



YOSHIMURA

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Signature Series

Qualified Manufacturer Declared "Replacement Part"

2019~2020

KTM

250SX-F

250XC-F

350SX-F

350XC-F

2019~2020

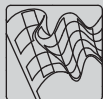
Husqvarna

FC 250

FC 350

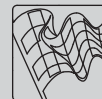
262530D320 (SS/AL)

RS-4 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.

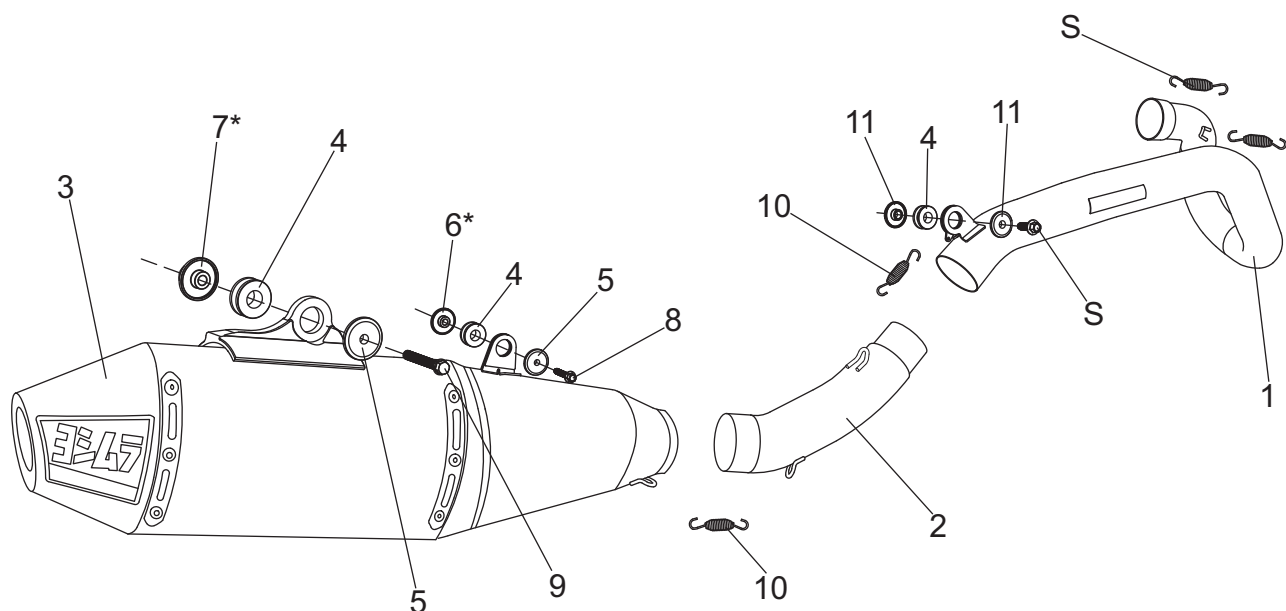


CAUTION: The muffler packing on this system **MUST** be replaced every 6-8 hours of use, or after each moto. Failure to follow recommended muffler re-packing interval can cause muffler damage and may void the warranty.



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.	Item	Description	Qty.
1	26253-104	Yoshimura SS Header	1
2	26253-144	Yoshimura SS Tailpipe	1
3	262530D320-RMA	SS/AL Muffler Assembly	1
4	Z1023	Rubber Grommet	3
5	ALS-046	Aluminum Spacer	2
6	ALS-054	Aluminum Spacer for Husqvarna	1
	ALS-057	Aluminum Spacer for KTM	1
7	ALS-047	Aluminum Spacer for Husqvarna	1
	ALS-056	Aluminum Spacer for KTM	1
8	M6X35H	6mm x 35mm Flanged Hex Head Bolt	1
9	M6X45H ¹	6mm x 45mm Flanged Hex Head Bolt	1
	M6X50H ²	6mm x 50mm Flanged Hex Head Bolt	
10	RACE-SPS-1	Medium Exhaust Spring	2
11	ALS-043	Aluminum Spacer	2
**	INS-U-2	Low Volume Sound Insert (Installed)	1
**	ST-200	Spring Puller Tool	1
**	347PLUG	Wash Plug	1
**	17100	Sticker Sheet	1
OPTIONAL REPLACEMENT PARTS			
REPACK-RS4-PK29		Re-pack Kit	
SA-04-K		Spark Arrester Kit	

** Not shown on diagram.

¹ M6X45H used on KTM 250/350SX-F.

² M6X50H used on Husqvarna FC 250/350.

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

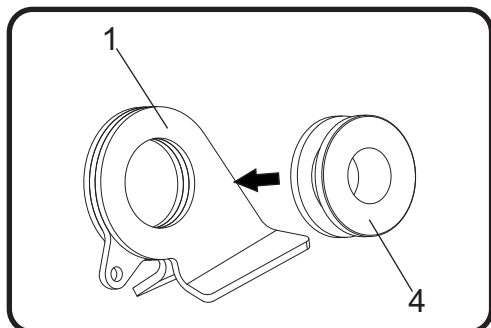
1. Remove the stock exhaust spring between the muffler and header.
2. While securely supporting the stock muffler, remove the two muffler mount bolts and carefully remove the stock muffler.

