



YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

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RACE SERIES

Qualified Manufacturer Declared "Modified Part"

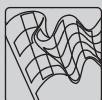
2018

BMW G310R / GS

15350AJ521 (SS/CF)

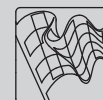
R-77 Stainless Steel Full-System

FOR CLOSED COURSE COMPETITION ONLY; NOT INTENDED FOR STREET USE



Race Series systems are:

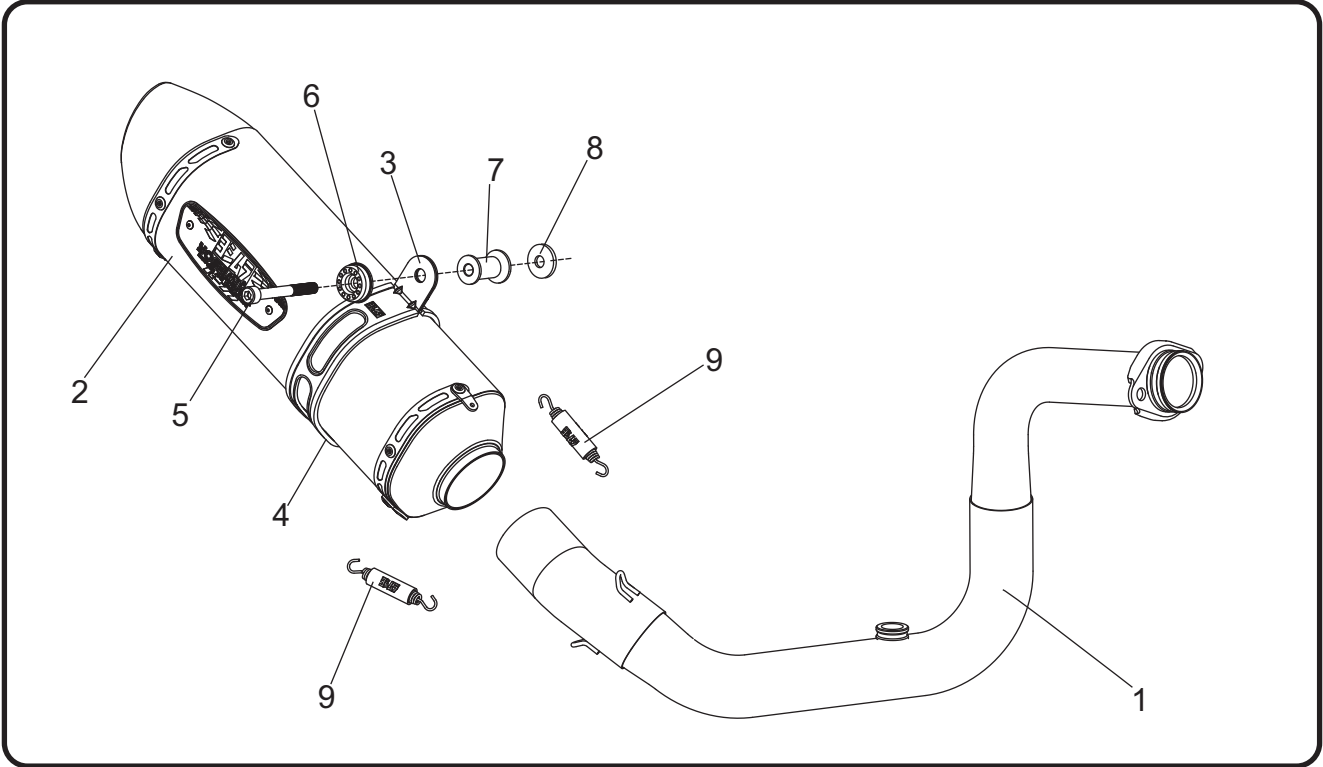
- NOT CARB/EPA tail-pipe emissions compliant.
- NOT street legal.
- For "Closed Course Competition" use only.



