



RESEARCH&DEVELOPMENT OF AMERICA, INC.

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Signature Series

Qualified Manufacturer Declared "Replacement Part"

Yamaha

**2014-2018
YZ250F**

**2015
YZ250FX**

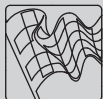
**2015-2018
WR250F**

231010D321 (SS/AL)

231011D221 (Ti/CF)

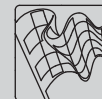
231011D721 (Ti/Ti)

RS4 Full-System Exhaust



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.

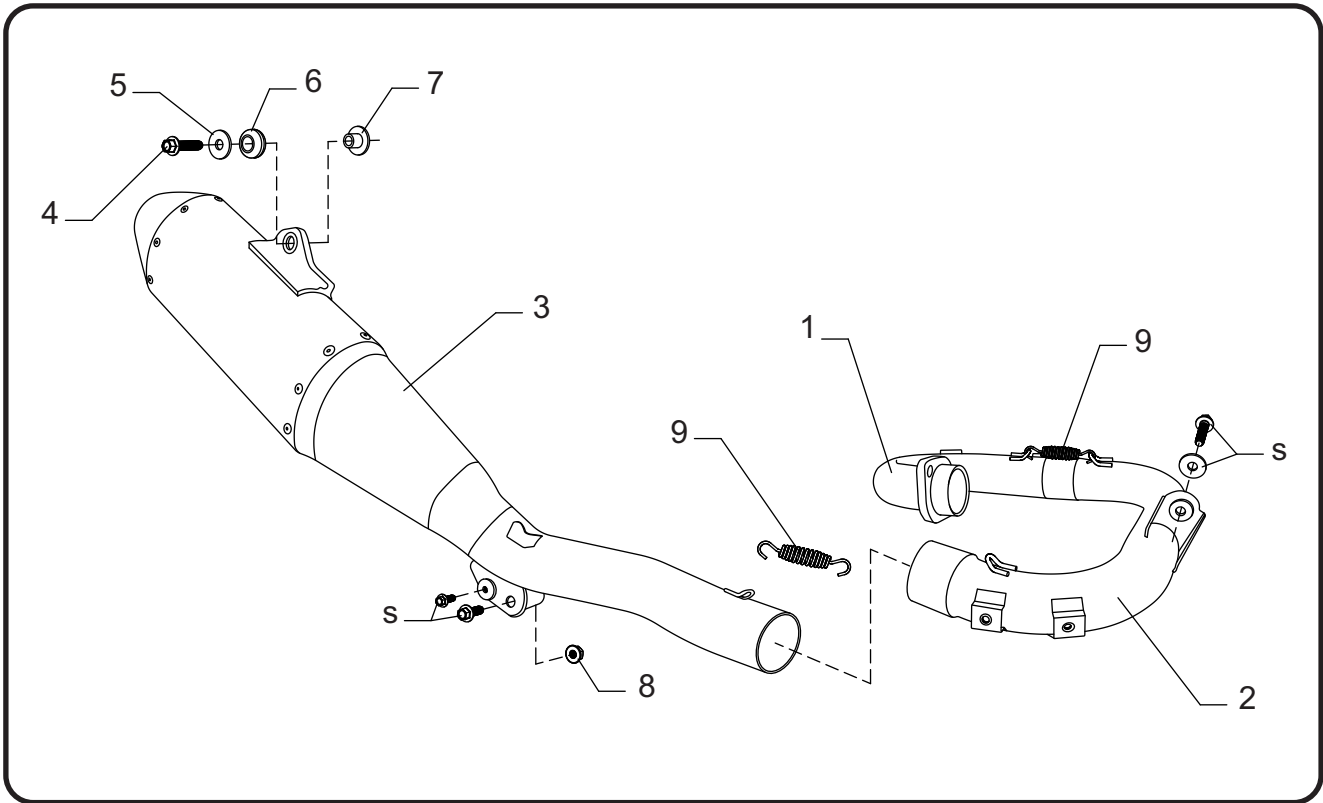


CAUTION: The muffler packing on this system **MUST** be replaced every 6-8 hours of use, or every 1-2 motos. Failure to follow recommended muffler re-packing interval can cause muffler damage and may void the warranty.



NOTE: IN THE STATE OF CALIFORNIA, IT IS ILLEGAL TO MODIFY THE EMISSION CONTROL SYSTEM, WHICH INCLUDES THE FUEL INJECTION OF ANY VEHICLE.

