

Ford F-150 Tremor

DUAL REAR EXIT
2021+ 5.0L
2021+ 3.5L Ecoboost



IMPORTANT! WARRANTY AND INSTALLATION INSTRUCTIONS

Please Forward All Information to End Consumer

Be sure to review the enclosed instructions prior to beginning the installation process. If you have any questions about the enclosed parts or instructions, or if you encounter a problem during installation:

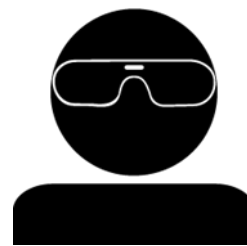
CALL TECHNICAL SUPPORT: 440.891.0999 or 800.486.0999

**TO ACTIVATE YOUR WARRANTY, GO TO:
corsaperformance.com/warranty**

**COLOR INSTRUCTIONS ARE AVAILABLE BY PART NUMBER ON:
corsaperformance.com**



NEVER work on a hot exhaust system.
Allow time for the vehicle to cool.



**Always wear eye protection
when working under a vehicle.**

INSTALL DIFFICULTY



Recommended Tools & Supplies

- 10mm Socket & Ratchet or Wrench
- 2 - 13mm Sockets & Ratchets or Wrenches
- 15mm Socket & Ratchet or Wrench
- Soap and Water Solution
- Grommet Pulling Pliers or Similar
- Torque Wrench
- Extension for Socket & Ratchet
- Small Flat Head Screwdriver

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 installer who has the necessary equipment, tools, and experienced personnel. However, if you decide to perform this installation yourself, the use of an additional person may be required.

WARNING: Never work on a hot exhaust system. Allow time for the vehicle to cool.
Always wear eye protection when working under a vehicle.

