



# 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"

2011~2019

### **SUZUKI GSX-R 600/750**

**11600EM220 (CF/CF)**

**11600EM520 (SS/CF)**

### **Alpha Stainless Steel Slip-On**



Signature Series systems are:

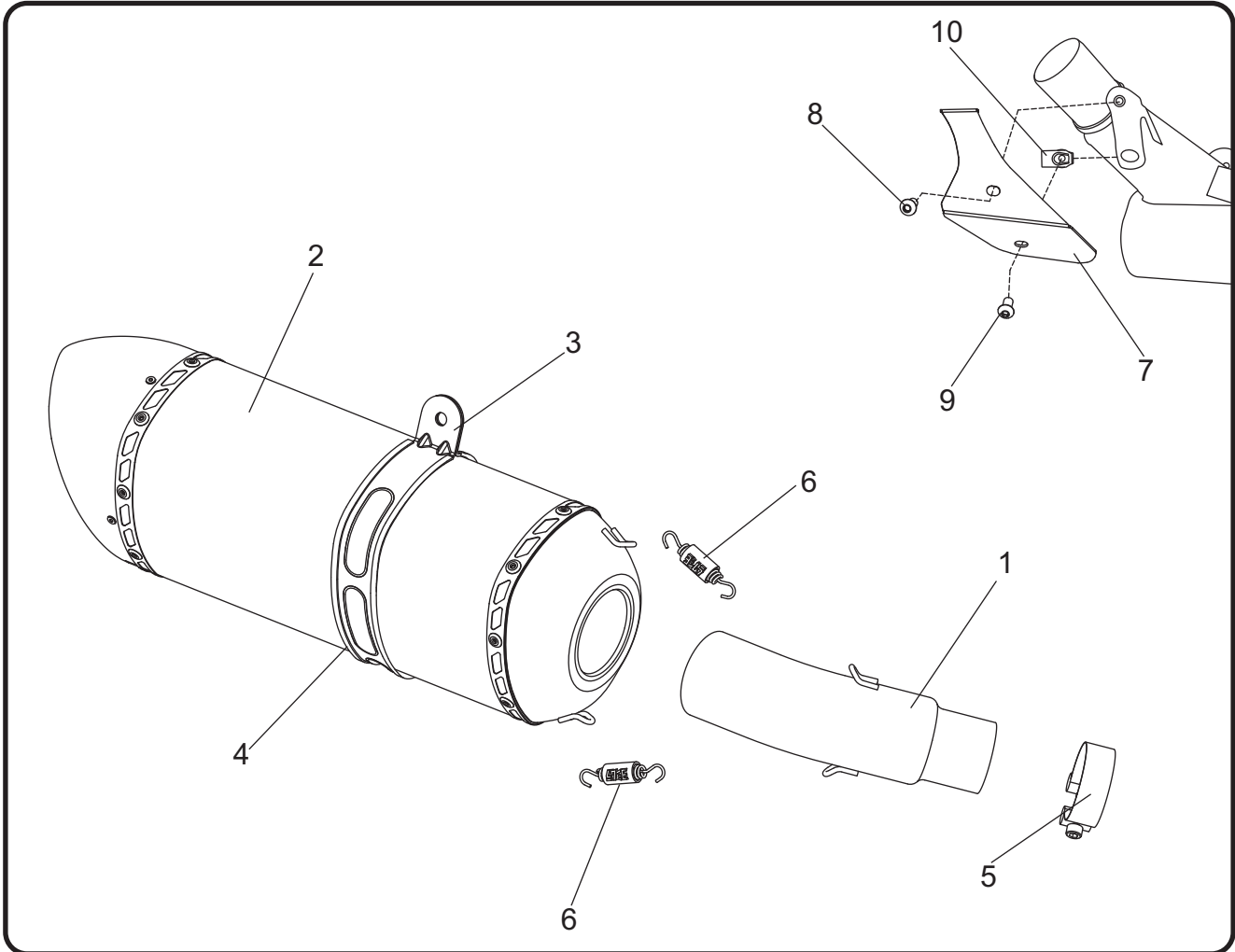
- CARB/EPA tail-pipe emissions compliant.
- Marked with appropriate EPA noise labels.
- Independent laboratory tested for EPA new vehicle noise compliance.



✘ 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.

## Assembly Diagram



No.	Item	Description	Qty.
1	11600-435-1	Yoshimura Tailpipe	1
2	****	Signature Series Muffler	1
3	MCYM5-CCBX(-X)	Muffler Clamp	1
4	HT SHLDR77	Muffler Clamp Heat Insulator	1
5	27-61M	Exhaust Clamp	1
6	RACE-SPS-1	Medium Exhaust Spring	2
7	11600-HS	Heatshield	1
8	M6X10BHS	6mm x 10mm Button Head Screw	1
9	M6X12BHS	6mm x 12mm Button Head Screw	1
10	M6X1U	6mm x 1.0 U-Nut	1
**	17029	Sticker Sheet	1
**	ST-200	Spring Puller Tool	1

(-X) For use with Stainless Steel canister.

\*\* Not Shown on diagram.

\*\*\*\* Signature Series muffler replacement part number unavailable. Repair or replacement of Signature Series exhaust systems is only available directly through Yoshimura R&D of America, Inc.

