



2022+

Toyota Tundra

3.4L i-Force & i-Force Max



IMPORTANT! WARRANTY AND INSTALLATION INSTRUCTIONS

Please Forward All Information to 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:

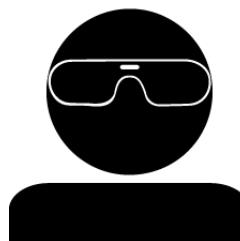
CALL TECHNICAL SUPPORT: 440.891.0999 or 800.486.0999

**TO ACTIVATE YOUR WARRANTY GO TO:
[CORSAPERFORMANCE.COM/WARRANTY](https://corsaperformance.com/warranty)**

COLOR INSTRUCTIONS ARE AVAILABLE BY PART NUMBER ON: [CORSAPERFORMANCE.COM](https://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

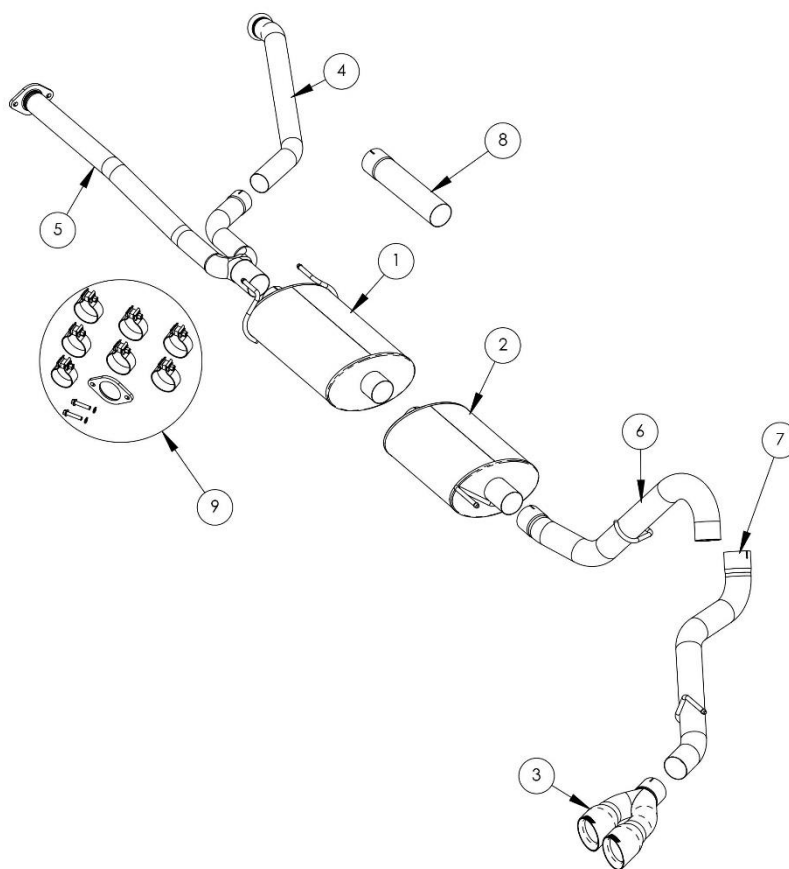
- 3/8" Drive Ratchet
- 3/8" Drive 15mm Deep Socket
- Torque Wrench
- Safety Glasses
- 3/8" Drive 14mm Deep Socket
- Grommet Pullers
- Penetrating Lubricant Spray
- Soapy Water Solution

PLEASE READ THESE INSTRUCTIONS BEFORE INSTALLATION.

