



# YOSHIMURA

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

## **RACE SERIES**

**Qualified Manufacturer Declared "Modified Part"**

**2017 ~ 2019**

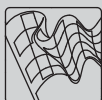
**Suzuki V-Strom 650**

**11621C0520 (SS/SS)**

**Works Finish**

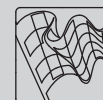
**R-77 Stainless Steel 3/4 System**

**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.

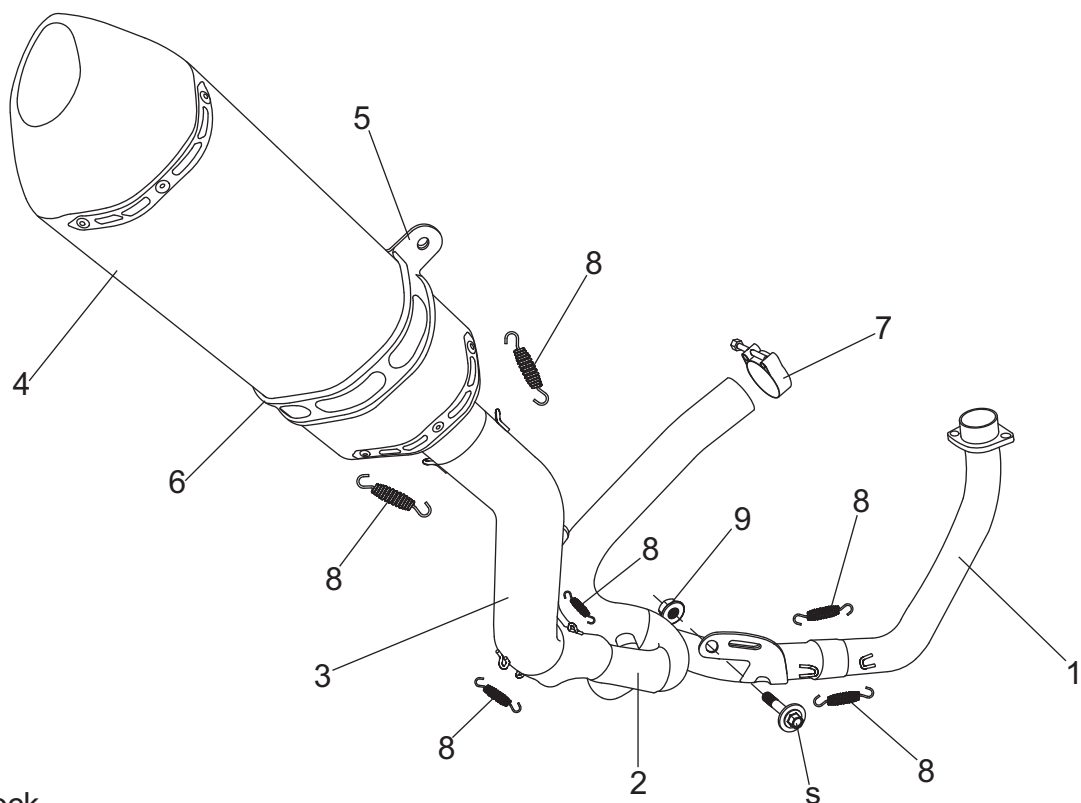


*You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new Yoshimura exhaust depending on the application. Read 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	11621-401D	Yoshimura Front Header	1
2	11621-415D	Yoshimura Midpipe	1
3	11621-419D	Yoshimura Tailpipe	1
4	11621C0520-RMA	Yoshimura Muffler	1
5	1121-MPCR	Muffler Clamp	1
6	HT SHLDR77	Muffler Clamp Heat Insulator	1
7	22055	Exhaust Clamp	1
8	RACE-SPS-1	Medium Exhaust Spring	6
9	8MMNUT	8mm Flange Nut	1
**	ST-200	Spring Puller Tool	1
**	INS-27-K	Low Volume Sound Insert	1
**	17100	Sticker Kit Sheet	1

\*\* Not shown on 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.

