



# YOSHIMURA

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[www.yoshimura-rd.com](http://www.yoshimura-rd.com)

## **RACE SERIES**

Qualified Manufacturer Declared "Modified Part"

**2006~2019**

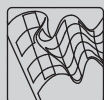
**Yamaha R6**

**13630AP520 (SS/CF)**

**136301P720 (TI/CF)**

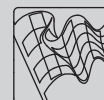
**Alpha Taper Full-System**

**FOR CLOSED COURSE COMPETITION ONLY; NOT INTENDED FOR STREET USE**



Race Series systems are:

- NOT CARB/EPA tail-pipe emissions compliant.
- NOT street legal.
- For "Closed Course Competition" use only.

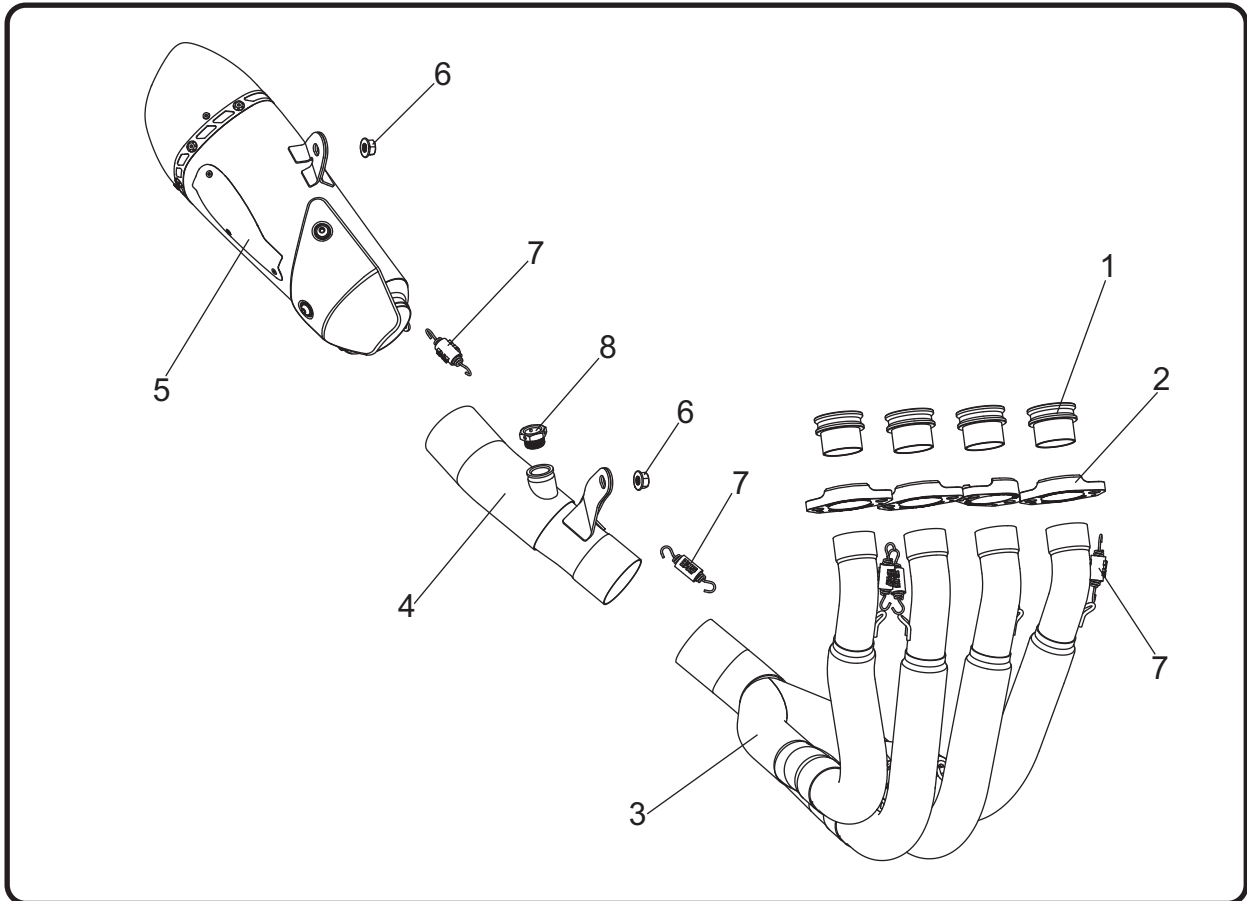


*You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new Yoshimura exhaust depending on the application. Read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



