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## Suggested Installation Instructions for:

**618-908, 618-910, 618-911, 638-010**

## 2005-2008 Corvette C6: Exhaust System

**6-Spd. Manual/4-Spd. Automatic (Does not apply to 2006 A6 Automatic)**

**Count on Mid America Motorworks for all your Corvette Parts and Corvette Accessories**

**Please take time to read and understand these installation instructions.**

MAM and CORSA recommend that installation of this system be performed by a qualified service center or professional muffler installer who has the necessary equipment, tools, and experiences 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:

- 13mm Socket
  - 15mm Socket
  - 18mm Socket
  - 15mm Open End Wrench
  - Torque Wrench (20-100 ft.-lb.)
  - Drive extensions for Ratchet
- (MINIMUM OF 17 INCHES)**

### Additional Tools for Auto Transmission Cars Only:

- Large Flat-head Screwdriver
- Rubber Mallet
- Needle Nose Pliers

## Bill of Materials:

### Sport System

**(MAM PN: 618-910), (CORSA PN: 14160)**

**(MAM PN: 618-911), (CORSA PN: 14169)**

- (1) Driver Side Over-the-Axle Pipe **(16CS4003)**
- (1) Passenger Side Over-the-Axle Pipe **(16CS4002)**
- (1) Driver Side Muffler Assembly **(16CS2002)(16CS2010)**
- (1) Passenger Side Muffler Assembly **(16CS2001)(16CS2009)**
- (1) Hardware Kit **(18VP7031):**
  - (2) Torca Clamps 2.5"
  - (1) Package Anti-Seize

### Conversion Kit

**(MAM PN: 622-468), (CORSA PN: 14162)**

- (1) Tunnel Muffler Assemblies **(16CS2006)**
- (1) H-Pipe Assembly **(16CS4007)**
- (1) Hardware Kit **(16CS7004):**
  - (4) Torca Clamps 2.5"
  - (1) Package Anti-Seize

### Touring System (Sport + Conversion Kit)

- (1) Driver Side Over-the-Axle Pipe **(16CS4003)**
- (1) Passenger Side Over-the-Axle Pipe **(16CS4002)**
- (1) Driver Side Muffler Assembly **(16CS2002)**
- (1) Passenger Side Muffler Assembly **(16CS2001)**
- (2) Tunnel Muffler Assemblies **(16CS2006)**
- (1) H-Pipe Assembly **(16CS4007)**
- (1) Hardware Kit **(16CS7004):**
  - (4) Torca Clamps 2.5"
  - (1) Package Anti-Seize
- (1) Hardware Kit **(16CS7003):**
  - (2) Torca Clamps 2.5"
  - (1) Package Anti-Seize

### Xtreme System

**(MAM PN: 638-010), (CORSA PN: 14469)**

- (1) Driver Side Over-the-Axle Pipe **(16CS4003)**
- (1) Passenger Side Over-the-Axle Pipe **(16CS4002)**
- (1) Driver Side Muffler Assembly **(16CS2054)**
- (1) Passenger Side Muffler Assembly **(16CS2053)**
- (1) Hardware Kit **(18VP7031):**
  - (2) Torca Clamps 2.5"
  - (1) Package Anti-seize

**CAUTION:** Prior to installation, be sure your vehicle is parked on a level surface, and your 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.

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 your vehicle.

**INSTALLATION NOTE:** Be sure to apply the provided anti-seize lubricant to all bolts, fasteners, and clamps. A pouch is included with the hardware kit. Apply the supplied anti-seize lubricant to the thread **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.

## Exhaust Removal

Your C6 must be raised high enough to remove the one-piece stock muffler over-axle pipe assemblies. A safe vehicle hoist is strongly recommended for this task.

**NOTE:** Be sure to save all nuts. These will be used to install your CORSA Performance exhaust system.

1. Using a 15mm socket or wrench, remove the four front flange nuts (See Fig. A).
2. Using a 13mm socket or wrench, remove the H-Pipe hanger nuts (See Fig. B).
3. Using a 15mm socket or wrench, loosen the clamps connecting the H-Pipe to the Rear Muffler Assembly (See Fig. C).
4. Slide the flanges off the bolts (See Fig. D).
5. Remove the H-Pipe assembly.
6. Using an 18mm socket and a 15mm open end wrench, remove the rear stabilizer bar mounting nut (See Fig. E).
7. Use an 18mm socket to remove the upper stabilizer bar mounting bolt (See Fig. F).
8. Swing the stabilizer bar down, away from the rear cradle.

