



IMPORTANT WARRANTY & INSTALLATION
INSTRUCTIONS ATTACHED

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

We ask that you take a few moments to complete our warranty registration form:

TO ACTIVATE YOUR LIMITED LIFETIME WARRANTY GO TO:
CORSAPERFORMANCE.COM/WARRANTY



**For Full-Color Installation Instructions, Please Visit:
CORSAPERFORMANCE.COM and Search by Part Number**

Please be sure to review the enclosed instructions prior to beginning the installation process. If you have any questions about the enclosed parts, instructions or encounter a problem during installation:
CALL CORSA PERFORMANCE TECHNICAL ASSISTANCE AT 800.486.0999

Please take time to read and understand these installation instructions.

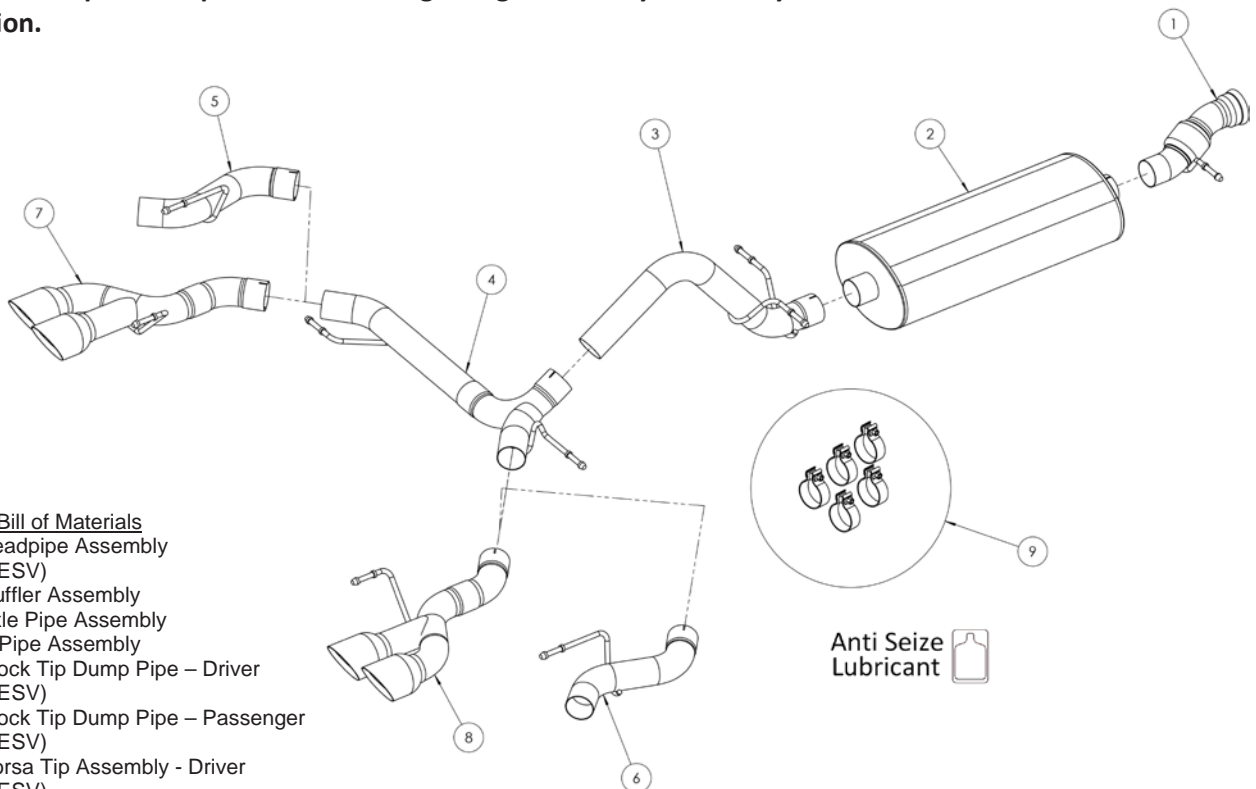
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