| <b>NO.</b> | <b>DESCRIPTION</b>  | <b>QTY</b> | <b>PART #</b>                    |
|------------|---|------------|----------------------------------|
| 1          | Yoshimura Stainless Steel Manifold                                | 4          | 13630SDM                         |
| 2          | Yoshimura Aluminum Flange   | 4          | YZ616SDR-04                      |
| 3          | Yoshimura Stainless Steel Header<br>Yoshimura Titanium Header     | 1          | 13630-404<br>13630-704           |
| 4          | Yoshimura Stainless Steel Tailpipe<br>Yoshimura Titanium Tailpipe | 1          | 13630-419<br>13630-719           |
| 5          | Yoshimura Stainless Steel Muffler<br>Yoshimura Titanium Muffler   | 1          | 13630AP520-RMA<br>136301P720-RMA |
| 6          | 8mm Flanged Nut   | 2          | 8MMNUT                           |
| 7          | Medium Exhaust Spring   | 10         | RACE-SPS-1                       |
| 8          | O2 Sensor Bung Plug   | 1          | M18X9PLG                         |
| **         | Low Volume Sound Insert   | 1          | INS-20-K                         |
| **         | Yoshimura Decal Sheet   | 1          | 17029                            |
| **         | Spring Puller Tool  | 1          | ST-200                           |

\*\* Not shown on the diagram.

\*\*\*\* Not compatible with European model.

**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.

**WARNING:** Always properly support vehicle with a stand and/or lift when servicing or performing any work. Unstable vehicles may present dangerous conditions and may cause property damage and/or personal injury.

**NOTE:** Read through all instructions before beginning installation.

## Removal

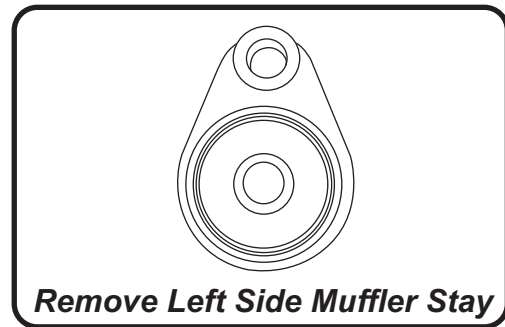
1. Remove left and right side fairing.
2. Remove the three bolts that secure the black muffler protector, exposing the exhaust valves and exhaust clamp.
3. Disconnect and remove the exhaust valve cables (refer to your service manual for complete removal instructions).

Note: Do not unplug servo motor. Unplugging the servo motor may cause the bike to run in a power limited fail safe mode.

4. Loosen the stock exhaust clamp
5. While securely supporting the stock muffler, remove the muffler mount bolt and carefully remove the stock muffler assembly by sliding toward the rear of motorcycle.
6. Remove O2 sensor from the stock header.
7. Remove the two header chassis mount bolts.
8. While securely supporting the stock header assembly, remove header nuts and carefully remove the stock header assembly.

Note: The stock exhaust port gaskets will not be used with the Yoshimura full-system. Remove gaskets from exhaust ports before installing Yoshimura manifolds.

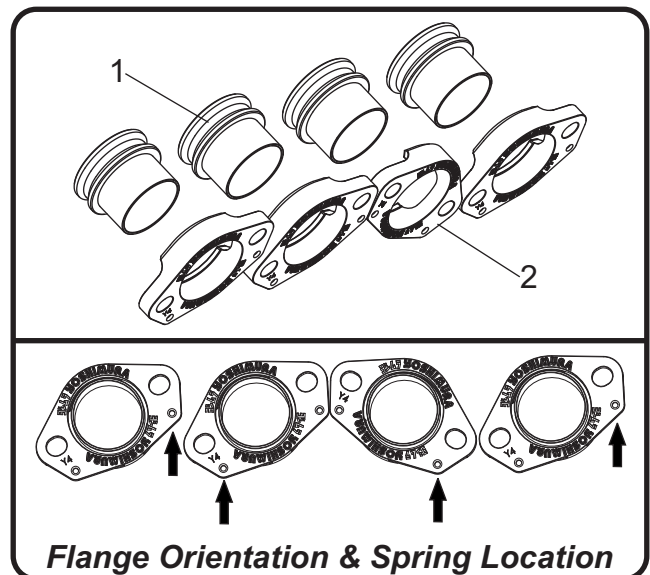
9. Remove the bolt securing left side muffler stay to frame as it will not be used with the Yoshimura full-system.