For Husqvarna FC250/350, remove side panel to access muffler bolts.

3. Remove the two header exhaust springs.
4. Remove the header chassis mount bolt and carefully remove the stock header.

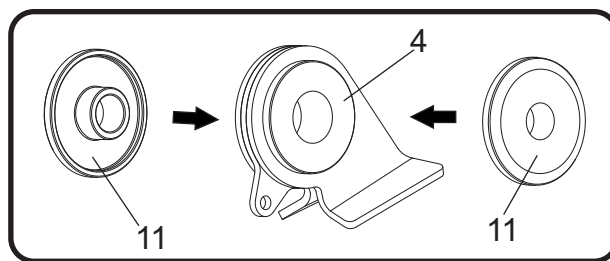
Installation

1. Install (No. 4) Z1023, rubber grommet into (No. 1) 26253-104, header chassis mount bracket. Use soap and water mixture to lubricate grommet to ease installation.

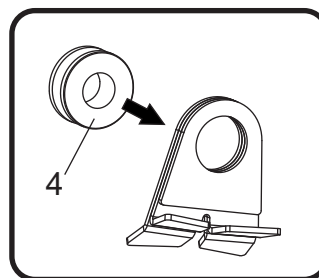


2. Install (No. 11) ALS-043, aluminum spacers into (No. 4) Z1023, rubber grommet as shown.

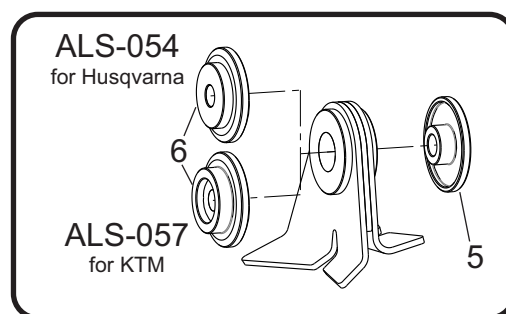
Note: ALS-043 spacers have 8mm hole to be used with the header chassis mount bolt. ALS-046 spacers have a 6mm hole used for the muffler mount bolts.



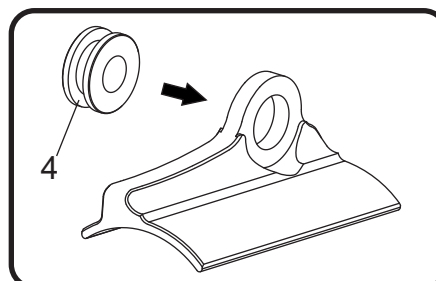
3. Install (No. 1) 26253-104, header onto stock flange and secure using the stock header springs. Align header chassis mount bracket to chassis and secure using the stock header chassis mount bolt. Do not torque at this time.
4. Install (No. 4) Z1023, rubber grommet into muffler resonator bracket.



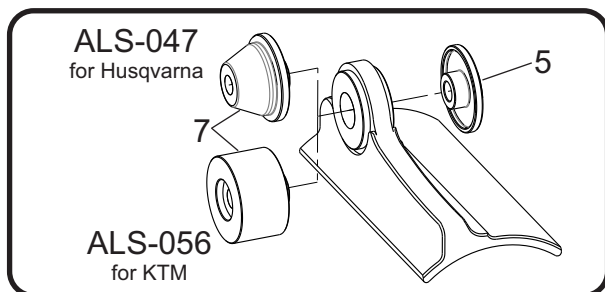
5. Install (No. 5) ALS-046, aluminum spacer in the front side of (No. 4) Z1023, rubber grommet and install (No. 6) ALS-054 for Husqvarna OR ALS-057 for KTM, aluminum spacer in the back side of (No. 4) Z1023, rubber grommet as shown below.



6. Install (No. 4) Z1023, rubber grommet into muffler bracket.

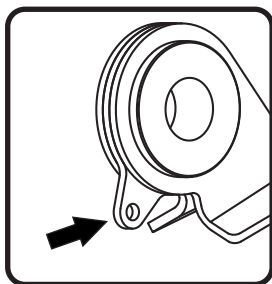


7. Install (No. 7) *ALS-047 for Husqvarna* OR *ALS-056 for KTM*, aluminum spacer in the backside of (No. 4) *Z1023*, rubber grommet and install (No. 5) *ALS-046*, aluminum spacer in the frontside as shown below.



8. Install (No. 2) *26253-144*, tailpipe outlet into (No. 3) *muffler* inlet.
9. Install *muffler/tailpipe assembly*, onto (No. 1) *26253-104*, header outlet. Align muffler bracket and muffler resonator bracket to subframe and secure using (No. 8,9) 6mm bolts as shown in the assembly diagram.
10. Torque muffler mount bolts to factory specification.
11. Torque header chassis mount bolt to factory specification.
12. Install (No. 10) *RACE-SPS-1*, medium exhaust spring between muffler and tailpipe.
13. Install (No. 10) *RACE-SPS-1*, medium exhaust spring between header and tailpipe.

Note: Hook spring onto header chassis mount.



14. For Husqvarna FC250/350, it is required to trim the right side panel to clear the rear muffer mount spacers. Mark and mask side panel as shown and trim using a rotary tool. Using a file, file edges smooth and re-install side panel.



15. 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.

16. 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.