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 13mm deep socket
- 3/8" drive 15mm deep socket
- 3/8" drive 10mm shallow socket
- 3/8" drive swivel
- 1/4" drive ratchet
- 1/4" drive 7mm socket
- 1/4" 6" extension
- Grommet pullers
- Soap and water solution
- Permanent Marker
- Tape measure
- 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. 15CE4043 – Headpipe Assembly
(15CE4044 for ESV)
2. 16SE2027 – Muffler Assembly
3. 15CE4050 – Axle Pipe Assembly
4. 15CE4051 – Y-Pipe Assembly
5. 15CE4055 – Stock Tip Dump Pipe – Driver
(15CE4071 for ESV)
6. 15CE4059 – Stock Tip Dump Pipe – Passenger
(15CE4070 for ESV)
7. 15CE3007 – Corsa Tip Assembly - Driver
(15CE3009 for ESV)
8. 15CE3006 – Corsas Tip Assembly - Passenger
(15CE3008 for ESV)

Factory Exhaust System Removal:

1. Using the 3/8" ratchet and 13mm deep socket, loosen the clamp on the spherical joint at the front of the headpipe. **(Fig. A)**
2. Using the 3/8" ratchet and 15mm deep socket, loosen the clamp on the inlet pipe to the rear muffler. **(Fig. B)**
3. Using grommet pullers or a similar device, remove the rubber grommet from the rear hanger for the driver side tip pipe. **(Fig. C)** Repeat for passenger side. **(Fig. D)**
NOTE: The use of a soap and water solution may aid in the removal of hanger grommets.
4. Using grommet pullers or a similar device, remove the rubber grommet from the hanger on the driver side of the rear muffler. **(Fig. E)** Repeat for the hanger at the end of the axle pipe. **(Fig. F)**
NOTE: The use of a soap and water solution may aid in the removal of hanger grommets.
5. Remove the factory rear muffler by twisting then pulling it off of the axle pipe. **(Fig. G and H)**
NOTE: The use of a penetrating lubricant spray on the pipe joint may aid in removal.
6. Using grommet pullers or a similar device, remove the three hanger grommets from the tunnel muffler. There are two at the rear of the muffler and one in front near the flex pipe. **(Fig. I, J and K)**
NOTE: Once these hanger grommets are removed, there will be nothing supporting the exhaust system. Take care when removing these hanger grommets. Use a jack stand or similar device to support the system.
7. Remove the stock system from the vehicle. **(Fig. L)** Keep the stock clamp on the head pipe for use in the installation of the Corsa system.

IF YOU ARE INSTALLING THE CORSA TIP ASSEMBLIES, PROCEED WITH REMOVAL STEP 8. IF YOU ARE UTILIZING THE STOCK BUMPER MOUNTED TIPS, SKIP AHEAD TO THE INSTALLATION SECTION OF THESE INSTRUCTIONS.

8. Using the 3/8" ratchet and 10mm shallow socket, remove the bolt under the bumper to the inside of the stock driver side tip. **(Fig. M)** Keep this bolt. It is to be reinstalled after stock tip is removed.
9. Using the 1/4" ratchet with 6" extension and 7mm socket, remove the three bolts holding the stock driver side tip in place. There is one bolt on the inboard side **(Fig. N)** and there are two bolts on the outboard side. **(Fig. O and P)** The tip will slide out towards the front of the vehicle.
10. With the tip removed, reinstall the bolt retained in step 8.
11. Repeat steps 8, 9 and 10 on the passenger side stock tip.

