



# YOSHIMURA

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[www.yoshimura-rd.com](http://www.yoshimura-rd.com)

## RACE SERIES

Qualified Manufacturer Declared "Modified Part"

**2019  
Honda CRF450L / X**

**124500D320 (AL/CF)  
RS-4 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.

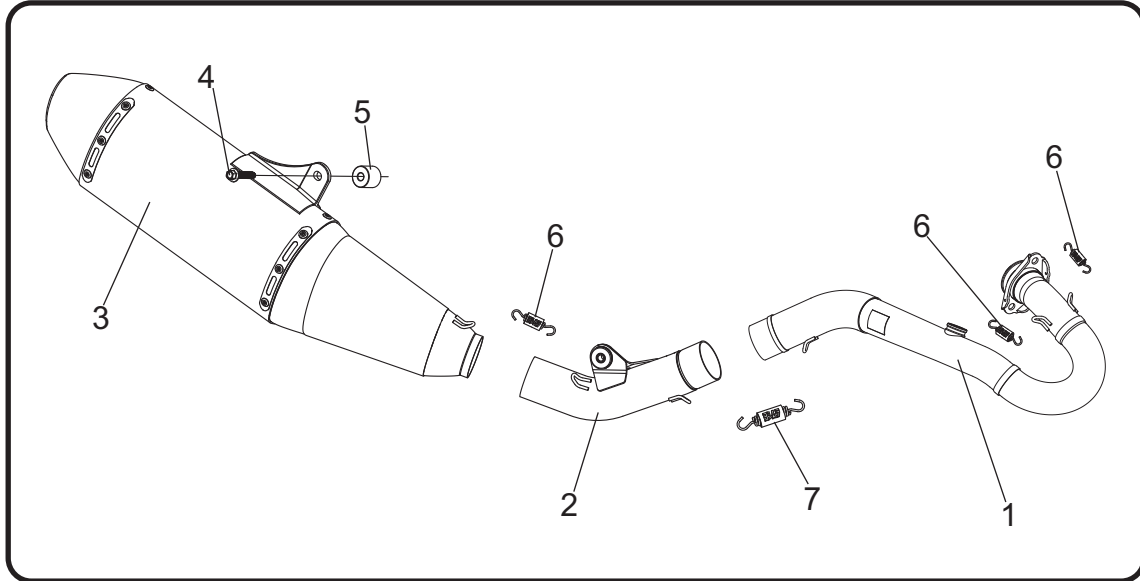


*You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new Yoshimura exhaust depending on the application. Read 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	12450-104F	Yoshimura Header Kit	1
2	22450-144	Yoshimura Tailpipe	1
3	224500D320-RMA	Yoshimura Muffler	1
4	M8X45H	8mm x 40mm Flanged Hex Head Bolt	1
5	8X22SPC	Aluminum Spacer	1
6	RACE-SPX-2	Short Exhaust Spring	3
7	RACE-SPS-1	Medium Exhaust Spring	1
**	OXYBA12X125SS	O2 Bung Adapter	1
**	M18X13PLG	O2 Bung Plug	1
**	ST-200	Spring Puller Tool	1
**	17100	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.

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## Removal

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1. Remove right side panel.
2. Loosen muffler exhaust clamp and remove muffler chassis mount bolt.
3. While securely supporting the muffler assembly, remove muffler mount bolt and carefully remove the stock muffler assembly by sliding toward the rear.
4. Remove the stock O2 sensor from header.
5. While securely supporting the stock header, remove header nuts and carefully remove the stock header.

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

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## Installation

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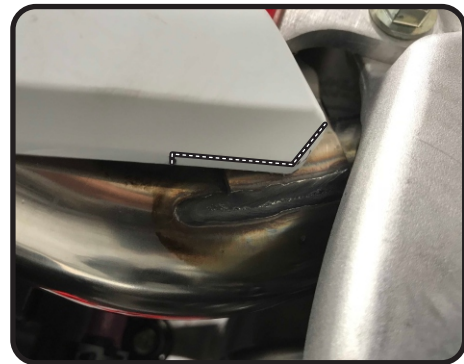
1. Install (No. 1) *12450-104F*, header kit using the stock header nuts. Torque header nuts to factory specifications and hook (No. 6) *RACE-SPX-2*, short exhaust springs onto flange and header spring hooks using *ST-200*, spring puller tool.
2. Install (No. 2) *22450-144*, tailpipe inlet onto (No. 1) *12450-104F*, header outlet. Align tailpipe chassis mount bracket to chassis and secure using the stock chassis mount bolt. Do not torque at this time.

3. Install (No. 3) *224500D320-RMA*, muffler onto (No. 2) *22450-144*, tailpipe outlet. Using the (No. 5) *8X22SPC*, aluminum spacer, align muffler mount bracket to muffler mount and secure using (No. 4) *M8X45H*, 8mm bolt as shown on the assembly diagram. Torque bolt to 23 Nm (2.3 kg-m, 17 ft-lb).
4. Torque stock muffler tailpipe chassis mount bolt to factory specification.
5. Install (No. 6) *RACE-SPX-2*, short exhaust spring between muffler and tailpipe using *ST-200*, spring puller tool.
6. Install (No. 7) *RACE-SPS-1*, medium exhaust spring between tailpipe and header using *ST-200*, spring puller tool.
7. Install *OXYBA12X125SS*, O2 bung adapter in *12450-104F*, header and re-install stock O2 sensor. Torque to factory specification.

Note: If O2 sensor will not be used, install supplied *M18X13PLG*, O2 sensor plug into header.

8. Re-install right side panel following the opposite steps of removal.

Note: Check to make sure the side panel is not contacting the tailpipe. If necessary, trim the bottom right corner of the side panel.



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