



**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.

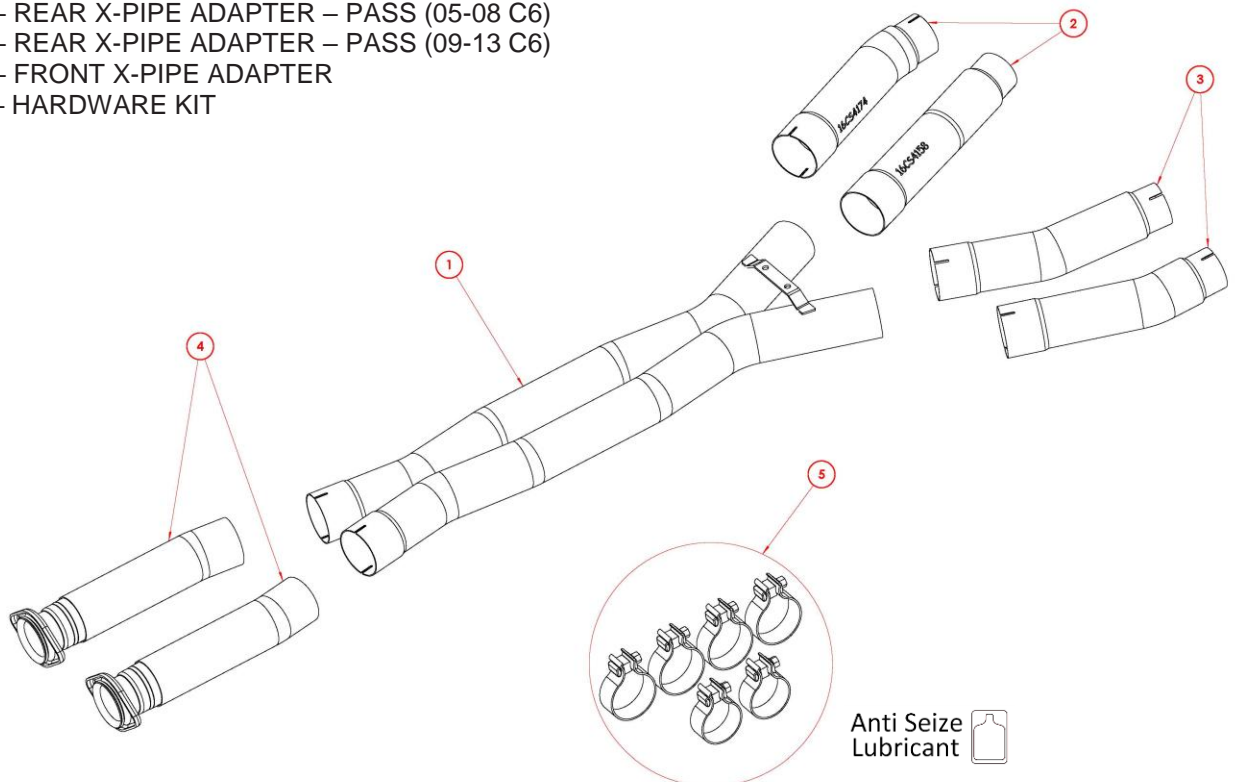
Recommended Tools:

- 3/8" drive ratchet
- 3/8" drive torque wrench
- 3/8" drive 13mm socket
- 3/8" drive 15mm deep socket
- Flat head screw driver
- Torque wrench
- Penetrating lubricant spray
- Safety glasses

