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**2016-17 KTM 250/350/450  
SX-F/XC-F & 2017 KTM  
350/450/500 EXC-F**  
S1R Slip-On Part # 005-4790409-S1

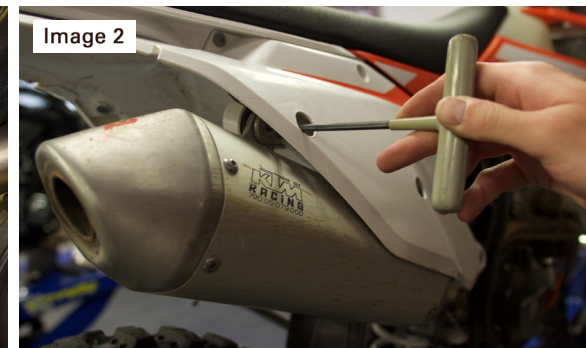


**BILL OF MATERIALS**

1	Off Road S1R Stainless Muffler	
1	Slip Tube	005-47904S
2	Springs 45mm	005-S45
1	Bolt 6x35mm	005-SH635
1	Washer 6mm	005-WF6-18
1	Barrel Clamp 63mm	005-27-63MSH
1	Spark Arrestor (Pre Installed)	005-106S
1	P1 Power Tip (Pre Installed)	005-P1

**INSTALLATION INSTRUCTIONS**

1. Make sure the bike is completely cool before starting the installation.
2. Remove muffler spring. **(Reference image 1)**
3. Loosen and remove muffler bolts. **(Reference image 2)**



4. Install TBR Slip Tube into S1R Muffler and attach springs
5. Slide the muffler and slip tube assembly onto existing header using the barrel clamp to tighten the slip tube down to the header. **(Reference image 3)**
6. Use the supplied hardware and 15mm spacer to secure the muffler to the rear OEM muffler mounting point on the subframe. **(Reference images 4 & 5)**



7. Begin to tighten all bolts and hardware on the exhaust, start from the header and work your way back to the muffler. Be sure the exhaust has clearance and fits properly.
8. Before you run the bike, clean off all fingerprints and dirt, as any oily residue will etch the metal and become somewhat permanent when the system gets hot. Run the bike and enjoy. It is normal for some white smoke to appear the first time you start the bike. This is packing/manufacturing oil from inside the pipe burning off. Check for gaps or leaks. If you find a leak, a little high temperature silicon sealant should fix it. After 50 to 100 miles, recheck all fasteners for tightness.

**IMPORTANT - PLEASE READ CAREFULLY:** We recommend that this performance part be installed by a qualified motorcycle technician. If you have any doubts as to your ability to install this performance part, please consult with your local motorcycle dealer. Read all instructions first before starting installation. Make sure the motorcycle and exhaust system are completely cool before starting the installation. Also, make sure the bike is secure on a center stand or ideally a service lift during installation. Be sure to save all stock components for possible use later.

**WARRANTY:** Two Brothers Racing products are intended for closed course competition purposes only, and therefore are sold "as is" without warranty. Two Brothers Racing specifically disclaims any warranties of merchantability or fitness for a particular purpose and disclaims all responsibility for consequential and incidental damages or any other losses arising from the use of these products or parts.

### Care & Cleaning

Keep system free of dirt and moisture. Store in a cool, dry place. Make sure vehicle is completely cool before maintenance.

**Stainless Header System:** Polished stainless steel pipes will turn a light golden hue after a few heat cycles, this is a normal characteristic of high quality stainless steel. Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

**Titanium Header System:** Polished titanium pipes will experience color shift ranging from deep blue/purple through amber after a few heat cycles. This is a normal characteristic of high quality titanium. Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

**Polished Aluminum Canisters:** Use an aluminum or mag wheel polish to restore the bright finish to factory spec.

**Brushed Aluminum Canisters:** Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

**Carbon Fiber Canisters:** Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth. Always make sure the fiberglass packing inside is in good condition and not burned out, as exhaust heat inside an empty canister will deteriorate the carbon fiber sleeve. TBR sells repack kits (Road - #005-10038, Offroad - #005-10038MX) that include everything you need to easily do it yourself.

**Titanium Mufflers:** For cleaning use a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth. Always make sure the fiberglass packing inside is in good condition and not burned out, as exhaust heat inside an empty canister will deteriorate the carbon fiber sleeve.

TBR sells repack kits (Road - #005-10038, Offroad - #005-10038MX) that include everything you need to easily do it yourself.

Repack all road canisters at the first signs of packing material deterioration. Part #005-10038

Repack all offroad canisters after every 10 hours of use. Part #005-10038MX

NEVER dyno test your bike with carbon fiber or titanium canisters installed - the intense heat and lack of cooling air can quickly burn through the canister material. Two Brothers Racing does not provide a warranty for burned canisters.



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