



# YOSHIMURA

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## **OFF-ROAD PERFORMANCE EXHAUST SYSTEM SPARK ARRESTED**

**HONDA  
2011-2013  
CRF250R**

<b>228401D220</b>	TITANIUM FULL SYSTEM WITH CARBON FIBER SLEEVE RS4
<b>228401D720</b>	TITANIUM FULL SYSTEM WITH TITANIUM 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.



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

## 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.
  - Remove header flange nuts
  - Remove stock header.
  - Inspect stock exhaust gasket. Replace with new if necessary.
2. Yoshimura full system installation.
  - Attach exhaust springs to flange before installing flange and manifold to engine to ease installation. Mount flange using stock nuts. (Fig. 3) Do not torque at this time.
  - Install Yoshimura header to flange and manifold.
  - Carefully install Yoshimura muffler assembly onto header. (Note: Make sure that tailpipe is seated against the stopper on the 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. The tailpipe mounting bracket is designed to allow slight horizontal movement.
  - Tighten Header Nuts, Tailpipe, and Muffler Mount bolts to 16.5 ft-lb ( 23 N-m ).
  - Install exhaust spring on flange to header.
  - Install exhaust spring between Header and Tailpipe.



Fig. 1



Fig. 2

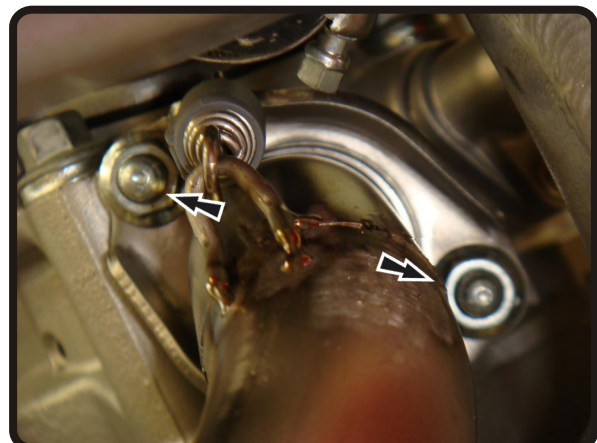


Fig. 3

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.*

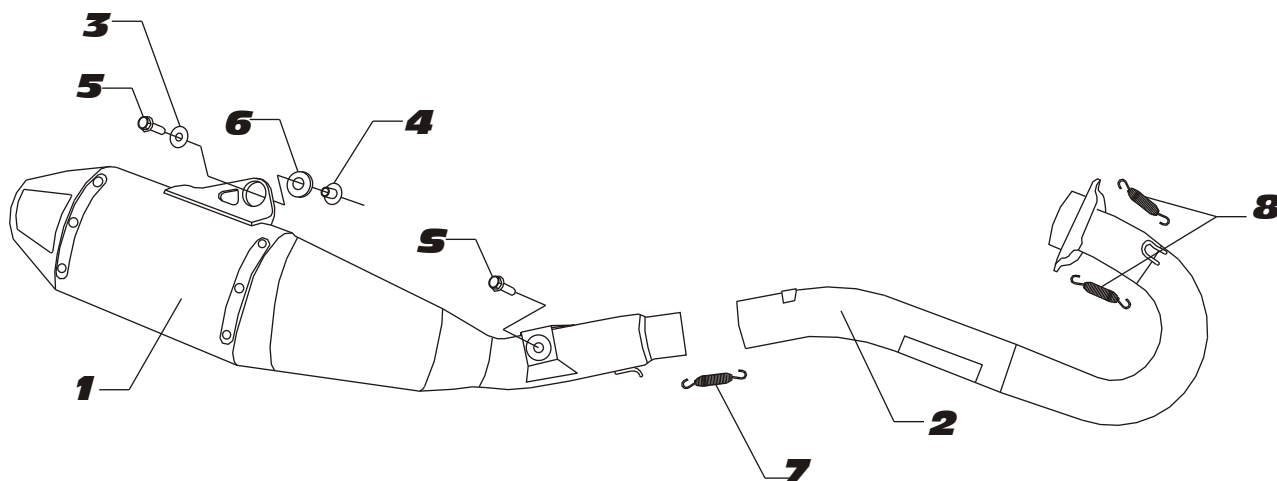
**NOTE:** After starting motorcycle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.

**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.*

**#228401D(220,720)**

**S=STOCK**

Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Muffler Assembly w/ Carbon Fiber Sleeve w/ Titanium Sleeve	1	228401D220RMA 228401D720RMA
2	Yoshimura Titanium Header	1	2283-704-01F
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
7	Medium Exhaust Spring	1	RACE-SPS-1
8	Short Exhaust Spring	2	RACE-SPX-1
**	Offroad Endcap Plug	1	347PLUG
**	Spring Puller Tool	1	ST-200
**	Yoshimura Vinyl Sticker	1	17029
<b>OPTIONAL REPLACEMENT PARTS</b>			
****	AMA Sound Insert Kit		INS-17-K
****	2m-MAX Sound Insert Kit		INS-14-K
****	Re-pack Kit		REPACK-RS4-PK24