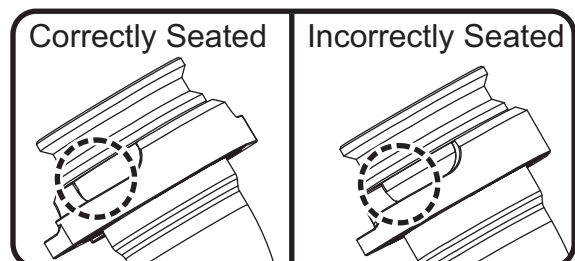
## Installation

1. Install (No. 1) 13630SDM, manifold and (No. 2) YZ616SDR-04, flange onto exhaust port using the stock header nuts. Do not torque at this time. See below for proper orientation of flanges.

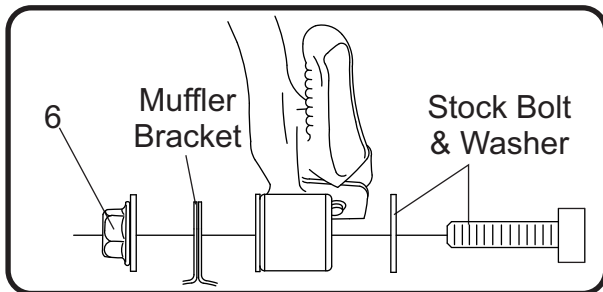
Note: Hook (No. 7) RACE-SPS-1, medium exhaust springs onto flanges before installing header. Access will be limited once header is installed.



2. Install (No. 3) 13630-404/13630-704, header onto manifolds by slipping one header leg at a time from one end to the other. Using a rubber mallet, gently tap header legs to make sure header is fully seated onto the manifolds.

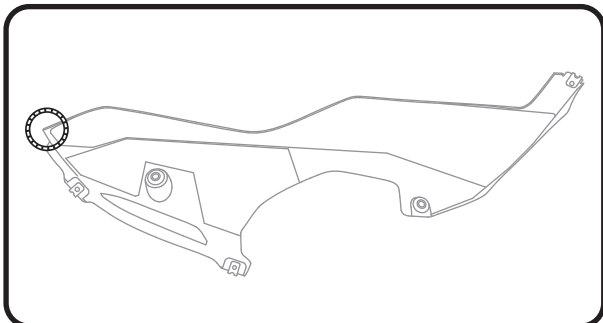


3. Torque header nuts to factory specification and hook springs onto header legs.
4. Install (No. 4) 13630-419/13630-719, tailpipe over header outlet. Align tailpipe bracket to the backside of the right muffler stay and secure using the stock bolt and supplied (No. 6) 8MMNUT, flange nut. Do not torque at this time.
5. Install (No. 5) *muffler*, over tailpipe outlet and align muffler bracket to the backside of the muffler mount. Secure using the stock muffler mount bolt, washer, and (No. 6) 8MMNUT, flange nut.



6. Torque muffler mount bolt to factory specification.
7. Torque tailpipe chassis mount bolt to factory specification.
8. Install (No. 7) *RACE-SPS-1*, medium exhaust spring between muffler to tailpipe connection and tailpipe to header connection.
9. Re-install the stock O2 sensor plug into (No. 4) 13630-419/13630-719, tailpipe. Torque to factory specification.
10. Re-install left and right side faring using the opposite steps of removal.

Note: For 2017 model, it may be necessary to trim the left side corner of the lower cowl if close to the header leg.



11. Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swing 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.
12. 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.

## Works Finish Care & Maintenance

Before starting vehicle, clean pipe thoroughly using a soft cloth and rubbing alcohol to remove any oil and finger prints.

The color of the exhaust will change once the system has gone through a heat cycle of 15 minutes or more. Color will vary depending on lean/rich conditions.

Clean using a soft cloth and soap. Do not use abrasive materials as it will scratch the surface.

Surface reconditioning services are available to remove scratches and undesirable discoloration due to extreme heat. Contact Yoshimura Tech Department at (800) 634-9166 / in CA (909) 628-4722 for more information.