



# YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

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[www.yoshimura-rd.com](http://www.yoshimura-rd.com)

## *Signature Series*

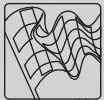
Qualified Manufacturer Declared "Replacement Part"

**2025**

**Honda CRF450R**

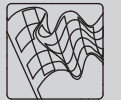
**2258605520 (SS/SS)**

**RS-12 Stainless Steel Full-System**



Signature Series systems are:

- CARB/EPA tail-pipe emissions compliant.
- Marked with appropriate EPA noise labels.
- Independent laboratory tested for EPA new vehicle noise compliance.

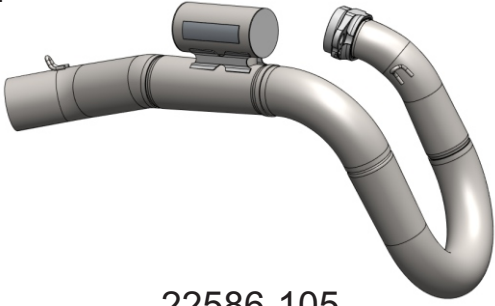


*You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new Yoshimura exhaust depending on the application. Read through all instructions before beginning installation. Exhaust system can be extremely hot. Let motorcycle cool down before beginning installation. Always wear hand and eye protection and take precautionary measures to avoid injury.*



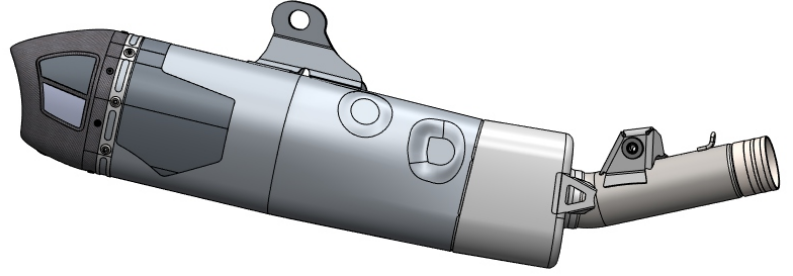
NOTE: IN THE STATE OF CALIFORNIA, IT IS ILLEGAL TO MODIFY THE EMISSION CONTROL SYSTEM, WHICH INCLUDES THE CARBURETORS OF ANY VEHICLE.

