



YOSHIMURA

RESEARCH & DEVELOPMENT OF AMERICA, INC.

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www.yoshimura-rd.com

Signature Series

Qualified Manufacturer Declared "Replacement Part"

Yamaha

**2014-2018
YZ250F**

**2015
YZ250FX**

**2015-2018
WR250F**

231012D320 (SS/AL)

RS4 Slip-On Exhaust 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.

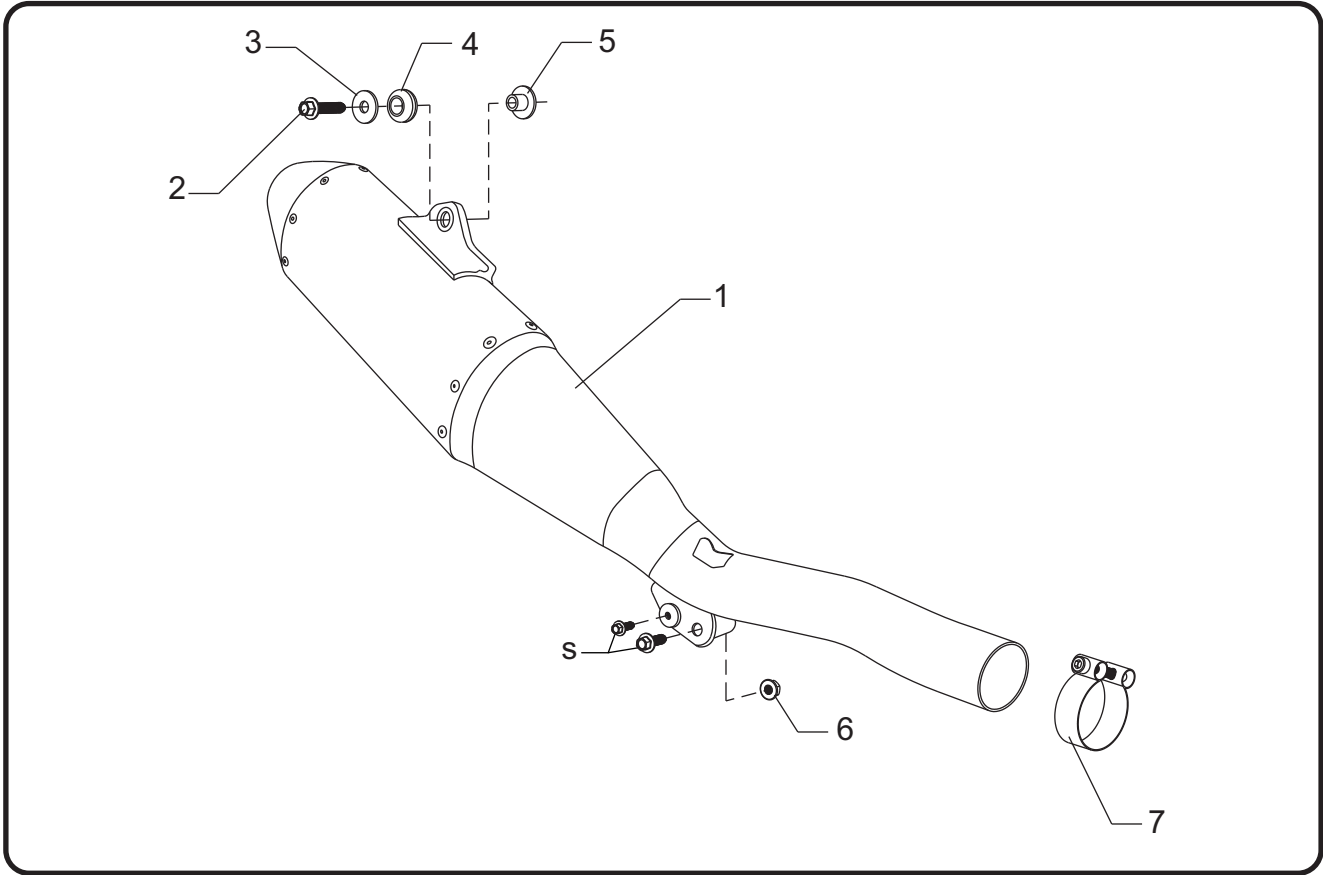


You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new Yoshimura exhaust depending on the application. Read 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.

