



# YOSHIMURA

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## **YOSHIMURA PERFORMANCE EXHAUST SYSTEM**

**SUZUKI**  
**2012-2013**  
**GSX-R1000**

**1118103220**

R77D FULL SYSTEM WITH CARBON FIBER SLEEVE

**1118103520**

R77D FULL SYSTEM WITH STAINLESS SLEEVE



**THIS PRODUCT IS DESIGNED FOR USE IN CLOSED COURSE RACING AND IS NOT INTENDED FOR HIGHWAY USE.**



NOTE: IN THE STATE OF CALIFORNIA, IT IS ILLEGAL TO MODIFY THE EMISSION CONTROL SYSTEM, WHICH INCLUDES THE FUEL INJECTION 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                      3/8" ratchet and extension  
Metric Allen Wrench Set              Torque Wrench

Metric Combination Wrench Set  
Small Flat Head Screwdriver

## Installation Steps:

- 1 Loosen stock exhaust clamps.
- 2 Unbolt and remove stock muffler from passenger foot rest mounts.
- 3 Remove left and right fairings. Unscrew O2 sensor from stock header.
- 4 Completely remove exhaust valve cables. Do not remove or unplug exhaust valve servo motor. Only the exhaust valve cables are to be removed.
- 5 Unbolt oil cooler from bracket. Remove lower radiator bracket and tilt radiator forward. (Fig. 1)
- 6 Remove stock header and exhaust port gaskets.
- 7 Install Yoshimura manifolds and flanges into exhaust ports using stock header bolts (see Fig. 2 for flange orientation). Install exhaust springs onto flanges for ease of installation.  
  
**NOTE:** This Yoshimura full system is designed to be installed without exhaust port gaskets. If exhaust port gaskets are used, there may be insufficient clearance between the header and radiator.
- 8 Install Yoshimura header from one end of the engine to the other by slipping one tube at a time onto manifolds. (NOTE: Make sure header is fully seated to manifold. This may be accomplished by lightly tapping the header with a soft faced mallet.)
- 9 Connect header to flanges using the supplied springs.
- 10 Bolt header to chassis mount using stock bolt, washer, spacer, supplied washer and supplied nut (See Parts Diagram and Fig. 3). Orientation from left side of the bike is as follows: Stock bolt, stock washer, chassis, stock spacer, Yoshimura tailpipe mount, supplied washer, supplied nut. Do not torque at this time.
- 11 Install chassis mount bolt but do not tighten at this time. Install stock O2 sensor into Yoshimura header.
- 12 Install rubber heat insulator to inside of muffler clamp. Slide muffler clamp onto Yoshimura muffler.

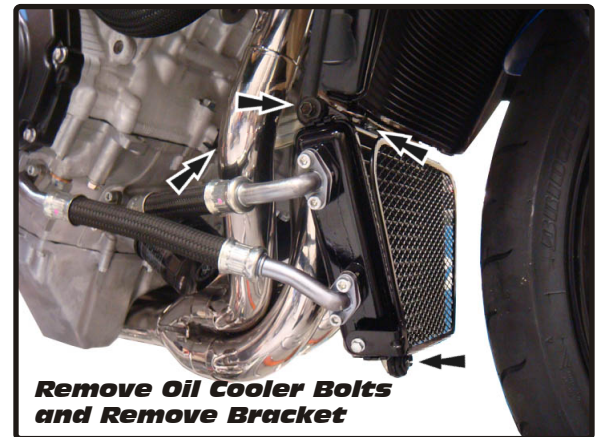


Fig. 1

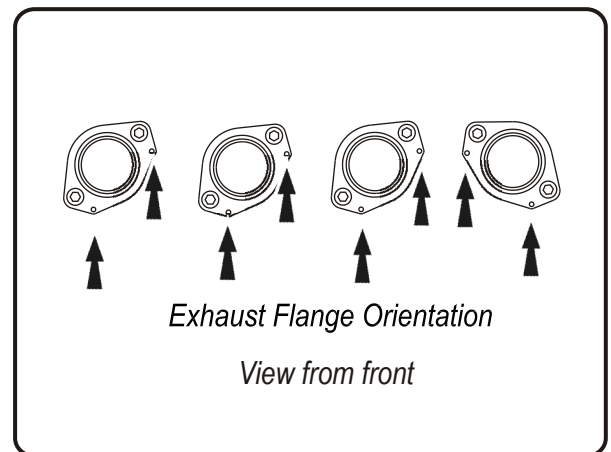


Fig. 2



Fig. 3

- 13 Slip Yoshimura muffler and tailpipe onto the Yoshimura header.
- 14 Mount muffler to stock muffler mounting location using stock hardware. Do not torque at this time. (Fig. 4)
- 15 Install supplied exhaust springs to header and tailpipe.
- 16 Check header and tailpipe position by adjusting header so that chassis mount bolt lines up. Check for clearance between muffler and swingarm.
- 17 Reinstall lower radiator bracket and oil cooler bracket.
- 18 Torque header nuts to 1.0 kgf-m (7.3 lb-ft).
- 19 Torque chassis mount bolt to 2.3 kg-m (16.5 lb-ft).
- 20 Torque muffler mount bolt to 2.3 kgf-m (16.5 lb-ft).
- 21 Install Yoshimura Servo Stopper Plate. See Page 4 for Instructions.
- 22 Reinstall the left and right side fairings.
- 23 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.
- 24 Check for proper clearance between new exhaust system and motorcycle. (i.e. Swing-arm, body work, 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.

