



# YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

5420 DANIELS STREET STE A, CHINO CA., 91710 · (800) 634-9166 · (909) 628-4722 · FAX (909) 591-2198

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

## *Signature Series*

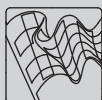
Qualified Manufacturer Declared "Replacement Part"

**2011~2013**

**Honda CRF250R**

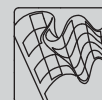
**228400D321 (SS/AL)**

**RS-4 Stainless Steel Full-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.



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.**

- Install Yoshimura header using stock nuts (Fig. 3). Do not torque at this time.
- 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 between Header and Tailpipe.



Fig. 1



Fig. 2

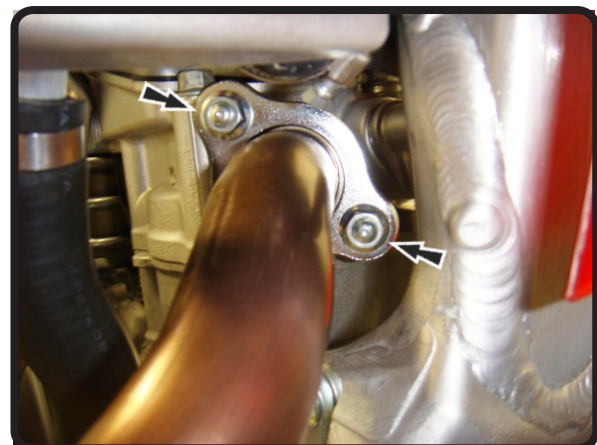


Fig. 3

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.

