



YOSHIMURA

RESEARCH&DEVELOPMENT OF AMERICA, INC.

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www.yoshimura-rd.com

Signature Series

Qualified Manufacturer Declared "Replacement Part"

Yamaha

2019

YZ250F

231020D320 (SS/AL)

231021D720 (Ti/Ti)

RS4 Full-System



Signature Series systems are:

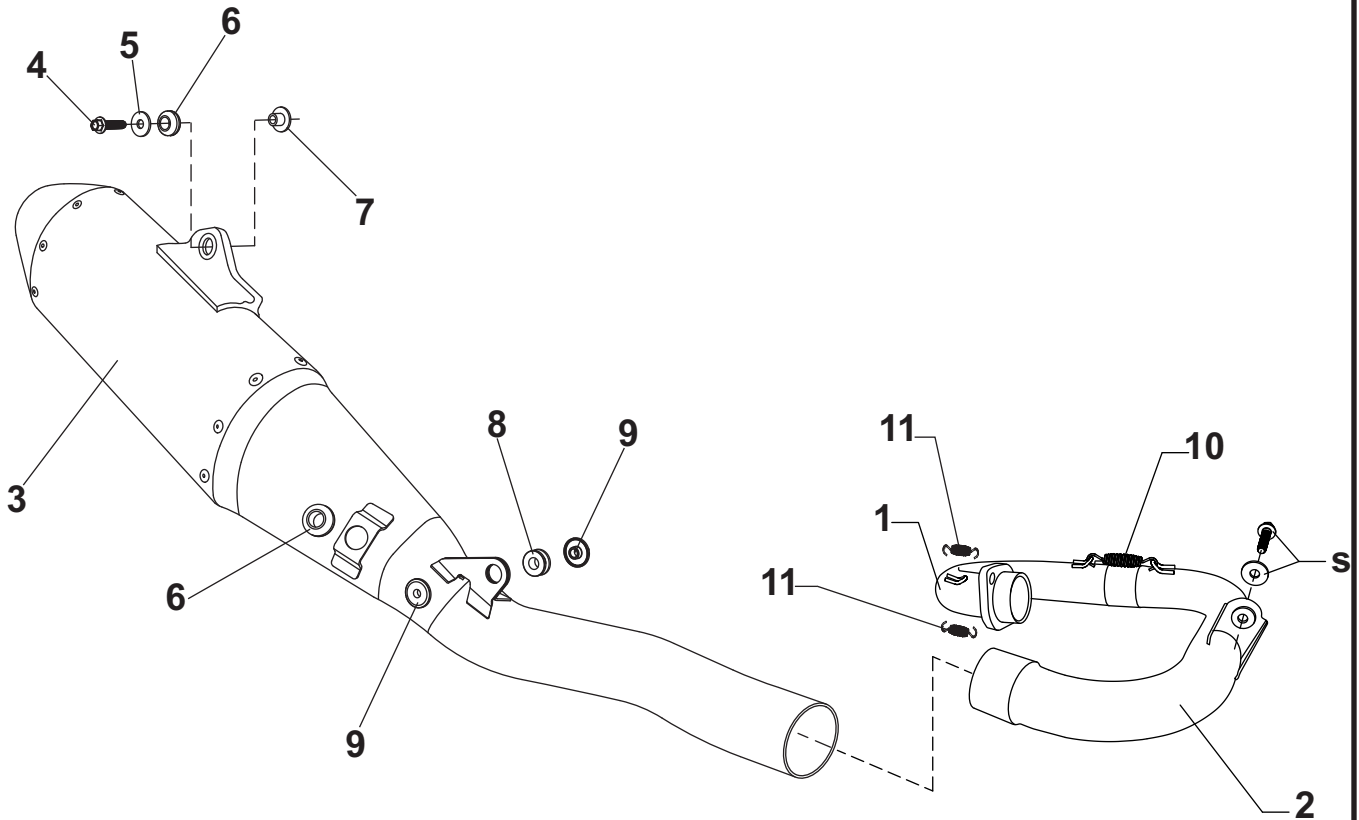
- CARB/EPA tail-pipe emissions compliant.
- Marked with appropriate EPA noise labels.
- Independent laboratory tested for EPA new vehicle noise compliance.



✘ 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.

Assembly Diagram

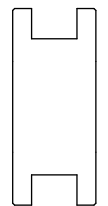


S = Stock

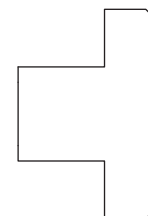
NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Stainless Steel Header Yoshimura Titanium Header	1	23102-101F 23101-704F
2	Yoshimura Stainless Steel Midpipe Yoshimura Titanium Midpipe	1	23102-140 23102-740
3	Yoshimura Muffler Assembly, SS/AL Yoshimura Muffler Assembly, Ti/Ti	1	231020D320-RMA 231021D720-RMA
4	8mm x 35mm Flanged Hex Head Bolt	1	M8X35H
5	8mm Large Washer	1	8MMWASHERL
6	Rubber Grommet (Round)	2	Z1022
7	Aluminum Spacer	1	ALS-002
8	Rubber Grommet (Flat)	1	Z1023
9	Aluminum Spacer	2	ALS-043
10	Medium Exhaust Spring	1	RACE-SPS-1
11	Short Exhaust Spring	2	RACE-SPX-2
**	8" x 10" Aluminum Heatshield Foil	1	ALFOILHS-8X10
**	Low Volume Sound Insert, 1.625" (Installed)	1	INS-10-K
**	Spring Puller Tool	1	ST-200
**	Offroad Endcap Plug	1	347PLUG
**	Yoshimura Vinyl Sticker	1	17029
OPTIONAL REPLACEMENT PARTS			
Repack Kit		REPACK-RS4-PK26	



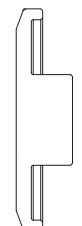
Z1022



Z1023



ALS-002



ALS-043

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.