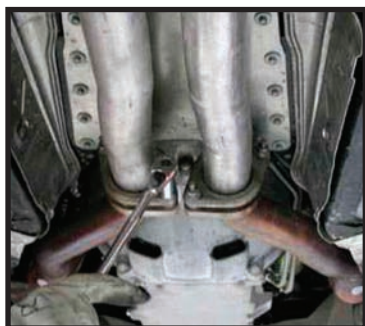


FIG. A

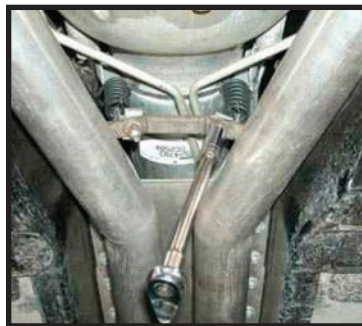


FIG. B



FIG. C



FIG. D



FIG. E



FIG. F

9. On the Passenger side, but tailpipe 3-4" after H-Pipe joint (**See Fig. G**). [2005 AUTOMATIC TRANSMISSION ONLY].
10. Slide the rear muffler hangers out of the rubber isolators, using soapy water to aid in removal if needed (**See Fig. H**).
11. Carefully slide the Driver side muffler out of the vehicle.
12. Carefully slide the Passenger side muffler out of the vehicle (**See Fig. I**).
13. Reinstall the stabilizer bar using the factory nuts and bolts. Tighten the bolts and nuts to factory specifications.
14. If installing a CORSA Performance C6 SPORT exhaust system, reinstall the factory H-Pipe at this point. Tighten the flange nuts and H-Pipe hanger nuts to factory specifications.



FIG. G



FIG. H



FIG. I

## CORSA Performance SPORT Exhaust Installation: \_\_\_\_\_

1. Remove all exhaust system components from the shipping carton, including clamps. **NOTE: There are two 2.5-inch clamps supplied.**
2. Locate the Driver side (16CS4003) and Passenger side (16CS4002) axle pipes (**See Fig. L & M**).
3. Slide both Driver and Passenger axle pipes into position from the rear (**See Fig. N**).
4. Insert the axle pipes into the H-Pipe outlets and snug fit the clamps (**See Fig. O**). **NOTE: If using the factory H-Pipe, axle pipe will not bottom-out in the expansion. This is as designed.**



FIG. I



FIG. J



FIG. K



**(Continued)**

5. Locate the Passenger side muffler (16CS2001, 15CS2009, or 16CS2053). Slide one Torca clamp onto muffler inlet **(See Fig. AB)**.
6. Slide the muffler hanger into the factory rubber isolators **(See Fig. Y)**.
7. Carefully align the muffler inlet to the axle pipe.
8. Slide the axle pipe into the muffler inlet expansion and snug fit the Torca clamp using the 17-inch extensions and a 15mm socket **(See Fig. W)**. **NOTE: All the muffler clamps should point towards the center of the vehicle when installed.**
9. Repeat Steps 6 to 9 above for the Driver side muffler (16CS2002, 16CS2010, or 16CS2054).
10. Adjust the entire system as necessary to achieve the desired tips location and clearance to all driveline components.
11. Starting from the front of the vehicle, tighten all Torca clamps to **45 ft.-lb.**
12. It is **MANDATORY** that all clamps and fasteners be checked and re-tightened (if necessary) after a road test. Make sure the system has cooled prior to touching any exhaust components.

**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.

## Conversion Kit Installation

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### CORSA Performance Sport to Touring Conversion Kit Installation:

**NOTE:** Be sure to save all nuts. These will be used to install your CORSA Performance exhaust system.

1. Using a 15mm socket or wrench, remove the four front flange nuts **(See Fig. A)**.
2. Using a 13mm socket or wrench, remove the H-Pipe hanger nuts **(See Fig. B)**.
3. Using a 15mm socket or wrench, loosen the clamps connecting the H-Pipe to the Rear Muffler Assembly **(See Fig. C)**.
4. Slide the flanges off the bolts **(See Fig. D)**.

