



# YOSHIMURA

RESEARCH & DEVELOPMENT OF AMERICA, INC.

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**WWW.YOSHIMURA-RD.COM**

## *Signature Series*

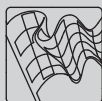
**Qualified Manufacturer Declared "Replacement Part"**

**1999~2013**

**Honda TRX400E(X)**

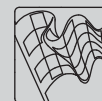
**2270503 (AL/SS)**

**RS-2 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 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.

**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  
3/8" ratchet and extension  
Metric combination wrench set  
Power drill and 13/64" drill bit  
Metric Allen bit set for torque wrench  
Torque wrench  
Safety glasses

## Installation Steps:

1. Remove right heel guard for easier access when installing Yoshimura full system.
2. Unbolt and remove stock muffler. (see Fig. 1)
3. Remove heat shield from stock header and install onto Yoshimura header using stock bolts.
4. Drain oil tank (See Fig. 2). (Warning: Oil may be very hot take precautionary measures to avoid being burnt.)
5. Remove bolts holding oil tank to frame to allow clearance for header removal and installation. (See Fig. 2)
6. Remove front fender mounting bracket bolts and push up out of the way as shown in Fig. 3.
7. Remove stock header and exhaust port gaskets.
8. Install new exhaust port gaskets. not supplied (Honda Part no. 18291-MN5-650)
9. Install Yoshimura header using stock header nuts. Do not torque at this time.
10. Slip 1.5" exhaust clamp on midpipe and install midpipe onto header. (Do not tighten clamp at this time)
11. Slip 1.75" exhaust clamp on tailpipe and install tailpipe w/muffler onto midpipe.
12. Bolt muffler to chassis using supplied hardware. Do not torque at this time.



Fig. 1

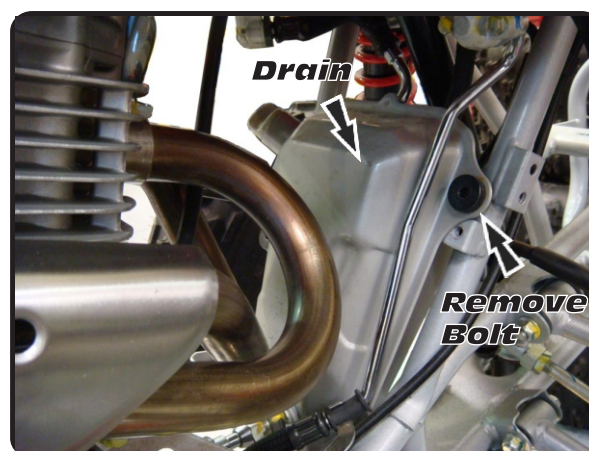


Fig. 2

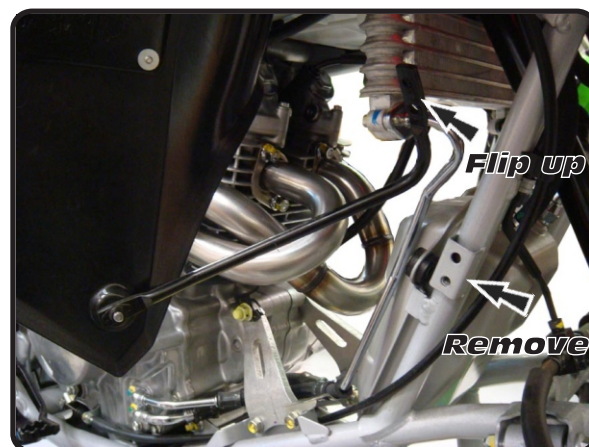
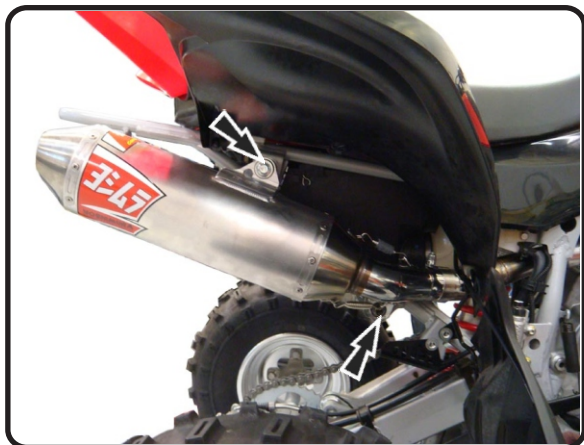