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



**TOYOTA TUNDRA CAT BACK EXHAUST
 BILL OF MATERIALS – 21245, 21245BLK**

1.	Front Muffler (25TU2004)	2.	Rear Muffler (25TU2005)
3.	Dual 4.0" Tip (25TU3000)	4.	Passenger Head-Pipe (25TU4068)
5.	Driver Head-Pipe (25TU4069)	6.	Axle Pipe (25TU4077)
7.	Tailpipe (25TU4079)	8.	Pipe Extension for 164.6" WB (25TU4081)
9.	Hardware Kit (25TU7032)		

'22+ Toyota Tundra 3.4L i-Force & i-Force Max

3.00" Cat-Back Exhaust, Single Rear Exit

Part #: 21245, 21245BLK (Sport)



CAUTION: Never work on a hot exhaust system. Allow the vehicle to cool for at least an hour and a half. Always wear eye protection when working under a vehicle. It is recommended to use cotton gloves in order to protect stainless steel surfaces from permanent grease and oil stains.

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

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

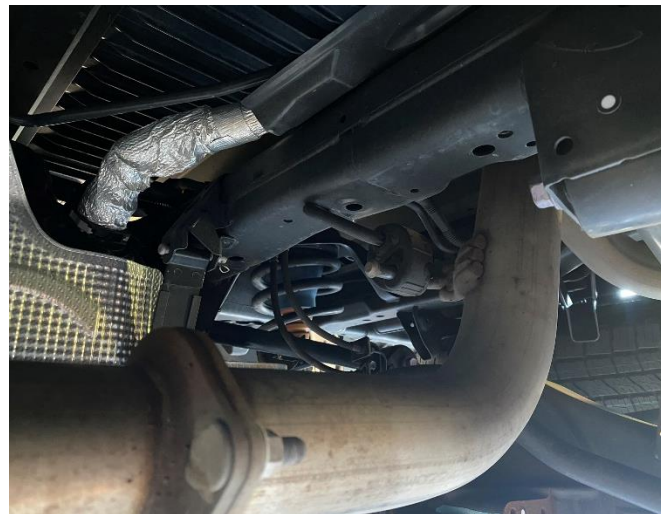
REMOVAL INSTRUCTIONS

FACTORY EXHAUST

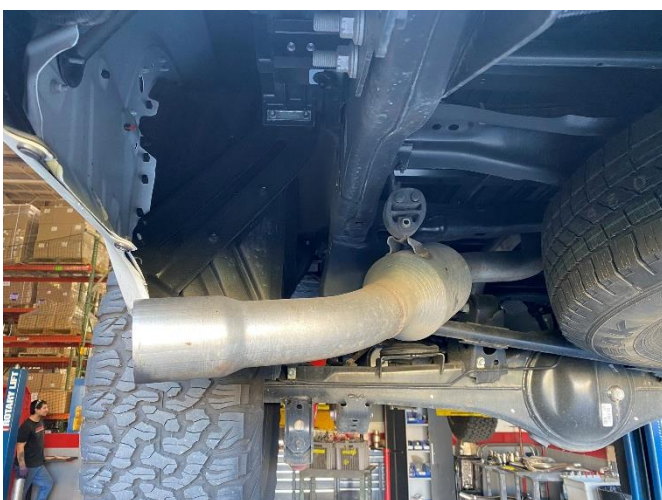
NOTE: A two post lift and removal of the spare tire may be necessary to remove the stock axle pipe without cutting. Please follow the spare tire removal instructions found in your Tundra owner's manual for detailed instructions on the removal and reinstallation of the spare tire. A two-post lift may also be necessary to let the rear axle droop to create enough clearance for removal.



1. Using the ratchet and 14mm socket, remove the two nuts at the axle back flange connection, located directly behind the center muffler.



2. Using grommet pullers or a similar device, remove the axle pipe front hanger directly behind the flange connection. **NOTE:** The use of soapy water solution will aid in the removal of the hanger grommets.



3. Using grommet pullers or a similar device, remove the axle pipe rear hanger located near the tailpipe outlet. **NOTE:** The use of soapy water solution will aid in the removal of the hanger grommets.



4. The axle pipe is now free. Maneuver the axle pipe rearward and over the vehicles axle. **Note:** As noted above, a 2-post lift and removal of the spare tire may be necessary to remove the axle pipe without cutting.