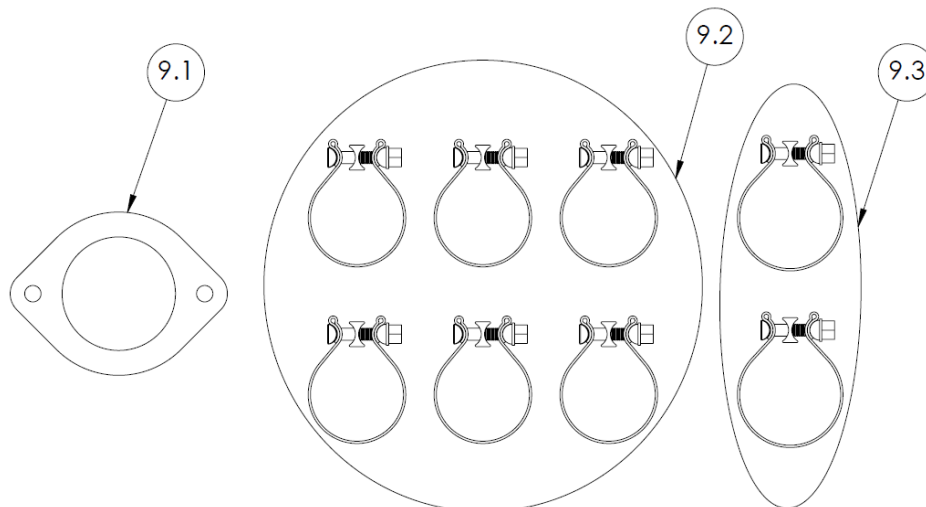
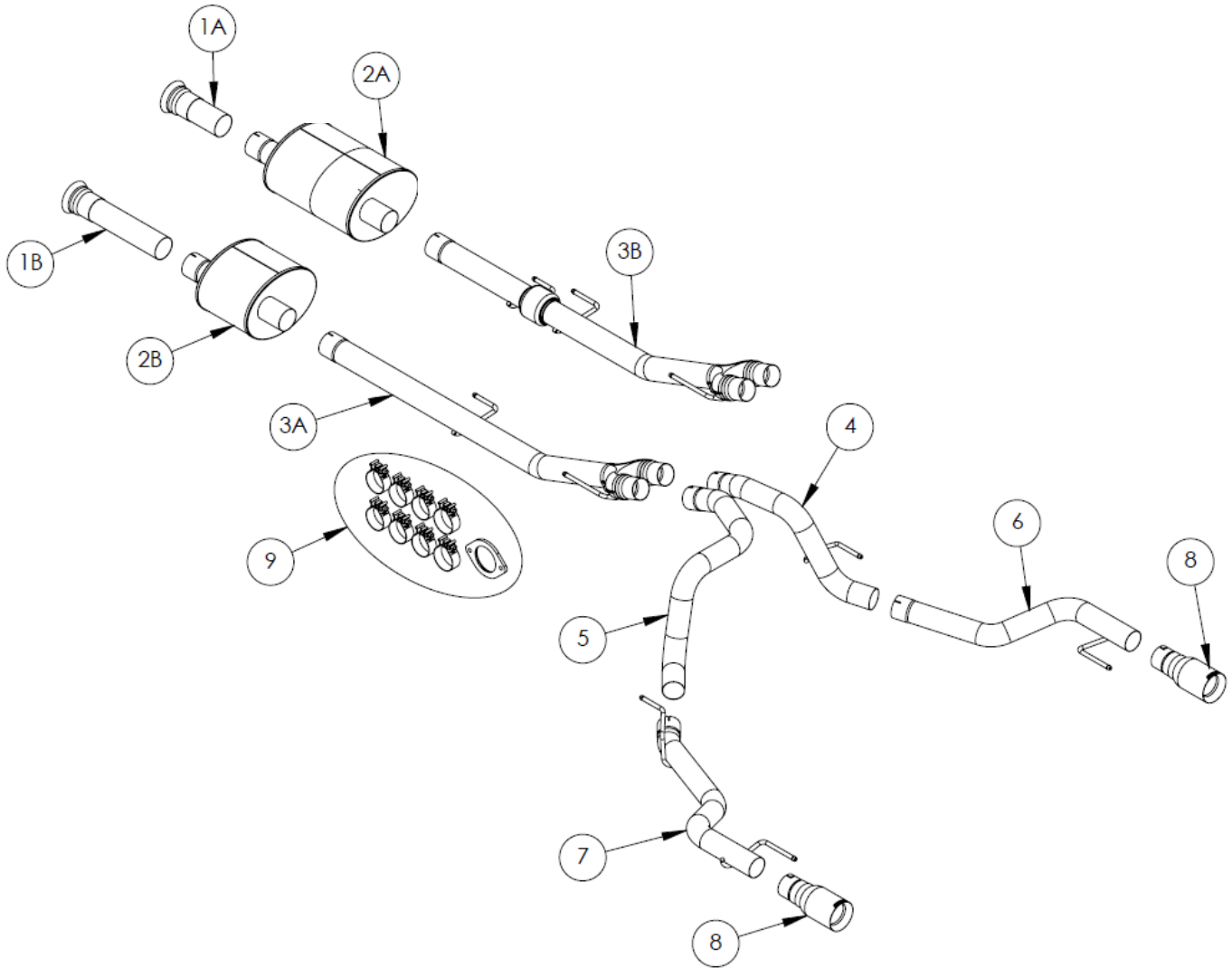
This warranty does not extend to damaged or defect in the finish of a product or to any product, that in the opinion of CORSA Performance, has been misused, damaged by accident or negligence, altered, or modified in any way, faulty installation or installed contrary to CORSA installation instructions, or repaired by an unauthorized service facility. Full warranty available on www.corsaperformance.com

Please confirm that all parts are present according to the bill of materials before beginning the installation.

