

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.

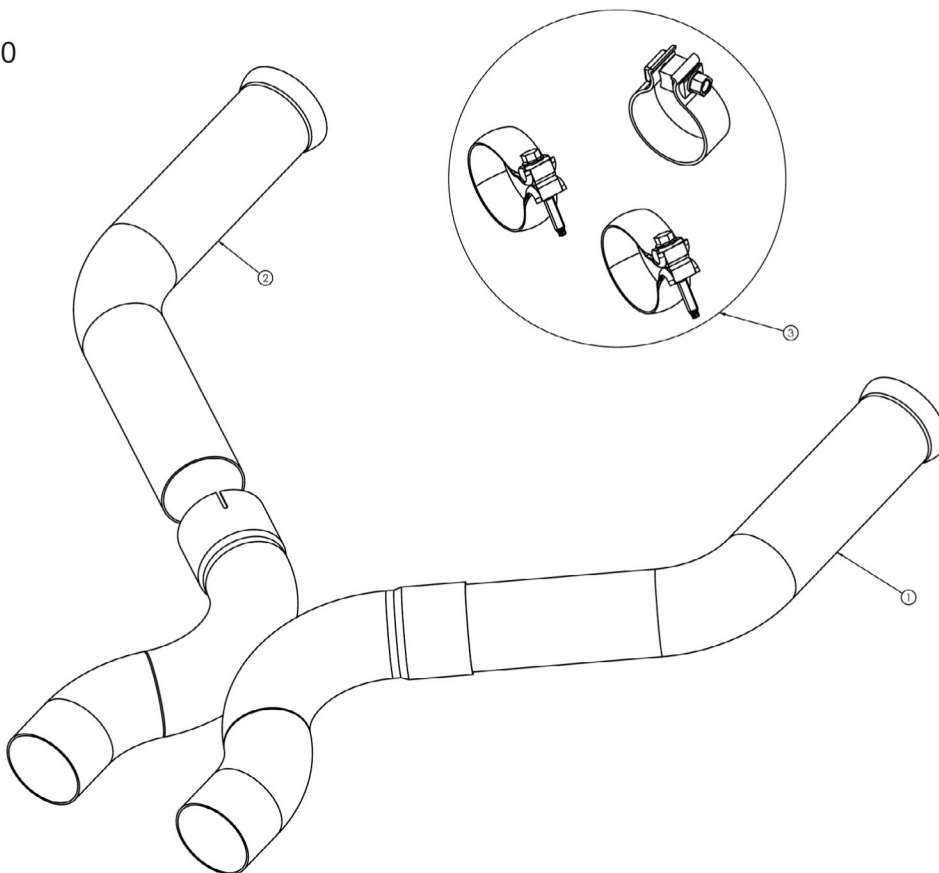
Recommended Tools:

Safety glasses, Torque wrench, 15mm socket or wrench, 13mm socket or wrench, Flat head screwdriver

PN 14318

Bill of Materials

- 1 XO-Pipe Assembly - 20MU4030
- 2 Front Pipe - 20MU4028
- 3 Hardware Kit - 20MU7017
 - One 2.75" Torca clamp
 - Two 70mm spherical clamps



Stock Exhaust Removal:

1. Using a 13mm socket or wrench, loosen the spherical clamps at the inlet of the h-pipe on the passenger side and driver side (**See Fig. A**).

NOTE: Some vehicles shipped with the bolt head facing away from the ground. Using an open-end wrench to loosen and then turning the threaded end by hand will make this difficult to access clamp easier to remove.

2. Using a 15mm socket or wrench, loosen the clamps (4 bolts) after the h-pipe assembly (**See Fig. B**).

3. On the driver side, use a flat screwdriver to pry the clamp spring clip from the retainer pin on the h-pipe (**See Fig. C**). Repeat on passenger side.

4. Slide both clamps towards the rear of the vehicle to free the end of the h-pipes (**See Fig. D**).

5. Pull the front of the h-pipe from the clamp joint on both sides (**See Fig. E**), and slide the outlet ends from the clamps to complete removal (**See Fig. F**).

