PART NUMBER: 208.50.4800
APPLICATION: 1997–2004 CORVETTE
INSTRUCTION SHEET NUMBER: 908.50.9900A

PACKAGE CONTENTS:

- Instruction Sheet
- Pipe, Over-Axle, LH
- Pipe, Over-Axle, RH
- Muffler, LH
- Muffler, RH
- Tip Assembly, Double-D
- Pipes, Muffler Inlet (2)
- Clamps, Large, for Tip Inlet (2)
- Washers, Over-Axle Flange Box Cover (4)
- Clamps, Small, for Muffler Inlet Pipes (4)

TOOLS REQUIRED:

- Torque Wrench
- 3/8" Drive Socket Set
- 1/2" Drive Socket Set
- Metric Wrench Set
0 READ THIS FIRST

Review the entire instruction manual before proceeding with the installation. If any of these steps are not clear, please call (860) 434–9002 or e-mail us at techinfo@callawaycars.com for further explanation.

A working knowledge of the C5 Corvette is assumed as well as good mechanical practices. When checking the kit contents against the packing slip, make sure that no parts were damaged during shipping.

This installation involves raising the vehicle to gain access to the exhaust system. Whenever the car is lifted, be sure to use suitable jackstands or a locking vehicle lift to support your car’s weight.

If any of these instructions are unclear, call Callaway Technical Service at (860) 434–9002 for assistance.

1 REMOVE OLD SYSTEM

F) Hinge LH muffler down to clear the rear fascia, and pull the over-axle pipe clear of the vehicle.

G) Remove the two (2) 13mm nuts from RH muffler hanger.

H) Lower RH muffler until the hanger clears the studs in the bumper beam.

CAUTION: DO NOT PUSH STUDS INTO BUMPER BEAM.

I) Hinge RH muffler down to clear the rear fascia, and pull the over-axle pipe clear of the vehicle.

2 INSTALL OVER-AXLE PIPES

J) Inspect the over-axle pipe gaskets for damage and replace if necessary.

K) Install RH over-axle pipe as follows: Inspect and remove any stickers or residue as required.

L) Slip the RH pipe over the axle.

M) Install one of the supplied washers onto each 15mm bolt.

N) Install the gasket and the two (2) bolts at the pipe flange connection.

O) Holding the over-axle pipe flange centered on the catalytic converter pipe flange, tighten the bolts to 37 lb-ft.

P) Install LH over-axle pipe as follows: Inspect and remove any stickers or residue as required.

Q) Slip the LH pipe over the axle.

CAUTION: DO NOT PUSH STUDS INTO BUMPER BEAM.
2 INSTALL OVER-AXLE PIPES (cont.)

R) Install one of the supplied washers onto each 15mm bolt.

S) Install the gasket and the two (2) bolts at the pipe flange connection.

T) Holding the over-axle pipe flange centered on the catalyst pipe flange, tighten the bolts to 37 lb-ft.

3 INSTALL MUFFLERS (cont.)

J) Slide the Tip Assembly as far as it will go onto the RH muffler outlet, obeying any markings on the Tip for Driver and Passenger side.

K) Install LH Muffler as follows: Transfer muffler hanger to new muffler.

L) Slip an elbow and one of the smaller clamps onto the LH over-axle pipe.

M) Place the remaining smaller clamp onto the LH muffler inlet.

N) Align the muffler inlet elbow to approximately the same angle as the Tip Assembly inlet.

O) Start the LH muffler into the elbow and the Tip Assembly, rocking the muffler as required.

P) Rotate the muffler until it clears the rear fascia.

Q) Push the muffler up into place, rotating it back to level after clearing the rear fascia.

R) Align the muffler hanger to the studs coming out of the bumper beam.

CAUTION: DO NOT PUSH STUDS INTO BUMPER BEAM.

S) Start and tighten the two (2) 13mm nuts for the LH hanger. Torque to 12 lb-ft.

T) Tighten the two (2) 13mm nuts on the RH muffler hanger that were left loose earlier. Torque to 12 lb-ft.

U) Make sure that the pipes are inserted fully and space cannot be seen in the clamping slot.

V) Snug the clamps on the muffler inlet, and the elbow to over-axle joint enough to give the pipes traction, but not fully tightened yet.

W) With the Tip Assembly hanging down, remove any stickers or residue.
**FINAL ADJUSTMENTS**

A) Adjust both mufflers to be parallel with the curve of the side of the rear fascia, they should hang down approximately 1/2” below the opening of the fascia.

B) The mufflers should appear to be level with each other, while allowing the Tip Assembly to rotate freely, and slide side-to-side within the two mufflers.

C) If installing the optional Tip Surround Panel (P/N 250.50.5200), do so at this time.

D) Snug the clamps on the Tip Assembly to give the pipes traction.

E) If not using the Tip Surround Panel, rotate the Tip Assembly up so that it is level and centered in the opening.

F) If using the Tip Surround Panel, the Tip Assembly should be centered in the opening with a gap of approximately 1/2” at the closest point on both sides, and a 1/2” gap at the top.

G) Verify that the Tip Assembly and Mufflers appear to be positioned correctly and symmetrically.

H) Tighten Clamps in the following order:
   1) Over-axle pipe to elbow
   2) Elbow to muffler inlet
   3) Tip to muffler

I) Re-Install Rear Sway bar to cradle:
   1) Tighten top bolts to 49 lb-ft.
   2) Tighten lower nuts to 70 lb-ft.

J) Wipe down the entire system of any fingerprints before starting the engine.

**REFERENCE PICTURE OF INSTALLED SYSTEM**

![Reference Picture](image-url)