



PERFORMANCE EXHAUST SYSTEM

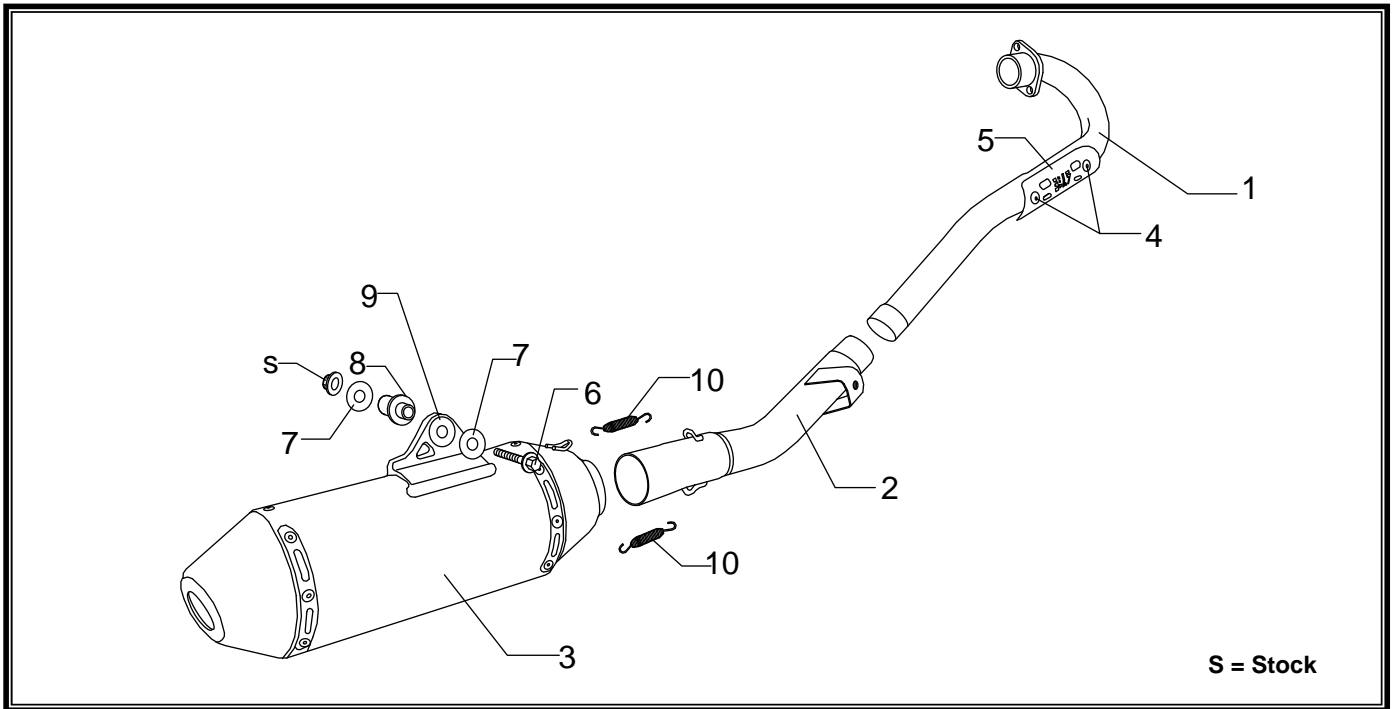
APPLICATION

YEAR	MODEL
2003-2009	Honda CRF230F

PRODUCT

222300C350	RS2 SS Full-System Exhaust with Aluminum Sleeve; Spark Arrested
222300C250	RS2 SS Full-System Exhaust with Carbon Fiber Sleeve (No Spark Arrestor)

- This product is designed for use in closed course racing and is not intended for highway use. In the state of California, it is illegal to modify the emission control system, which includes the fuel injection of any vehicle.
- 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.



No.	Part #	Description	Qty
1	22230-101	Yoshimura Header	1
2	22230-144	Yoshimura Tailpipe	1
3	222300C350-RMA 222300C250-RMA	Yoshimura Muffler Aluminum Sleeve Carbon Fiber Sleeve	1
4	RC116HSB	6mm x 8mm Button Head Screw	2
5	2205-HS	Yoshimura Heatshield	1
6	M8X50H	8mm x 50mm Flanged Head Bolt	1
7	8MMWASHERL	8mm Washer	2

8	ALS-025	Aluminum Spacer	1
9	Z1022	Rubber Grommet	1
10	RACE-SPS-1	Med Spring w/ Insulator 2.3"	2
**	347PLUG	Muffler Wash Plug	1
**	ST-200	Spring Puller Tool	1
**	17029	Yoshimura Sticker Sht	1
<i>Replacement Parts</i>			
****	SA-02-K	Spark Arrestor Kit	
****	REPACK-RS2-PK13	Muffler Repacking Kit	

