



'03 WR250F

Thank you for selecting and purchasing a TiForce exhaust system for your '03WR250F. TiForce is the world's finest titanium exhaust system available today. Please read the following instructions and materials to fully familiarize yourself with new exhaust system before getting started.

#### 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. Detach the seat and right-side rider's plate. And detach the standard pipe.
  2. Loosely attach the front exhaust pipe to the engine. (See Picture 2)
    - ★ We recommend you to use a new gasket, to prevent exhaust leaks.
    - ★ A standard flange-nut is required. Loosely tighten by hand.
  3. Insert the tail pipe to the front exhaust pipe attached in step 2. Shake the whole assembly gently until all fit properly. Attach the springs to the joints and loosely attach this pipe to the motorcycle using the supplied collar (18x4mm) and the standard bolt.
  4. Insert the silencer to the tail pipe and loosely attach the silencer band to the same position as the standard using the supplied bolt and aluminum collar (22x10mm). (Make sure to put the silencer band rubber to the silencer band.)
  5. Securely tighten in order of the exhaust flange, tail pipe and the silencer stay .
  6. Attach the spring to the joint of the silencer. (use the spring with rubber)
  7. Attach the supplied Heat Shield to the front pipe. (use truss screw x2)
  8. Attach the seat and the rider's plate detached in step 1.
  9. Make sure all bolts and nuts are securely tightened. Wipe off oil. Start the engine and make sure there is no exhaust leaks.

End



## 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.

---

TiForce Japan Co., Ltd.  
13-25, Minami Ejima  
Suzuka city, Mie  
510-0235, Japan

81-593-873992 tel  
81-593-873993 fax

<http://tiforce.co.jp>  
[sales@tiforce.co.jp](mailto:sales@tiforce.co.jp)



**Enclosed parts**

Front pipe	1	Tail pipe	1	Silencer	1
Collar (22x10mm)	1	silencer band rubber	1	Heat Shield	1
Collar (18x4mm)	1	M8 Washer	1	M8 Bolt 35mm	1
Silencer band	1	Spring	2	Truss screw	2
Spring with rubber	1				



Pic.1



Pic.2



Pic.3