



## 2000 / 2001 / 2002 -- Suzuki GSXR-600 / 750 / 1000

Thank you for selecting and purchasing a TiForce exhaust system for your Suzuki GSXR 600 / 750 / 1000. TiForce is the world's finest titanium exhaust system available today. Please read the following instructions and materials to fully familiarize yourself with your new exhaust system before getting started. Instructions are also available in Adobe Acrobat PDF format on the TiForce website ([www.TiForce.com](http://www.TiForce.com)).

### Before installation:

- Verify that all parts and accessories have been included (see list below).
- Coat all exhaust pipe mating joints with anti-seize compound / lubricant (Finish Line Ti-Prep packet included).
- Read and review these instructions, cautions, diagrams and images prior to starting any work.

- 
1. **GSXR-1000 – 2001 model only** – Unbolt and raise tank up onto prop rod. Disconnect and remove the SET valve servomotor. Failure to disconnect the SET valve servomotor may result in serious damage to the servomotor. See photos 1 to 3. **2002 GSXR-1000** models - please leave the SET valve servomotor connected to the harness on **2002** models to avoid a FI warning light. You may choose to disconnect the actuator cables from the servomotor. Please secure them where they will not interfere with the safe operation of the motorcycle. Lower the tank and secure with the original bolts.
  2. **GSXR-1000 - 2001 / 2002 only** - Disconnect the SET valve control wire from the harness (see photo 4 – brown and black wire on larger connector). Lower and secure fuel tank.
  3. Remove the fairing lowers, remove the radiator mounting bolts and lower support (leave hoses connected), rear turn signals, the SET valve control cables (**GSXR-1000 only**), and remove the existing exhaust system. Save the head pipe flange nuts for reuse.
  4. Inspect exhaust gaskets. Replace if necessary.
  5. Assemble the head pipes 1 (blue), 2 (red), 3 (yellow), and 4 (green) by matching the joints of the same color to the pair of front Y-pipes. Do not install the exhaust springs at this time.
  6. Attach the assembled head pipe sections to the exhaust ports, but do not tighten the flange nuts fully. Reuse the flange nuts saved from above. Make sure the ends of the headpipes fit snug in the ports before tightening.
  7. Install the S-Bend to the front section of the headpipes and two Y-pipes. Do not install the exhaust springs yet.
  8. Go back and retighten the head pipe flange nuts per factory specifications. Verify that the headpipes fit flush.
  9. Remove the right passenger footpeg assembly from the sub frame. Set bolts aside, save the 2 nuts for reuse.
  10. If you plan to keep the passenger footpegs, follow this step, otherwise, skip to step 11. Reassemble the right passenger footpeg assembly in this order (from the subframe outwards): Spacer A, Stay Arm F, Spacer B, passenger footpeg assembly (from step 7 above). Use the supplied 8x110mm bolts D (2x) to fasten to the subframe (reuse nuts). See figure 1.
  11. If you plan to remove the passenger footpeg assemblies, follow this step and ignore step 9 above. Use: Spacer A and place the Stay Arm F against it. Use the supplied 8x50mm bolts E (2x) to fasten to the subframe (reuse nuts). See figure 1, but use only the hardware specified in this step.
  12. Install the TiForce end can to the S-bend tail pipe.
  13. Attach the supplied springs to all the joints, starting from the headpipes and working back to the end can. Make sure the exhaust system is free and clear of the bike. If necessary, adjust for proper clearance. Use a spring puller if available to prevent damage to the springs that could lead to future failure.
  14. Carefully align the two stainless bands so that they are parallel to each other, and spaced properly on the can. Tighten the 6mm hardware (H). Make sure that the rubber pads fully cover the bands (K). **USE CAUTION WHEN TIGHTENING THE 6MM HARDWARE AND THE TWO BANDS SO AS NOT TO CRUSH OR DISTORT THE SLEEVE OF THE CAN.**
  15. Using some brake and contact cleaner on a clean rag, carefully wipe down the entire exhaust system to remove any residual oils, anti seize, fingerprints and dirt prior to starting the motor. **FAILURE TO CLEAN THE TUBING AND CAN MAY RESULT IN PERMANENT STAINING OF THE SYSTEM WHEN HEATED.**
  16. Attach the short hanger / stay arm G to the long hanger / stay arm F. Place the collar / spacer C between the two hangers and insert the M8x75mm bolt through. Place the M8 washer and nut to the inside of the long hanger / stay F. Hand-tighten for now. See figure 2.
  17. Install the two supplied blinkers using the splice connectors provided.
  18. Install the radiator and lower radiator support bracket per factory specification. Verify fluid levels as needed.
  19. Check that all fasteners are tightened per specifications, then start the motor and check for exhaust leaks.