Assembly Diagram



No.	Item	Description	Qty.
1	****	Yoshimura Muffler Assembly	1
2	M8X35H	8mm x 35mm Flanged Hex Head Bolt	1
3	8MMWASHERL	8mm Large Washer	1
4	Z1022	Rubber Grommet	1
5	ALS-003	Aluminum Spacer	1
6	8MMNUT	8mm Flange Nut	1
7	27-62MSH	Exhaust Clamp	1
**	INS-10-K	Low Volume Insert (1.625")	1
**	ALFOILHS-8x10	Adhesive Heatshield Foil	1
**	347PLUG	Wash Plug	1
**	17029	Sticker Kit Sheet	1
OPTIONAL REPLACEMENT PARTS (not incl.)			
***	SA-04-K	Spark Arrester Kit (Required for WR250F)	

** Not shown on diagram.

*** Spark Arrester Kit **MUST** be installed if to be used on WR250F for USFS compliance.

**** 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.

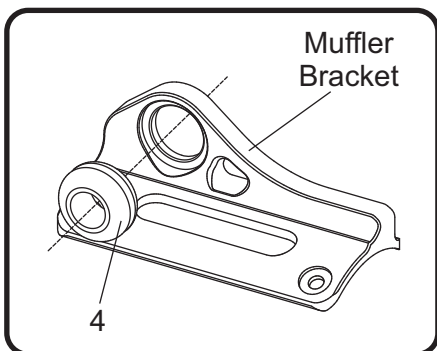
Removal

1. Remove right side panel by removing the three side panel bolts.
2. Loosen exhaust clamp at muffler to midpipe connection.
3. Remove forward muffler chassis mount bolt.
4. While securely supporting the stock muffler assembly, remove rear muffler mount bolt and carefully remove muffler from midpipe.

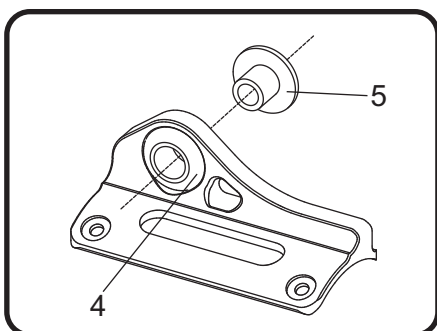
Note: The stock exhaust gasket will not be used with the Yoshimura slip-on system.

Installation

1. Install (4) Z1022 rubber grommet into muffler bracket.



2. Install (5) ALS-003 aluminum spacer into (4) Z1022 rubber grommet as shown in the diagram.



3. Slide (7) 27-62MSH exhaust clamp over Yoshimura tailpipe inlet as shown in the Assembly Diagram.

4. Install (1) 231012D320-RMA Yoshimura muffler assembly over the stock midpipe.
5. Secure (1) 231012D320-RMA Yoshimura muffler assembly to rear muffler mount using the provided (2) M8X35H bolt and (3) 8MMWASHERL washer as shown in the assembly diagram. Do not torque at this time.
6. Secure Yoshimura forward muffler chassis mount to chassis using the stock bolt and provided (6) 8MMNUT flange nut. Do not torque at this time.
7. Torque (2) M8X35H rear muffler mount bolt to 30 Nm (3.0 kg-m, 22 ft-lb).
8. Torque stock forward muffler mount bolt to 30 Nm (3.0 kg-m, 22 ft-lb).
9. Torque (7) 27-62MSH exhaust clamp to 8.5 Nm (0.86 kg-m, 6 ft-lb).
10. Cut out provided heat shield template along the solid line.
11. Using a marker, trace the paper template onto the provided 8x10 adhesive foil sheet.

Note: When tracing paper template onto foil sheet, be sure both templates fit on the 8x10 adhesive foil sheet before cutting.

12. Cut out heatshield foil.
13. Clean number plate thoroughly with soap and water where heatshield foil will be applied.
14. Remove adhesive backing from foil heatshield and apply to number plate.

Note: Be sure number plate is dry and clean prior to applying heatshield foil. Debris may hinder the foil from adhering to the surface.

15. Re-install right side panel.
16. Before starting vehicle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, control arm, 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.

17. 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 vehicle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.

