



# Installation Instructions

04-08 HONDA CRF250R/X, 05-08 CRF450R/X

**BE SURE TO REGISTER YOUR DMC EXHAUST ONLINE AT WWW.DMC-ON-LINE.COM**

Thank you for choosing to install the finest exhaust system available. DMC uses only the latest technology to deliver big gains in acceleration, horsepower and torque, while capturing additional strength and critical weight savings.

Please read all instructions carefully and thoroughly before installing this system. Any references to "left" or "right" indicates sides as if you were sitting on the bike facing forward.

## PARTS INCLUDED

- (1) Muffler
- (1) Head Pipe\*
- (1) Mid Pipe
- (1) Hardware Kit
- (1) Fender Sticker Kit

## TOOLS REQUIRED

- Pipe Spring Puller
- 8, 10, 12mm box wrenches

**NOTE:** To prevent exhaust leaks, we recommend inspection and replacement of the exhaust gasket if necessary upon installation.

\*Head Pipe included with full system Afterburner models only

## REMOVAL PROCEDURE

1. Be sure that engine and exhaust are cool to the touch before beginning.
2. If you are installing a DMC SLIP-ON, loosen and remove the muffler mounting bolts and muffler clamp at the midpipe junction. If you are installing a FULL SYSTEM, loosen and remove all the mounting bolts that secure your stock system. Keep them as they may be used in installation of your new pipe.
3. Remove your stock exhaust components.

## INSTALLATION PROCEDURE

4. Inspect exhaust port for cleanliness and exhaust gasket for wear.
5. If you are installing a FULL SYSTEM, go to step 6. For SLIP-ON installation, jump to step 8.
6. Properly seat the new headpipe in position and secure loosely to the cylinder head.
7. Insert midpipe into headpipe and secure loosely to any (sub) frame mounting points.
8. Insert silencer into midpipe and install two (2) 63mm DMC springs (provided).
9. Secure muffler to subframe loosely using provided hardware.
10. Prior to tightening any bolts or nuts, ensure entire exhaust system is free of any binding or stress.
11. If you are installing a FULL SYSTEM, tighten the exhaust flange nuts to the cylinder head studs using the stock hardware.

**DO NOT OVERTORQUE! FOLLOW OEM TORQUE SPECIFICATIONS UNLESS NOTED OTHERWISE**

12. Tighten the silencer and midpipe mounting bolts to (sub) frame.
13. Install the heatshield (if supplied), using the hardware supplied.
14. Look over installation to insure pipe does not come in contact with any cables, hoses or frame.

## JETTING

DMC highly recommends you check your carburetor jetting. Failure to do so could result in engine and/or system damage. DMC jetting specs are based on a stock motor, at sea level, temperature of 65°F using 91 octane pump gas. Appropriate jetting specs for your specific riding area may be available by contacting your local dealer or mechanic. See the chart below for any jetting requirements, if applicable for you bike.

	CRF250	CRF450		
Pilot Jet	45	Stock		1st
Main Jet	172-175	Stock		2nd
Needle	Stock	Stock		3rd
Fuel Screw	1-3/4 ~ 2-1/4	Stock		4th
Air Screw	Stock	Stock		5th
Clip Position	4th	Stock		<b>LEAN</b> Move the clip up <b>RICH</b> Move the clip down <b>NEEDLE/CLIP POSITION</b>

## ADJUSTMENTS FOR ALTITUDE & TEMPERATURE

All jetting recommendations are based on standard jetting with an unmodified engine. It may be helpful to know that these conditions can affect the fuel mixture.

CONDITION	MIXTURE WILL BE	ADJUST TO
Cold Temperature	lean	richer
Warm Temperature	rich	leaner
Dry Air	lean	richer
High Humidity	rich	leaner
High Altitude	rich	leaner

## START UP PROCEDURE

1. After completing installation and making any jetting changes (if required), start your engine in a well-ventilated area and check for any exhaust leaks.
2. We recommend riding for 30 minutes to allow components to properly seat.
3. Allow engine to cool down and recheck all fasteners.