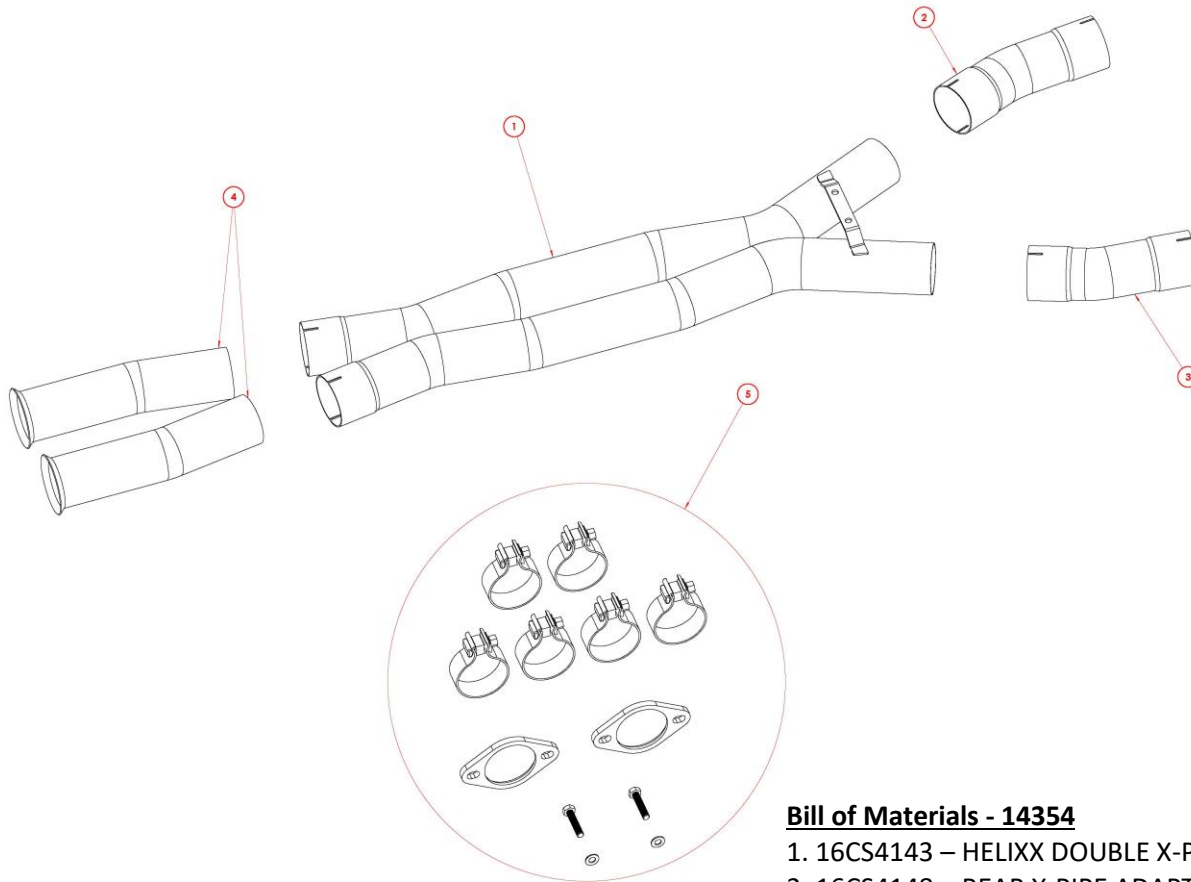
Please confirm that all parts are present before beginning the factory exhaust system removal and CORSA exhaust system installation.

Bill of Materials 14352 & 14353

1. 16CS4143 - HELIXX DOUBLE X-PIPE
2. 16CS4157 - REAR X-PIPE ADAPTER - DRIVER (05-08 C6)
16CS4175 - REAR X-PIPE ADAPTER - DRIVER (09-13 C6)
3. 16CS4158 - REAR X-PIPE ADAPTER - PASS (05-08 C6)
16CS4174 - REAR X-PIPE ADAPTER - PASS (09-13 C6)
4. 16CS4165 - FRONT X-PIPE ADAPTER
5. 18VP7000 - HARDWARE KIT



14354 (2006-2011 C6 ZO6)



Bill of Materials - 14354

1. 16CS4143 – HELIXX DOUBLE X-PIPE
2. 16CS4148 – REAR X-PIPE ADAPTER – PASS
3. 16CS4149 – REAR X-PIPE ADAPTER – DRVR
4. 16CS4169 – FRONT X-PIPE ADAPTER
5. 16CS7030 – HARDWARE KIT

Factory Exhaust System Removal:

1. Using a 3/8" drive ratchet and 15mm deep socket, loosen the two clamps at the driver and passenger side axle pipe connection points. **(Fig. A)**
2. Using the 3/8" drive ratchet and 13mm socket loosen and remove the two nuts holding the spring hangers just before the transmission. **(Fig. B)** Place the hardware in a safe location as it will be reused during the installation for your Helixx Double X-Pipe.
3. Using a 3/8" drive ratchet and 15mm deep socket, loosen the four flange nuts holding the two flanges at the cat-back connection point. **(Fig. C)** Store the hardware in a safe location as it will be reused during the installation process. Slide the two flanges off of the studs. Next, push the x-pipe rearward and angle the front of the x-pipe down. Slide the x-pipe forward to remove it from the axle-back connection points. **(Fig. D)**

NOTE: Have a friend hold and push down on the rear exhaust tips while you lower and raise the front of the stock x-pipe. This will help break the axle-back connections loose.

REMOVAL PICTURES ON NEXT PAGE



Factory X-Pipe Removal Pictures:



Fig. A



Fig. B

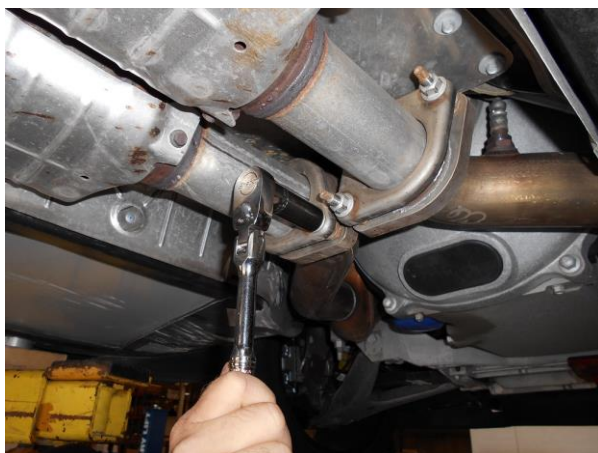


Fig. C

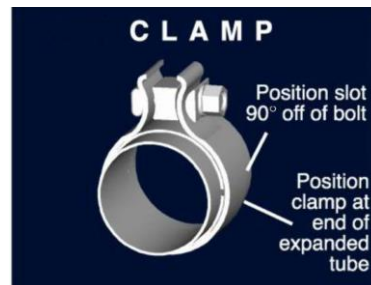


Fig. D

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. Remove all exhaust system components from the shipping boxes, including clamps and hardware.

2. **FOR 2006-2011 C6 ZO6 – CONTINUE TO STEP 2A**
FOR ALL OTHERS – CONTINUE TO STEP 2B

2A. Locate the two double x-pipe inlet adapters, two 3" clamps, the double x-pipe, and two flanges located in the hardware kit. Install the flanges on the front adapters so that the chamfer is towards the flare. **(Fig. F)** Next, Position the clamps on the expanded inlet ends of the double x-pipe so that when the x-pipe is installed the bolt on the clamp is vertical with the nut towards the ground the bolt towards the outside of the vehicle. Insert the front double x-pipe adapters into the expanded inlet ends of the double x-pipe and snug the clamps using a 3/8" drive ratchet and 15mm deep socket. The front adapters should be positioned so that they are in plane with the double x-pipe. **(Fig. G)**

2B. Locate the two x-pipe inlet adapters, two 3" clamps and the double x-pipe. Position the clamps on the expanded inlet ends of the x-pipe so that when the x-pipe is installed the bolt on the clamp is vertical with the nut towards the ground and the bolt towards the outside of the vehicle. Insert the front double x-pipe adapters into the expanded inlet ends of the double x-pipe and snug the clamps using a 3/8' drive ratchet and 15mm deep socket. The front adapters should be positioned so that they are in plane with the double x-pipe. **(Fig. H)**