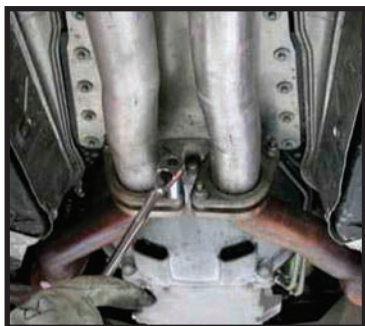


FIG. A

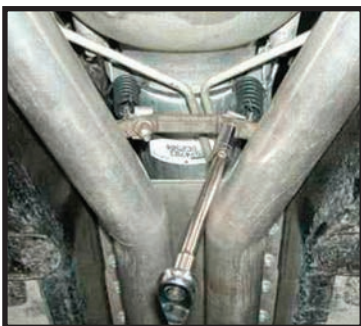


FIG. B

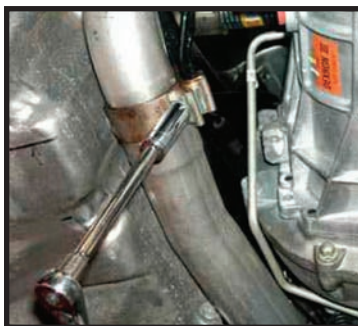


FIG. C

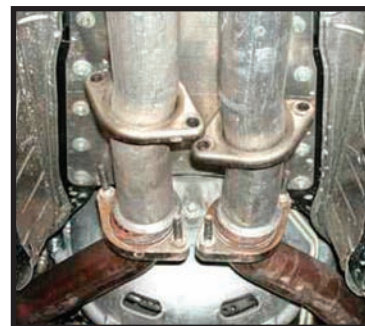


FIG. D

**(Continued)**

5. Remove the H-Pipe assembly.
6. Remove all Conversion Kit components from the shipping carton. **NOTE: There are four 2.5-inch clamps supplied.**
7. Locate one of the tunnel mufflers (16CS2006) **(See Fig. P)**.
8. Slide the flange over the flange bolts and snug tighten the nuts using a 15mm open end wrench **(See Fig. Q)**. The inlet of the muffler should be towards the center of the vehicle.
9. Repeat Step 8 for the other tunnel muffler.
10. Locate the H-Pipe assembly and the four Torca clamps (16CS4007).
11. Snug fit the clamps onto the inlet and outlet ends of the H-Pipe assembly **(See Fig. R)**.
12. Slide the H-Pipe assembly onto the tunnel mufflers and tighten both clamps to **45 ft.-lb. (See Fig. S)**.
13. Tighten the flange nuts to factory specifications.
14. Insert each axle pipe into the corresponding H-Pipe outlet and tighten both clamps to **45 ft.-lb.**
15. Using a 13mm socket or wrench, install the H-Pipe hanger nuts. Tighten to factory specifications **(See Fig. T)**.
16. It is **MANDATORY** that all clamps and fasteners be checked and re-tightened (if necessary) after a road test. Make sure the system has cooled prior to touching any exhaust components.