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REMOVAL INSTRUCTIONS

FACTORY EXHAUST



- 5.** Moving to the front of the vehicle and using the ratchet and 14mm socket, remove the 4 bolts and springs located at the cat-back flanges on both the driver and passenger sides. **NOTE:** The use of penetrating lubricant spray on the rear of the threads may aid in removal.



- 6.** Using grommet pullers or a similar device, remove the two forward muffler hangers. **NOTE:** The use of soapy water solution will aid in the removal of the hanger grommets.



- 7.** Using grommet pullers or a similar device, remove the rear muffler hanger. **NOTE:** The use of soapy water solution will aid in the removal of the hanger grommet.



- 8.** The rest of the factory exhaust system will come out in one piece. Slide the entire exhaust system down and rearwards to remove it from the vehicle.

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REMOVAL INSTRUCTIONS

FACTORY EXHAUST



9. Inspect both the driver and passenger side exhaust gaskets left on the stock cat-back flanges for any cracking or damage and replace if necessary.

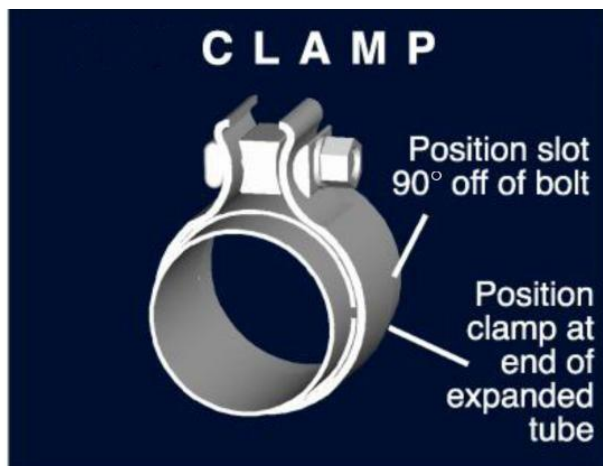
This concludes the removal of the factory exhaust.

WARNING! DO NOT SKIP THIS STEP!

It is recommended to apply the anti-seize lubricant to the threads **ONLY** of 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.

INSTALLATION INSTRUCTIONS

CORSA EXHAUST



1. Locate the Corsa front muffler assembly. Slide the two hangers into the factory grommets.
NOTE: The use of soapy water solution will aid in the installation of hangers.
2. Locate the Corsa rear muffler assembly along with a 3" clamp. Slide the clamp over the expanded inlet side of the muffler with the nut and bolt perpendicular to the ground.

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INSTALLATION INSTRUCTIONS

CORSA EXHAUST



- 3.** Slide the rear hanger into the factory rear muffler grommet.

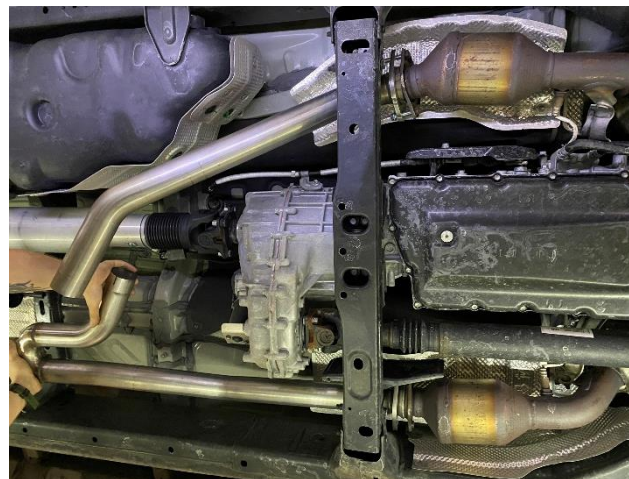
NOTE: The use of soapy water solution will aid in the installation of the hanger into the factory grommet.