x1



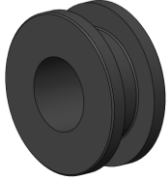
22586-105  
Header

x1



225860S520-RMA  
Muffler

x1



Z1024  
Rubber Grommet

x1



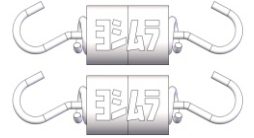
ALS-074  
Aluminum Spacer

x1



RACE-SPS-1  
Medium Spring

x2



RACE-SPX-2  
Small Spring

x1



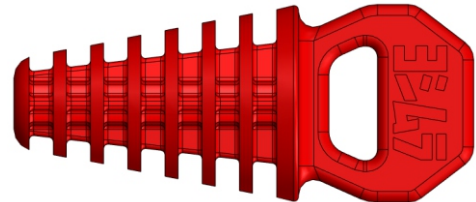
ALS-064  
Aluminum Spacer

x1

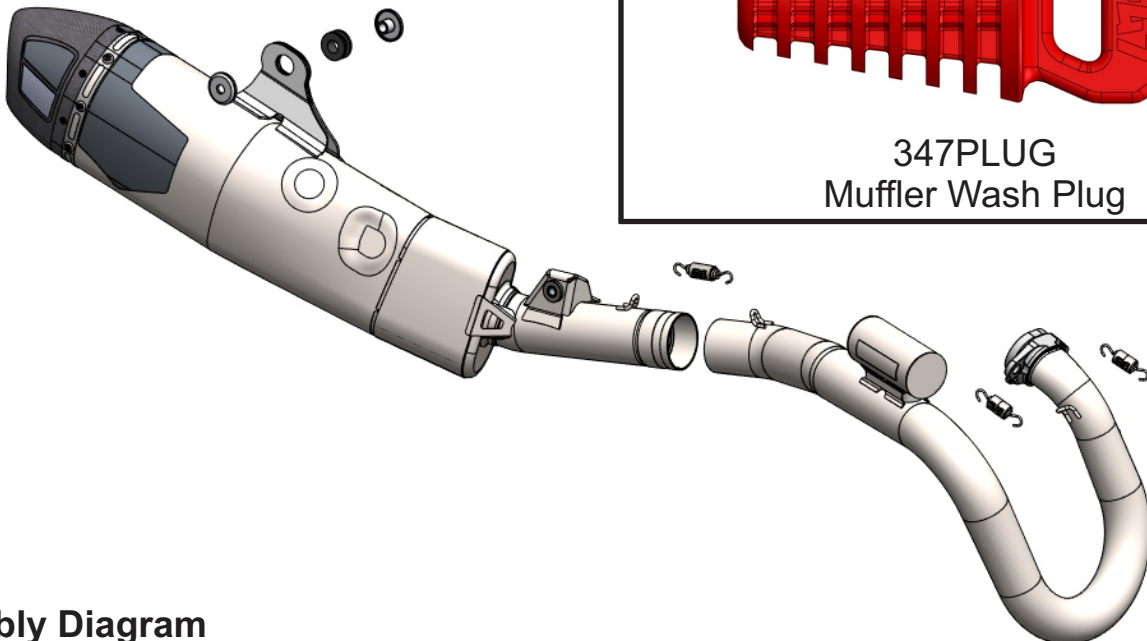


ST-200  
Spring Puller Tool

x1



347PLUG  
Muffler Wash Plug



Assembly Diagram

**CAUTION:** Exhaust system can be extremely hot. Let motorcycle cool down before beginning installation. Always wear hand and eye protection and take precautionary measures to avoid injury.

**WARNING:** Always properly support vehicle with a stand and/or lift when servicing or performing any work. Unstable vehicles may present dangerous conditions and may cause property damage and/or personal injury.

**NOTE:** Read through all instructions before beginning installation.

## Removal

1. Remove the right side panel.
2. Loosen muffler exhaust clamp.
3. Remove muffler tailpipe chassis mount bolt.
4. While securely supporting the stock muffler assembly, remove muffler mount bolt and carefully remove the stock muffler assembly.
5. Remove the header nuts and carefully remove the stock header.

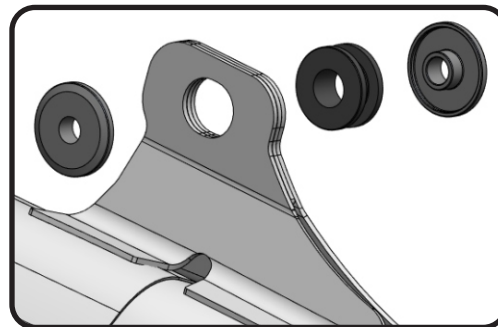
Note<sup>1</sup>: The stock exhaust port gasket will be re-used with the Yoshimura full-system exhaust. Inspect and replace if necessary.

Note<sup>2</sup>: If having difficulty removing the stock header, inspect stock header flange and/or exhaust port studs to see if bent. It may be necessary to use a soft mallet to remove the stock header off of the studs. After removing stock header, inspect exhaust port stud threads for damage and check to see if bent.

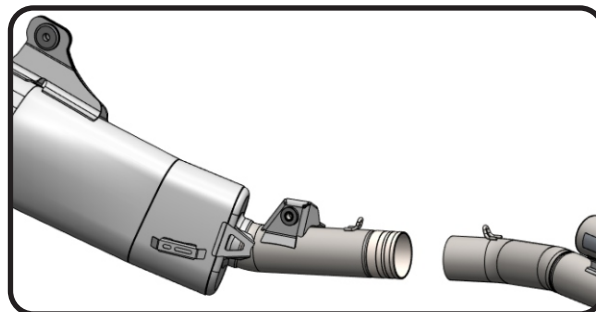
Note<sup>3</sup>: If exhaust port studs are bent, the Yoshimura header flange may not fit and the bent studs must be removed from the cylinder head prior to installing the Yoshimura system. It is recommended to replace using OEM studs. See supplemental exhaust port stud removal instructions at the end of this manual if necessary.

## Installation

1. Install 22586-105, Yoshimura header using the stock header nuts. Do not torque at this time.
2. Install Z1024, rubber grommet into muffler bracket and install ALS-074, aluminum spacers to the backside of the grommet and ALS-064, aluminum spacer to the frontside as shown.



3. Install 225860S520-RMA, Yoshimura muffler by sliding onto header outlet. Align tailpipe chassis mount bracket and muffler mount bracket to subframe and secure using the stock chassis mount and muffler mount bolts. Do not torque at this time.



4. Torque header nuts to factory specification.
5. Torque tailpipe chassis mount bolt to factory specification.
6. Torque muffler mount bolt to factory specification.
7. Using the ST-200, spring puller tool provided in the kit, install RACE-SPX-2, short exhaust springs between flange and header.
8. Install RACE-SPS-1, medium exhaust spring between muffler tailpipe and header connection.
9. Re-install right side panel following the opposite steps of removal.

10. Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swingarm, brakes, rear shock, and etc.) If any problem is found, please carefully follow through the installation steps again. If problem still persists, please call Yoshimura Tech Department at (800) 634-9166 / in CA (909) 628-4722.

11. It is recommended that the muffler and tailpipe be wiped down with rubbing alcohol to remove oil and fingerprints. This will help prevent tarnishing of the finish after the exhaust is heated up.

Note: After starting motorcycle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.

## **Machined Joint Care & Maintenance**

Clean and inspect machined joints when servicing the muffler during regular intervals.