-TOOLS REQUIRED-

*Metric Socket Set • Combination Wrench Set • Torque Wrench
Metric Allen Wrench Set • Screwdriver*

-REMOVAL-

1. *Removing the side panel.*
 - a) **Remove the side panel screw with screwdriver.**
 - b) **Carefully pull off side panel from the top corner tabs.**
2. *Removing the muffler.*
 - a) **Loosen the muffler clamp on the tailpipe.**
 - b) **Remove the (2) bolts that hold the muffler assembly to subframe.**
 - c) **Remove the muffler and tailpipe from the stock header.**
 - d) **Remove the (2) header nuts to take off header.**
 - e) **Remove stock rubber grommet from muffler mount on subframe.**

-INSTALLATION-

1. *Small parts installation.*
 - a) **Install provided rubber grommet into muffler bracket. See diagram for orientation.**
 - b) **Install aluminum spacer provided in the kit onto muffler mount in the subframe. See diagram for orientation.**
 - c) **Install Yoshimura heatshield onto header using the (2) 6mm button head screws provided in the kit. Torque to 7lb-ft (10N-m, 1.0kg-m)**
2. *Installing the header.*
 - a) **Install Yoshimura header using stock nuts. Do not torque header nuts at this time.**
(NOTE: Inspect the stock gasket. If damaged, it is recommended that you replace the exhaust port gasket. Stock P/N: 18291-MN5-650)
3. *Installing the muffler tailpipe assembly.*
 - a) **Carefully install Yoshimura muffler tailpipe assembly by sliding onto Yoshimura header. (Removing the muffler springs may ease installation.)**
 - b) **Bolt the tailpipe to front subframe mount using the stock bolt and washer. Start threads by hand to prevent cross-threading.**
 - c) **Install provided 50mm muffler mounting bolt, washers, and stock nut. See diagram for orientation. (NOTE: Do not torque muffler bolt at this time.)**
 - d) **Torque header nuts to 14lb-ft (20N-m, 2.0kg-m)**
 - e) **Torque front tailpipe mounting bolt to 20lb-ft (26N-m, 2.7kg-m)**
 - f) **Torque muffler mounting bolt to 20lb-ft (26N-m, 2.7kg-m)**
 - g) **Re-install the tailpipe to muffler springs using the spring puller tool provided in the kit if removed earlier.**
4. *Re-install side panel.*
 - a) **Re-install side panel using the reverse steps of removal.**

5. *Fitment check and Notes.*

- a) **Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swing-arm, brake, rear shock, engine, 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.**
- b) **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.**
- c) **NOTE: After starting motorcycle, it is normal for new exhaust system and muffler to emit smoke until oil residue burns off.**
- d) **NOTE: It is not recommended using a spark arrestor on Carbon Fiber Systems due to possible damage caused by heat build up.**

-SPARK ARRESTOR CARE AND MAINTENANCE-



YOSHIMURA

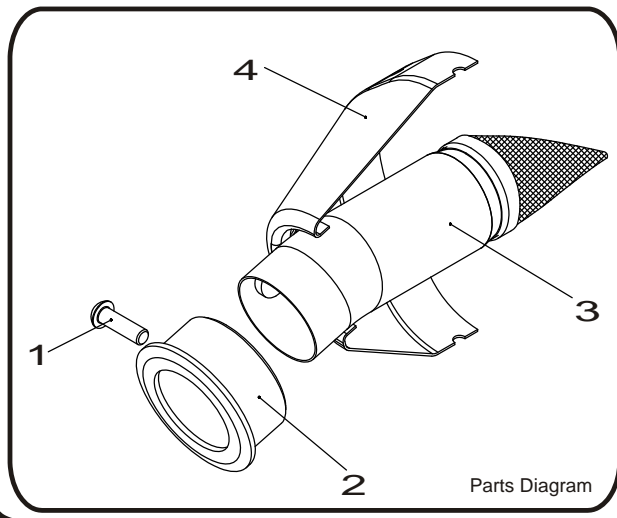
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SA-02-K

YOSHIMURA TEC-SD8 SPARK ARRESTOR KIT



NO.	DESCRIPTION	QTY	PART #
1	6mm X 20mm Button Head Cap Screw	1	M6X20BHS
2	RS2 Spark Arrester Ring 1.500"	1	DS4-RING-1500
3	TEC-SD8 Spark Arrester	1	TEC-SD8
4	Yoshimura Exhaust	**	**

- 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.
- 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.