REMOVAL PICTURES ON NEXT PAGE 

Factory Exhaust System Removal Pictures:



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

Factory Exhaust System Removal Pictures:



Fig. G



Fig. H



Fig. I



Fig. J



Fig. K



Fig. L

Stock Tip Dump Removal Pictures:



Fig. M



Fig. N



Fig. O

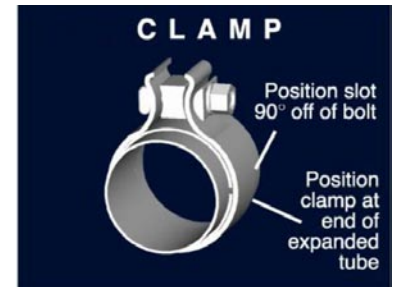


Fig. P

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 the clamps and hardware.
2. Locate the head pipe assembly and the clamp retained in step #7 of the removal process. Orient the clamp so the bolt is towards the passenger side of the vehicle and towards the ground. **(Fig. Q)**
3. Insert the head pipe hanger in the rubber grommet. **(Fig. R)** The part of the hanger running through the grommet should be roughly parallel to the ground.
NOTE: The use of a soap and water solution may aid in the installation of hangers.
4. Using the 3/8" ratchet and 13mm deep socket, tighten the clamp until the head pipe is snug with the stock exhaust pipe. **(Fig. S)**
5. Locate the muffler assembly and one of the 3" clamps. Orient the clamp on the inlet of the muffler so the bolt is vertical with the nut towards the ground and the bolt is towards the driver side of the vehicle. **(Fig. T)**
6. Slide the muffler inlet pipe onto the outlet of the head pipe. **(Fig. U)** Using the 3/8" ratchet and 15mm deep socket, tighten the clamp until the muffler is snug on the head pipe. **(Fig. V)**
NOTE: Support muffler with jack stand or similar device.
7. Locate the axle pipe assembly and one of the 3" clamps. Orient the clamp so that the bolt is vertical with the nut towards the ground and the bolt towards driver side of the vehicle. **(Fig. W)**

INSTALLATION INSTRUCTIONS CONTINUED ON NEXT PAGE



8. Slide the axle pipe over the outlet of the muffler. **(Fig. X)** Insert the driver side hanger into the rubber grommet. **(Fig. Y)** Repeat for the passenger side hanger.
9. Using the 3/8" ratchet and 15mm deep socket, tighten the clamp so the axle pipe is snug on the outlet of the muffler. **(Fig. Z)**
10. Locate the Y-pipe assembly and one of the 3" clamps. Orient the clamp so the bolt is vertical with the nut towards the ground and the bolt towards the long leg of the Y-pipe. **(Fig. AA)**
11. Insert the passenger side hanger into the rubber grommet. **(Fig. BB)** Insert the driver side hanger into its corresponding rubber grommet. **(Fig. CC)**
NOTE: The use of a soap and water solution may aid in the installation of hangers.
12. Slide the Y-pipe onto the axle pipe. Using the 3/8" ratchet and 15mm deep socket, tighten the clamp until the Y-pipe is snug on the axle pipe. **(Fig. DD)**

IF YOU ARE UTILIZING THE STOCK BUMPER MOUNTED TIPS CONTINUE WITH STEP 13. IF YOU ARE INSTALLING THE CORSA TIP ASSEMBLIES, SKIP TO INSTALLATION STEP 17.

13. Locate the passenger side stock tip dump pipe and one of the 3" clamps. Orient the clamp so the bolt is vertical with the nut towards the ground and the bolt towards the outside of the vehicle. **(Fig. EE)**
14. Insert the hanger into the rubber grommet. **(Fig. FF)**
NOTE: The use of a soap and water solution may aid in the installation of hangers.
15. Slide the stock tip dump pipe onto the Y-pipe. Using the 3/8" ratchet and 15mm deep socket, tighten the clamp until the stock tip dump pipe is snug on the Y-pipe. **(Fig. GG)**
16. Repeat steps 13, 14 and 15 for the driver side of the vehicle.
NOTE: SKIP TO INSTALLATION STEP 21.
17. Locate the driver side CORSA tip assembly and one of the 3" clamps.
18. Insert the hanger into the rubber grommet. **(Fig. HH)**

