



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.

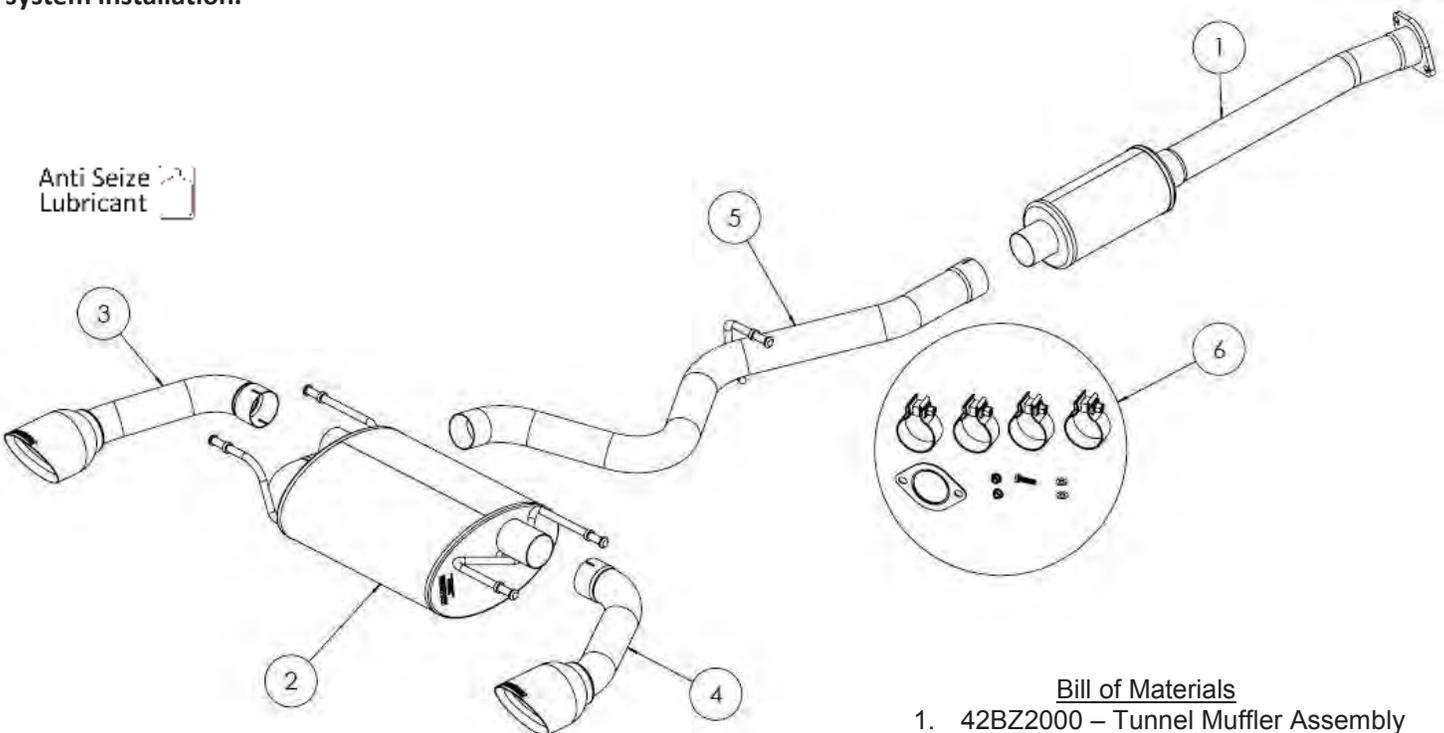
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

**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 14mm shallow socket
- 3/8" drive 15mm deep socket
- 3/8" 4" ratchet extension
- Small pry bar or flathead screwdriver
- 12mm wrench
- 13mm wrench
- Grommet pullers
- 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. 42BZ2000 – Tunnel Muffler Assembly
2. 42BZ2003 – Rear Muffler Assembly
3. 42BZ3000 – Driver Tip Assembly
4. 42BZ3001 – Passenger Tip Assembly
5. 42BZ4003 – Axle Pipe Assembly
6. 42BZ7006 – Hardware Kit