Fig. 3

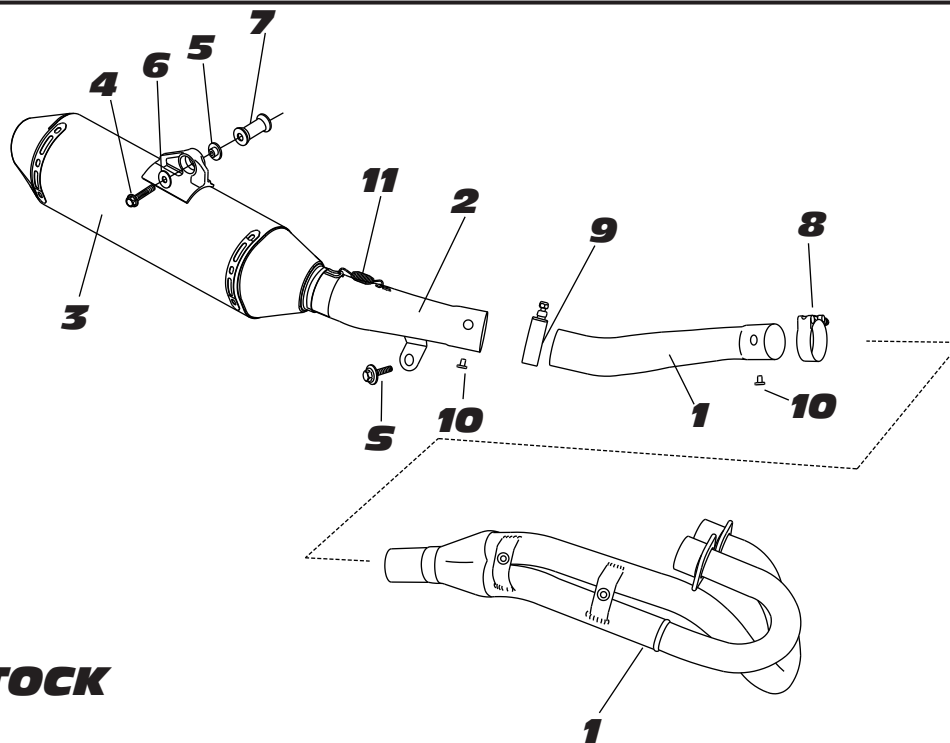
**Fig. 4****Fig. 5****Fig. 6**

13. Bolt tailpipe to lower chassis mount using stock bolt and nut. Do not torque at this time. (See Fig. 4)
14. Standing at the back of the motorcycle, check the orientation of the muffler. Muffler should not be tilted to one side or the other. (See Fig. 5)
15. Check for proper clearance between new exhaust system and motorcycle. (i.e. rear brake, frame, tire, etc.) If any problem is found, please carefully follow through the installation steps again. If problem still persists, please call Yoshimura Technical Department. At (800)634-9166 / in CA (909)628-4722.
16. Torque header nuts to 2.0 kg-m (14.6 lb-ft).
17. Torque tailpipe mounting bolt to 2.5 kg-m (18 lb-ft).
18. Torque muffler mounting bolt to 2.5 kg-m (18 lb-ft).
19. Drill a 13/64" hole thru both ends of midpipe at the center of midpipe's securing hole. (See Fig. 6)  
(Caution: Always wear eye protection when using any power tool.)
20. Install securing rivets in drilled holes, slide collector clamps over rivets and torque collector clamps to 1.25 kg-m (9 lb-ft).
21. Reinstall right rear heel guard.
22. Reinstall oil pan. Fill oil to factory recommended level.
23. Reinstall front fender mount.
24. It is recommended that the entire exhaust system 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 smoke until oil residue burns off.



