



YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

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OFF-ROAD PERFORMANCE EXHAUST SYSTEM

**Yamaha
2007-2012
YZ250F**

231002D320

STAINLESS STEEL SLIP-ON WITH RS4 ALUMINUM SLEEVE



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 every 1-2 motos. Failure to follow recommended muffler re-packing interval can cause muffler damage and may void the warranty.*

NOTE: IN THE STATE OF CALIFORNIA, IT IS ILLEGAL TO MODIFY THE EMISSION CONTROL SYSTEM FOR HIGHWAY OR OFF-HIGHWAY USE, WHICH INCLUDES THE FUEL INJECTION SYSTEM OR CARBURETOR OF ANY VEHICLE.

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
Spring Puller Tool

Installation Steps:

1. Remove stock exhaust system.
 - a. Remove right rear number plate (see Fig. 1).
 - b. Loosen exhaust clamp and slide forward onto header. (see Fig. 2).
 - c. Remove muffler mounting bolts and remove muffler. (See Fig. 2)
 - d. Remove exhaust clamp from header.
 - e. Loosen stock header nuts.

2. Install Yoshimura exhaust system

- a. Insert rubber grommet into muffler mounting bracket.
 - b. Insert aluminum spacer into rubber grommet.

Note: Aluminum spacer is to rest between muffler and subframe. See Fig. 3.

- c. Slide supplied talipipe clamp onto stock header in orientation as shown in the parts diagram.
 - d. Insert muffler/tailpipe assembly onto header outlet.

Note: Yoshimura system does not retain stock gasket or exhaust clamp.

Note: It may be necessary to loosen and adjust the header to allow for proper alignment of the slip-on exhaust system.



Fig. 1



Fig. 2

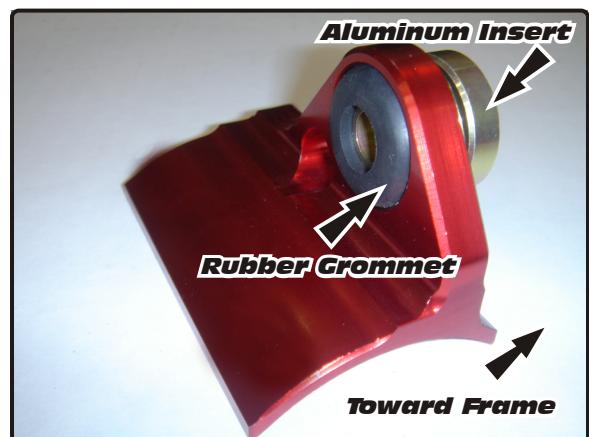
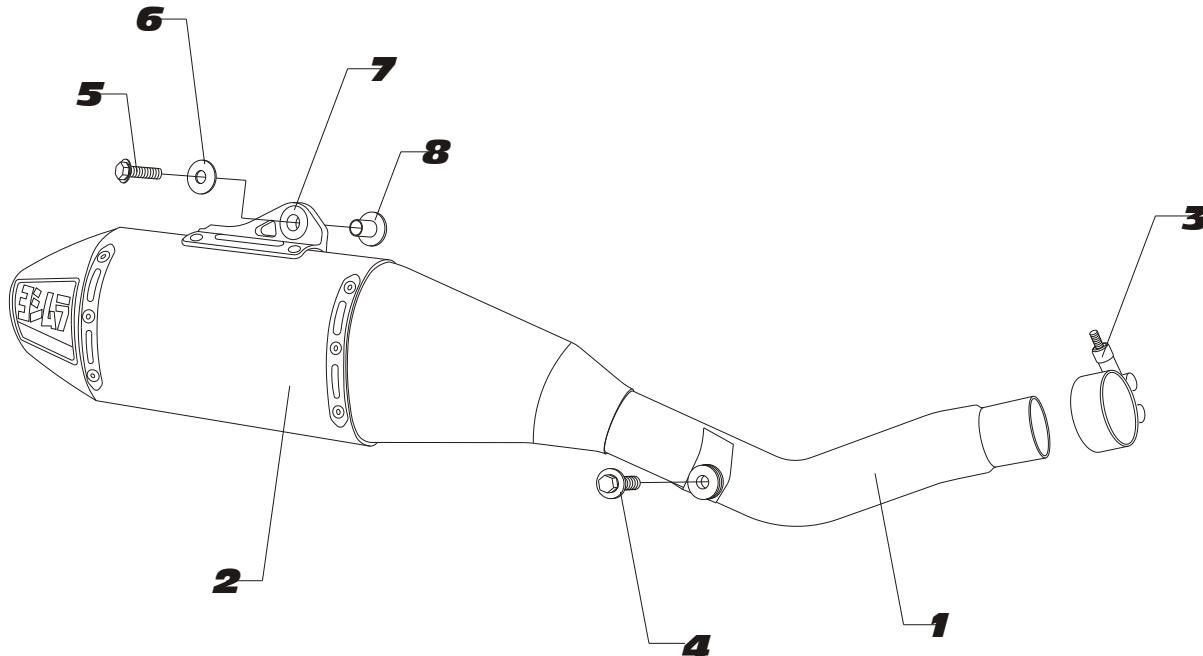