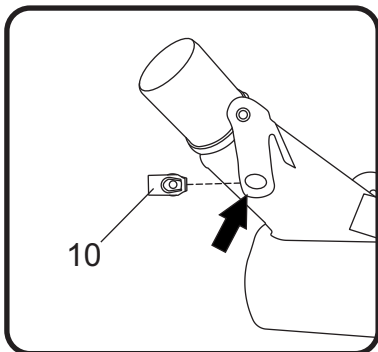
## Removal

1. Remove the stock muffler heatshield.
2. Remove the stock rubber grommet from heatshield bracket located on the header.
3. Loosen exhaust clamp between muffler and header.
4. While securely supporting the muffler assembly, remove the muffler mount bolt and carefully remove the stock muffler assembly.

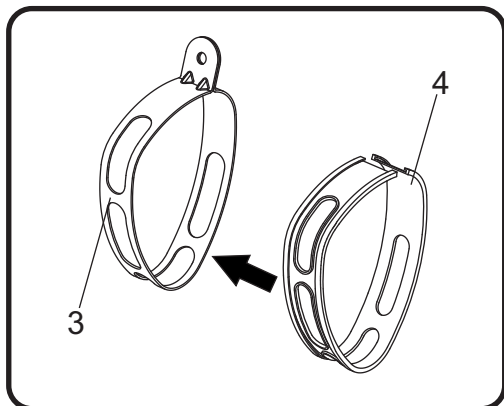
Note: The stock exhaust gasket will not be used with the Yoshimura slip-on system.

## Installation

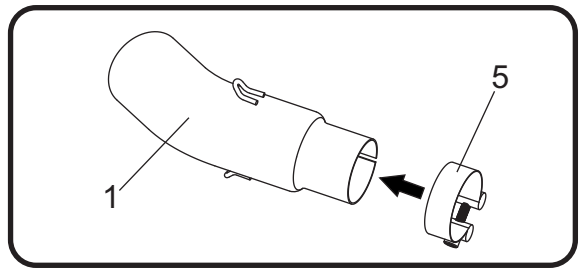
1. Install (No. 10) *M6X1U*, U-Nut on the lower heatshield bracket hole where the stock rubber grommet was removed previously.



2. Install (No. 4) *HT SHLDR77*, muffler clamp heat insulator onto (No. 3) *MCYM5-CCBX(-X)*, muffler clamp.



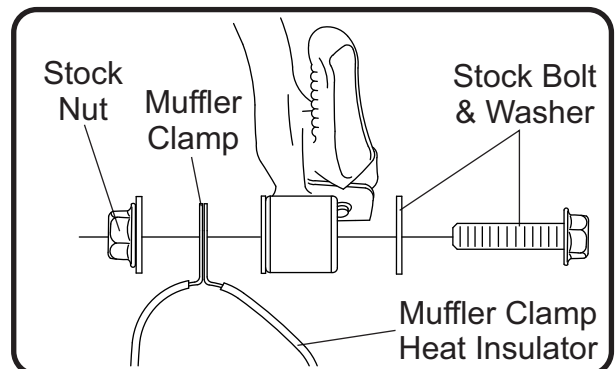
3. Install (No. 5) *27-61M*, exhaust clamp over (No. 1) *11600-435-1*, tailpipe. Do not torque at this time.



4. Slide (No. 3) *MCYM5-CCBX(-X)*, muffler clamp over (No. 2) *muffler*.
5. Install Yoshimura muffler assembly by sliding (No. 1) *11600-435-1*, tailpipe over header outlet.
6. Align (No. 3) *MCYM5-CCBX(-X)*, muffler clamp to the stock muffler mount and secure using the stock bolt, washer and nut.

Note<sup>1</sup>: The muffler clamp mounts to the backside of the stock muffler mount.

Note<sup>2</sup>: It may be necessary to remove (No. 6) *RACE-SPS-1*, medium exhaust springs to rotate the muffler and/or tailpipe to achieve desired alignment.



7. Torque the stock muffler mount bolt to factory specification.
8. Torque (No. 5) *27-61M*, exhaust clamp to 8.5 Nm (0.85 kg-m, 6 ft-lb).
9. Install (No. 7) *11600-HS*, heatshield using (No. 8,9) 6mm screws provided in the kit as shown on the assembly diagram.
10. Before starting vehicle, 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.

## **NOISE EMISSION WARRANTY**

Yoshimura warrants that this exhaust system, at time of sale, meets all applicable U.S. E.P.A. Federal noise standards. This warranty extends to the first person who buys this exhaust system for purposes other than resale, and to all subsequent buyers. Warranty claims should be directed to Yoshimura R&D of America, Inc. 5420 Daniels St. Chino, CA 91710 | Tel (800) 634-9166

## **TAMPERING PROHIBITION**

Federal law prohibits any modification to this exhaust system which causes the motorcycle to exceed the Federal noise standard. Use of the motorcycle with such a modified exhaust system is also prohibited.

Acts likely to constitute tampering include removal or puncturing the muffler, baffles, header pipes, or any other component which conducts exhaust gases.

**WARNING: This product should be checked for repair or replacement if the motorcycle noise has increased significantly through use. Otherwise, the owner may become subject to penalties under state and local ordinances.**