



**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.

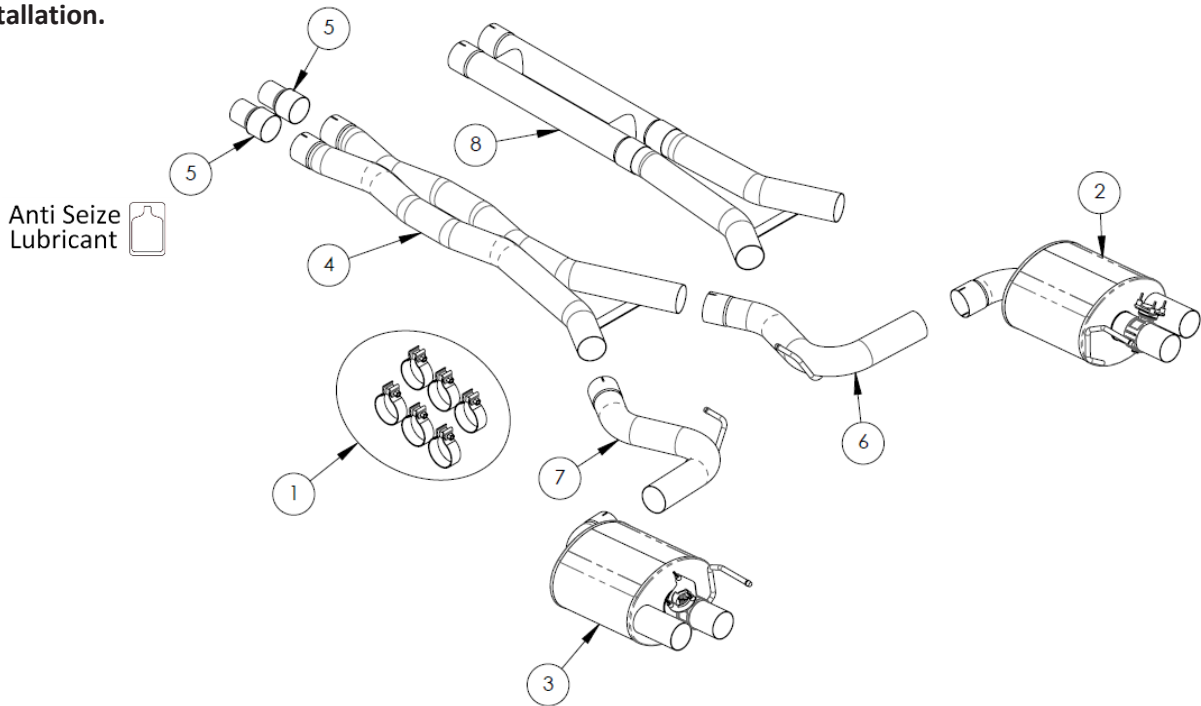
CORSA recommends that the installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools and experienced personnel. However, if you decide to perform this install, the use of a hoist and an additional person will be required.

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 torque wrench
- 3/8" drive 13mm socket
- 3/8" drive 15mm deep socket
- 1/4" drive ratchet
- Grommet pullers
- Soap and water solution
- Penetrating lubricant spray
- Safety glasses
- 1/4" drive 8mm socket

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



Bill of Materials 21096

1. 15AT7007 – HARDWARE KIT
2. 20MU2135 – REAR MUFFLER ASSEMBLY PASS
3. 20MU2136 – REAR MUFFLER ASSEMBLY DRIVER
4. 20MU4078 – DOUBLE X-PIPE ASSEMBLY
5. 20MU4154 – X-PIPE INLET ADAPTER (2)
6. 20MU4163 – AXLE PIPE ASSEMBLY – PASS
7. 20MU4164 – AXLE PIPE ASSEMBLY – DRIVER

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7. 20MU4164 – AXLE PIPE ASSEMBLY – DRIVER
8. 20MU4208 – DOUBLE H-PIPE ASSEMBLY

Factory Exhaust System Removal:

1. Using a clip removal tool or a flat head screw driver remove the six plastic clips holding the rear diffuser to the bottom of the rear bumper. **(Fig. A)** Using a 13mm socket and 3/8" drive ratchet, remove the two bolts located on the bottom of the diffuser. Remove the second pair of bolts at the axle pipe hanger grommets. **(Fig. B)** Lastly, remove the two Christmas tree connectors at the rear of the diffuser and remove the diffuser from the vehicle. Place the diffuser and hardware in a safe location as it will be reused during the installation of the Corsa Performance cat-back exhaust system.
2. Unplug both the driver and passenger side rear exhaust valve actuators by sliding the red plastic clip on the plug away from the actuator. Once the clip is slid back, push down on the plug tab and pull the plug off the actuator. **(Fig. C)**. Remove the wiring restraint clips from both of the stock rear muffler hangers.
3. Using a 3/8" drive ratchet and 15mm deep socket, loosen the two sleeve clamps at the cat-back connection point. Both nuts must be loosened in order for the clamp to fully disengage. **(Fig. D)**
4. Using the 3/8" drive ratchet and 13mm socket, remove the bolt holding down the driver side hanger grommet assembly. **(Fig. E)** Once the bolt is removed, push up slightly on the exhaust and slide the hanger grommet assembly rearward to free it from the rear suspension sub-frame. Rotate the hanger grommet assembly a minimum of 90° so that it will not interfere with the rear suspension sub-frame. Place the bolt in a safe location as it will be reused during the installation of the Corsa cat back exhaust system. Repeat this process for the passenger side hanger grommet assembly.
5. Slide the stock exhaust assembly rearward until the stock resonator inlet pipes are free of the sleeve clamps. Lower the front of the exhaust in order to create clearance between the resonator inlet pipes and the sleeve clamps, then slide the complete exhaust forward to remove the rear muffler driver and passenger side hangers from their respective hanger grommets. The stock exhaust assembly will now be free from the vehicle.