3. Locate the rear driver side double x-pipe adapter and a 3" clamp. All adapters have a laser etch with the two digits of their respective part numbers and an arrow indication direction of flow to help distinguish inlet and outlet sides. **(Fig. J)** Slide the clamp over the expanded **inlet** side of the adapter so that when installed, the bolt on the clamp is vertical, with the nut towards the ground and the bolt towards the center of the vehicle. Side the expanded inlet side of the adapter over the driver side x-pipe outlet. Position the rear adapter so that the outlet is slightly angled up. Snug the clamp but do not fully tighten at this point. **(Fig. I)**

INSTALLATION INSTRUCTIONS CONTINUED ON NEXT PAGE



4. Locate the passenger side rear adapter and a 3" clamp and repeat step 3 for the passenger side.
5. **If installing a 2006-2013 ZO6 kit, locate two 3" clamps.**
If installing on a base 2005-2013 C6, locate two 2.5" clamps.
Position the clamps on the outlet end of the rear adapter so that when installed the clamp bolt will be vertical with the nut towards the ground and the bolt towards the center of the vehicle. **(Fig. K)**
6. With the double x-pipe fully assembled, slide the x-pipe outlets into the corresponding driver and passengers axle pipe inlets. **(Fig. L)** Then, position the front of the x-pipe to the stock connection point along with the flanges. Using the existing hardware, secure the flanges on the x-pipe to the stock flanges. **(Fig. M & N)**

NOTE: Have a friend hold the x-pipe assembly level and centered with the chassis tunnel as you tighten down the hardware at the front flanges.

7. Insert the spring hangers into the holes on the rear x-pipe brace and secure using the existing hardware, 3/8" driver ratchet, and 13mm deep socket. **(Fig. O & P)**
8. Snug the driver and passenger side clamps at the axle back connection point using a 3/8" ratchet and 15mm deep socket. **(Fig. Q)** Adjust the system accordingly, including the adapter overlaps, the rear muffler depth and rotation, along with the tip depth and rotation, so that the tips are centered and aligned in the bumper valence. 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 45ft-lbs using the torque wrench and 15mm socket. **(Fig. R, S, & T)**

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 Installation Pictures



Fig. F



Fig. G



Fig. H



Fig. I



Fig. J



Fig. K

CORSA Installation Pictures



Fig. L

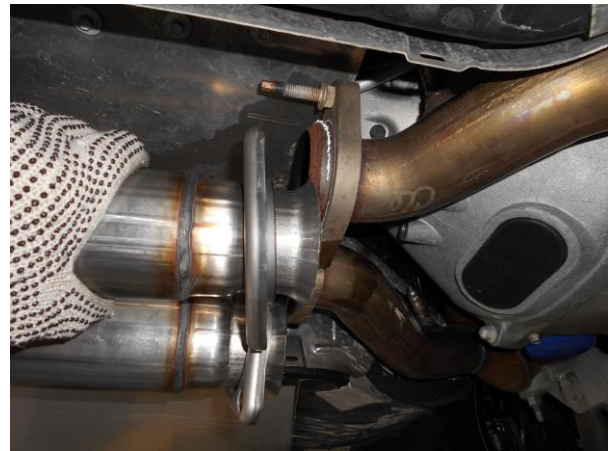


Fig. M



Fig. N



Fig. O

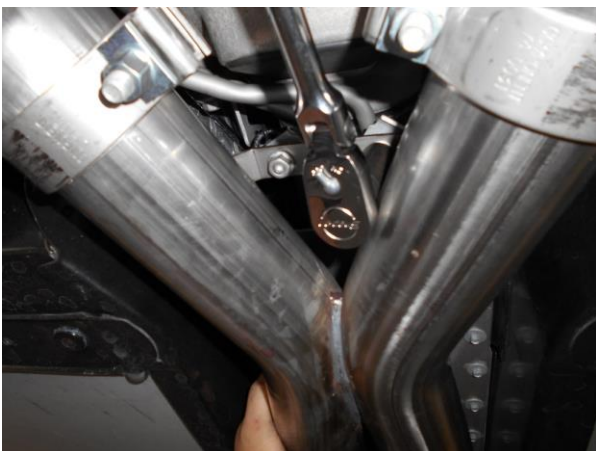


Fig. P



Fig. Q

CORSA Installation Pictures



Fig. R



Fig. S



Fig. T