



## HONDA '03- '04 CRF450R

Thank you for selecting and purchasing a TiForce exhaust system for your '03-'04 CRF450R. TiForce is the world's finest titanium exhaust system available today. Please read the following instructions and materials to fully familiarize you with new exhaust system before getting started. We recommend the installation be done by your nearest dealer or specialist.

### Before Installation

- Verify that all parts and accessories have been included (see list below).
  - Coat all exhaust pipe mating joints with anti-seize compound / lubricant.
  - Read and review these instructions, cautions, diagrams and images prior to starting any work.
1. Take off the seat and right number plate. And take off the standard exhaust.
  2. Attach the ring collar to the mouth piece and lightly attach the front exhaust pipe to the engine. (See pic. 2)
    - ★ Suggest to use new gasket in order to prevent leaking the exhaust.
    - ★ Use the standard flange nut and lightly tighten by hand.
  3. Insert the tailpipe to the lightly attached front exhaust pipe. Jiggle the whole and lightly tighten it with standard bolt. (standard bolt, M8 spring washer, M8 washer)
  4. Insert the silencer to the tailpipe and lightly attach it to the standard pipe position. (M8x50, M8 large washer, aluminum collar, silencer band, silencer band rubber)
  5. Attach the spring to the joint section of the silencer.
  6. Tightly fasten the exhaust pipe flange, tailpipe and then silencer band in order
  7. Attach the standard heat guard to the front exhaust pipe. (See Pic. 3)
  8. Make a cut (H30mm x W30mm) to the toughing place where the back side of the number plate and the silencer band bolt. (See Pic. 4)
  9. Attach the seat and the number plate removed in step 1.
  10. Remove any oil on the exhaust pipe and silencer.
  11. Make sure all bolts and nuts are tightly fastened. Run the engine and ensure there are no exhaust gas leaks.
    - Completion of the installation.



## General Cautions For Exhaust System Installations

**CAUTION** –For your safety, carefully read these instructions and those above, and fully familiarize yourself with the content before beginning installation and use. Keep these instructions in a safe place for future reference. Install the exhaust system as explained in these instructions.

**DANGER** –when the motor is running, and shortly after it has been turned off, the motorcycle, the exhaust system and end-can will be hot. Severe burns, bodily injury and even death may result.

**DANGER** –Keep gasoline and other flammable materials away from the exhaust system at all times. Exposure of gasoline and to heat can lead to fire.

**CAUTION** –Stop the motorcycle should the exhaust system come in contact with people or animals. Never touch the exhaust system when hot. Direct contact with the system can cause burns.

**DANGER** –Allow the motor to cool before installing or removing the exhaust system. Working with a hot motor can lead to burns.

**CAUTION** –Stand the motorcycle on a flat and level surface and ensure that the motorcycle is stable before installing the exhaust system. Bodily injury and /or death could result to you or others if the motorcycle falls over. Damage may also result to the motorcycle or nearby property or equipment.

**DANGER** –Start and run the motorcycle in a well-ventilated area. With prolonged exposure to exhaust gas you run the risk of severe oxygen deficiencies, bodily injury or death may result.

**CAUTION** –Install the muffler only on the specified model of motorcycle. Improper installation will lead to loss of performance and or damage to the motorcycle.

**CAUTION** –Do not disassemble, modify or remodel this exhaust system.

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(Enclosed parts)

F Head Pipe	1		Silencer band rubber (344mm)	1
Tail pipe	1		M8 x 50 cap bolt	1
Silencer	1		M8 washer(f 18)	1
Exhaust port ring collar	1		M8 large washer(f 22)	1
Aluminum collar (f 24X30)	1		M8 spring washer	1
Silencer band	1		Spring (short type)	1



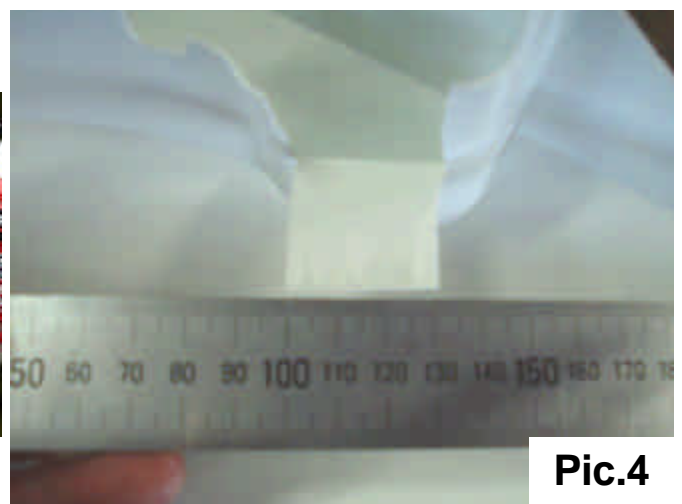
**Pic.1**



**Pic.2**



**Pic.3**



**Pic.4**