✘ 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



No.	Item	Description	Qty.
1	15350-401-1	Yoshimura Header	1
2	SRR77M12AD	Yoshimura Muffler Assembly	1
3	YM7M-MPCAX	Muffler Clamp	1
4	HT SHLDR77	Muffler Clamp Heat Insulator	1
5	M8X70	8mm x 70mm Socket Head Cap Bolt	1
6	M8ALCSW-00	8mm Aluminum Countersink Washer	1
7	8X35SPCR-HA	Aluminum Spacer	1
8	8MMWASHERXL	8mm XL Washer	1
9	RACE-SPL-1	Long Exhaust Spring	2
**	INS-20-K	Low Volume Sound Insert	1
**	ST-200	Spring Puller Tool	1
**	17029	Yoshimura Sticker Kit Sheet	1

** Not shown in diagram.

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.

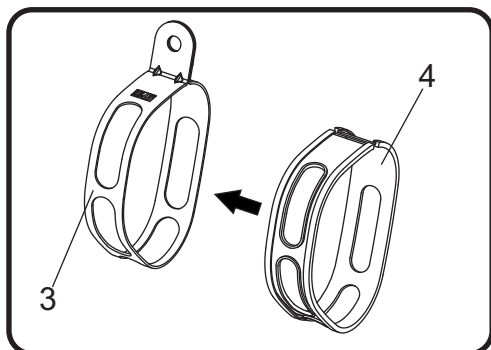
Removal

1. Remove O2 sensor from the stock exhaust system.
2. Remove the exhaust support hanger bracket.
3. Remove header nuts.
4. While securely supporting the stock exhaust system, remove muffler mount bolt and carefully remove the stock exhaust system.

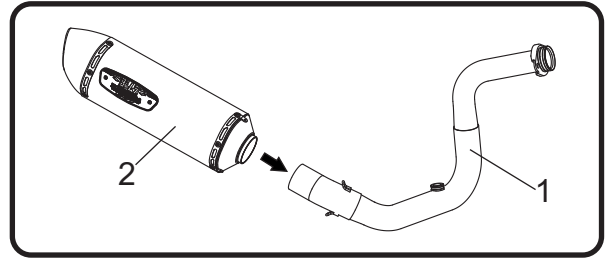
Note: The stock exhaust port gaskets will be re-used with the Yoshimura full-system. Inspect and replace if necessary.

Installation

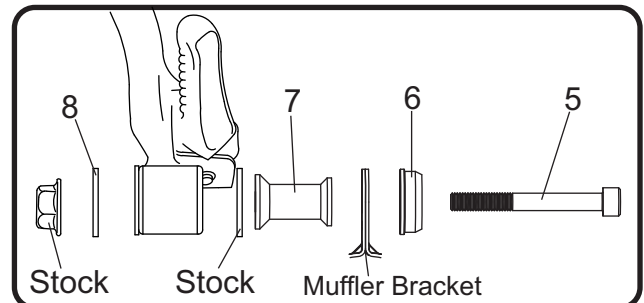
1. Install 15350-401-1, Yoshimura header using the stock header nuts. Do not torque at this time.
2. Install (No. 4) HT SHLDR77, muffler clamp heat insulator onto (No. 3) YM7M-MPCAX, muffler clamp.



3. Install (No. 2) SRR77M12AD, muffler onto (No.1) 15350-401-1, header outlet.



4. Slide (No. 3) YM7M-MPCAX, muffler clamp over (No. 2) SRR77M12AD, muffler. Secure muffler to muffler mount using the supplied hardware as shown below.



5. Torque (No. 5) M8X70, 8mm bolt to factory specification.
6. Torque header nuts to factory specification.
7. Install (No. 9) RACE-SPL-1, long exhaust spring between muffler and header using ST-200, spring puller tool supplied in the kit.
8. Re-install the stock O2 sensor into (No. 1) 15350-401, Yoshimura header. Torque to factory specification.
9. Before starting vehicle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swingarm, 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.
10. 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.

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.