Fig. 3

- e. *Install supplied muffler mounting bolt and washer. Orientation is as follows: Bolt, Washer, Rubber Grommet (Inside of muffler bracket), Aluminum Spacer, Subframe. Do not torque at this time.*
- f. *Install supplied bolt into tailpipe mounting bracket. Do not torque at this time.*
- g. *Torque header nuts to 16.5 lb-ft (23 N-m).*
- h. *Torque tailpipe mounting bolt to 16.5 lb-ft (23 N-m).*
- i. *Torque muffler mounting bolt to 16.5 lb-ft (23 N-m).*
- j. *Torque collector clamp to 7 lb-ft (10 N-m).*

3. *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.*
4. *Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swingarm, brake, rear shock, 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.*
5. *Reinstall number plate using reverse steps of removal.*

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

PN: 231002D320

Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Stainless Steel Tailpipe	1	231002D320-RMA
2	Yoshimura RS4 Muffler w/ Aluminum Sleeve		
3	Stainless Tailpipe Clamp	1	22059
4	8mm X 20mm Flanged Hex Head Bolt	1	M8X20H
5	8mm X 35mm Flanged Hex Head Bolt	1	M8X35H
6	8mm Flat Washer, Large	1	8MMWASHERL
7	Muffler Bracket Rubber Grommet	1	Z1022
8	Aluminum Insert	1	ALS-003
**	AMA 94dB Sound Insert (Installed)	1	INS-14-K
**	2m-MAX Sound Insert	1	INS-10-K
**	Yoshimura Vinyl Sticker	1	17029
**	Muffler Washer Plug	1	347PLUG
**	Instruction Manual	1	INST KIT

OPTIONAL REPLACEMENT PARTS

Spark Arrestor	SA-04-K
Re-pack Kit	REPACK-RS4-PK11



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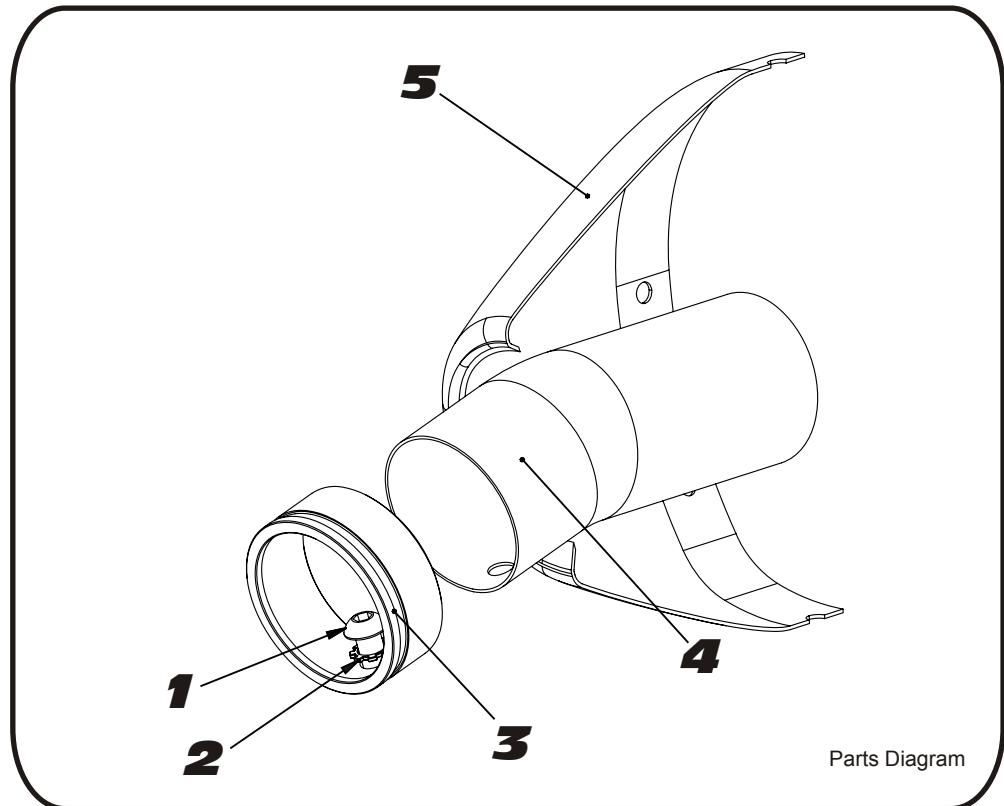
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INS-14-K

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 Spark Arrestor Ring 1.500"	1	RS4-RING-1500
4	AMA 94dB Sound Insert	1	INS-U
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.*