If something is missing, call CORSA Tech Support at 440.891.0999 or Toll Free: 1.800.486.0999

2021+ Ford F-150 Tremor
3.0" Cat-Back Exhaust, Dual Rear Exit w/ 4.0" Straight Cut Tips

5.0L: 21183, 21183BLK (Xtreme), 21184, 21184BLK (Sport)
3.5L: 21185, 21185BLK (Sport)



Bill of Materials

1. Head Pipe**	1A - SPORT - 20FF4214 1B - XTREME - 20FF4212
2. Muffler	2A - 20FF2038 - SPORT 3.5L, 20FF2044 - SPORT 5.0L 2B - 20FF2039 - XTREME 5.0L
3. Mid Pipe	3A - 20FF4194 – 5.0L 3B - 20FF4232 – 3.5L
4. Passenger Split Pipe	20FF4257
5. Driver Split Pipe	20FF4260
6. Passenger Tail Pipe	20FF4253
7. Driver Tail Pipe	20FF4254
8. Tip Assembly	25JK3002 or 25JK3002BLK 20FF7110
9. Hardware Kit	Contents: 9.1 20FF5008 - Head Pipe Flange 9.2 16CF7005 - 2.75in Clamp (QTY 6) 9.3 16CF7001 - 3in Clamp (QTY 2)
10. Instructions	INS5433 (This Document)

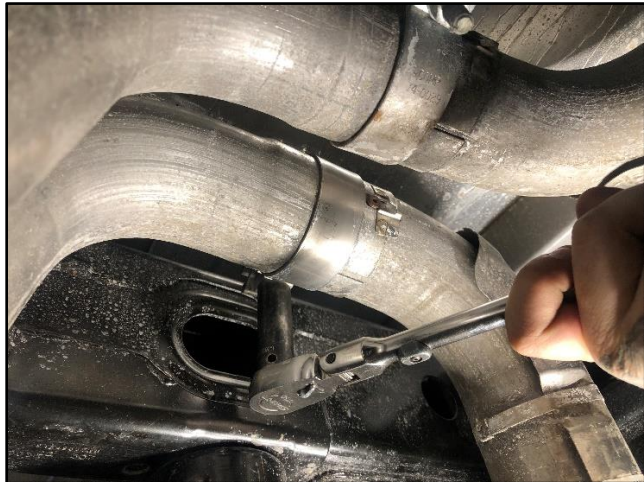
If something is missing, call CORSA Tech Support at 440.891.099 or Toll Free: 1.800.486.0999

Removal Instructions

Factory Exhaust



1. Identify the passenger side factory tailpipe connection located above the rear differential on the passenger side of the vehicle. Using a Small flat head screwdriver, pry open the locking tab to free the tailpipe locating key from the factory muffler section.



2. Using a 15mm socket & ratchet, loosen the factory clamp securing the passenger side tailpipe to the factory muffler section.

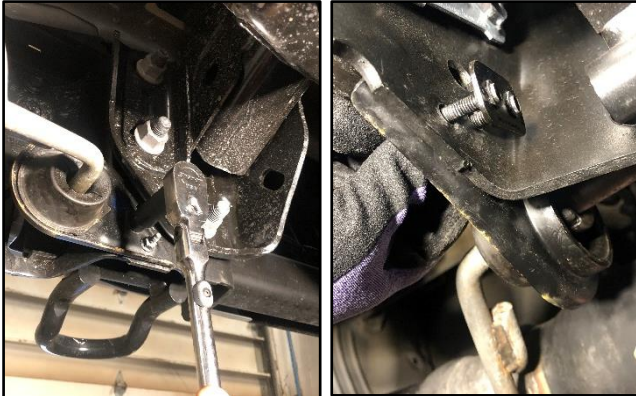


3. Using a 10mm socket & ratchet, remove the 2 bolts securing the passenger front tailpipe hanger mount to the chassis. Set aside the 2 Bolts in a safe place. They will be reused during **INSTALL STEP 15**.

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Removal Instructions

Factory Exhaust



4. Using a 10mm socket & ratchet, remove the 2 nuts securing the passenger rear tailpipe hanger mount and mounting bracket to the chassis. Remove the mounting bracket to free the rear tailpipe hanger mount from the vehicle. Set aside the 2 nuts and the mounting bracket in a safe place. They will be reused during **INSTALL STEP 17**.