INSTALLATION INSTRUCTIONS CONTINUED ON NEXT PAGE 

19. Place the clamp on the inlet end of the tip assembly. Orient the clamp so the bolt is vertical with the nut towards the ground and the bolt towards the outside of the vehicle. **(Fig. II)** Slide the tip assembly onto the Y-pipe. Using the 3/8" ratchet and 15mm deep socket, tighten the clamp until the tip assembly is snug on the Y-pipe. **(Fig. JJ)**
20. Repeat steps 17, 18 and 19 for the passenger side of the vehicle.
21. Adjust the system accordingly so that the tips are centered in the bumper valence. 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. Q



Fig. R



Fig. S



Fig. T



Fig. U



Fig. V

CORSA Installation Pictures



Fig. W

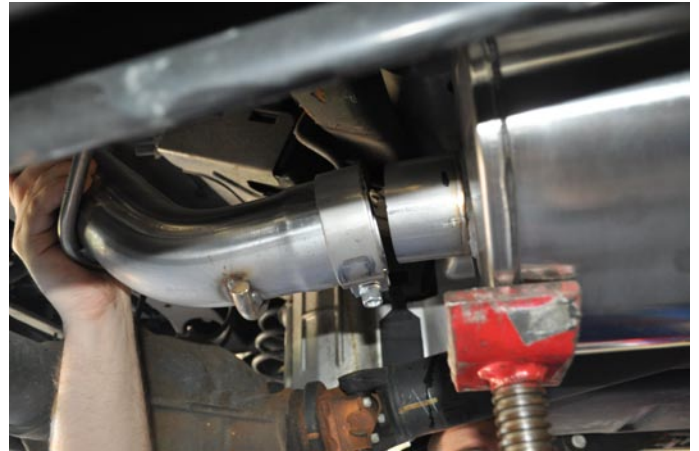


Fig. X



Fig. Y



Fig. Z



Fig. AA

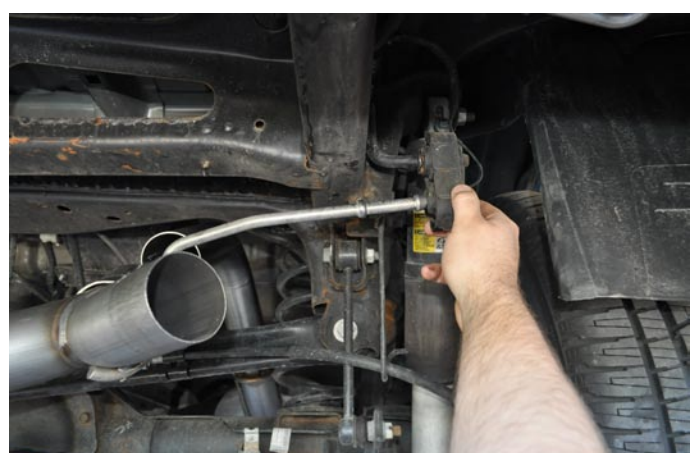


Fig. BB

CORSA Installation Pictures



Fig. CC



Fig. DD



Fig. EE



Fig. FF



Fig. GG

CORSA Tip Assembly Installation Pictures



Fig. HH



Fig. II

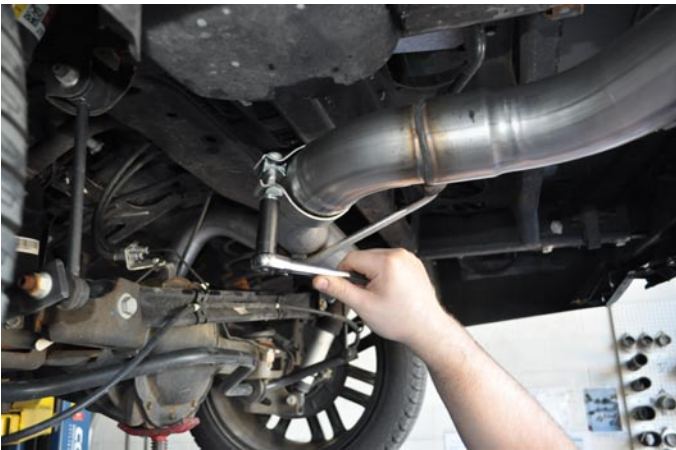


Fig. JJ