

ENDO'STM

SPARK ARRESTORS

Thank you for purchasing the Pro Moto Billet Spark Arrestor end cap. We're sure you will be pleased with your purchase. Follow these instructions for a quick and easy installation:

Spark Arrestor Instructions (PMB-01-1113) 2011 CRF 450R, 2011-13 CRF 250R

Parts List: (1) end cap base, (1) inner core spacer, (1) nozzle, (3) M6 bolts, (8) self-tapping bolts, (1) screen

Tools that you will need during the installation:

Drill, 13/64" & 3/16" drill bit	Hammer
Center punch	High Temp. RTV silicone
Hacksaw	Heat Gun

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

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. Place protective material on the exhaust pipe mount and place securely in a vise.
2. Use a 3/16" drill bit to drill out the rivets that hold the stock end cap in place; make sure to remove the head of the rivet. **FIGURE 1**

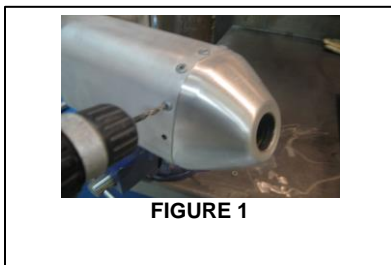


FIGURE 1

3. Use a center punch and a hammer to push the remainder of each rivet through the hole and out of the stock end cap.
4. Once again, you will not be able to re-use the stock end cap, so drilling or bending it will not affect the finished installation. However, be careful not to bend the muffler canister as this may interfere with the finished installation. Using a heat gun, heat the muffler canister where it is joined to the stock end cap. This will loosen the factory sealant.
5. Remove the stock end cap by gripping it with a pair of pliers/channel locks and tapping with a rubber mallet. Be sure to apply even pressure and do not damage the muffler canister. If stock end cap is difficult to remove, another option is drill a hole through both sides of the aluminum endcap, slide a long screwdriver through the holes and use it as a handle for better pulling leverage. **FIGURE 2**

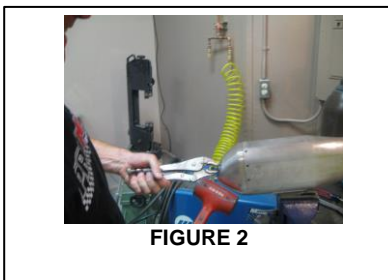


FIGURE 2

6. Stock end cap will likely be destroyed during removal. **FIGURE 3**



FIGURE 3

7. **If installing on a 2011 CRF 450 R, (if not, go to step #9):** Discard the inner core spacer tube included in this kit. Use a hacksaw or band saw to cut the inner core flush to the outside support base of the inner core. **FIGURE 4**



FIGURE 4

8. **2011 CRF 450 R ONLY! (If not, skip to step #9):** Remove and discard the outside support base and end section of inner core. **FIGURE 5**, then skip to step#13



FIGURE 5

9. **If installing on a 2011 CRF 250 R, (if not, go to step #10):** Remove the inner core and use a hacksaw or band saw to cut the inner core flush with the inside edge of the support. **FIGURE 6**, then skip to step#11

10. **If installing on a 12-13 CRF 250 R:** Remove the inner core and use a hacksaw or band saw to cut off the inner core 3/8" back (towards motor) from inside edge of the support. **FIGURE 6**

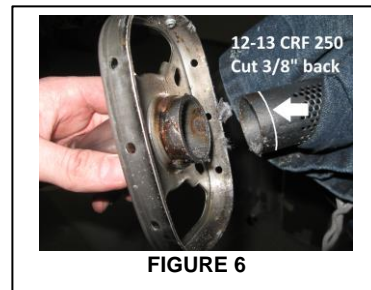


FIGURE 6

11. Discard the end of the inner core containing the support.
12. Clean any contaminants off of the inner core and apply high temperature RTV silicone to the outside end of the inner core. Identify the end of the inner core spacer with the deeper recess, this end must be installed onto the inner core or the assembly will not fit together properly. Slide the end of the inner core spacer onto the inner core and clean up excess RTV silicone. **FIGURE 7**

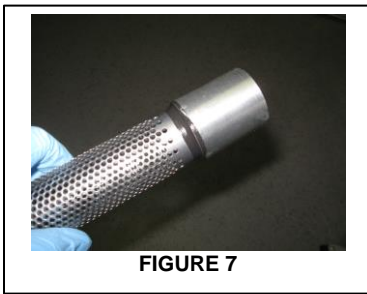


FIGURE 7

13. You must use high temperature RTV silicone to prevent vibration and damage to the canister. Coat the outside lip of the end cap base that installs into the muffler canister and the outside lip where the inner core support will rest. **FIGURE 8**



FIGURE 8

14. Install end cap base onto the inner core support with inner core attached. Install the assembly into the muffler canister and ensure inner core is in the proper location. **FIGURE 9**

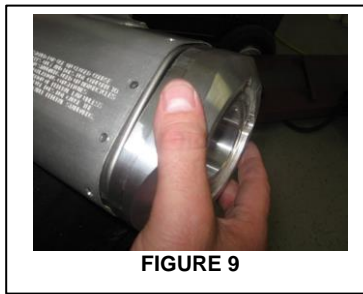


FIGURE 9

15. Lightly tap everything together with a rubber mallet and use a piece of cardboard or similar material to protect the finish on the end cap. **FIGURE 10**

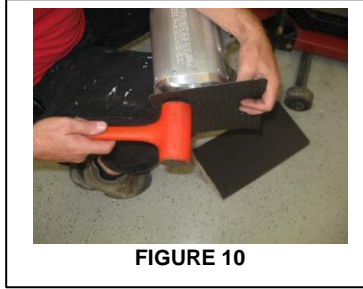


FIGURE 10

16. Wipe the excess silicone off the seams of the end cap. **FIGURE 11**

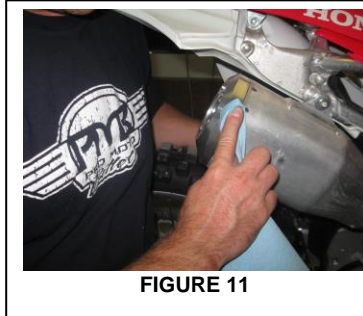


FIGURE 11

17. Install one self-tapping bolt at a time by drilling a 13/64" hole at each rivet hole location. Each time you drill a new hole and install a bolt, make sure that the end cap is pushed in, tight to the muffler. **FIGURE 12**

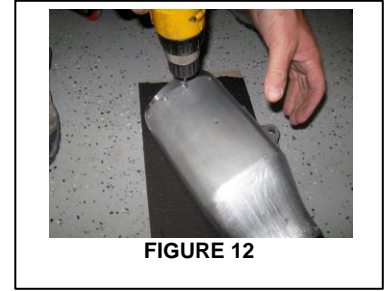


FIGURE 12

18. Clean up excess silicone.
 19. Insert the spark arrestor screen and install the turnout nozzle with three M6 bolts. **FIGURE 13**
 20. You must clean and inspect the spark arrestor screen often. We recommend checking it every time you clean your air filter or change your oil.

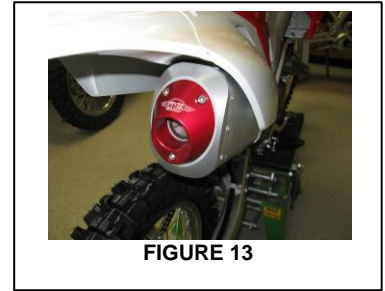


FIGURE 13