20. Reinstall the fairing lowers. On the GSXR-600/750 models, use the small spacers provided to space the right side fairing lowers out away from the exhaust to prevent melting the fairing.

---

**General Cautions For Exhaust System Installations:**

- **CAUTION** - For your safety, carefully read these instructions and those above, and fully familiarize yourself with the content before beginning installation and use. Keep these instructions in a safe place for future reference. Install the exhaust system as explained in these instructions.
- **DANGER** – when the motor is running, and shortly after it has been turned off, the motorcycle, the exhaust system and end-can will be hot. Severe burns, bodily injury and even death may result.
- **DANGER** - Keep gasoline and other flammable materials away from the exhaust system at all times. Exposure of gasoline and to heat can lead to fire.
- **CAUTION** - Stop the motorcycle should the exhaust system come in contact with people or animals. Never touch the exhaust system when hot. Direct contact with the system can cause burns.
- **DANGER** - Allow the motor to cool before installing or removing the exhaust system. Working with a hot motor can lead to burns.
- **CAUTION** - Stand the motorcycle on a flat and level surface and ensure that the motorcycle is stable before installing the exhaust system. Bodily injury and / or death could result to you or others if the motorcycle falls over. Damage may also result to the motorcycle or nearby property or equipment.
- **DANGER** - Start and run the motorcycle in a well-ventilated area. With prolonged exposure to exhaust gas you run the risk of severe oxygen deficiencies, bodily injury or death may result.
- **CAUTION** – Install the muffler only on the specified model of motorcycle. Improper installation will lead to loss of performance and or damage to the motorcycle.
- **CAUTION** – Do not disassemble, modify or remodel this exhaust system.

---

TiForce high performance exhaust systems are distributed exclusively by Orient Express Powersports. Please have your dealer contact Orient Express for technical assistance, information, and parts if needed.

TiForce / Orient Express  
81 Hanse Ave  
Freeport, NY 11520

800.645.6521  
516.546.5232 tel  
516.546.5247 fax.

[www.TiForce.com](http://www.TiForce.com)  
[www.OrientExpress.com](http://www.OrientExpress.com)  
[Sales@TiForce.com](mailto:Sales@TiForce.com)

**PARTS LIST (Suzuki GSXR-600 / 750 / 1000)**

- Exhaust head pipes - #'s 1,2,3,4 – 1 each / 4 total
- Exhaust Y-pipes – 2
- Exhaust S-bend pipe – 1
- End can – 1
- Collar / Spacer A 24 x 23mm – 2
- Collar / Spacer B 24 x 44mm – 2
- Collar / Spacer C 24 x 49mm – 1
- M8 x 110mm allen bolt D – 2
- M8 x 50mm allen bolt E – 2
- Long End can stay arm / hanger F – 1
- Short stay arm / hanger G – 1
- M6 x 20mm allen bolt H – 2
- M8 x 75mm allen bolt I – 1
- Exhaust springs J – 7
- Stainless steel bands and rubber pads K – 2 each
- Replacement Turnsignals & connectors L - 2
- M6 nut – 2
- M6 washer – 4
- M8 washer – 2
- M8 nut – 1
- Finish Line TiPrep Anti-Seize – 1 packet
- Aluminum spacer / washer (600/750 only) – 2

