

Instructions – PMB-01-1113

Thank you for your purchase! We are confident that you will be pleased with the quality of our product.

Parts List:

1-Spark Arrestor Base
1-Inner Core Spacer
1-Nozzle
1-Screen
3-M6 Bolts
8-Self-tapping Screws

Tools List:

Drill	13/64" Drill Bit
Hammer	3/16" Drill Bit
Hacksaw	High-Temp Silicone Sealant
Heat Gun	
Center Punch	

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

Figure 1



Figure 2

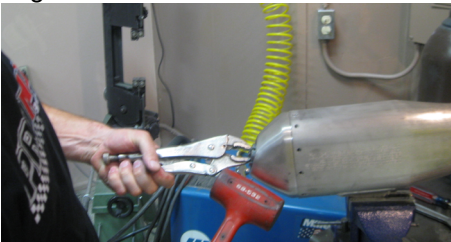


Figure 3



To install your new spark arrestor:

1. Remove side panels and mufflers per manufacturer instructions.
 2. Using a 3/16" drill bit, drill out the existing rivets holding the stock end cap in place. You do not need to drill all the way through the muffler canister, but you must make sure to drill deep enough to remove the head of the rivet. **Figure 1.**
 3. Using a center punch, or similar device, and a hammer, 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 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.**
- WARNING:** Remove all pieces of the old rivets from the packing material inside of the muffler canister.
6. **If installing on a 2011 CRF 450 R (if not, go to step #9):** Discard the inner ore 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 3.**
 7. **If installing on a 2011 CRF 450 R (if not, go to step #9):** Remove and discard the outside support base and end section of inner core. Skip to step #13.

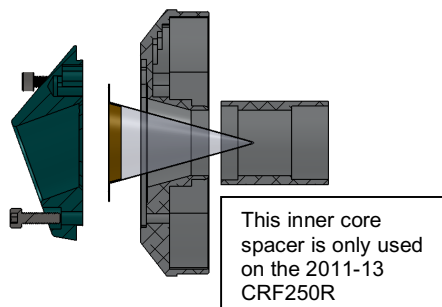


Figure 4

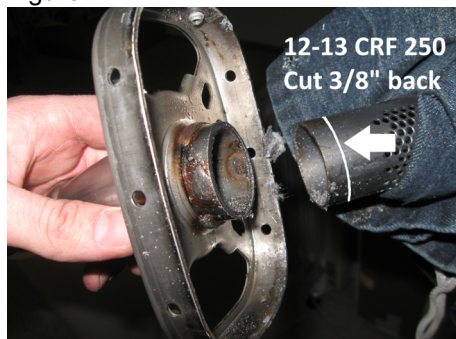


Figure 5

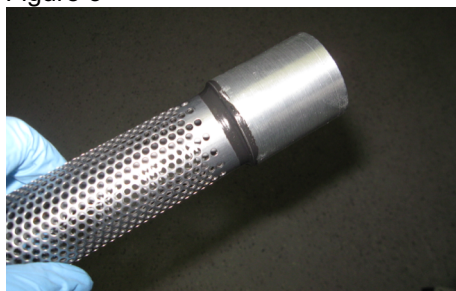


Figure 6



Figure 7



8. **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 ore flush with the inside edge of the support. **Figure 4**, then skip to step #11.
9. **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 4**.
10. Discard the end of the inner core containing the support.
11. 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 silicone. **Figure 5**.
12. You must use high temperature RTV silicone to prevent vibration and damage to the canister. Coat the outside lip of the spark arrestor base that installs into the muffler canister and the outside lip where the inner core support will rest.
13. Install spark arrestor 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.
14. Lightly tap everything together with a rubber mallet and use a piece of cardboard or similar material to protect the finish on the new spark arrestor base. **Figure 6**.
15. Wipe excess silicone off the seams of the new end cap.
16. Install one self-tapping screw at a time by drilling a 13/64" hole at each hole in the muffler. Each time you drill a hole and install a self-tapping screw, make sure the base is pushed up tight to the muffler. *Note: We recommend using lubricant for the self-tapping screws, such as WD-40®.* **Figure 7**.
17. Clean up excess silicone.
18. Insert the spark arrestor screen and install the turndown nozzle with three M6 bolts.

NOTE: Your new Fastway by Pro Moto Billet spark arrestor is coated with colored anodized finish. Anodizing will fade by prolonged exposure to sunlight. To insure your spark arrestor remains looking it's best, do not store in direct sunlight and remove any mud or debris as soon after riding as possible.



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!