NOTE: The use of a soap and water solution may aid in the removal of hanger grommets.

6. Remove both the driver and passenger side hanger grommet assemblies from the axle pipe hangers using grommet pullers or a similar device. Set the hanger grommet assemblies aside, in a safe location, as they will be re-used for the installation of the Corsa cat back exhaust system. **(Fig. F)**
7. Remove the six nuts (3 per side) that secure both of the factory valve actuators using an 8mm socket and a 1/4" ratchet **(Fig. G)**. Set aside the valve actuators and hardware in a protected location. The valve actuators will be reused during the installation of the CORSA exhaust system.

REMOVAL PICTURES ON NEXT 2 PAGES 

Factory Exhaust System Removal Pictures:



Fig. A



Fig. B



Fig. C



Fig. D



Fig. E



Fig. F

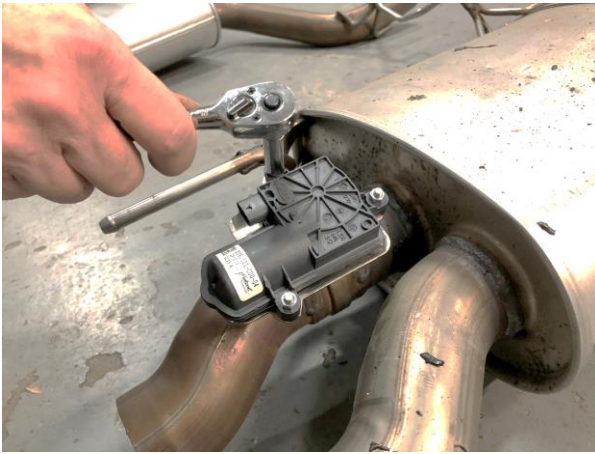
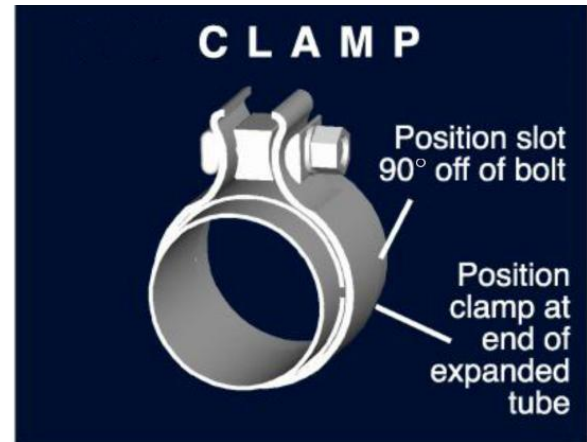


Fig. G (Removal)



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 ABOVE)

1. Remove all exhaust system components from the shipping boxes, including clamps and hardware.
2. Locate the two crossover inlet adapters. Slide the adapters into the factory sleeve clamps, and tighten the clamps using the ratchet and 15mm deep socket, until the adapters are snug in the clamps. **(Fig. H)**
3. Locate the double X-pipe (or double H-pipe) and two 3" clamps. Install the clamps on the driver and passenger crossover pipe inlets so that the bolt is vertical with the nut towards the ground and the bolts towards the outside of the vehicle. **(Fig. I)** Slide the pipe inlets over the adapter outlets. Position the crossover pipe so that the cross-brace located at the rear of the assembly is facing down and is parallel with the ground, and the crossover pipe outlets are centered around the rear differential. Tighten the clamps using the ratchet and 15mm deep socket until the assembly is snug on the adapters. **(Fig. J)** Place a jack stand or similar device under the rear of the crossover pipe for support. **(Fig. K)**