## Removal

1. Remove the right passenger foot peg bracket assembly to allow more clearance for muffler removal. For XT models, remove lower cowling.
2. Remove muffler heatshield.
3. Remove the O2 sensor from the stock muffler assembly.
4. Loosen front and rear header exhaust clamps.
5. Loosen front header flange bolts to allow for adjustment when removing the muffler assembly.
6. Remove forward muffler chassis mount bolt.
7. While securely supporting the stock muffler assembly, remove muffler mount bolt and carefully remove the stock muffler assembly off of front and rear header.

Note<sup>1</sup>: The muffler exhaust gasket will not be re-used with the Yoshimura system. Remove gasket off of rear header.

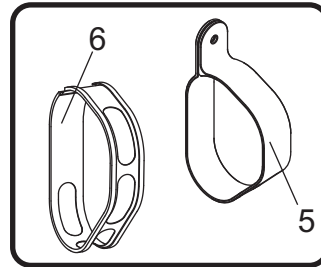
Note<sup>2</sup>: The short stock rear header will be re-used with the Yoshimura 3/4 system. Do not remove.

8. Remove front header flange bolts and remove stock front header.

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

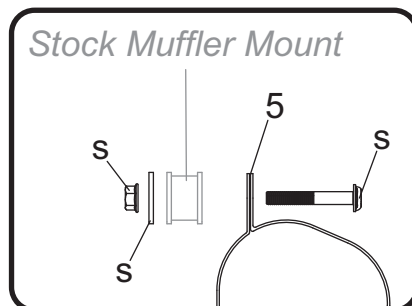
## Installation

1. Install (No. 7) 22055, exhaust clamp onto (No. 2) 11621-415D, midpipe inlet as shown on the assembly diagram.
2. Install (No. 1) 11621-401D, front header into (No. 2) 11621-415D, midpipe.
3. Carefully align and install (No. 1) 11621-401D, header into front exhaust port and (No. 2) 11621-415D, midpipe onto stock rear header simultaneously and align midpipe chassis mount bolt to the backside of chassis mount. Secure using the stock chassis mount bolt, washer, and supplied (No. 9) 8MMNUT, 8mm flange nut. Do not torque at this time.
4. Install (No. 3) 11621-419D, tailpipe inlet onto (No. 2) 11621-415D, midpipe outlet.
5. Install (No. 6) HT SHLDR77, muffler clamp heat insulator onto (No. 5) 1121-MPCRX, muffler clamp and trim the excess heat insulator.



6. Install (No. 4) 11621C0520-RMA, muffler assembly onto (No. 3) 11621-419D, tailpipe outlet.
7. Slide (No. 5) 1121-MPCRX, muffler clamp over (No. 4) 11621C0520-RMA, muffler and align to frontside of stock muffler mount. Secure using the stock muffler mount bolt, washer, and nut. Torque muffler mount bolt to factory specification.

Note: It may be necessary to rotate the tailpipe and/or the muffler independently until proper alignment is achieved.



8. Re-install the stock O2 sensor into (No. 3) *11621-419D*, tailpipe. Torque to factory specification.
9. Torque chassis mount bolt and front header bolts to factory specification.
10. Torque (No. 7) *22055*, exhaust clamp on rear header to 8.5 Nm (0.86 kg-m, 6 ft-lb).
11. Using *ST-200*, spring puller tool supplied in the kit, install (No. 8) *RACE-SPS-1*, medium exhaust springs between muffler to tailpipe, tailpipe to midpipe, and midpipe to front header.
12. Re-install right passenger foot peg bracket. Re-install lower cowl for XT models.
13. Before starting motorcycle, check for proper clearance between new exhaust system and rear suspension (i.e. tire, swing arm, 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.
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.

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

## Works Finish Care & Maintenance

Before starting vehicle, clean pipe thoroughly using a soft cloth and rubbing alcohol to remove any oil and finger prints.

The color of the exhaust will change once the system has gone through a heat cycle of 15 minutes or more. Color will vary depending on lean/rich conditions.

Clean using a soft cloth and soap. Do not use abrasive materials as it will scratch the surface.

Surface reconditioning services are available to remove scratches and undesirable discoloration due to extreme heat. Contact Yoshimura Tech Department at (800) 634-9166 / in CA (909) 628-4722 for more information.