Assembly Diagram



No.	Item	Description	Qty.
1	23101-101-1	Stainless Steel Yoshimura Header	1
	23101-704-1F	Titanium Yoshimura Header	
2	23101-140-1	Stainless Steel Yoshimura Midpipe	1
	23101-740-1	Titanium Yoshimura Midpipe	
3	231010D321-RMA	SS/AL Muffler Assembly	1
	231011D221-RMA	Ti/CF Muffler Assembly	
	231011D721-RMA	Ti/Ti Muffler Assembly	
4	M8X35H	8mm x 35mm Flanged Hex Head Bolt	1
5	8MMWASHERL	8mm Large Washer	1
6	Z1022	Rubber Grommet	1
7	ALS-003	Aluminum Spacer	1
8	8MMNUT	8mm Flange Nut	1
9	RACE-SPS-1	Medium Spring	2
**	INS-10-K	Low Volume Insert (1.625")	1
**	ALFOILHS-8X10	Adhesive Heatshield Foil	1
**	ST-200	Spring Puller Tool	1
**	347PLUG	Wash Plug	1
**	17029	Sticker Kit Sheet	1
***	RACE-SPX-2	Small Spring (Used On TI System Only)	2
OPTIONAL REPLACEMENT PARTS (not incl.)			
****	SA-04-K	Spark Arrester Kit (Required for WR250F)	

** Not shown on diagram.

*** Only used on Titanium Full-System on header flange.

**** Spark Arrester Kit **MUST** be installed if to be used on WR250F for USFS compliance. Not recommended to be used with carbon fiber canisters.

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.

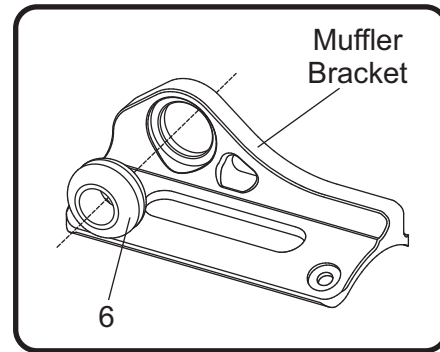
Removal

1. Remove 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.
5. Loosen exhaust clamp at midpipe to header connection.
6. Remove midpipe support bracket bolt and carefully remove midpipe from header.
7. Remove the two header nuts and carefully remove the stock header.

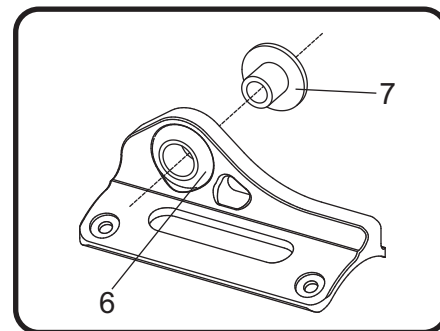
Note: The stock header gasket will be re-used with the Yoshimura full-system. Inspect and replace if necessary.

Installation

1. Install (No. 6) Z1022, rubber grommet into muffler bracket.



2. Install (No. 7) ALS-003, aluminum spacer into (No. 6) Z1022, rubber grommet as shown in the diagram.



3. Install (No. 1) 23101-101-1/704-1F, header using the stock exhaust port gasket and stock header nuts. Do not torque at this time.
4. Carefully install (No. 2) 23101-140-1/740-1, midpipe by maneuvering between the frame and motor and slide midpipe inlet over header. Secure midpipe to midpipe support bracket using the stock bolt. Do not torque at this time.
5. Install (No. 3) XXXXXXXXXXXX-RMA, Yoshimura muffler assembly over (No. 2) 23101-140-1/740-1 midpipe.
6. Secure (No. 3) XXXXXXXXXXXX-RMA, Yoshimura muffler assembly to rear muffler mount using the provided (No. 4) M8X35H, bolt and (No. 5) 8MMWASHERL, washer as shown in the assembly diagram. Do not torque at this time.
7. Secure Yoshimura forward muffler chassis mount to chassis using the stock bolt and provided (No. 8) 8MMNUT, flange nut. Do not torque at this time.

8. Torque (No. 4) *M8X35H* rear muffler mount bolt to 30 Nm (3.0 kg-m, 22 ft-lb).
9. Torque stock forward muffler mount bolt to 30 Nm (3.0 kg-m, 22 ft-lb).
10. Install (No. 9) *RACE-SPS-1*, exhaust spring between tailpipe and midpipe.
11. Torque midpipe support bracket bolt to 20 Nm (2.0 kg-m, 14 ft-lb).
12. Install (No. 9) *RACE-SPS-1*, exhaust spring between header and midpipe.
13. Torque header nuts to 20 Nm (2.0 kg-m, 14 ft-lb).

Note: Titanium Full-System requires exhaust springs to be installed on the flange and header. Install provided *RACE-SPX-1* spring on flange and header.

14. Remove the stock midpipe heatshield and install onto Yoshimura midpipe using the stock heatshield bolts.
15. Cut out provided heat shield template along the solid line.
16. 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.
17. Cut out heatshield foil.
18. Clean number plate thoroughly with soap and water where heatshield foil will be applied.
19. 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.
20. Re-install right side panel.

21. 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.
22. 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.