4. Locate the two muffler assemblies, and the two stock valve actuators and mounting hardware set aside in removal Step 7. Align and secure both of the factory valve actuators to the CORSA valve assemblies and secure using an 8mm socket and a ¼" ratchet. **(Fig. L & M)** Torque to 89 In-lbs.
5. Locate the passenger side rear muffler assembly, the passenger side axle pipe assembly, and two 3" clamps. Install the first clamp over the expanded end of the rear muffler assembly so that the bolt is vertical with the nut towards the ground and the bolt is towards the muffler outlet. Next, insert the axle pipe outlet into the expanded end of the rear muffler assembly as shown so that the hanger shoulder is towards the top and facing away from the body of the muffler. The second straight of the axle pipe should be in plane with the rear muffler. **(Fig. N)** Using a 15mm socket and 3/8" drive ratchet, snug the clamp at the muffler inlet. Do not fully tighten. Install the second clamp on the expanded end of the axle pipe so that the bolt is vertical with the nut towards the ground and the bolt is towards the inside of the vehicle.
6. Locate the passenger side hanger grommet assembly set aside in removal step 6. Install the hanger grommet assembly onto the axle pipe hanger in the same orientation as previously installed on the stock exhaust. **(Fig. O)**
7. Install the passenger muffler assembly and axle pipe assembly (clamped together) by sliding the rear muffler hanger into the rear hanger grommet located on the vehicle above and just inside of the passenger side bezel. **(Fig. P)** Next, slide the axle pipe inlet onto the passenger side crossover pipe outlet. **(Fig. Q)**

NOTE: The use of a soap and water solution may aid in the installation of hanger grommets.

8. Locate the 13mm bolt set aside in removal step 4. Install the front passenger hanger grommet assembly onto the rear suspension sub-frame and secure with the 13mm bolt, using the 3/8" ratchet and 13mm socket. **(Fig. R)** Torque to 17 Ft-lbs.
9. Tighten the clamp connecting the passenger axle pipe to the passenger side x-pipe outlet using the ratchet and 15mm deep socket until the axle pipe assembly is snug on the crossover pipe. **(Fig. S)**
10. Reconnect the wiring connector to the passenger side valve actuator. Push in the red locking tab on the wiring connectors to secure the connection. Next, secure the wiring restraint clip to the Corsa rear muffler hanger. **(Fig T & U).**
11. Repeat steps #5-#10 on the driver side of the vehicle. Once the system is secure, it is safe to remove the jack stand from beneath the x-pipe.
12. Adjust the system accordingly, including the adapter overlap on the stock sleeve clamps, the axle pipe depth and rotation, and the rear muffler depth and rotation. Loosen both the crossover pipe to axle pipe connection clamps and the axle pipe to rear muffler connection clamps as needed. Adjust and

hold the axle pipe and rear muffler in position while tightening the clamps. Check the position of all hangers to make sure they are properly seated within their corresponding grommets. Check clearances between the system components and chassis. At this time, tighten all clamps to 45 Ft-lbs using the torque wrench and 15mm socket.

13. Locate the rear diffuser and stock hardware set aside during removal step 1. Position the rear diffuser and reinstall all the push pins. Next, using a 13mm socket and 3/8" drive ratchet, install and tighten the two bolts on the bottom of the diffuser near the rear bumper connection and the second pair of bolts at the axle pipe hanger grommets. **(Fig. V)**. This concludes the installation of your Corsa Performance exhaust system.

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 3 PAGES 

CORSA Installation Pictures



Fig. H



Fig. I



Fig. J



Fig. K



Fig. L



Fig. M

CORSA Installation Pictures



Fig. N



Fig. O



Fig. P

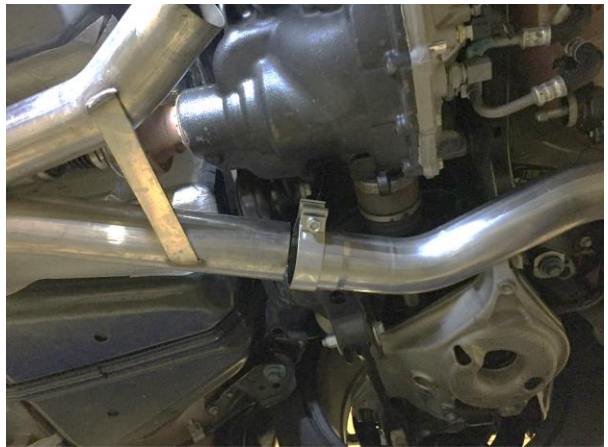


Fig. Q



Fig. R

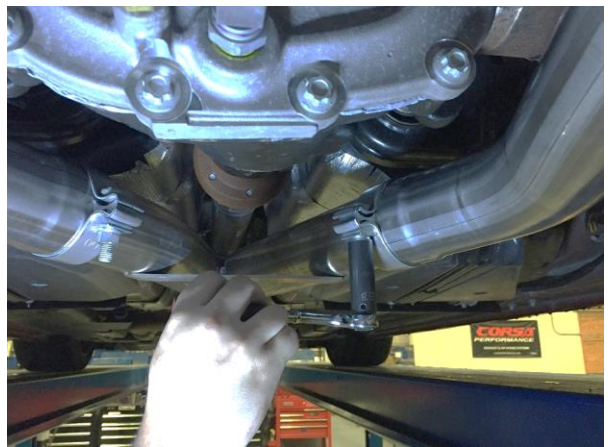


Fig. S

CORSA Installation Pictures



Fig. T



Fig. U



Fig. V