YOSHIMURA
RESEARCH&DEVELOPMENT OF AMERICA, INC.
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www.yoshimura-rd.com

Signature Series

Qualified Manufacturer Declared "Replacement Part"

2004~2013
Yamaha Raptor 350
2391703 (SS/AL)
RS-2 Stainless Steel Slip-On

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.

Caution: Exhaust system can be extremely hot. Let motorcycle cool down before beginning installation.

Note: Read through all instructions before beginning installation.

Tools Needed:

10mm,11mm (or 7/16"), 12mm sockets
3/8" ratchet and extension
12mm wrench
Phillips screwdriver
Torque wrench

Installation Steps:

1 *Remove tailpipe heat shields from stock exhaust system and loosen exhaust clamp. (Fig. 1)*

2 *Remove muffler mouting bolts and grab bar bolt. (Fig. 2)*

3 *Slide Stock Muffler / Tailpipe assembly out*

4 *Install supplied rubber grommet and aluminum insert to muffler bracket (Fig. 3).*

5 *Slip 1.75" exhaust clamp onto Yoshimura tailpipe and install tailpipe with muffler onto stock header*

Note: No gasket is needed.

8 *Mount Muffler using supplied bolt, washer and spacers. (See Fig. 4)*

Torque bolt to 2.5 kg-m (18 lb-ft).

11 *Reinstall stock heat shield to Yoshimura Tailpipe.*

13 *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 tech. dept. At (800)634-9166 / in CA (909)628-4722*

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

Fig. 1

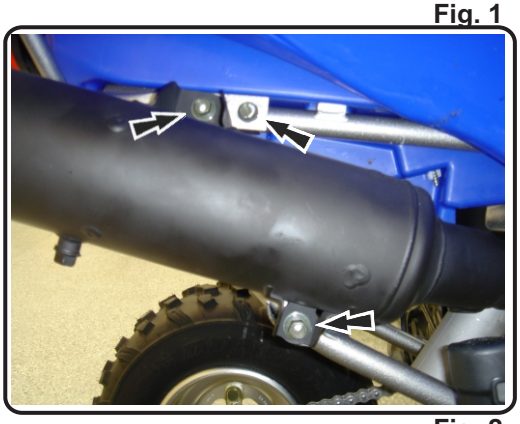


Fig. 2

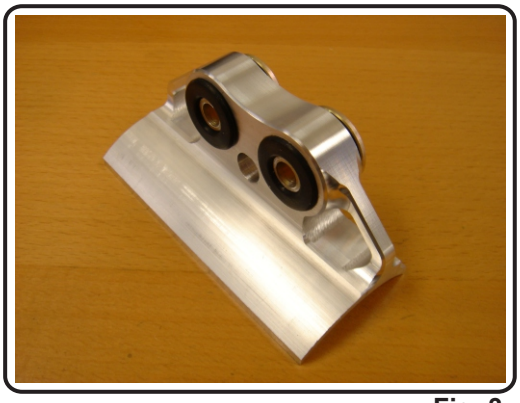


Fig. 3

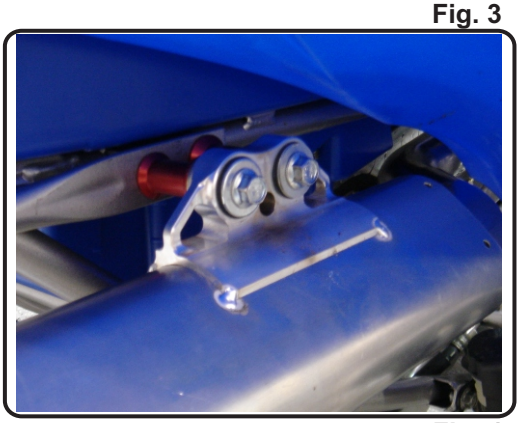
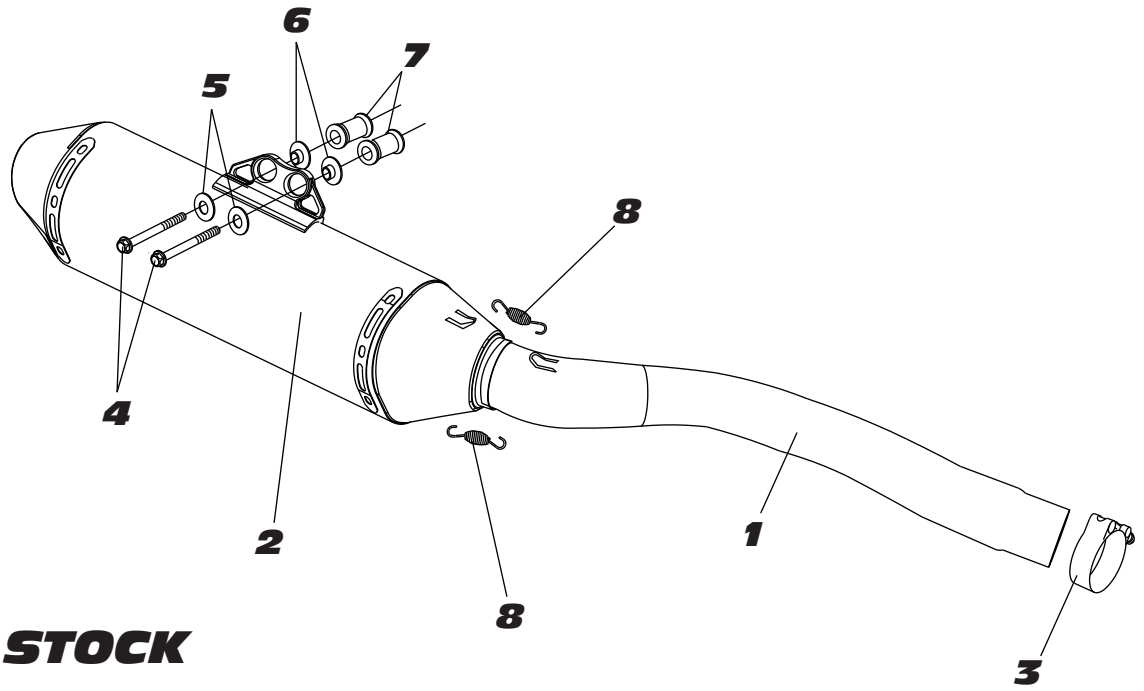