### Factory Exhaust System Removal:

1. Beginning at the flange connection of the catback, use the ratchet, 14mm socket, and 12mm wrench to remove the two spring bolts. **(Fig A)** Support the catback with a jack stand or similar device.
2. Using grommet pullers or a similar device, remove the hanger from the rubber grommet near the rear differential. **(Fig B)**

**Note:** The use of a soap and water solution may aid in the removal of hangers.

3. Using grommet pullers or a similar device, beginning on the driver's side of the rear muffler, remove the two muffler hangers from the rubber grommets. **(Fig C)** Support the driver's side of the exhaust with a jack stand or similar device as only the passenger's side grommets on the rear muffler are supporting the exhaust.
4. Repeat Step #3 on the passenger's side.
5. Carefully remove the factory exhaust from under the vehicle.
6. Using a small pry bar or similar device, remove the graphite donut gasket on the factory exhaust flange upstream of the catback. This gasket is not reused during the Corsa exhaust installation. **(Fig D)**

REMOVAL PICTURES ON NEXT PAGE 

Factory Exhaust Removal Pictures



Fig. A



Fig. B



Fig. C

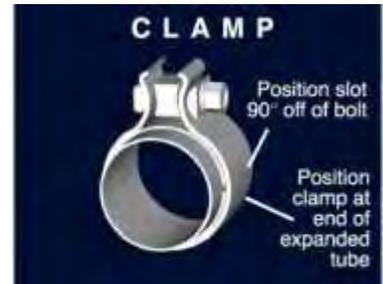


Fig. D

## 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. Locate the gasket in the supplied hardware kit and place it against the factory flange with the factory pipe protruding through it. **(Fig A)** Insert the bolt through the factory flange, followed by the gasket, tunnel muffler assembly, the washer, and lastly the nut. Tighten using the 13mm socket, ratchet, and 13mm wrench. **(Fig B)** The outlet of the tunnel muffler assembly should be pointing towards the driver's side of the car once secured.
2. Locate the axle pipe assembly and one of the 2.5" clamps. Insert the axle pipe hanger into the rubber grommet. **(Fig C)** Slide the clamp over the expansion such that the bolt is vertical with the nut towards the ground. Slide the expansion over the end of the tunnel muffler assembly and snugly tighten with the 15mm socket and ratchet. **(Fig D)**
3. Locate the rear muffler assembly and one of the 2.5" clamps. Slide a clamp over the muffler inlet expansion such that the bolt is closer to the muffler case. Align the expansion with the outlet of the axle pipe and slide the expansion over it. Beginning on the driver's side, insert the hangers into the rubber grommets. **(Fig E)** Repeat with the passenger's side hangers. **(Fig F)** Snugly tighten the clamp using the 15mm socket and ratchet. **(Fig G)**
4. Locate the passenger's side tip assembly and one of the 2.5" clamps. Slide the clamp over the expansion and slide the expansion over the outlet of the rear muffler. Adjust the depth and rotation of the tip assembly until the tip is centered within the cutout in rear bumper valence and then snugly tighten the clamp with the 15mm socket and ratchet. **(Fig H)**
5. Repeat step #4 on the driver's side of the vehicle. The use of a 4" ratchet extension may make tightening the clamp easier. **(Fig J)**
6. Adjust the system accordingly to maximize chassis and heat shield clearance while positioning the tips within the bumper valence. Starting at the front and working backwards, tighten the clamps to 45ft-lb using the torque wrench and 15mm socket, ensuring that the tips are still in the desired position.

**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 Exhaust Installation Pictures**



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

**INSTALLATION PICTURES CONTINUED ON NEXT PAGE** 

**CORSA Exhaust Installation Pictures**



Fig. G



Fig. H



Fig. J