5. Carefully remove the passenger side factory tailpipe from the vehicle.



6. Repeat **REMOVAL STEPS 1-5** to remove the driver side factory tailpipe from the vehicle.



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Removal Instructions

Factory Exhaust

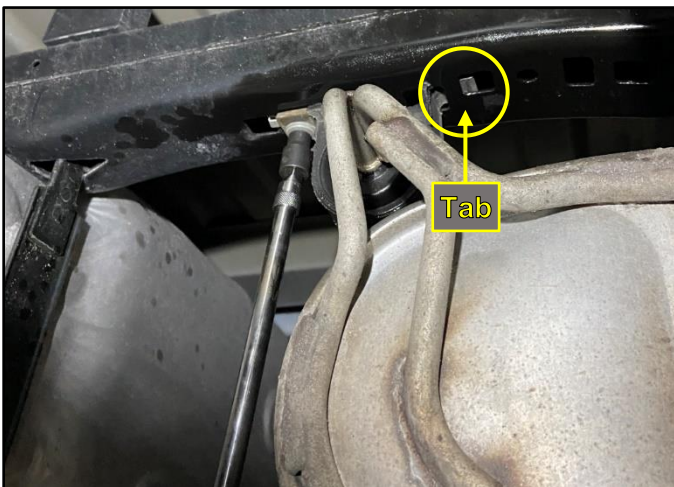


- 7. Using a 15mm socket & ratchet, loosen the factory clamp securing the factory muffler section to the factory head pipe.



- 8. Using a 10mm socket & ratchet, remove the 2 bolts securing the front hanger mount to the chassis. Set aside the 2 Bolts in a safe place. They will be reused during **INSTALL STEP 11**.

IMPORTANT NOTE: At this time, support the underside of the factory muffler section using an adjustable support stand (or equivalent), as it will be free to drop down once the mid hanger mount is unbolted from the chassis in the following step. A second person may be needed to assist with this step.



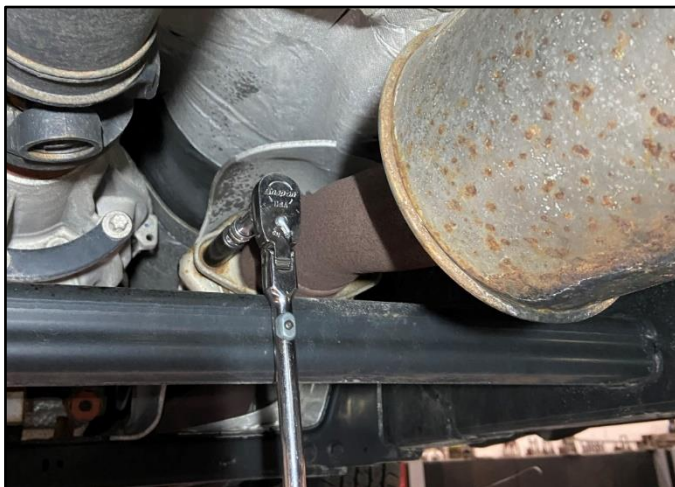
- 9. Locate the mid hanger mount above the back of the factory rear muffler. Using a 10mm socket & ratchet with a long extension, remove the bolt securing the hanger mount to the chassis. Next, pull the hanger mount towards the center of the vehicle and then downwards to release the hanger mount locating tab from the chassis. Set aside the bolt in a safe place. It will be reused during **INSTALL STEP 12**.

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Removal Instructions

Factory Exhaust

- 10.** To remove the muffler section of the factory exhaust, rotate the entire muffler section so that the two muffler outlet pipes move upwards and inwards toward the driveshaft in the center of the vehicle. Rotating the muffler section unlocks the key in the joint where the muffler connects to the factory head pipe. The key is on top of the factory muffler section (see image below for location). Once the key is unlocked, the muffler section can be pulled rearwards to disconnect from the head pipe. Once disconnected, the muffler section is then removed by carefully moving it forward, over the rear axle, and then downwards from under the vehicle. A second person may be needed to assist with this step.