- 4.** Install the expanded inlet end of the rear muffler onto the outlet of the front muffler. Snug the clamp using a 15mm socket and ratchet but do not fully tighten at this time.



- 5.** Locate the CORSA passenger side head-pipe and the flange, two M10 bolts, and lock washers from the hardware kit. Slide the flange over the pipe with the chamfer of the flange facing the pipe flare. Using a 14mm socket and ratchet, snug the flange and head-pipe to the factory cat-back flange.



- 6.** Locate the Corsa driver side head-pipe and two M10 bolts and lock-washers. Slide the floating flange to the flare on the head-pipe inlet and bolt it to the factory cat-back flange using the supplied M10 bolts, lock-washers and 14mm socket and ratchet.

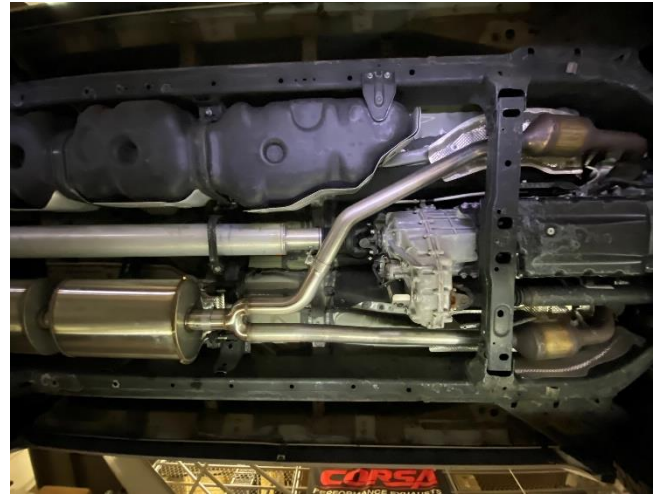
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INSTALLATION INSTRUCTIONS

CORSA EXHAUST



7. Locate a 2.5" clamp and slide it over the expanded outlet end of the driver side head-pipe assembly. Next, insert the outlet end of the passenger head-pipe into the inlet of the driver side assembly. Position the clamp so that the bolt and nut is perpendicular to the ground and snug using a 15mm socket and ratchet. Do not fully tighten at this time.



8. Locate a 3.0" clamp and slide it over the Corsa front muffler inlet. Next, slide the wye outlet into the muffler and snug the clamp using a 15mm socket and ratchet. Ensure the clamp nut and bolt is perpendicular to the ground. Do not fully tighten at this time. **NOTE:** The driver side head-pipe wye should be level and parallel with the ground. **NOTE:** If installing this kit on a 164.6" WB Tundra, the installation of the extension pipe will be necessary. Install the extension pipe and an additional 3.0" clamp between the wye outlet and the front muffler.

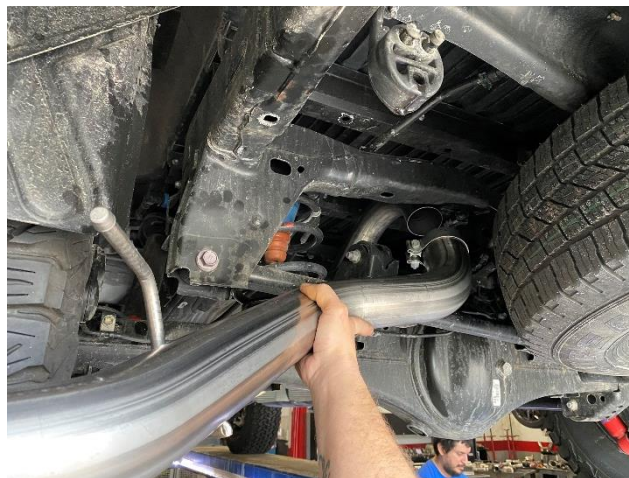
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INSTALLATION INSTRUCTIONS