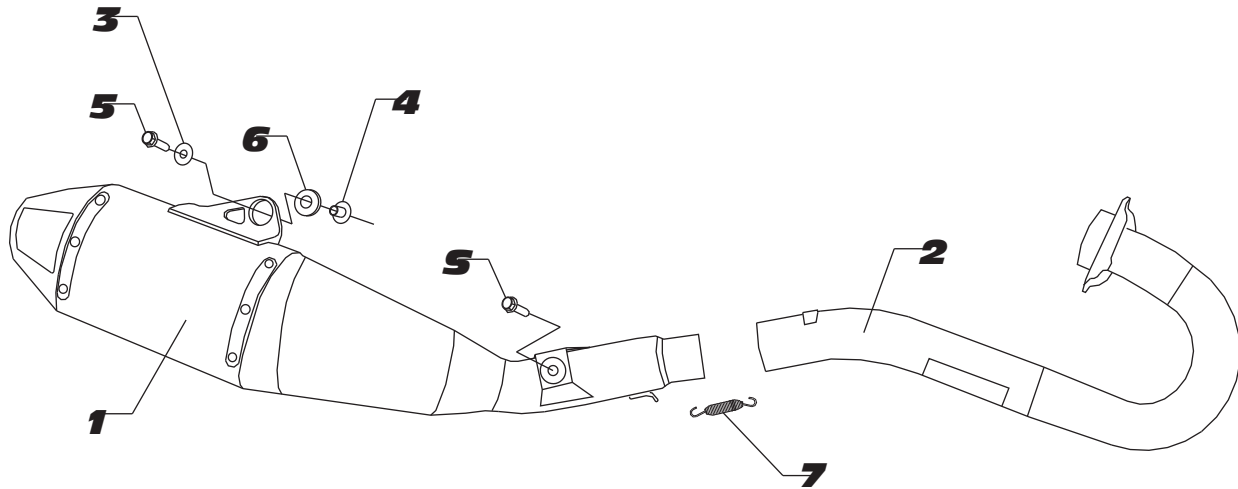
**Fuel Injection Mapping:**

*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.*

**#228400D321**



**S-STOCK**

Parts Diagram

<b>NO.</b>	<b>DESCRIPTION</b>	<b>QTY</b>	<b>PART #</b>
1	Yoshimura Muffler Assembly	1	228400D321-RMA
2	Yoshimura Stainless Steel Header	1	2283-101-01
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
**	AMA 94dB Sound Insert Kit (Installed)	1	INS-17-K
**	2m-MAX Sound Insert Kit	1	INS-2M26-K
**	Offroad Endcap Plug	1	347PLUG
**	Spring Puller Tool	1	ST-200
**	Yoshimura Vinyl Sticker	1	17029
<b>OPTIONAL REPLACEMENT PARTS</b>			
TEC-SD10 Spark Arrestor Kit		SA-04-K	
Re-pack Kit		REPACK-RS4-PK24	



# YOSHIMURA

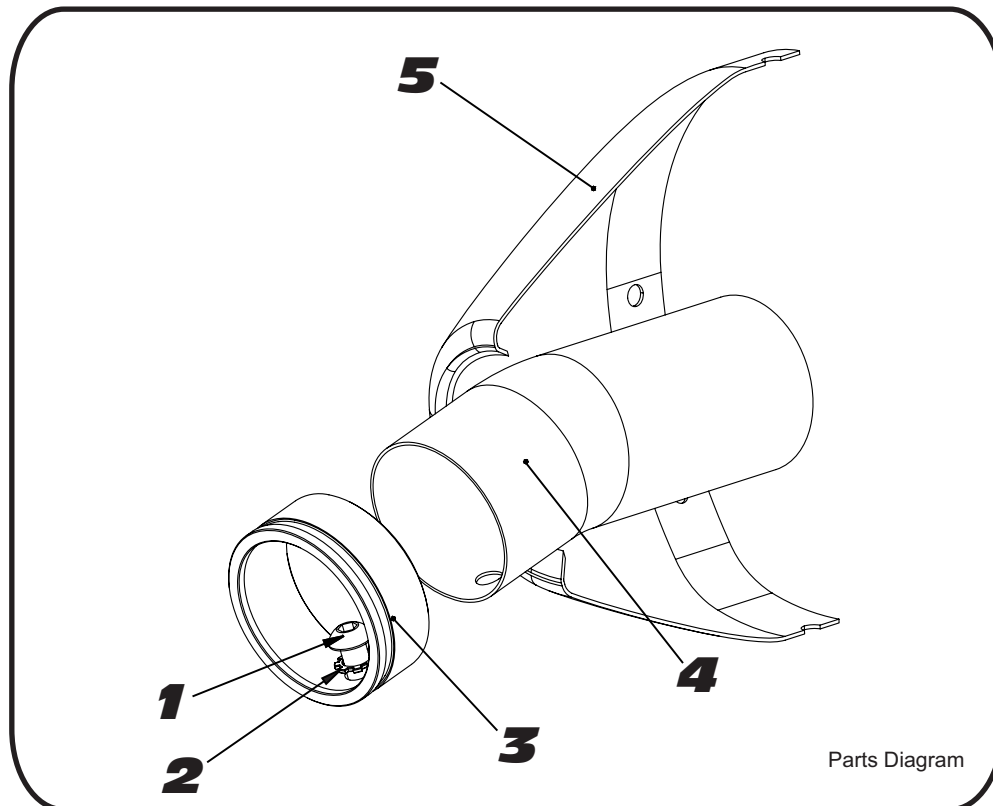
RESEARCH & DEVELOPMENT OF AMERICA, INC.

5420 DANIELS STREET SUITE A, CHINO, CA 91710 · (800)634-9166 · (909)628-4722 · FACSIMILE (909)591-2198

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

**INS-17-K**

**YOSHIMURA RS4 LOW VOLUME INSERT KIT**



Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	6mm X 12mm Button Head Cap Screw	1	M6X12BHS
2	6mm Lock Washer	1	6MMLCKWSHR-TH
3	RS4 Aluminum Insert Ring	1	RS4-RING-1500
4	Low Volume Sound Insert	1	INS-X-00
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.