



## 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 10 Year LIMITED WARRANTY, Go To:  
[CORSAPERFORMANCE.COM/WARRANTY](http://CORSAPERFORMANCE.COM/WARRANTY)



MADE IN THE USA



For Full-Color Installation Instructions, Please Visit:  
[CORSAPERFORMANCE.COM](http://CORSAPERFORMANCE.COM) & Search Part #

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**





**PERFORMANCE EXHAUSTS Exhaust System Installation**

EC/SB & CC/SB (2003 & newer) Chevrolet Silverado 2500 HD 8.1/6.0L  
EC/SB & CC/SB (2003 & newer) GMC Sierra 2500 HD 8.1/6.0L

- Single Side Exit Exhaust System with Twin Pro-Series 4.0 Tips
- Split Dual Side Exit Exhaust System with Hydroformed Tips

**TOOLS NEEDED:**

Safety Glasses, 15 mm Wrench & Deep Socket, Silicone Spray or WD40, Saw or Chain-Style Pipe Cutter, Torque Wrench

Please be sure to review the attached 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. Do not attempt to make any modifications to parts as this will void your warranty.

All TORCA 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.

**CAUTION**

Prior to installation, be sure your vehicle is parked on a level surface, and the exhaust system is cool. For safety purposes and ease of installation, we urge you to take your vehicle to a qualified service center or muffler installer that employs the use of a lift.

**INSTALLATION NOTE:** Be sure to apply the anti-seize lubricant that has been provided to all bolts, fasteners and clamps. A pouch with anti-seize lubricant is included with the hardware kit. Apply the supplied anti-seize lubricant to the threads **ONLY** of all TORCA band clamps. Failure to follow this procedure can cause the nuts to seize on clamps and potentially damage threads. **WARNING:** Be sure to thoroughly clean hands after use. Anti-seize lubricant will tarnish stainless steel parts.

**System Removal for Extended Cab/Short Bed (EC/SB):  
(See Page 2 for Crew Cab/Short Bed System Removal)**

- 1) In order to remove factory exhaust system from vehicle and install your CORSA exhaust system, the pipe between the Catalytic Converter and Muffler must be cut. Measure 2-inches from the O2 Oxygen Sensor back towards the Muffler (See Fig A1).

NOTE: Recheck your measurement and be sure to support muffler to prevent injury.

It is recommended that a chain-style pipe cutter be used to make the cut (See Fig B1).

- 2) Next, remove the clamp from the other pipe entering the front of the Muffler (See Fig C1).

**IMPORTANT:** Be sure to follow the correct instructions for your vehicle (i.e. EC/SB or CC/SB) and the correct instructions for the system purchased (i.e. single side exit or split dual side exit).

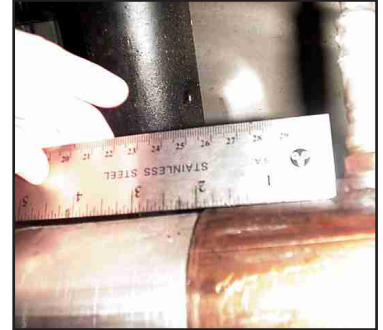


FIG. A1

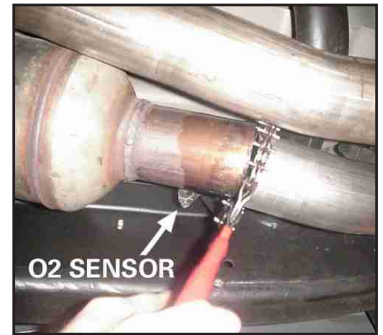


FIG. B1



FIG. C1

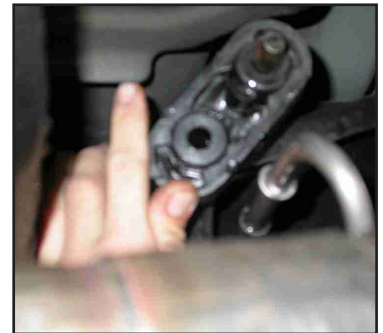


FIG. D1

3) Now remove the rubber insulator from the front Muffler hanger (**See Fig D1**). Be sure to keep the rubber insulator as it will be needed for the installation.

4) Next, remove the rubber insulators from rear Muffler (**See Fig E below**) and Tail Pipe hangers (**See Fig F below**).