Fig. 4

#2391703



Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Tailpipe	1	2391-152
2	RS2 Muffler Assembly	1	2391503-RMA
3	Stainless Steel Clamp	1	22059
4	8mm x 75mm Flange Hex Bolt	2	M8X75H
5	Large 8mm Washer	2	8MMWASHERL
6	Aluminum Spacer	2	ALS-001
7	Aluminum Spacer	2	8X35SPCR
8	Medium Exhaust Spring	2	RACE-SPS-1
**	Rubber Grommet	2	011257-00
**	Spring Puller Tool	1	ST-200
**	Yoshimura Endcap Plug	1	347PLUG
**	Yoshimura Vinyl Sticker	1	17029

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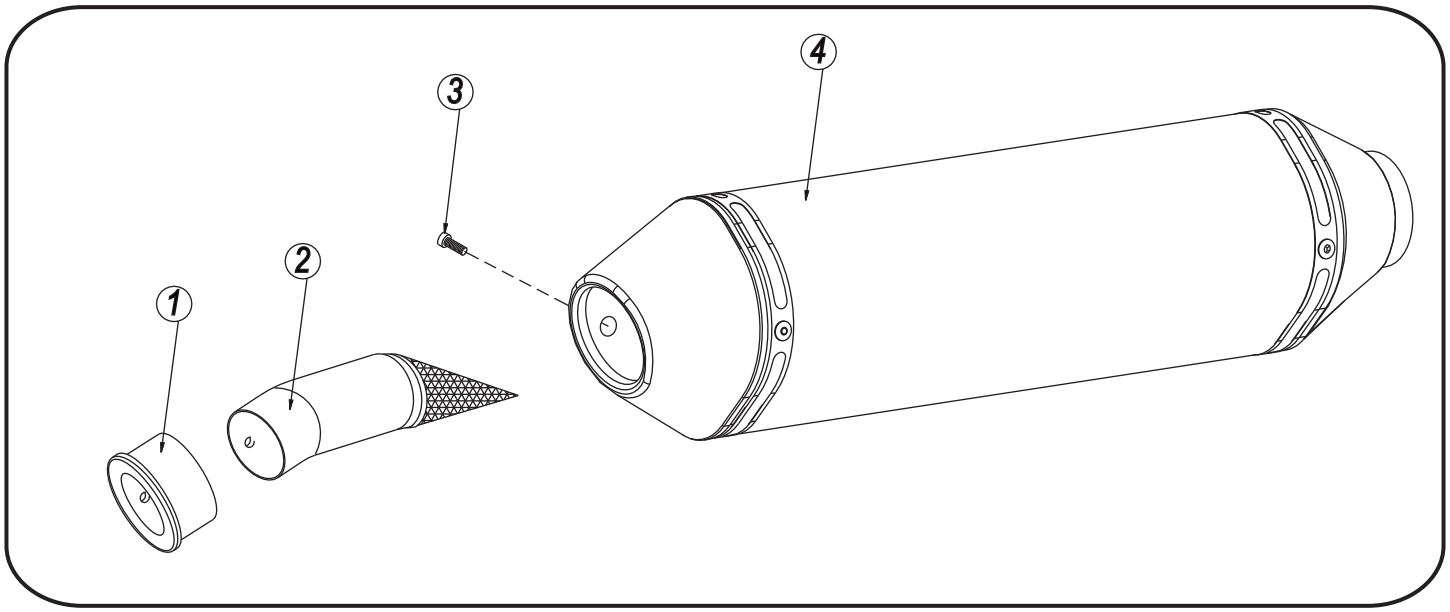
Spark Arrester Cleaning Information



Parts Diagram

NO.	DESCRIPTION	QTY
1	Aluminum Ring	1
2	Spark Arrester	1
3	Spark Arrester Securing Bolt	1
4	Muffler Assembly	1

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.*

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 at the same time as muffler repacking. Repacking is recommended every 8-10 hours of riding or 2 motos, whichever comes first.*

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.