- 11.** Using a 13mm socket & ratchet with extension, loosen the two bolts securing the stock flange connection on the factory head pipe. A second person may be needed to support the head pipe when the two bolts are loosened.

After removing the bolts, the factory head pipe can then be removed from under the vehicle. Set aside the 2 bolts in a safe place. They will be reused during **INSTALL STEP 9**.

This concludes the removal of the factory exhaust.

WARNING!!

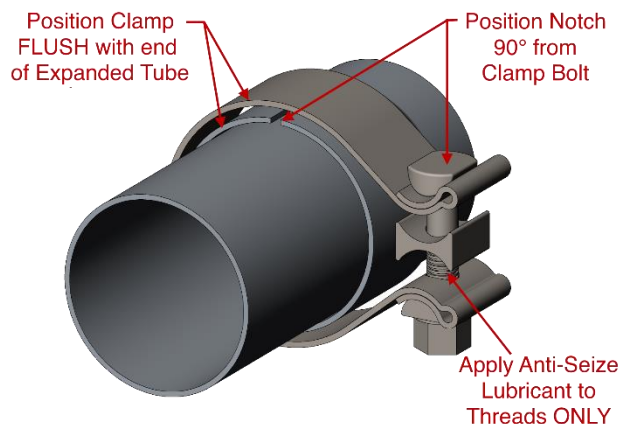
DO NOT SKIP THIS STEP

WARNING!!

It is recommended to apply Anti-Seize Lubricant to the threads of the clamps and flange bolts. Failure to follow this procedure can cause nuts to seize on clamps and potentially destroy the threads.

After applying anti-seize lubricant, be sure to thoroughly clean your hands. The anti-seize lubricant will tarnish stainless steel.

All clamps should be tightened using a properly calibrated Torque Wrench. Using an 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.



PRO TIP

Before installing, make a line from the end of non-expanded side of the pipes and muffler that is 1⁵/₈in on 2³/₄in tubing and 1³/₄in on 3in tubing. These are CORSA's nominal joint overlaps. This will help during final adjustment. Do not be alarmed if the overlap varies slightly when the installation is complete. Any differences are caused by manufacturing variances from vehicle to vehicle and exhaust to exhaust.

Installation Instructions

CORSA Exhaust



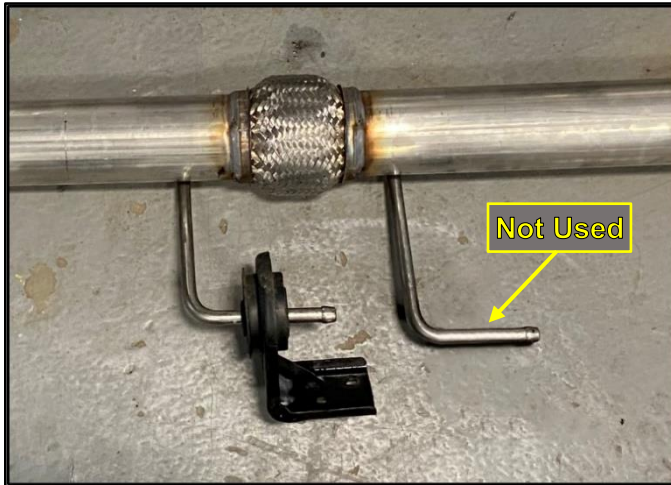
1. With the factory muffler section on the ground, use grommet pullers or similar device to remove the two factory muffler hangers from the corresponding hanger mounts. Note the orientation of the hanger mounts before removal for the next two steps.

NOTE: The use of soapy water solution will aid in the removal and later installation of the hangers from the factory grommets.

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Installation Instructions

CORSA Exhaust



2. Locate the CORSA mid pipe, then Install the front hanger mount as shown onto the forward hanger location.

NOTE: The 3.5L version of the mid pipe (with flex section) will have a second forward hanger location that is only used on the non-Tremor version of the CORSA exhaust. In this case, the rearward most of the two front hangers is the correct hanger position for the 3.5L Tremor exhaust. Make sure to orient the hanger mount in the same way as on the factory exhaust system.



