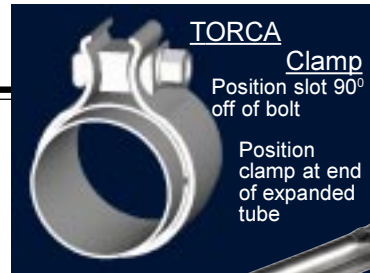




# Installation Instructions

## The Ultimate C5 Crossover Pipe™

Part number 14131



### Tools Required:

Chain cutter  
9/16" socket  
9/16" wrench  
15mm. socket  
13mm. socket  
5/16" allen wrench  
Black marking pen  
Ruler (straight-edge)  
Socket wrench (3/8" drive)  
Socket wrench extension  
Hammer (rubber mallet)  
Paper towels or rags  
Sandpaper or file  
Torque Wrench

### System Contents:

(1) Crossover pipe assembly  
(2) TORCA band clamps  
(2) Flange gaskets  
(4) 3/8" - 16x11/4" stainless bolts  
(4) 3/8" - 16 serrated flange nuts  
(1) Pkg. Anti-Seize lubricant

### Torque Settings:

2 1/2" TORCA band clamps- 35ft. lbs.  
Over-the-axle pipe flange bolts- 37ft. lbs.  
Center hanger bracket- 10-12 ft. lbs.



- (1) With your Corvette parked on a level surface, jack it up and support it with four jack stands. Give yourself enough room to work under the car comfortably. **The safest and preferred method would be to use a lift.**
- (2) Remove the CORSA Crossover Pipe, hardware kit and the installation instruction packet from the shipping carton.
- (3) Carefully review the installation instructions to make sure you have the tools required as indicated to perform the install - including a chain cutter available at auto parts stores.
- (4) Locate the two oxygen sensors mounted in the pipes behind each catalytic converter, referred to as intermediate pipe assembly. (see Fig. A) and locate the floor brace which is located several inches after the oxygen sensors (see Fig. B)
- (5) Using a straight edge ruler held perpendicular to the intermediate pipe assembly from the rear side of the brace, position the ruler at the rear of the floor brace connecting points as shown (see Fig. C) Place "reference" marks on each pipe. **These will serve as starting points to measure from to determine the "cut" marks.** (see Fig.D)
- (6) Measure back 2-inches from the reference mark on the **PASSENGER SIDE** pipe and make a mark. **This will represent the cutting location for the PASSENGER SIDE pipe**
- (7) Measure back 3 1/2-inches from the reference mark on the **DRIVER'S SIDE** pipe and make a mark. **This will represent the cutting location for the DRIVER'S SIDE pipe.**

### **Measure twice - cut once rule - Re-check steps and measurements.**

- (8) Using a chain cutter, cut the two staggered marks made on the intermediate pipe assembly. **IMPORTANT:** Be sure to follow the chain cutter instructions prior to making the final cuts. After the final cuts are made, your cuts should look like those in Figure E.

CAUTION: The cut edges are sharp, it would be a good idea to use sandpaper or a file to dull the edges.

- (9) Next remove the bolts from the intermediate pipe assembly to the over-the-axle pipe flanges (see Fig. F)
- (10) Remove the two intermediate pipe hanger bracket bolts. Save these bolts, as they will be needed to install your CORSA Crossover Pipe. (see Fig. G)
- (11) Locate the two CORSA TORCA band clamps from the hardware kit and slip them over the catalytic converter pipes - do not tighten (see Fig. H) Note direction of clamps!

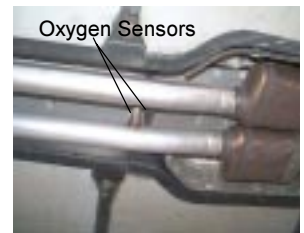


Fig. A

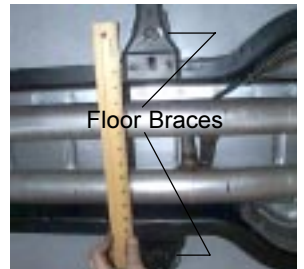


Fig. B



Fig. C



Fig. D

- (12) Now slip the CORSA Crossover Pipe over the intermediate pipe assembly with the Crossover Pipe hanger bracket facing up. Driver and passenger side inlets are labeled.
- (13) Reuse the center hanger bracket support bolts and lightly tighten.
- (14) Locate the supplied flange bolts and gaskets in the hardware kit. Insert new gaskets at each flange and using supplied flange bolts, lightly tighten. (see Fig. I)
- (15) Slip the CORSA TORCA band clamps over Crossover Pipe and lightly tighten. (see Fig. J)
- (16) Before tightening, check to make sure everything is aligned and centered. Then proceed to tighten the CORSA TORCA band clamps (see Fig. K), flange bolts (see Fig. L) and center hanger bracket (see Fig. M)

**Torque Settings:** TORCA band clamps- 35 ft. lbs., Flange bolts- 37 ft. lbs. and center hanger bracket- 10-12 ft. lbs.

- (17) Once installation is complete, start engine and check to ensure there are no leaks or rattles.

**Note:** Apply anti-seize lubricant (supplied) to the threads of the TORCA muffler band clamps, flange bolts & hanger bracket bolts. Failure to follow this procedure can cause nut to seize on clamp and potentially destroy threads.

**Note:** After applying Anti-Seize lubricant, be sure to thoroughly clean hands. Anti-Seize lubricant will tarnish stainless steel parts.



Fig. E



Fig. F



Fig. G



Fig. H



Fig. I



Fig. J



Fig. K



Fig. L



Fig. M