**NOTE: Use lubricant on all hangers and rubber insulators to facilitate removal.**

5) Now the entire factory exhaust system can be removed in one piece (**See Fig G below**).



FIG. E

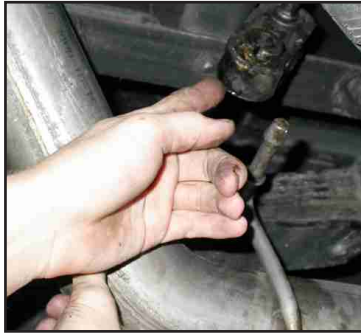


FIG. F

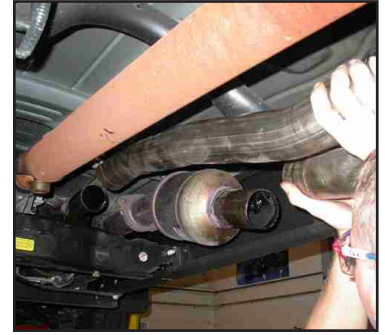


FIG. G

### System Removal for Crew Cab/Short Bed (CC/SB):

1) Locate the Intermediate Pipe with a factory hanger and measure 2-1/2" back towards the muffler and mark pipe (**See Fig. A2**). Using a straight edge, mark another cut line on the adjacent Intermediate Pipe (**See Fig. B2**).

**NOTE: Recheck your measurement and be sure to support muffler to prevent injury.**

It is recommended that a chain-style pipe cutter be used to cut each Intermediate Pipe (**See Fig. C2**).

2) Now remove the rubber insulator from the front of the Muffler hanger (**See Fig. D2**). Be sure to keep the rubber insulator as it will be needed for the installation.

3) Next, remove the rubber insulators from rear Muffler (**See Fig. E above**) and Tail Pipe hangers (**See Fig. F above**).

**NOTE: Use lubricant on all hangers and rubber insulators to facilitate removal.**

4) Now the entire factory system can be removed in one piece. (**See Fig. G above**)



FIG. A2



FIG. B2



FIG. C2

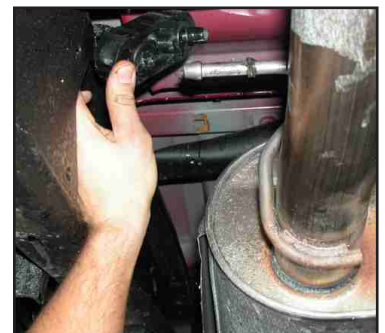


FIG. D2

## Installation for Extended Cab/Short Bed (EC/SB):

1) Locate Intermediate Pipe and slide supplied TORCA clamps over each inlet end (**See Fig H1**). Next, position Intermediate Pipe over factory outlet pipes (**See Fig I1**) and snug fit clamps (**See Figs. J & K**).



FIG. H1



FIG. I1

2) Insert Intermediate Pipe hanger in rubber insulator (**See Fig L**).

3) Next, locate Muffler and slide a supplied TORCA clamp over inlet end (**See Fig M**) and slide over Intermediate Pipe outlet (**See Fig N**) and snug fit clamp.

## Installation for Crew Cab/Short Bed (CC/SB):

1) Locate Intermediate Pipe and slide supplied TORCA clamps over each inlet end (**See Fig H2**). Next, position Intermediate Pipe over factory outlet pipes (**See Fig I2**) and snug fit clamps (**See Figs. J & K**).



FIG. H2



FIG. I2

2) Insert Intermediate Pipe hanger in rubber insulator (**See Fig L**).

3) Next, locate Muffler and slide a supplied TORCA clamp over inlet end (**See Fig M**) and slide over Intermediate Pipe outlet (**See Fig N**) and snug fit clamp.



FIG. J



FIG. K



FIG. L



FIG. M



FIG. N

**FOR SINGLE SIDE EXIT SYSTEMS W/ TWIN PRO-SERIES 4.0 TIPS, FOLLOW THESE INSTRUCTIONS: (For Split Dual Side Exit exhaust systems w/ hydroformed tip, see page 5.)**

