



## 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](http://CORSAPERFORMANCE.COM/WARRANTY)**



For Full-Color Installation Instructions, Please Visit:

**[CORSAPERFORMANCE.COM](http://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 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, 7mm socket, 15mm socket, Ratchet, Grommet pullers, Torque wrench, Small flathead screwdriver, Dremmel tool, Soap & water solution

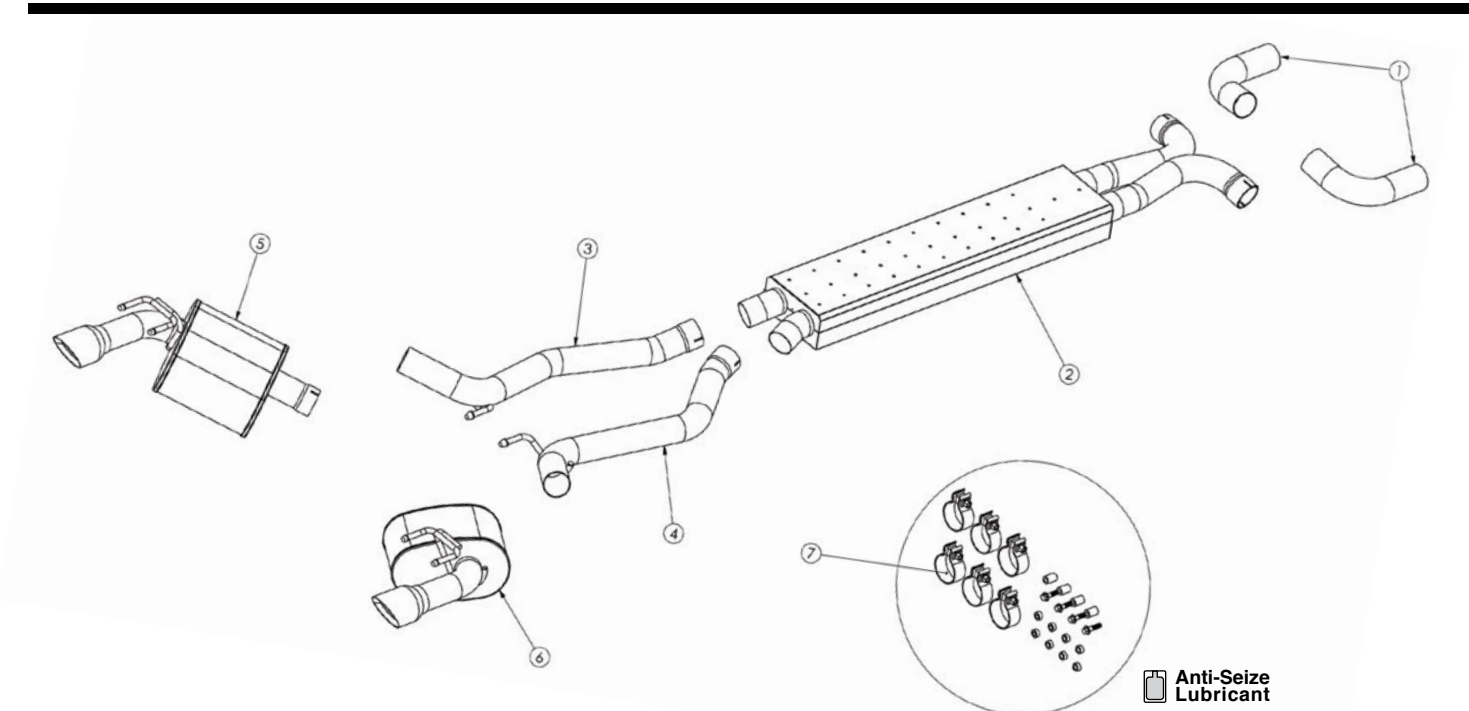
## Bill of Materials:

### PN 14963

- 1- Front Pipe (16CF4070)
- 2- XO-Pipe Assembly (16CF4071)
- 3- Driver Axle Pipe Assembly (16CF4078)
- 4- Passenger Axle Pipe Assembly (16CF4081)
- 5- Driver Rear Muffler Assembly  
w/ 3.5" Tip (16CF2080)
- 6- Passenger Rear Muffler Assembly  
w/ 3.5" Tip (16CF2081)
- 7- Hardware Kit (16CF7044)

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w/ 3.5" Tip (16CF2074)
- 6- Passenger Rear Muffler Assembly  
w/ 3.5" Tip (16CF2078)
- 7- Hardware Kit (16CF7044)



1. Using a 7mm socket, remove and save the bolts from the rear fascia (2 at the outside corners, 4 in the middle). (See Fig. A, B)
  2. Carefully separate the bottom section of the rear fascia by pulling out the tabs on the outside edges. (See Fig. C) There is one on each side.
  3. Remove and save the 4 bolts securing the cross brace near the middle of the car using a 15mm socket, and set brace aside (See Fig. D). The brace and the bolts will be reinstalled after the Corsa system is in place.
  4. Remove and save the 8 bolts holding the cross brace near the front of the car using a 15mm socket, and set the brace aside. The brace and bolts will be reinstalled after the CORSA system is in place. (See Fig. E)
  5. Using a 15mm socket and ratchet, remove the 3 bolts and nut holding in the driver side sub-frame bracing. Repeat on the passenger side. (See Fig. F, G, H, I)
  6. Loosen the sleeve clamps on the factory front pipes using a 15mm socket & pry away the retaining clips using a small flathead screwdriver. (See Fig. J, K)
  7. While preventing the tips from hitting the rear fascia, remove the hangers above the rear mufflers. This may be easiest to remove the double grommet from the car and muffler all at once. (See Fig. L). Repeat on the opposite side.
- NOTE:** The use of a soapy water solution may aid in the removal and later installation of the hangers in the rubber isolators.
8. Using a grommet puller or similar device, remove the axle pipe hangers. While supporting the mufflers and front pipes, remove the system from the front pipes by moving system towards the rear. Lower the front of the system first, allowing for clearance to then lower the mufflers. (See Fig. M, N, O). The removal of the factory system is complete.



FIG. A



FIG. B



FIG. C



FIG. D



FIG. E



FIG. F



FIG. G



FIG. H



FIG. I



FIG. J

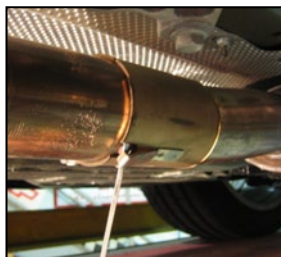


FIG. K

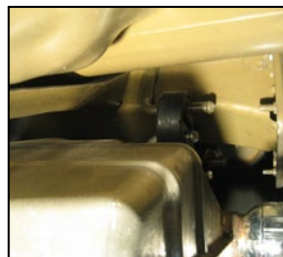


FIG. L



FIG. M



FIG. N



FIG. O

## 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 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 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. 1 to the right) 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.

