



YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

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OFF-ROAD PERFORMANCE EXHAUST SYSTEM

HONDA
2011-2013
CRF250R

228402D321

STAINLESS STEEL SLIP-ON SYSTEM WITH ALUMINUM SLEEVE RS4



**THIS PRODUCT IS DESIGNED FOR USE IN CLOSED COURSE
RACING AND IS NOT INTENDED FOR ANY OTHER USE.**



CAUTION: The muffler packing on this system MUST be replaced every 6-8 hours of use, or after each moto. Failure to follow recommended muffler re-packing interval can cause muffler damage and may void the warranty.

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.

Note: Read through all instructions before beginning installation.

Tools Needed:

Metric Socket Set
Ratchet Wrench and Extension
Torque Wrench

Installation Steps:

1. Stock exhaust removal.

- Remove right side panel. (Fig. 1)
- Loosen the muffler clamp.
- Remove the 2 bolts that hold the muffler assembly to subframe. (See Fig. 2)
- Remove muffler.
- Remove muffler clamp.



Fig. 1

2. Yoshimura Slip-On system installation.

- Loosen header nuts to allow for header adjustment.
- Slide muffler clamp over tailpipe. Make sure that the clamp fits as far forward on the tailpipe, but does not overhang.
- Carefully install Yoshimura muffler assembly onto header.
- Using stock tailpipe mounting bolt, and supplied muffler mounting bolt, mount the muffler to subframe. Check for alignment and clearance while mounting hardware is loose.
- Yoshimura tailpipe will not stop against stock header stopper. There will be a 2-3mm gap between the front of the tailpipe and the header stopper.
- Tighten Header Nuts, Tailpipe, and Muffler Mount bolts to 16.5 ft-lb (23 N-m).



Fig. 2

3. *Reinstall stock side panel using the reverse steps of removal.*
4. *Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swing-arm, brake, rear shock, engine 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.*

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.

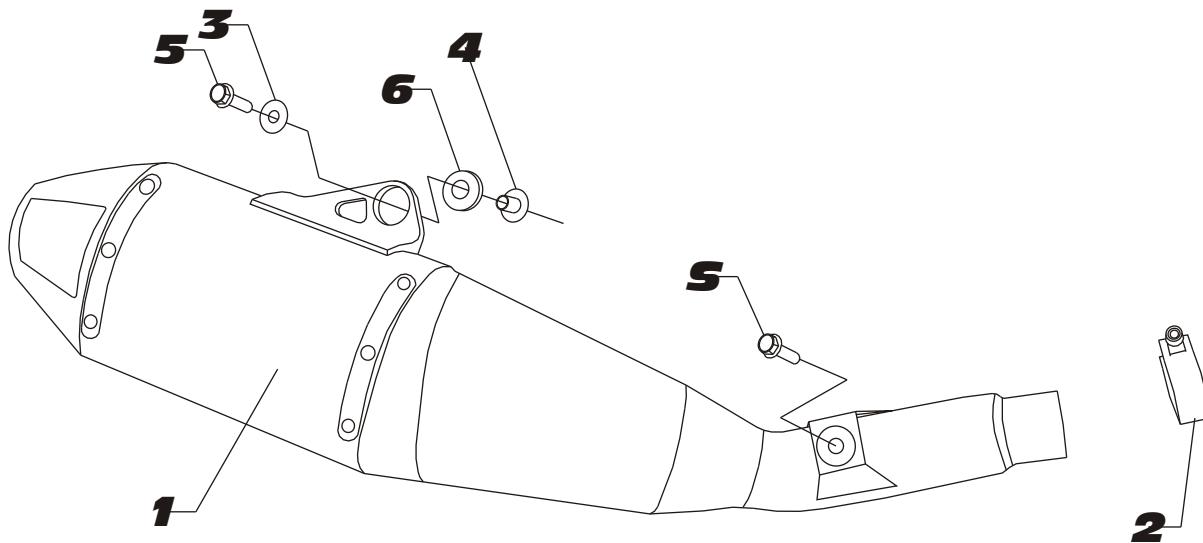
NOTE: *After starting motorcycle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.*

Fuel Injection Mapping:

For best results and to extract the most performance out of the Yoshimura system fuel injection mapping is recommended for closed course competition use only.

-It is recommended that idle be raised from 1800 rpm to 2000 rpm to prevent stalling.

Note: It is illegal to modify the fuel injection system of any vehicle in the state of California.