NOTE: The clamps on the outlet end are reused, so if they stick to the h-pipe assembly as shown in (**Fig. F**); remove and re-install onto the axle pipes.



Fig. A



Fig. B



Fig. C

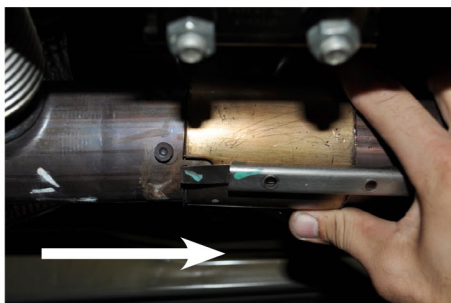


Fig. D



Fig. E



Fig. F

Installation of CORSA Exhaust System:

1. Remove all exhaust components from the shipping cartons, including clamps. **NOTE:** There are two 70mm spherical clamps and one 2.75" clamp supplied.

NOTE: Apply the anti-seize lubricant (supplied) to the threads **ONLY** of all the clamps. Failure to follow this procedure can cause nuts to seize on clamps and potentially destroy threads.

NOTE: Align all clamps so that the center of the clamp bolt is 90 degrees from the notch in the pipe (See Fig. G)

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.

2. Pre-assemble the XO-pipe assembly with: the separate pipe on the driver side, the flat 2.75" clamp over the expansion, and one 70mm spherical clamp on each end. Align the clamps so that they are accessible when installed as shown (See Fig. H).

3. Slide outlet of XO-pipe into the clamps at the inlet of the axle pipes (See Fig. I).

4. Seat the front flare of the XO-pipe on the passenger side to the stock mating pipe (See Fig. J), and repeat on driver side.

5. With clamps in place, hold xo-pipe assembly parallel to the ground and tighten the front spherical clamps to 21 lbs-ft. (See Fig. K).

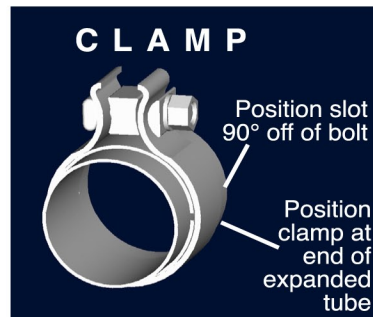


Fig. G



Fig. H



Fig. I



Fig. J

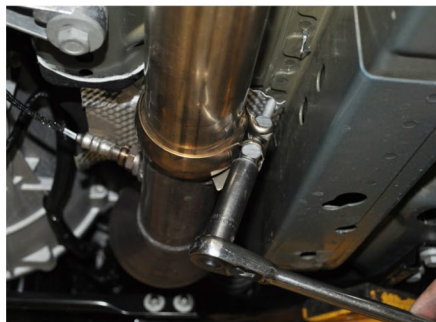


Fig. K

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6. Slide rear clamps forward so that rear edge is approximately centered between the two holes in the axle pipe bracket (**See Fig. L**), and using a 15mm socket tighten the 4 bolts on the rear clamps and the 2.75" clamp on the driver side of the xo-pipe, all to 45 lbs-ft. (**See Fig. M**).

NOTE: If installing Corsa Axle-back system, do not tighten rear clamps at this time. See installation instructions for the axle-back kit to continue.

10. It is **STRONGLY SUGGESTED** that all clamps be checked and re-tightened (if necessary) to the recommended torque after initial road testing of the vehicle, as thermal cycling has occurred on the system. Please wait until the system has fully cooled to perform 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.

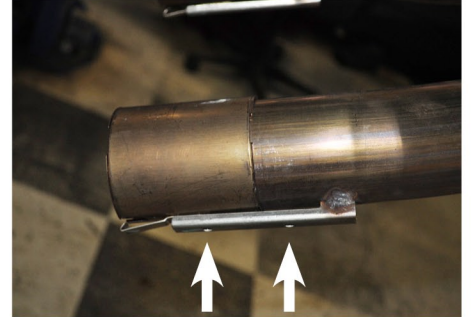


Fig. L



Fig. M