- 4A) Locate Tail Pipe and slide a supplied TORCA clamp over inlet end (**See Fig O**). Then route the inlet end over the axle housing, slide over Muffler outlet (**See Fig P**) and snug fit clamp. The Tail Pipe hanger can now be inserted into rubber insulator (**See Fig Q**).
- 5A) Insert Tail Pipe rear hanger into rubber insulator (**See Fig R**).
- 6A) Locate dual 4" Pro-Series tip assembly and slide a supplied TORCA clamp over inlet. Next slide assembly over Tail Pipe (**See Fig. S**) and snug fit clamp.
- 7A) Check for clearance from the front of the installed exhaust system to the Tail Pipe. Once clearance adjustments are made, start tightening each TORCA clamp beginning with the Intermediate Pipe clamp.
- 8A) Check alignment of tips first using a level (**See Fig. T**) and be sure to allow clearance between the top of the Tip Assembly and the body panel. Make necessary adjustments, including fore and aft, and begin tightening each clamp as noted in **Fig. MM. Torque Setting: 45 ft.-lbs.**
- 9A) It is MANDATORY that all clamps be checked and tightened if necessary after road testing the vehicle and only after system has cooled.



FIG. O



FIG. P



FIG. Q



FIG. R



FIG. S



FIG. T

**FOR SPLIT DUAL SIDE EXIT EXHAUST SYSTEMS W/ HYDROFORMED TIPS,  
CONTINUE HERE:**

- 4B) Locate Split Tail Pipe Assembly and slide a supplied TORCA clamp over the inlet (**See Fig. U**). Then slide the inlet (expanded) end over Muffler outlet making sure it is positioned as shown in **Fig. V**. Snug fit clamp for now. The Tail Pipe hanger can now be inserted into the rubber insulator (**See Fig. W**).
- 5B) Locate Rear Tail Pipe hangers [“U”-shaped Wire Loop & Plate] and hardware [threaded Mounting Plate, bolts and lock washers] (**See Fig. X**). Starting on either side of the vehicle, position one of the threaded rectangular-shaped mounting plates on top of the frame rail over the hole at the rear of the frame (**See Fig. Y & Z**).
- 6B) Insert the supplied 5/16”-18 bolt through one of the Tail Pipe Wire Loop & Plate hangers and thread it into the threaded Mounting Plate on top of the frame.  
**NOTE: At this time the factory PASSENGER SIDE Tail Pipe rubber insulator can be removed and discarded (See Fig. AA).**



FIG. U



FIG. V



FIG. W



FIG. X



FIG. Y



FIG. Z



FIG. AA



FIG. BB



FIG. CC

- 7B) Position the DRIVERS SIDE Wire Loop Hanger so the opening of the “U” shaped hanger faces in towards the spare tire and slightly toward the rear of the vehicle (**See Fig. GG**). Snug fit for now as the position will change once Tail Pipe is positioned.
- 8B) Mount the PASSENGER SIDE Wire Loop Hanger so the opening of the “U” shaped hanger faces out and towards the passenger side door (**See Fig. DD**). Snug fit for now as the position will change once Tail Pipe is positioned.
- 9B) Locate PASSENGER SIDE Tail Pipe (**See Fig. BB**) and slide a supplied TORCA clamp over the inlet (expanded end), route over the axle housing and slide over the **BOTTOM OUTLET** of the Split Tail Pipe Assembly (**See Fig. CC**). Snug fit for now as the position will change once Tail Pipe is positioned.
- 10B) Position the supplied rubber insulator on Wire Loop Hanger and insert PASSENGER SIDE Tail Pipe Hanger into the same rubber insulator (**See Fig. DD**).
- 11B) Locate DRIVER SIDE Tail Pipe (**See Fig. EE**) and slide a supplied TORCA clamp over inlet (expanded) end, route over the axle housing and slide over **UPPER OUTLET** of the Split Tail Pipe Assembly (**See Fig. FF**). Snug fit clamp at this time.
- 12B) Position supplied rubber insulator on Wire Loop Hanger and insert DRIVER SIDE Tail Pipe Hanger into the same rubber insulator (**See Fig. GG**).
- 13B) Locate Exhaust Tips (**See Fig. HH**) and slide a supplied TORCA clamp over inlet. Next slide an Exhaust Tip over each Tail Pipe (**See Fig. II**) and snug fit clamps making sure each clamping bolt is positioned to the outside of each Tail Pipe (**See Fig. JJ**).



