



YOSHIMURA

RESEARCH & DEVELOPMENT OF AMERICA, INC.

5420 DANIELS STREET STE A, CHINO CA 91710 · (800)634-9166 · (909)628-4722 · FACSIMILE (909)591-2198

WWW.YOSHIMURA-RD.COM

OFF-ROAD PERFORMANCE EXHAUST SYSTEM

HONDA
2005-2012
CRF450X

2254513

STAINLESS STEEL FULL SYSTEM WITH ALUMINUM SLEEVE



THIS PRODUCT IS DESIGNED FOR USE IN CLOSED COURSE RACING AND IS NOT INTENDED FOR ANY OTHER USE.



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:

8mm, 10mm, and 12mm Sockets
Ratchet Wrench and Extension
Torque Wrench
Spring Puller Tool

Installation Steps:

1. Remove right rear number plate (see Fig. 1 for bolt locations).
2. Remove stock exhaust system and stock exhaust port gasket (see Fig. 2 and 3 for nut and bolt locations).
3. Install new exhaust gasket (not supplied)
4. Install Yoshimura heat shield onto Yoshimura header using stock bolts and mounting clips (see parts diagram on Page 5).
5. Install Yoshimura header using stock header nuts. Do not tighten header nuts at this time. Leaving the header nuts loose will allow you to adjust the header if necessary for proper fitment of the exhaust system.
6. Install supplied rubber grommet into muffler mounting bracket. Install aluminum insert in grommet (ensure shoulder of insert faces toward the frame mount, see Fig. 4).
7. Line up tailpipe chassis mounting bolt position and install supplied chassis mount bolt (leave loose).
8. Mount muffler to stock muffler mount using supplied bolt and washer. Only hand tighten muffler mounting bolt at this time.



Fig. 1



Fig. 2

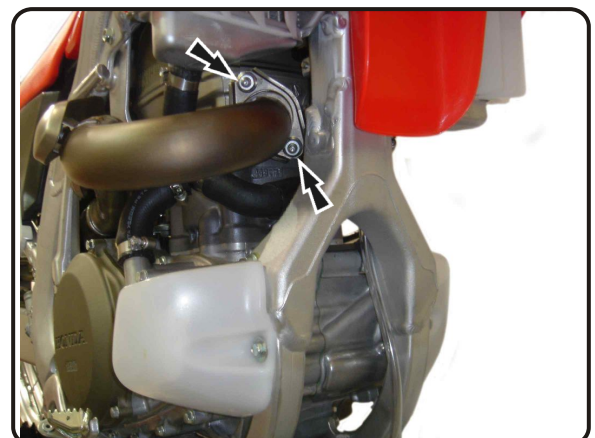
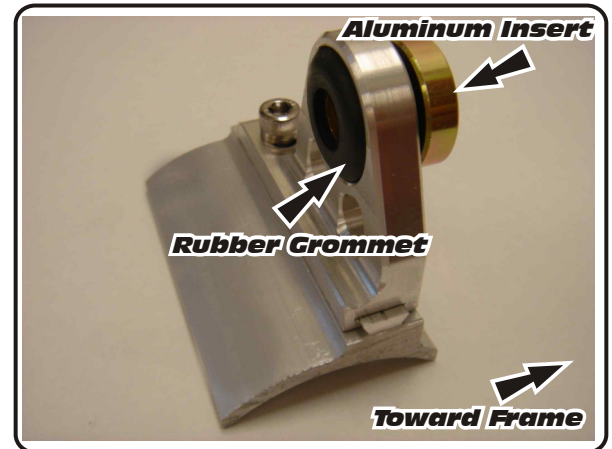
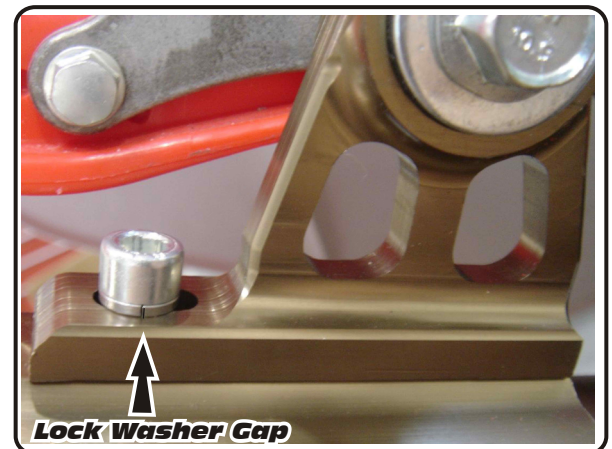


Fig. 3

9. If necessary, loosen the set screw on the aluminum muffler mounting bracket to line up the bolt holes. Do not tighten set screw at this time.
10. Check exhaust for proper position and clearance, adjust if necessary.
11. Torque muffler mount bolt to 2.5 kg-m (18 lb-ft).
12. Torque chassis mount bolt to 2.5 kg-m (18 lb-ft).
13. Torque set screw to 1.0 kg-m (7 lb-ft).