3. Install the mid hanger mount as shown onto the rear hanger location of the CORSA mid pipe. Make sure to orient the hanger mount in the same way as on the factory exhaust system.



4. With the factory passenger tailpipe section on the ground, use grommet pullers or similar device to remove the two tailpipe hangers from the corresponding hanger mounts. Note the orientation of the hanger mounts before removal for the next two steps.

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Installation Instructions

CORSA Exhaust



5. Locate the CORSA passenger split pipe assembly. Install the front tailpipe hanger mount as shown onto the hanger location of the CORSA split pipe. Make sure to orient the hanger mount in the same way as on the factory exhaust system.



6. Locate the CORSA passenger tailpipe assembly. Install the rear tailpipe hanger mount as shown onto the hanger location of the CORSA tailpipe. Make sure to orient the hanger mount in the same way as on the factory exhaust system.



7. Repeat **INSTALL STEPS 4-6** to install the two driver tailpipe hanger mounts onto the corresponding CORSA front and rear driver tailpipe hangers.

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Installation Instructions

CORSA Exhaust



- 8. Locate the CORSA head pipe and the head pipe flange from the hardware kit. Assemble the head pipe flange onto the head pipe, with the chamfer side facing towards the flare.



- 9. Locate the head pipe flange bolts from **REMOVAL STEP 11**.

NOTE: A second person may be needed to assist with **INSTALL STEPS 9-21**.

Lift the CORSA head pipe with assembled flange into position, then carefully thread the head pipe flange bolts into the factory connection. Next, lightly **SNUG** the bolts with a 13mm socket & ratchet with extension. This joint needs to be loose enough for alignment later but snug enough to support the CORSA head pipe and muffler.

DO NOT FULLY TIGHTEN at this time!



- 10. Locate the CORSA muffler and one of the 3in clamps from the hardware kit. Position the clamp onto the inlet of the CORSA muffler.

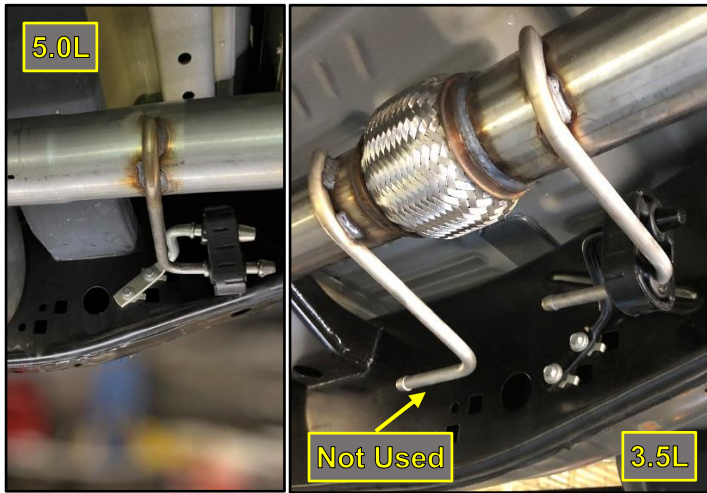
Lift the CORSA muffler into position and slide the expanded inlet over the head pipe outlet. While supporting the CORSA muffler, confirm the joint overlap and clearances to the vehicle, then **SNUG** the clamp with a 15mm socket & ratchet.

DO NOT FULLY TIGHTEN at this time!

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Installation Instructions

CORSA Exhaust



11. Locate the CORSA mid pipe and one of the 3in clamps from the hardware kit. Position the clamp onto the inlet of the CORSA mid pipe.

Locate the 2 bolts for the front hanger mount from **REMOVAL STEP 8**. Lift the CORSA mid pipe into position and slide the expanded inlet over the muffler outlet. While supporting the mid pipe, carefully thread the bolts thru the factory front hanger mount and into the factory clip nuts in the chassis. Use a 10mm socket & ratchet to **SNUG** the Bolts. Once again, note that the 3.5L version of the mid pipe (with flex section) will have a second forward hanger location that is only used on the non-Tremor version of the CORSA exhaust.