## SPARK ARRESTOR / QUIET CORE

Spark arrestors are included with every Afterburner Exhaust while Quiet Cores are included with Quiet Systems only. To access your Spark Arrestor and (or) Quiet Core Insert, simply remove the screws from the endcap.

www.spectro-oils.com

**DMC recommends using Spectro Oils for maximum protection.**

DMC Exhaust  
 930 Columbia Ave.  
 Riverside, CA 92507  
**WWW.DMC-ON-LINE.COM**

## MAINTENANCE

**Please allow exhaust system to cool prior to washing or repair.** DMC recommends using a mild soap such as dish detergent and water to wash your exhaust system. Also, you should not allow water to enter the silencer outlet while washing your bike or ATV.

As we all know, sound is a major issue, which can effect whether or not we continue to enjoy our sport without offending others. Also, your system performs best and will last longer when the silencer is properly maintained. Repacking your silencer depends on the type of riding and the amount of hours on the bike.

On a big-bore-four, frequent high speed riding will shorten the life of the packing. Your ears are the best guide to knowing when to repack, but as a rule, every 20-30 hours is a good guideline to inspect and replace if necessary. If and when it is time to repack, please use DMC Afterburner Repack Kits as they were tested and designed to provide the best performance.

To keep your spark arrestor clean, you can clear it out by using a soft bristled brush and soapy water.

## DMC EXHAUST ACCESSORIES

- USFS Approved Spark Arrestor / #25911-10
- USFS Approved S.O.S. Quiet Core Insert / #25911-20
- DMC Afterburner Repack Kit (Comp Mufflers) / #25911-40
- DMC Afterburner Repack Kit (Quiet Mufflers) / #25911-45
- Afterburner Replacement Springs (pair) / #25911-50

## AFTERMARKET PERFORMANCE ACCESSORIES

### 05-08 CRF250R

- K&N Air Filter #HA-4503
- No Toil Foam Filter #NT120-46
- DynoJet Jet Kit: CRF250R 2004 #81-1113
- DynoJet Jet Kit: CRF250R 2005 #81-1123
- DynoJet Jet Kit: CRF250R 2006 #81-1147

### 05-08 CRF250X

- K&N Air Filter: Call
- No Toil Foam Filter #NT220-09
- DynoJet Jet Kit: CRF250X 05-06 #81-1171

### 05-08 CRF450R

- K&N Air Filter #HA-4503
- No Toil Foam Filter #NT120-46
- DynoJet Jet Kit: CRF450R 2005 #81-1129
- DynoJet Jet Kit: CRF250R 2006 #81-1141

### 05-08 CRF450X

- K&N Air Filter #Call
- No Toil Foam Filter #NT220-09
- DynoJet Jet Kit: CRF450R 2005 #81-1172



DMC Exhaust  
930 Columbia Ave.  
Riverside, CA 92507  
[WWW.DMC-ON-LINE.COM](http://WWW.DMC-ON-LINE.COM)

## TECHNICAL SUPPORT

If you ever lose your instructions or need additional information, simply visit the DMC website where we offer all the installation information that came with your DMC exhaust. If, at any time, there is further news regarding modifications, jetting adjustments, or other, the DMC website is a great source for obtaining the latest news.

## WARRANTY

Since we designed, developed and manufactured your DMC Exhaust to provide reliable performance, we guarantee your system for one year against defects in materials and workmanship. We are proud of our attention to the quality of manufacturing your DMC product and we stand behind our products.

In the unlikely event a problem arises with your system, please contact the dealer from whom it was purchased. They can contact DMC and get your system to us for a warranty determination. We will make every attempt for a prompt repair or replacement at our determination and expense.

It is important to note that our warranty is not unconditional. Although your DMC product was made with the finest materials and hand crafted to strict stands, it is not indestructible. Therefore, our warranty does not cover product damage as a result from abuse, misuse, improper installation, modifications or lack of maintenance. We also do not cover any damages whether consequential, incidental, special, contingent or otherwise: or expenses or injury arising directly or indirectly from the use the use of the exhaust system.

As with any product, your DMC system should be expected to experience normal wear, which is not covered by any warranty. The duration of any and all implied warranties are limited to the duration of the express warranty.

