

# ENDO'S<sup>TM</sup>

## SPARK ARRESTORS

Thank you for purchasing the Pro Moto Billet Spark Arrestor end cap. We're sure you will be pleased with your purchase!

### Questions? Call:

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### Instructions: 04-05 HONDA CRF250R (PMB-01-1100)

**Parts List:** (1) end cap base, (1) nozzle, (3) M6 bolts, (8) self-tapping screws, (1) screen

**NOTE:** If you do not have the following tools, have your dealer install the end cap for you.

Tools that you will need during the installation:

Drill	Hammer	13/64" drill bit	Silicone sealant
	Flat screwdriver	Center punch	Hacksaw

**You will not be able to re-use the stock end cap after installing this product!** Read the instructions carefully before starting this installation. If you are not comfortable performing the work involved, have your dealer install the end cap for you.

1. Remove exhaust pipe from the bike and clamp the mounting tab securely in a vise. Place something between the vise jaws and the mount to prevent any marring of the aluminum mount.
2. Use a flat head screwdriver and a hammer to break the epoxy seal around the aluminum end cap and the steel inner core of the exhaust pipe. **FIGURE 1**



FIGURE 1

3. Using a 13/64" drill bit, drill out the rivets holding the stock end cap in place; make sure to remove the head of the rivet.
4. Use a center punch or similar device and a hammer; push the remainder of the rivets through the hole and out of the stock end cap. Using a flat head screwdriver and hammer, push the end cap out of the exhaust canister. **FIGURE 2**

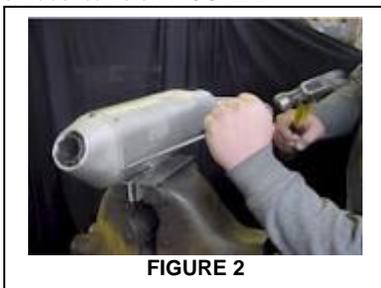


FIGURE 2

Move to several different locations around the end cap in order to push it out evenly. The perforated inner core is welded to the end cap, so they will come out together. If you are having problems removing the stock cap, using a heat gun

on the canister sleeve may make this easier.

5. Carefully remove the end cap and perforated inner core from the packing material.
6. Remove all pieces of the old rivets from the packing material inside of the muffler canister then carefully remove the packing material. You will re-use the material, so keep it in its bag. If the bag tears during removal, carefully tape it together with masking tape prior to re-installation.
7. Separate the aluminum portion of the end cap from the steel inner core. **FIGURE 3**



FIGURE 3

8. Using a hacksaw, cut the perforated inner core from the steel portion of the end cap. **Make this cut directly in front of the steel portion of the end cap.** **FIGURE 4**



The perforated inner core will now be separated from the steel end cap. **FIGURE 5**



FIGURE 5

9. Test fit the end cap to make sure the inner baffle is cut to the correct length.
10. Use a file to remove any sharp edges from the cut off portion of the perforated inner core.
11. Smooth out the bag of fiberglass packing material and wrap it tightly around the perforated inner core.
12. Install the perforated core and fiberglass packing into the muffler canister. Make sure that the end of the perforated core with the L-shaped stopper is installed first. This will keep the perforated core in place after the installation is completed.
13. Apply some high temperature silicone sealant to the outer stepped portion of the end cap, and a generous amount to the surface where the perforated inner core will be retained. **FIGURE 6**



FIGURE 6

**You must use high temperature silicone to prevent vibrations!**

14. Install the new end cap receiver; make sure that the receiver is pushed up tight to the muffler.
15. Install one rivet at a time by drilling a 13/64" hole at each rivet location. Each time you drill a new hole and install a self-tapping screw, make sure that the end cap is pushed up tight to the muffler.
16. Clean up excess silicone sealant.
17. Insert the spark arrestor screen and install the turndown nozzle with the M6 bolts provided.

### CAUTION:

**You must check the condition of the spark arrestor often!**  
**Your spark arrestor will not function properly if there are holes in the screen!**