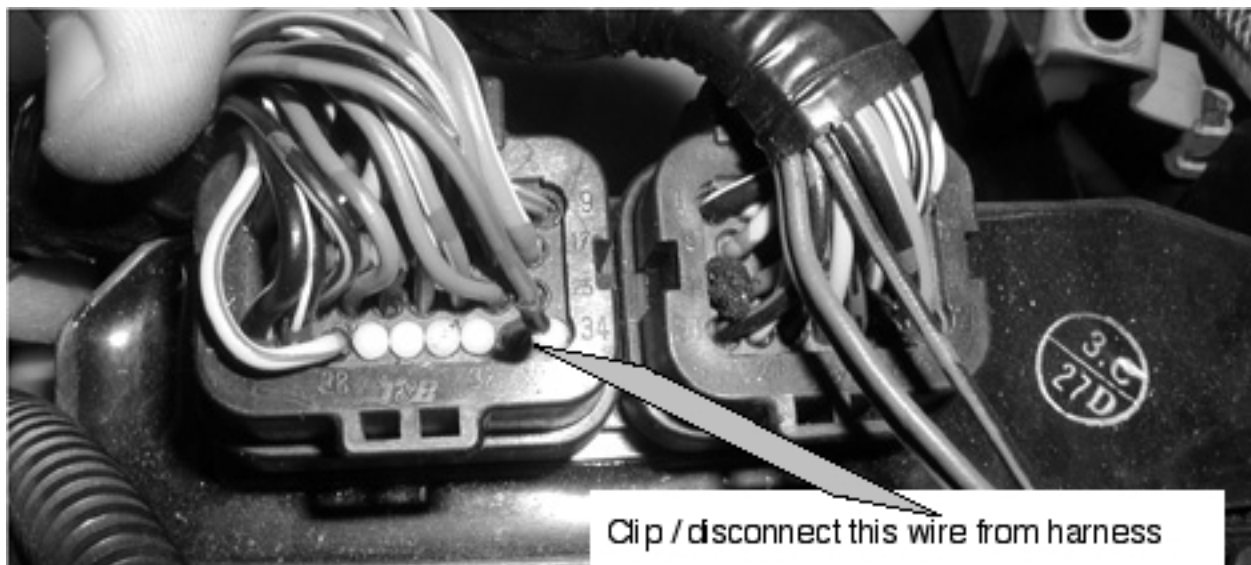
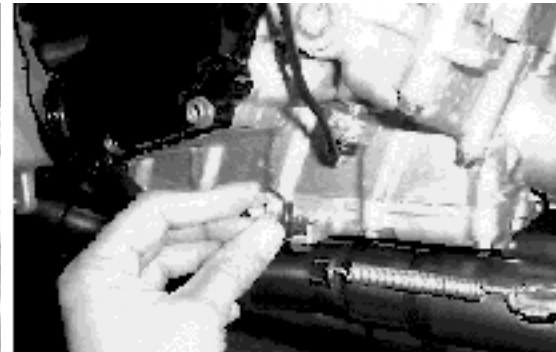
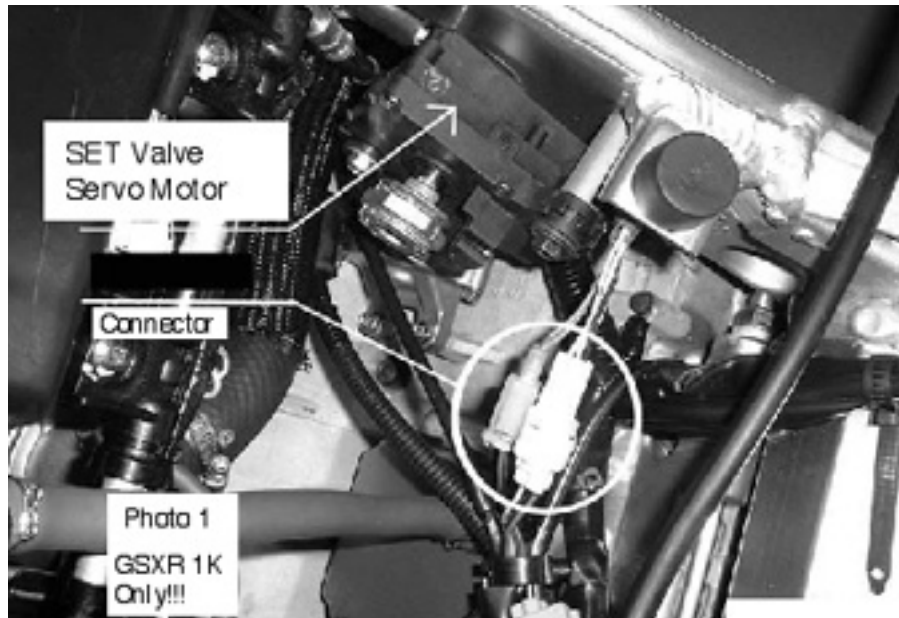


Figure 1 - GSXR 600 / 750 / 1000 Exhaust hanger procedure