DO NOT FULLY TIGHTEN at this time!



12. Locate the bolt for the mid hanger mount from **REMOVAL STEP 9**. While supporting the CORSA mid pipe, insert the tab on the hanger mount into the hole in the chassis and carefully thread the bolt through the hanger mount and into the factory clip nut in the chassis. Use a 10mm socket & ratchet with a long extension to **SNUG** the bolt.

DO NOT FULLY TIGHTEN at this time!



13. Confirm the pipe joint overlap and clearances to the vehicle, and make sure the outlet of the CORSA mid pipe is level with the ground, then use a 15mm socket & ratchet to **SNUG** the clamp connecting the CORSA mid pipe to the CORSA muffler.

DO NOT FULLY TIGHTEN at this time!

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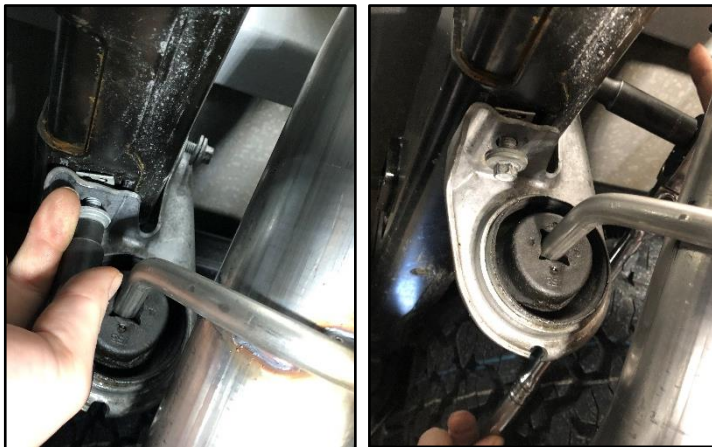
Installation Instructions

CORSA Exhaust



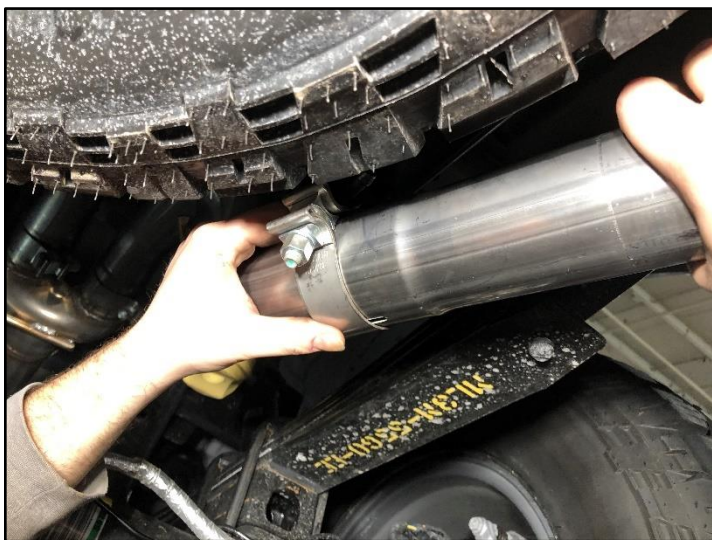
14. Locate the CORSA passenger split pipe and one of the 2.75in clamps from the hardware kit. Position the clamp onto the inlet of the CORSA split pipe.

Lift the CORSA split pipe into position by lifting it over the rear axle from the back of the vehicle and then slide the expanded inlet over the passenger mid pipe outlet. Leave the clamp connection loose until the next step.



15. Locate the 2 bolts for the passenger front tailpipe hanger mount from **REMOVAL STEP 3**. While supporting the CORSA split pipe, carefully thread the bolts thru the factory passenger front tailpipe hanger mount and into the factory clip nuts in the chassis. Use a 10mm socket & ratchet to **SNUG** the bolts. Confirm the pipe joint overlap and clearances to the vehicle, then use a 15mm socket & ratchet to **SNUG** the clamp connecting the CORSA passenger split pipe to the CORSA mid pipe.