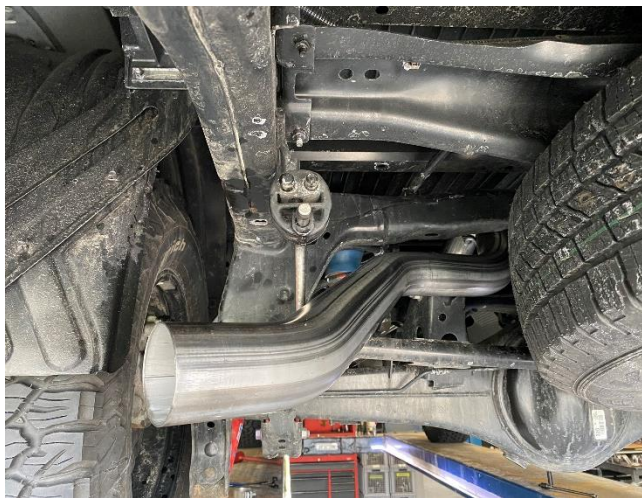
CORSA EXHAUST



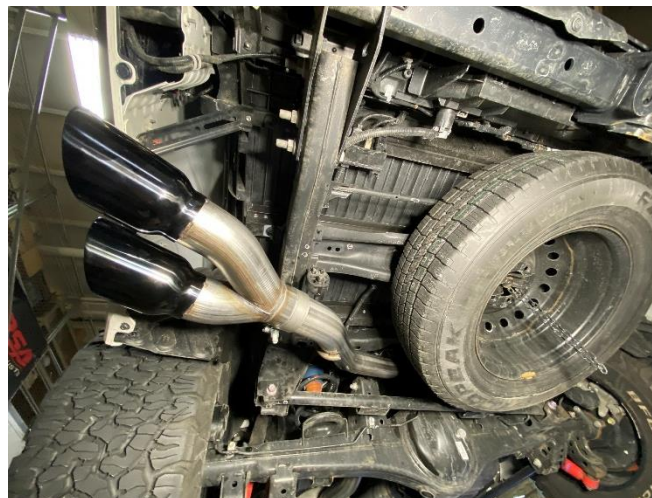
- 9.** Locate the CORSA axle pipe and one 3.0" clamp. Insert the axle pipe hanger into the factory hanger grommet. Next, slide the 3" clamp over the expanded inlet end of the axle pipe inlet. Slide the axle pipe over the rear muffler outlet. Position the clamp so that the clamp nut and bolt are perpendicular to the ground and snug using a 15mm socket and ratchet.



- 10.** Locate, the Corsa tailpipe and one 3.0" clamp. Slide the clamp over the expanded end of the tailpipe with the clamp nut and bolt face the driver side of the vehicle and nut facing down. Slide the expanded end of the tailpipe over the axle pipe outlet.



- 11.** Insert the tailpipe hanger into the factory hanger grommet. Using a 15mm socket and ratchet, snug the clamp at the axle pipe to tailpipe connection. Do not fully tighten at this time.
NOTE: The use of soapy water solution will aid in the installation of the hanger.



- 12.** Locate the Corsa tip assembly and one 3.0" clamp. Slide the clamp over the expanded inlet end of the tip assembly so that the clamp nut and bolt is facing the rear tire with the bolt perpendicular to the ground. Using the 15mm socket and ratchet, snug the clamp but do not fully tighten at this time.

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INSTALLATION INSTRUCTIONS

CORSA EXHAUST



- 13.** At this time, visually inspect the exhaust system position, tip alignment, clamp orientation, and exhaust pipe clearance. Make any necessary adjustments at the slip fit joints and flange connections.
- 14.** Torque all supplied flange mounting hardware to 35 ft-lbs. at the two flange connections.
- 15.** With the tips held in the desired location, start at the front of the vehicle, and tighten the nuts on the clamps. Torque all clamp nuts to 45 ft-lbs. (61 N-m) on the clamps.

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.

NOTE: It is strongly suggested that all clamps be checked and tightened after road testing the vehicle once the system has cooled.