



YOSHIMURA

RESEARCH & DEVELOPMENT OF AMERICA, INC.

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

www.yoshimura-rd.com

OFF-ROAD PERFORMANCE EXHAUST SYSTEM

KTM

2007-09 250XC-F/W, 450SX-F

2008-09 450XC-F/XC-RW/EXCR

530 EXCR

2523703 STAINLESS STEEL SLIP-ON WITH ALUMINUM SLEEVE



THIS PRODUCT IS DESIGNED FOR USE IN CLOSED COURSE RACING AND IS NOT INTENDED FOR ANY OTHER USE.



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 and Extension
Metric Torx Bit Set
Torque Wrench

Installation Steps:

1. Place motorcycle on centerstand.
2. Remove stock exhaust springs. Fig. 1
3. Remove muffler to tailpipe exhaust springs using supplied spring puller tool.
4. Remove stock muffler.
5. Install rubber grommets into Yoshimura muffler brackets. Insert supplied spacers to the inside of the rubber grommets. Refer to parts diagram for orientation.
6. Install Yoshimura muffler onto stock tailpipe.
7. Install supplied bolts and washers.
8. Install supplied exhaust springs.
9. Reinstall exhaust cover.
10. Torque muffler mounting bolts to 16 lb-ft (21.6 Nm)
11. 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.
12. Before starting motorcycle 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.

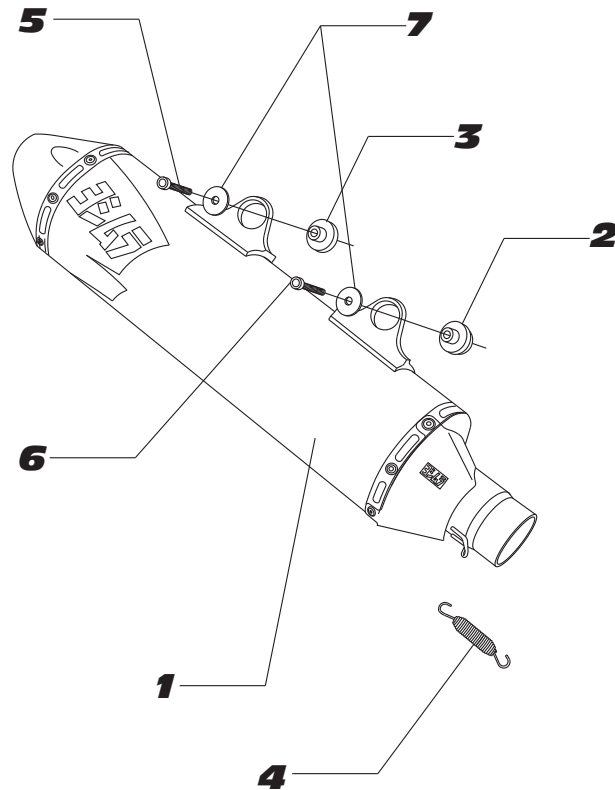


Fig. 1



Fig. 2

NOTE: After starting motorcycle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.

#2523703**S=STOCK**

Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Race Muffler with Aluminum Sleeve	1	2522703-RMA
2	Aluminum Spacer (Long)	1	ALS-019
3	Aluminum Spacer (Short)	1	ALS-007
4	Medium Exhaust Spring	1	RACE-SPS-1
5	6mm X 35mm Socket Head Cap Screw	1	M6X35
6	6mm X 50mm Socket Head Cap Screw	1	M6X50
7	6mm Washer XL	2	6MMWASHERXL
8	Aluminum Bracket Rubber Grommet	2	Z1022
**	Spring Puller Tool	1	ST-200
**	Off Road Encap Plug	1	347PLUG
**	Yoshimura Vinyl Sticker	1	17029



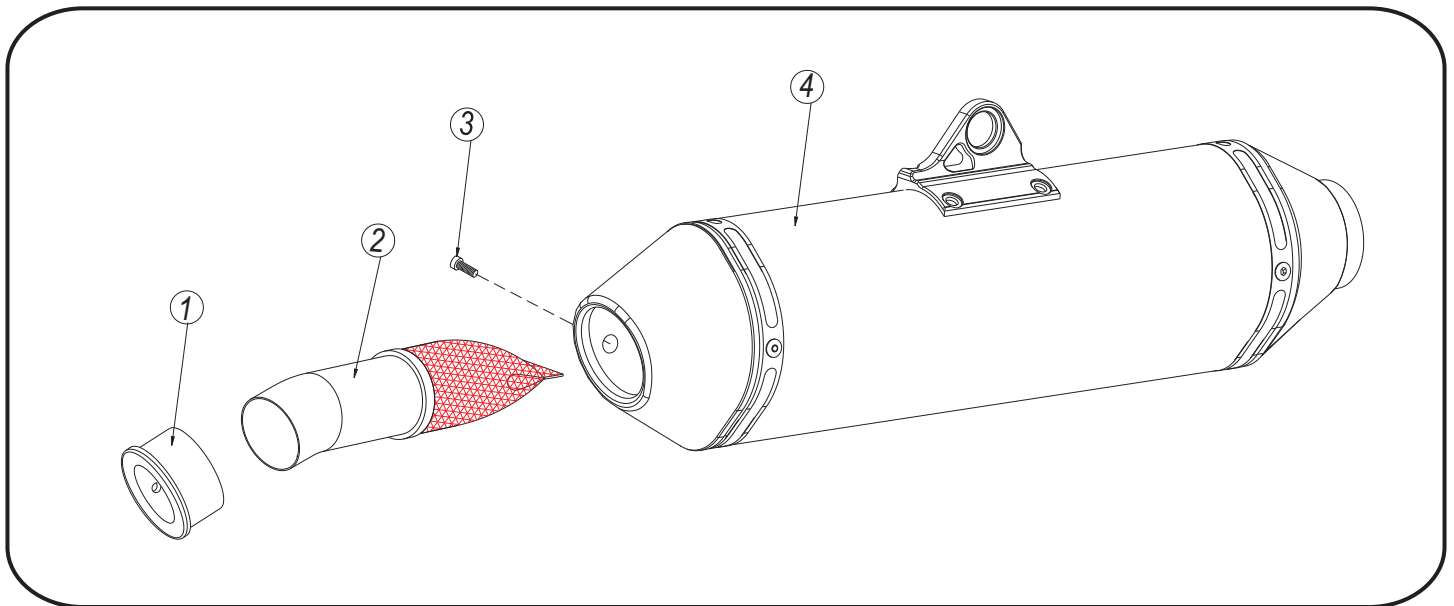
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Spark Arrester Cleaning Information



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 after every 60 hours of use.

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.*