



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.

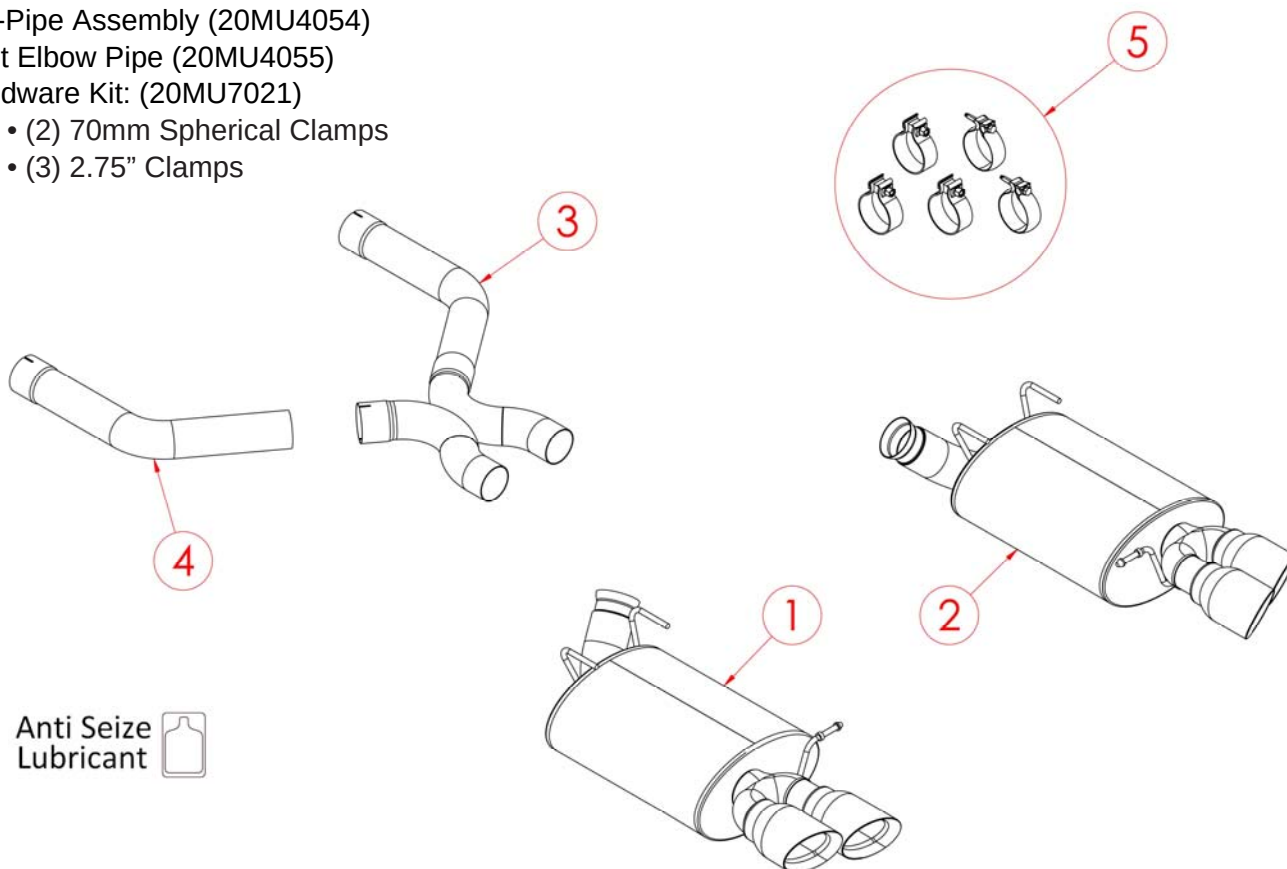
Recommended Tools:

- | | | |
|--|------------------------|--------------------|
| • Safety Glasses | • 18mm Socket | • Torque Wrench |
| • Saw or Chain Style Pipe Cutter | • 13mm Socket | • 3/8" Ratchet |
| • File or sanding device for Deburring | • 15mm Socket | • Flat Screwdriver |
| | • Soapy Water Solution | |

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

Bill of Materials:

- 1 - Driver Side Rear Muffler Assembly (20MU2054)
- 2 - Pass Side Rear Muffler Assembly (20MU2055)
- 3 - XO-Pipe Assembly (20MU4054)
- 4 - Inlet Elbow Pipe (20MU4055)
- 5 - Hardware Kit: (20MU7021)
 - (2) 70mm Spherical Clamps
 - (3) 2.75" Clamps



CROSSOVER PIPE SECTION:

Factory H-Pipe Removal:

1. Mark both of the stock after-cat pipes at 3.125 inches upstream from the front edge of the transmission cradle. This point is just downstream of the after cat oxygen sensor locations. **(See Fig. A)** This mark will be your cut line.
2. Using a saw or chain style pipe cutter, cut both after-cat pipes at the marks. **(See Fig B)**
3. Using a 15mm socket and a 3/8" ratchet, loosen the four nuts on the factory sleeve clamps located just after the factory H-pipe assembly. **(See Fig. C)**
4. On the driver side, use a flat screwdriver to pry the clamp spring clip up from the retainer pin on the factory H-pipe assembly. **(See Fig. D)** Repeat for the passenger side.
5. Slide both factory sleeve clamps toward the rear of the vehicle to free the outlet end of the factory H-pipe. **(See Fig. E)** Remove the factory H-pipe section from the vehicle.
6. Deburr the cut edge of the retained factory after-cat pipes using a file or sanding device. This will aid in the installation process.

H-PIPE REMOVAL PICTURES ON NEXT PAGE 

Factory H-Pipe Removal Pictures:



Fig. A



Fig. B



Fig. C

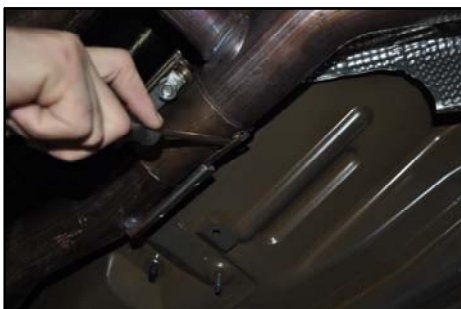


Fig. D

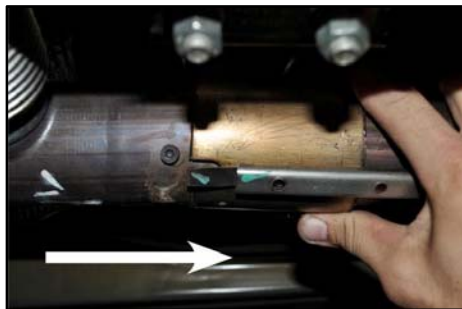
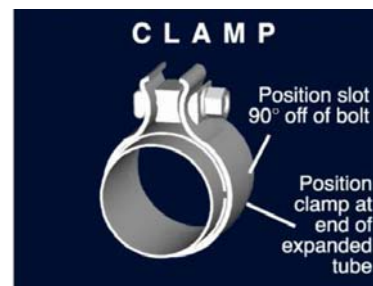


Fig. E

Installation of CORSA Crossover Pipe:

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 shipping carton, including the five supplied clamps.
2. Pre-assemble the CORSA XO-pipe assembly, with the three 2.75" clamps installed and positioned onto each expansion as shown. The separate inlet elbow pipe goes to the driver side, and all three clamp bolts will be facing downwards when installed. (See Fig. F)
3. Slide the inlet of the XO-pipe assembly onto the passenger side after-cat pipe first, and then repeat for the inlet elbow pipe on the driver side after-cat pipe. (See Fig. G) Next, position the XO-pipe inlet so that it has around 1.75" of overlap onto the factory passenger side after-cat pipe, and then snug this clamp using a 15mm socket and ratchet, leaving it loose enough for later adjustment. (See Fig. H)
4. Install both axle pipe inlets onto the XO-pipe outlets as shown. (See Fig. I) Slide the factory sleeve clamps forward so that their rear edge is approximately centered between the two holes in the axle pipe bracket. (See Fig. J) Next, snug tighten the four nuts on the factory sleeve clamps using a 15mm socket and ratchet. (See Fig. K)
5. Position the inlet elbow pipe to also have 1.75" of overlap onto the factory driver side after-cat pipe, and then snug tighten both remaining 2.75" clamps on each end of this pipe. (See Fig. L)
6. Proceed at this time to the rear muffler removal section.

CROSSOVER PIPE INSTALLATION PICTURES ON NEXT PAGE 

CORSA Crossover Pipe Installation Pictures



Fig. F



Fig. G



Fig. H



Fig. I

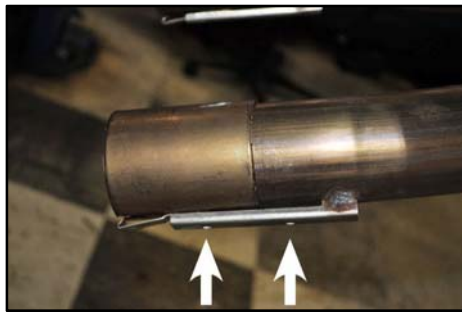


Fig. J



Fig. K

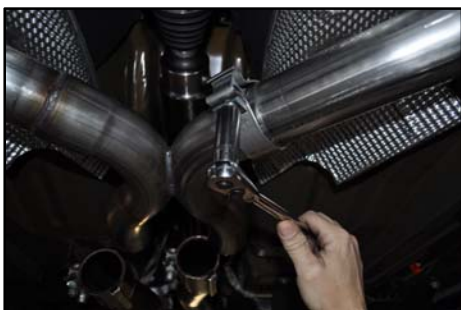


Fig. L

REAR MUFFLER SECTION:

Factory Rear Muffler Removal:

1. Using a 13mm socket and a 3/8" ratchet, loosen the two spherical clamps at the inlet of each of the factory rear mufflers. **(See Fig. M)**
2. Using a 15mm socket and ratchet, loosen the four nuts on the factory sleeve clamps located just after the factory H-pipe assembly. **(See Fig. N)**
3. Using a 15mm socket and ratchet, remove the two bolts that secure the driver side of the panhard bar to the chassis. **(See Fig. O)** Using an 18mm socket and ratchet, loosen, but do not remove, the bolt securing the passenger side of the panhard bar to the chassis; **(See Fig. P)** this will allow the bar to rotate freely. Rotating the bar downward on the driver side will create additional room, which allows the driver side rear muffler to be removed with less difficulty.
4. Remove the driver side rear muffler hanger using grommet pullers or a similar device. **(See Fig. Q)**

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

5. Pull the driver side axle pipe away from the clamp joint at the rear muffler inlet. **(See Fig. R)** While holding the axle pipe out of the way, move the muffler forward in the chassis to remove the two front hangers from the grommet. **(See Fig. S)** Carefully remove the muffler from the vehicle.
6. Repeat steps 4-5 for the passenger side. This completes the removal of the factory system.

REAR MUFFLER REMOVAL PICTURES ON NEXT PAGE 

Factory Rear Muffler Removal Pictures:



Fig. M

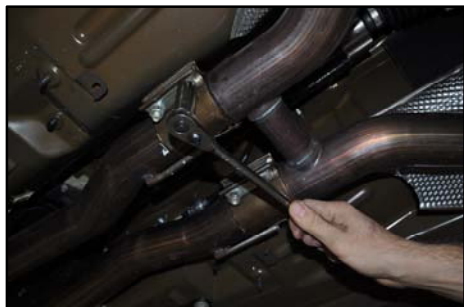


Fig. N



Fig. O



Fig. P



Fig. Q



Fig. R



Fig. S

Installation of CORSA Rear Mufflers:

1. Locate the passenger side muffler assembly and one of the spherical clamps. Align the clamp onto the muffler inlet as shown, so that it is accessible when installed on the vehicle. **(See Fig. T)**

NOTE: Use caution to avoid hitting the tips on the metal brace above the tip cutout in the rear valence while performing the following steps. **(See Fig. U)**
2. Insert the two front hangers into the factory grommet, and then carefully move the passenger side muffler rearward in the chassis to fully seat both front hangers. **(See Fig. V)**
3. Insert the rear muffler hanger into the grommet as shown. **(See Fig. W)** With the spherical clamp in place, align the passenger side muffler inlet flare to the mating form on the factory axle pipe, and snug the clamp using a 13mm socket and ratchet. **(See Fig. X & Y)**
4. Repeat steps 1-3 for the driver side rear muffler assembly.
5. Rotate the panhard bar back up into the installed position, and install the two bolts on the driver side with a 15mm socket and ratchet. Next, tighten the nut on the passenger side using an 18mm socket and ratchet. **(See Fig. O & P from the REMOVAL section)** Tighten the nut and bolts to factory specs.
6. While holding the over axle pipes in the proper position, tighten the 15mm nuts on the factory sleeve clamps using a 15mm socket and ratchet. Torque the nuts to 45 ft-lbs. **(See Fig. N from the REMOVAL section)**
7. Align the exhaust tips in the bumper opening as shown. **(See Fig. Z)** While holding each muffler in place, tighten the 13mm nuts on the spherical clamps to 21 ft-lbs.
8. Visually inspect the exhaust system position, clamp orientation, and exhaust pipe clearance. Make any necessary adjustments at the slip joints. Verify clearances to all underbody components.
9. 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 system has fully cooled to perform this step.

REAR MUFFLER INSTALLATION PICTURES ON NEXT PAGE 

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.

CORSA Rear Muffler Installation Pictures



Fig. T



Fig. U



Fig. V



Fig. W



Fig. X



Fig. Y



Fig. Z