FIG. P



FIG. Q



FIG. R



FIG. S



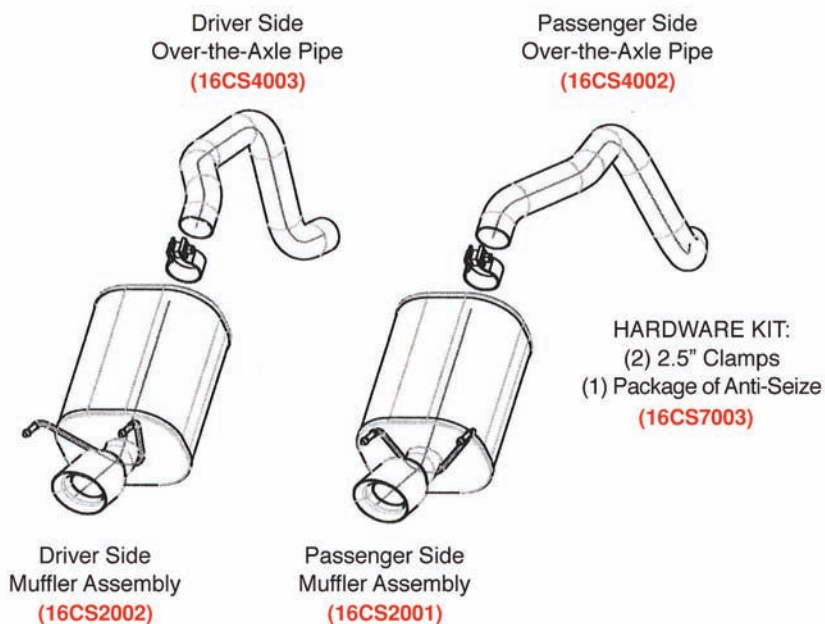
FIG. T

**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 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.

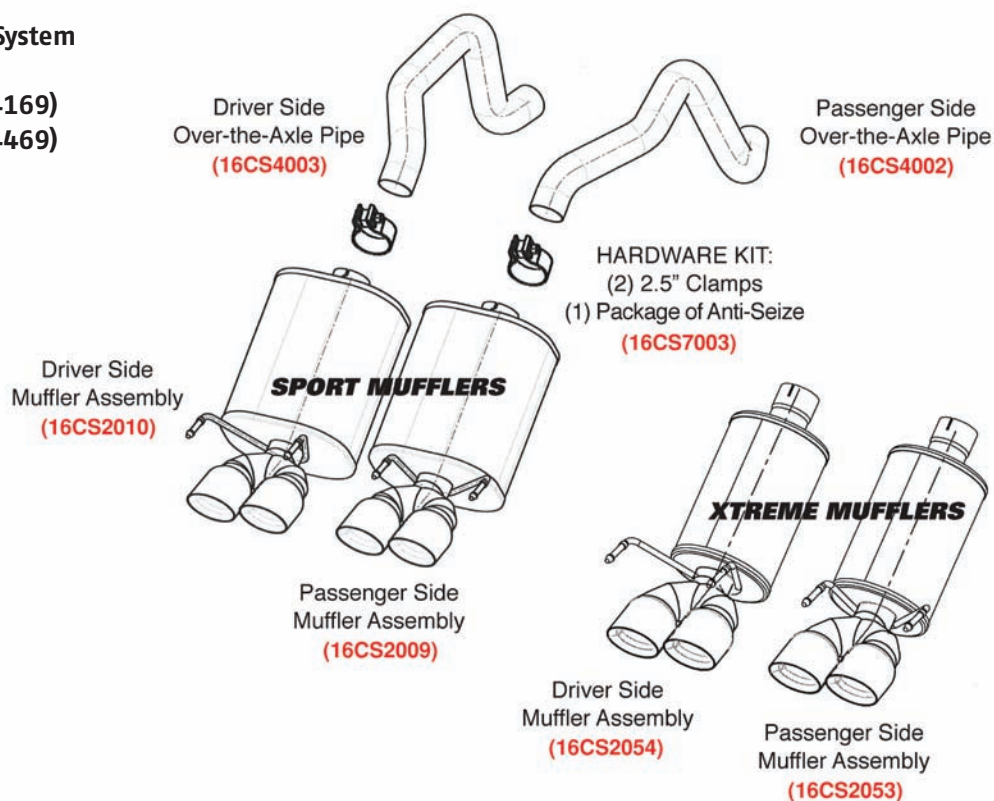
## SPORT

2005 Corvette C6 – Sport Exhaust System  
 4.0" Pro-Series Tips  
 (MAM PN: 618-910), (CORSA PN: 14160)



## SPORT & XTREME

2005 Corvette C6 – Sport Exhaust System  
 Twin 3.5" Pro-Series Tips  
 (MAM PN: 618-911), (CORSA PN: 14169)  
 (MAM PN: 638-010), (CORSA PN: 14469)



## TOURING

2005 Corvette C6  
 Touring Exhaust System = Sport Exhaust System + Conversion Kit

## CONVERSION KIT

2005 Corvette C6

Conversion Kit

(MAM PN: 622-468), (CORSA PN: 14162)

