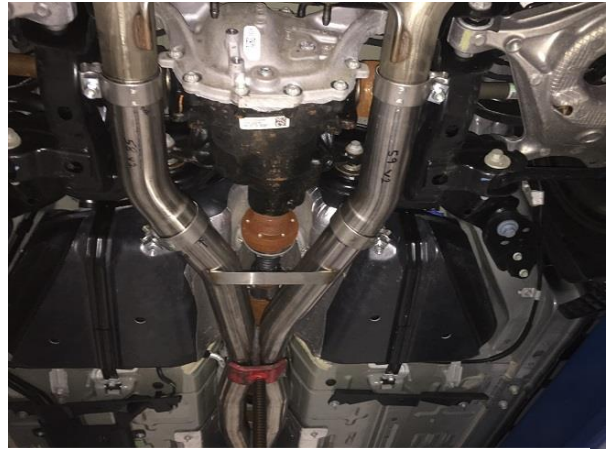


Fig. L

**CORSA Installation Pictures**



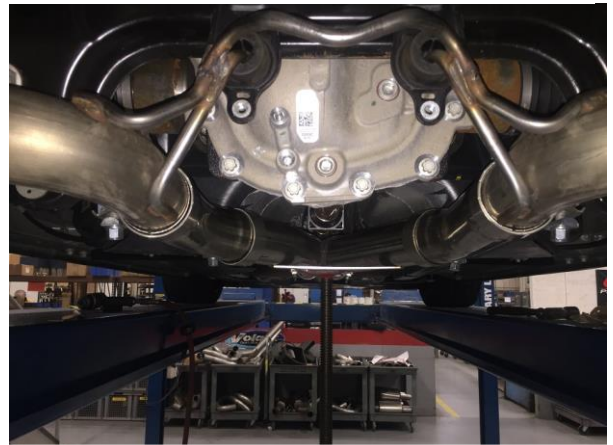
**Fig. M**



**Fig. N**



**Fig. O**



**Fig. P**



**Fig. Q**