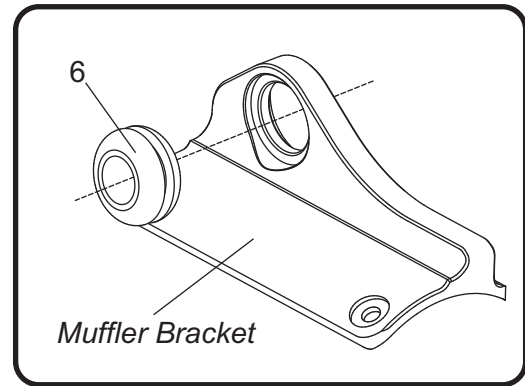
Removal

1. Remove the right side panel by removing the three side panel bolts.
2. Loosen the stock exhaust clamp at muffler to midpipe connection.
3. Remove the forward muffler chassis mount bolt.
4. While securely supporting the stock muffler assembly, remove the rear muffler mount bolt and carefully remove muffler from the stock midpipe.
5. Loosen the stock exhaust clamp between midpipe and header connection.
6. Remove midpipe support bracket bolt and carefully remove the stock midpipe from the header.
7. Remove the two header nuts and carefully remove the stock header.

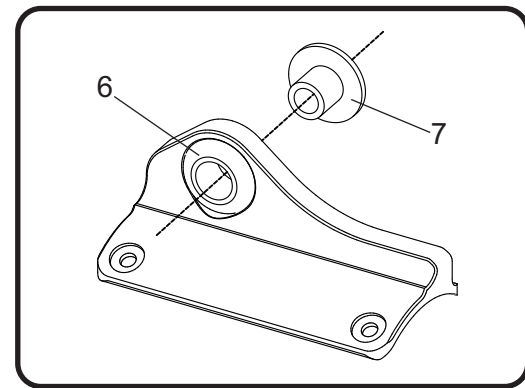
Note: The stock exhaust port gasket will be reused with the Yoshimura full-system. Inspect and replace if necessary.

Installation

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

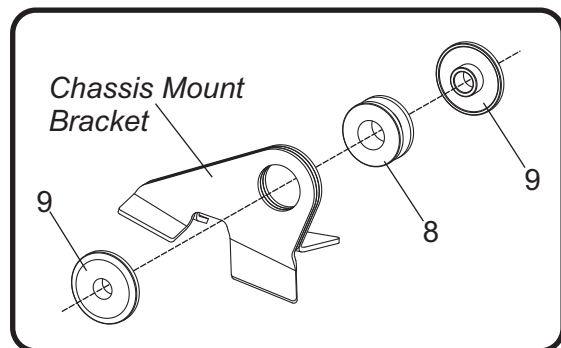


2. Install (No. 7) ALS-002, aluminum spacer into (No. 6) Z1022, round rubber grommet as shown.

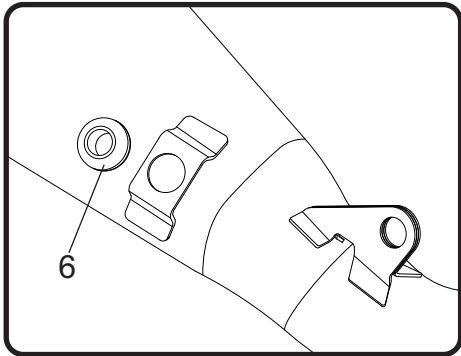


3. Install (No. 8) Z1023, flat rubber grommet into chassis mount bracket and install (No. 9) ALS-043, aluminum spacers into the front side and backside as shown.

Note: Use soapy water to lubricate rubber grommet to ease installation into chassis mount bracket.

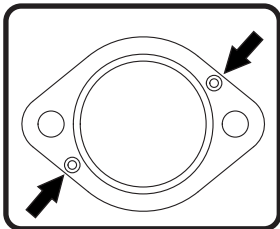


4. Install (No. 6) Z1022, rubber grommet into muffler resonator bracket as shown.



5. Install (No. 1) 23102-101F/704F, Yoshimura header using the stock header nuts. Do not torque at this time.

Note: It is recommended to hook *RACE-SPX-2*, short exhaust springs onto flange before installing header as it may be difficult to install springs after header has been installed.



6. Carefully install (No. 2) 23102-140/740, Yoshimura midpipe by maneuvering between the frame and engine. Slide midpipe inlet over the header outlet and align midpipe support bracket to midpipe mount. Secure using the stock bolt and washer. Do not torque at this time.
7. Install (No. 3) *muffler*, onto (No. 2) 23482-140/740, midpipe outlet. Secure Yoshimura forward muffler chassis mount to chassis using the stock bolt. Do not torque at this time.
8. Align and secure to muffler mount using (No. 4) M8X35H, bolt and (No. 5) 8MMWASHERL, washer supplied in the kit. Torque to factory specification.
9. Torque the stock forward muffler chassis mount bolt to factory specification.
10. Torque the midpipe support bracket bolt to factory specification.
11. Install (No. 10) *RACE-SPS-1*, medium exhaust spring between header and midpipe using *ST-200*, spring puller tool supplied in the kit.

12. Torque header nuts to factory specification and hook (No. 11) *RACE-SPX-2*, short exhaust springs between flange and header.

13. Cut out the provided heatshield template along the solid line.

14. Using a pen or marker, trace the paper template onto provided adhesive foil.

15. Cut out heatshield foil.

16. Clean number plate thoroughly with soap and water where heatshield foil will be applied.

17. Remove adhesive backing from foil heatshield and apply onto the inside of the 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.



18. Re-install right side panel.

19. 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.

20. 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.