#228402D321**S=STOCK**

Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Muffler Assembly	1	228402D321-RMA
2	Exhaust Clamp	1	22055
3	8mm Washer Large	1	8MMWASHERL
4	Aluminum Spacer	1	ALS-003
5	8mm X 35mm Flanged Hex Head Bolt	1	M8X35H
6	Aluminum Bracket Rubber Grommet	1	Z1022
**	AMA 94dB Sound Insert Kit (Installed)	1	INS-17-K
**	2m-MAX Sound Insert Kit	1	INS-2M26-K
**	Offroad Endcap Plug	1	347PLUG
**	Yoshimura Vinyl Sticker	1	17029
OPTIONAL REPLACEMENT PARTS			
TEC-SD10 Spark Arrestor Kit		SA-04-K	
Re-pack Kit		REPACK-RS4-PK24	



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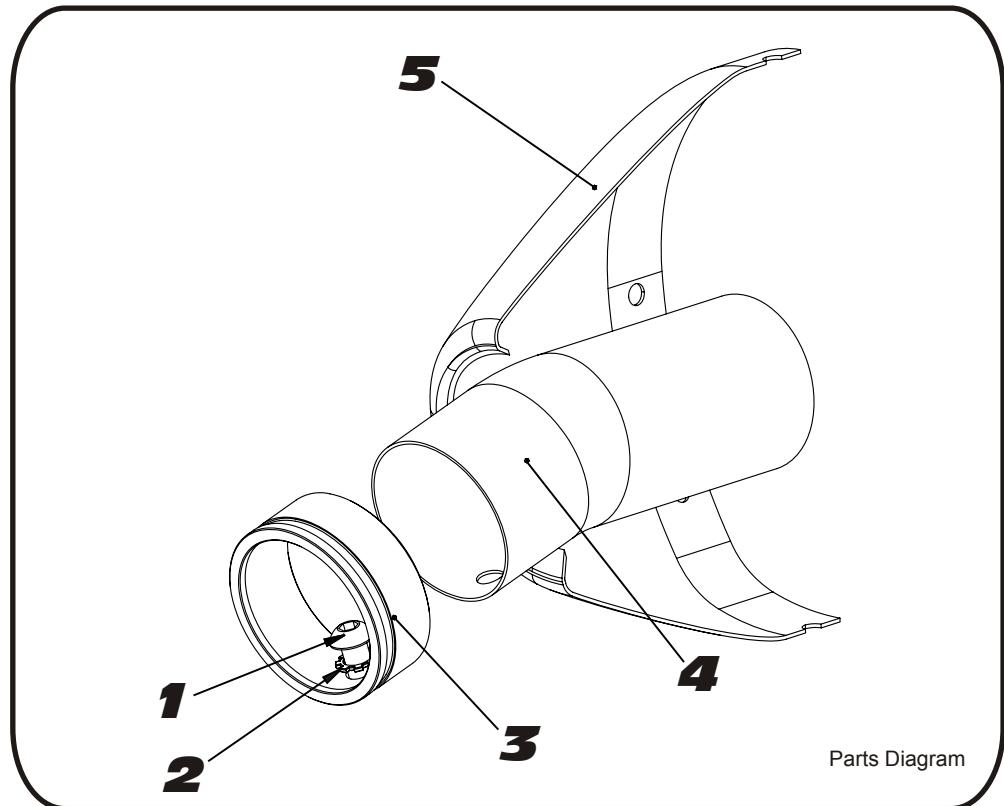
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INS-17-K

YOSHIMURA RS4 LOW VOLUME INSERT KIT



NO.	DESCRIPTION	QTY	PART #
1	6mm X 12mm Button Head Cap Screw	1	M6X12BHS
2	6mm Lock Washer	1	6MMLCKWSHR-TH
3	RS4 Aluminum Insert Ring	1	RS4-RING-1500
4	Low Volume Sound Insert	1	INS-X-00
5	Yoshimura Exhaust	**	**

- 1 *Using a 4mm Allen key, remove the bolt that secures the aluminum ring and sound insert to the muffler (see Parts Diagram for location).*
- 2 *Remove the sound insert from the muffler.*
- 3 *Inspect the sound insert for cracks or damage and replace if necessary.*
- 4 *Re-install sound insert and aluminum ring. Torque the sound insert securing bolt to 1.0 kg-m (7.3 lb-ft).*
NOTE: It is recommended that a low strength "Loc-tite" is used on the sound insert securing bolt.