NOTE: When tightening the set screw, note the orientation of the lock washer in Figure 5. Make sure that the gap in the lock washer is not in the adjustment slot.

14. 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.

**Fig. 4****Fig. 5**

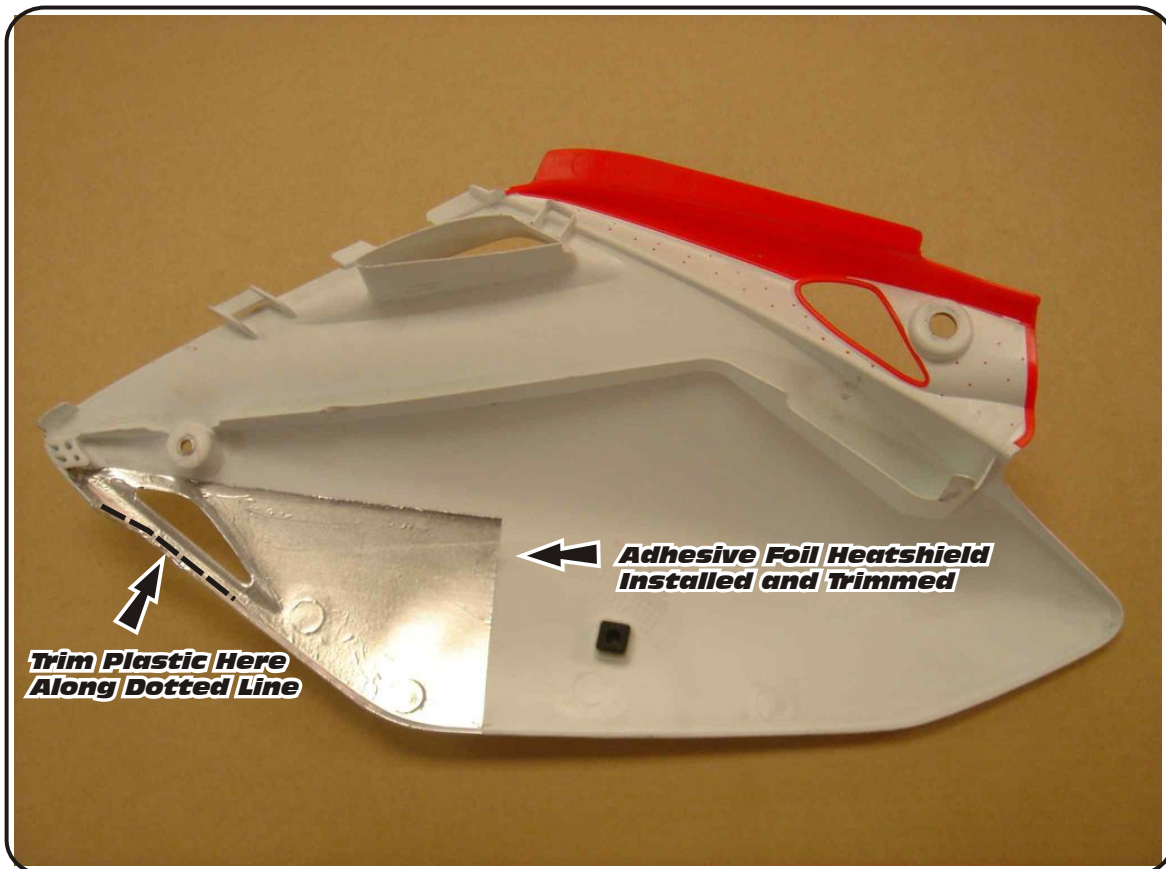


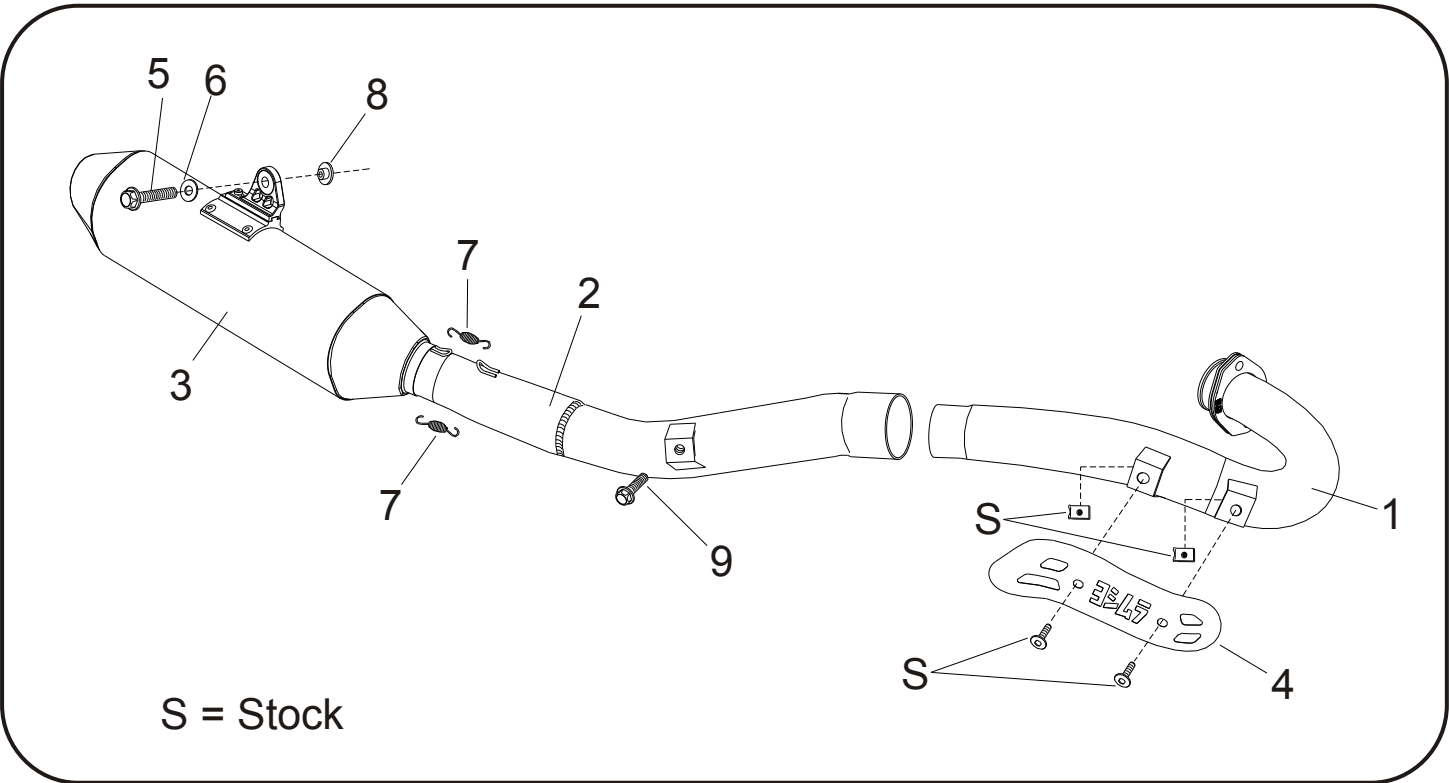
Fig. 7

15. Trim the number plate as shown in figure 7. The dotted line in figure 7 shows where the plastic must be cut.
16. Apply adhesive foil heatshield to the inside of the number plate and trim off excess material as shown in figure 7.

NOTE: Your Yoshimura exhaust system has been designed with weight centralization in mind. Trimming of the number plate is required in order to move the muffler as far forward as possible.
17. Reinstall number plate.
18. Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swing-arm, brake, rear shock, 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.

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

#2254513



Parts Diagram

NO.	DESCRIPTION	QTY	PART #
1	Yoshimura Stainless Steel Header	1	2254-101
2	Yoshimura Stainless Steel Tailpipe	1	2254-144-A
3	Yoshimura Race Muffler with Aluminum Sleeve	1	2254513-RMA
4	Yoshimura Heatshield	1	2190-HS
5	8mm X 35mm Flange Bolt	1	M8X35H
6	8mm Large Washer	1	8MMWASHERL
7	Small Exhaust Spring	2	RACE-SPX-1
8	Aluminum Insert for Rubber Bushing	1	ALS-003
9	8mm x 20mm Flange Bolt	1	M8X20H
**	Rubber Grommet	1	Z1022
**	Adhesive Foil Heatshield	1	2255-00-01
**	Spring Puller Tool	1	ST-200
**	Yoshimura Vinyl Sticker	1	17029