DO NOT FULLY TIGHTEN at this time!



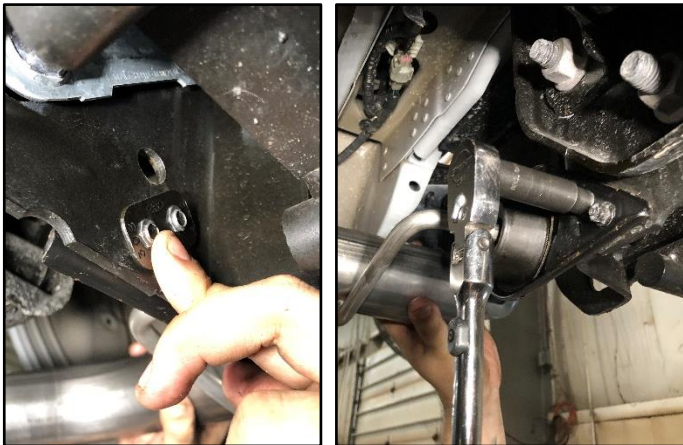
16. Locate the CORSA passenger tailpipe and one of the 2.75in clamps from the hardware kit. Position the clamp onto the inlet of the CORSA tailpipe.

Lift the CORSA tailpipe into position by sliding the expanded inlet over the passenger split pipe outlet. Leave the clamp connection loose until the next step.

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Installation Instructions

CORSA Exhaust



17. Locate the 2 nuts and the mounting bracket for the passenger rear tailpipe hanger mount from **REMOVAL STEP 4**. While supporting the tailpipe, install the mounting bracket into the chassis from the rear of the vehicle, and then place the rear tailpipe hanger mount onto the studs from the mounting bracket. Thread the nuts onto the studs, then use a 10mm socket & ratchet to **SNUG** the 2 nuts. Confirm the pipe joint overlap and clearances to the vehicle, then use a 15mm socket & ratchet to **SNUG** the clamp connecting the CORSA passenger tailpipe to the CORSA split pipe.

DO NOT FULLY TIGHTEN at this time!



18. Repeat **INSTALL STEPS 14-17** to install the CORSA driver split pipe and CORSA driver tailpipe. Note that both driver hangers are located on the driver tailpipe.

DO NOT FULLY TIGHTEN at this time!



19. Locate one of the CORSA tip assemblies and one of the 2.75in clamps from the hardware kit. Position the clamp onto the inlet of the CORSA tip assembly.

Lift the tip into position and slide the expanded inlet over the passenger tailpipe outlet. Adjust the position and rotation of the tip assembly until the CORSA logo is centered on top and the tip has even clearance to the cutout in the rear bumper on all sides. Use a 15mm socket & ratchet to **SNUG** the clamp connecting the CORSA tip assembly to the passenger tailpipe.

DO NOT FULLY TIGHTEN at this time!

20. Repeat **INSTALL STEP 19** for the driver side CORSA tip assembly.

Continued on Next Page...

Installation Instructions

CORSA Exhaust

21. Starting at the head pipe flare connection, verify all hangers are properly in the Grommets, the muffler is close to level, all connections are straight, and there is proper clearance around the entire CORSA exhaust and the vehicle. Starting at the head pipe flange connection, use a torque wrench to tighten the bolts to factory specifications, then tighten the clamps to 45ft-lbs and the factory hanger bolts/nuts to factory specifications.

This concludes the installation of the CORSA Exhaust.

Before Road Testing

1. Start engine, leaving the transmission in park and/or securing the parking brake.
2. Make sure to look and listen for any unusual noises. Repair problems if needed.
3. 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.
4. It is strongly suggested that the alignment of the components be checked and all clamps re-torqued after road testing the vehicle and allowing the system to fully cool.
5. 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.