FIG. DD Passenger Side

Rubber Insulator



FIG. EE



FIG. FF



FIG. GG Driver Side



FIG. HH



FIG. II



14B) Starting at the Intermediate Pipe, check clearance of each installed pipe and muffler, in particular near brake lines and differential vent tube on Driver Side (**See Fig. KK**). Use a supplied nylon tie to group lines together. **DO NOT PULL NYLON TIE TIGHT - BE SURE TO LEAVE SUFFICIENT PLAY FOR LINE(S) TO MOVE FREELY. (See Fig. LL).**

15B) Now begin tightening each clamp as noted in **Fig. MM. Torque Setting: 45 ft.-lbs.**

16B) It is **MANDATORY** that all clamps be checked and tightened if necessary after road testing the vehicle and only after system has cooled.



FIG. JJ



FIG. KK



FIG. LL

FIG. MM

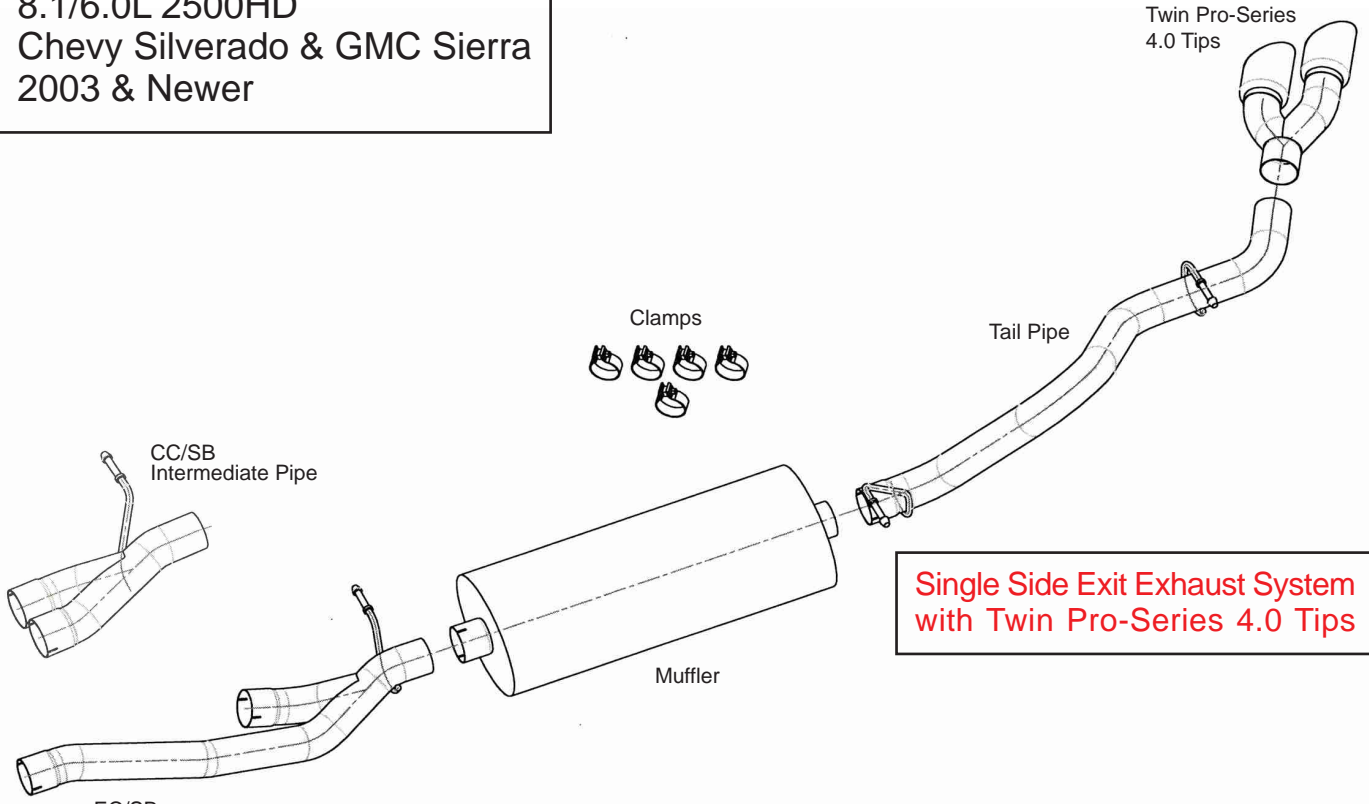


**NOTE: IMPORTANT-Make sure that the small drain hole in the muffler faces down when installed.**

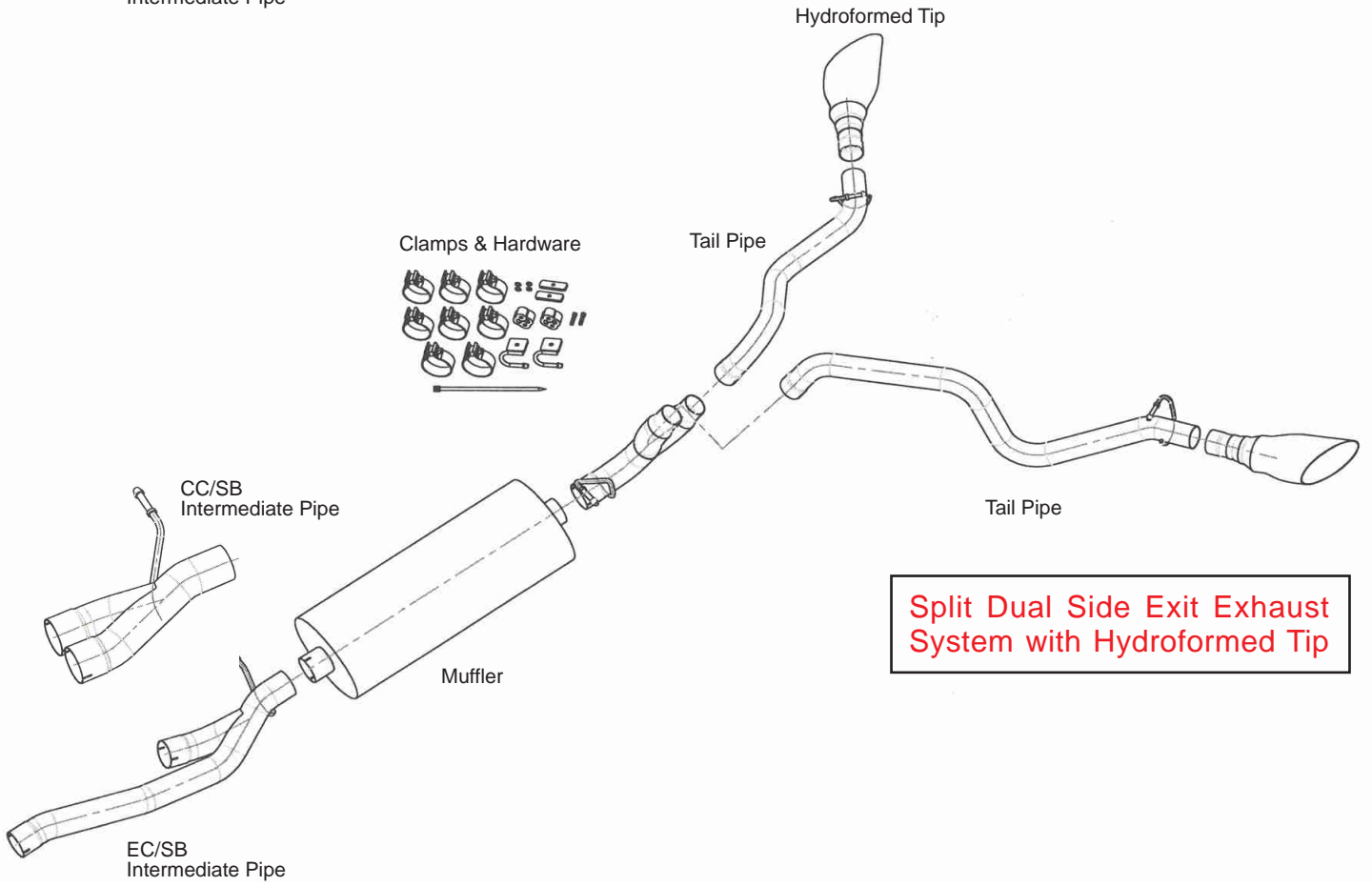
**NOTE:** During cold weather start-ups, you may experience an exhaust sound that is deeper and louder in tone than usual. This is temporary and will diminish to normal levels once your engine has reached its normal operating temperature.

**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.

8.1/6.0L 2500HD  
Chevy Silverado & GMC Sierra  
2003 & Newer



Single Side Exit Exhaust System with Twin Pro-Series 4.0 Tips



Split Dual Side Exit Exhaust System with Hydroformed Tip