**#2270503**



Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	TRX400EX Stainless Header	1	EX460SRRH
2	Yoshimura Stainless Steel	1	2270-144
3	Yoshimura RS2 Muffler Assembly	1	2270503-RMA
4	8mm X 65mm Flanged Hex Head Bolt	1	M8X65H
5	Aluminum Spacer for Rubber Grommet	1	ALS-002
6	8mm Washer Large	1	8MMWASHERL
7	8mm X 26mm Flanged Aluminum Spacer	1	8X29SPC
8	220-55 Collector Clamp	1	22055
9	220-59 Collector Clamp	1	22059
10	Collector Securing Rivet	2	S-RIVET
11	Medium Exhaust Spring	2	RACE-SPS-1
**	Rubber Grommet	1	Z1022
**	Spring Puller Tool	1	ST-200
**	Offroad Endcap Plug	1	347PLUG
**	Yoshimura Sitcker Kit Sheet	1	17029





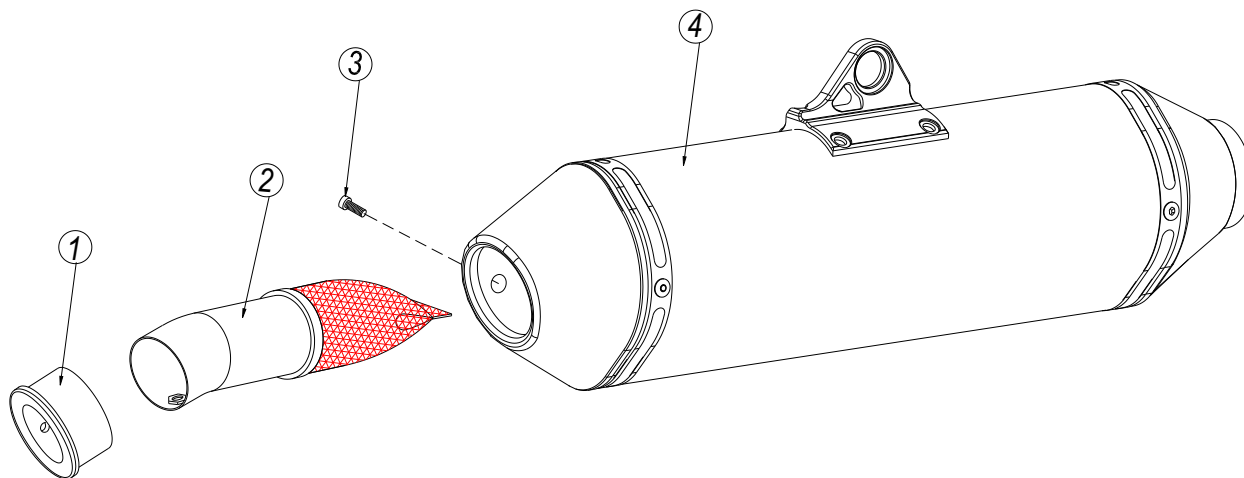
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## Spark Arrester Cleaning Information



Parts Diagram

**Caution:** *Muffler can be extremely hot. Let muffler cool down before removing spark arrester.*

**Note:** *Read through all instructions before beginning disassembly.*

### Tools Needed:

4mm Allen Key  
Wire Brush  
Pair of Gloves  
Safety Glasses

### Cleaning Steps:

- 1 Using a 4mm Allen key, remove the bolt that secures the aluminum ring and spark arrester to the muffler (see Parts Diagram for location).
- 2 Remove the spark arrester from the muffler.

NO.	DESCRIPTION	QTY
1	Aluminum Ring	1
2	Spark Arrester	1
3	Spark Arrester Securing Bolt	1
4	Muffler Assembly	1

- 3 Using a wire brush, remove carbon deposits from spark arrester screen. Inspect the screen for excessive wear or damage. If spark arrester is excessively worn or damaged, the spark arrester must be replaced. Cleaning and inspection should be performed at the same time as muffler repacking. Repacking is recommended every 8-10 hours of riding or 2 motos, whichever comes first.

**CAUTION:** Gloves and safety glasses should be worn while cleaning spark arrester.

- 4 Re-install spark arrester and aluminum ring. Torque the spark arrester 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 spark arrester securing bolt.