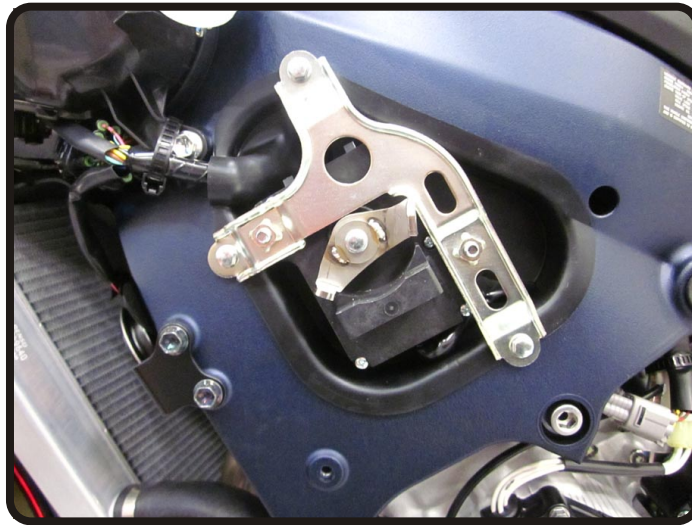
**Note:** After starting motorcycle, it is normal for new exhaust system and muffler to smoke until oil residue burns off.



**Fig. 4**

**Yoshimura Servo Motor Bracket Installation**

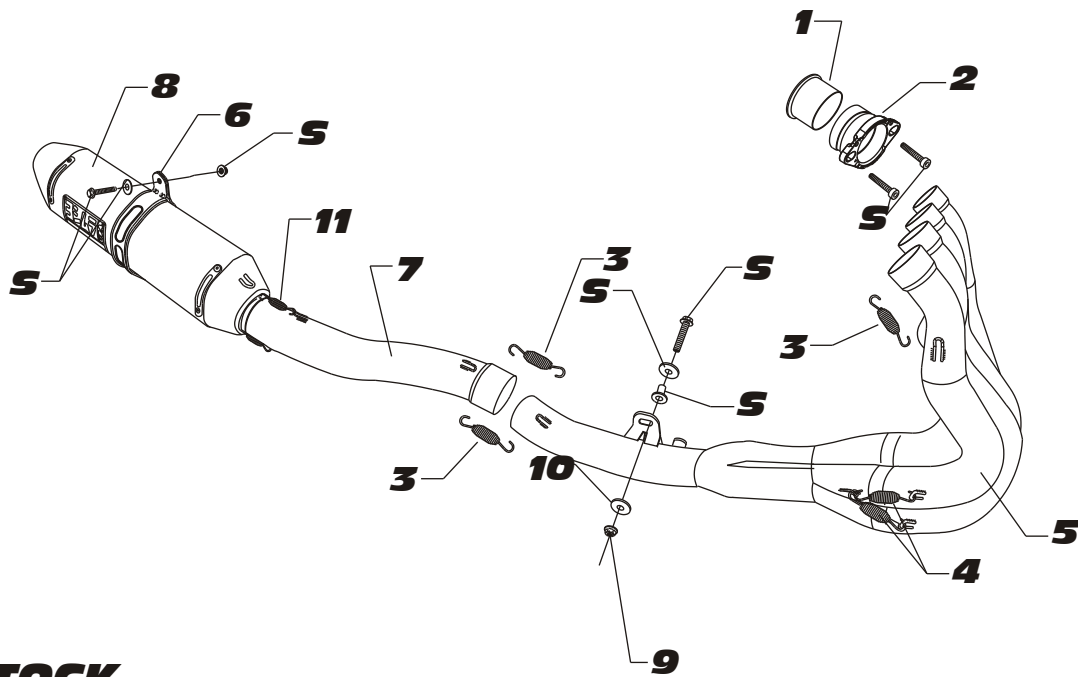
1. Remove left side fairing.
2. Take note of position of exhaust valve servo.
3. Remove cables.
4. Remove exhaust servo nut using tamper proof torx bit. *Note: Firmly hold servo pulley in place while loosening servo nut to prevent damage to servo motor.*
5. Install Yoshimura stopper plate onto the servo motor using stock bolt. *Note: Firmly hold servo pulley in place while tightening servo nut to prevent damage to servo motor.*  
*Note: The stopper bracket tabs on the ends should be pointing up when properly installed. Improper installation may permanently damage servo motor.*
6. Reinstall fairing.



**NOTE:** The Yoshimura header includes an adapter for the O2 sensor bung to be used with the M12X1.25 OEM O2 sensor. In the case that an aftermarket O2 sensor is utilized requiring an M18X1.5 thread pitch, remove the adapter shown in Fig. 9 to reveal the M18X1.5 bung.

**Fig. 9**

**#1118103(220,520)**



**S=STOCK**

Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Stainless Steel Manifold	4	1118SMT
2	Yoshimura Stainless Steel Flange	4	1118SDY-1
3	Small Race Spring	10	RACE-SPX-1
4	Medium Race Spring	4	RACE-SPS-1
5	Yoshimura Header	1	11181-404-01
6	Stainless Steel Muffler Clamp Stainless Steel Sleeve use Carbon Fiber Sleeve use	1	1121-MPCAX 1121-MPCA
7	Yoshimura Tailpipe	1	1118-419
8	Yoshimura R77D Muffler with Carbon Fiber Sleeve with Stainless Steel Sleeve	1	CRR77D146W SRR77D146W
9	8mm Nut	1	8MMNUT
10	8mm Washer XL	1	8MMWASHERXL
11	82mm Exhaust Spring	2	RACE-82MM
**	EVA Stopper Plate	1	11181-CKRPLT
**	Muffler Clamp Heat Insulator	1	HT SHLDR77
**	Spring Puller Tool	1	ST-200
**	Yoshimura Sticker Kit Sheet	1	17029