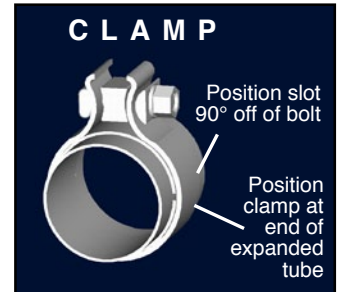


FIG. 1

1. Install the front pipes of the Corsa system into the sleeve clamps on the factory pipes and loosely snug the sleeve clamps using a 15mm socket. **(See Fig. P, Q)**
2. It will be necessary to shorten the driver side rear stud on the tunnel heat shield. Using a dremmel tool or similar device, cut or grind down the stud, leaving 1/8" extra length after the factory nut. **(See Fig. R, S, T)**
3. Note: Use a jackstand or similar object to support & hold level the rear of the XO-pipe assembly at this step. Slide a clamp over the inlet expansion of the xo-pipe and slide the front pipe into the expansion **(See Fig. U, V)**. Do not torque anything yet, but clamp can be loosely tightened. Repeat installing the clamp and front pipe on the other side. Leave the jackstand support in place until installation is complete.
4. Install the factory cross braces using the supplied spacers. Use the 4 longer spacers and the new bolts for the cross brace in the middle of the car. Use the 8 shorter spacers and the factory bolts for the cross brace near the front of the car. **(See Fig. W, X)**. Torque the bolts to 18 ft-lbs. The factory sub-frame braces can also be reinstalled at this time. Torque the bolts to 18 ft-lbs.



FIG. P



FIG. Q

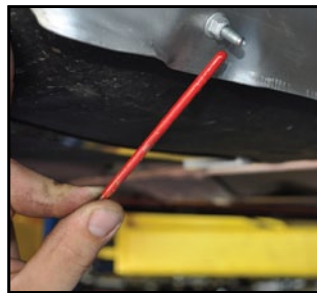


FIG. R

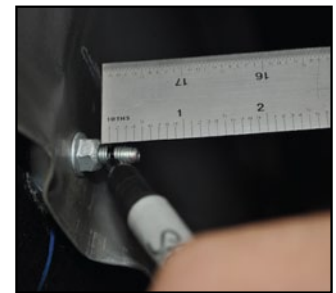


FIG. S



FIG. T



FIG. U



FIG. V



FIG. W

- Slide clamps over the inlet ends of the axle pipes and slide the expanded end of the axle pipe over the xo-pipe (See Fig. Y), then slide the hanger into the rubber grommet near the differential (See Fig. Y, Z, AA, BB). Loosely snug the clamp at this time. Repeat on the other side. Pay close attention to clamp orientation for proper clearances.
- Slide the double rubber grommets over the hangers on the Corsa rear mufflers. Being careful not to damage the rear fascia or the exhaust tips, slide the rubber grommet over the stock hangers on the vehicle. (See Fig. CC).
- Slide a clamp over the expanded inlet of the rear muffler and slide the expanded inlet over the outlet of the axle pipe (See Fig. DD). The clamp can be loosely tightened at this time. Be sure to check for clearance to the spare tire well. (See Fig. EE). Repeat on the other side.



FIG. X



FIG. Y



FIG. Z



FIG. AA



FIG. BB

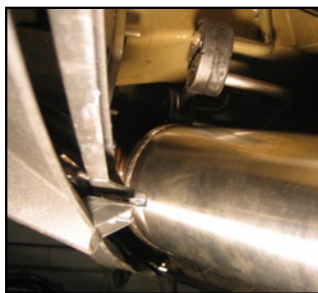


FIG. CC



FIG. DD



FIG. EE

Continue to step 8 on page 5.

8. Starting at the front of the vehicle, tightening all the connections while holding the xo-pipe at least 1/2" off the cross brace. If working alone, a wood block or similar item can be used to hold this distance. It will drop slightly when the support is removed. Torque all clamps to 45ft-lbs (**See Fig. FF, GG**).
9. Check clearance around the xo-pipe assembly, axle pipes, & rear mufflers and make adjustments at the clamp joints to properly align.
10. It is strongly suggested that all clamps be checked and tightened if needed after road testing the vehicle once the system has cooled.

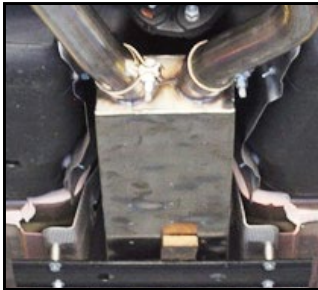


FIG. FF



FIG. GG

**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 CORSA 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.