



Part:	Velocity stack assembly
P/N:	SPSS-320
Model:	Yamaha R3 (2015 - present)
Doc:	Assembly and installation instructions, v0.1

WARNING: For racing vehicle use only! Our products are intended to be used only on racing vehicles on closed courses and are not for use on public roads. It is the user's responsibility to ensure that all Spears Enterprises LLC. installation and assembly instructions are followed explicitly. Spears Enterprises LLC. recommends that installation be performed by a trained, professional technician. The User recognizes that any alteration or modification to any motorcycle and/or improper installation may increase the risk of serious injury, accident or death and may also render the motorcycle illegal for public road use.

Tools required:

- Phillips screwdriver
- Dremel, jigsaw, or similar
- Band saw or hand saw

Materials required:

- Silicone Rubber sealant, 1oz tube included



Upgrade products if desired:

- Air filter upgrade:
MWR race filter recommended
(Part number SP02-320 at www.spearsenterprises.com)

Parts included:

- 2x Snap Stacks™ velocity stacks
- 2x Intake manifold designs:



Design 1

Design 2

R3 Airbox Assembly



Side cover screws (8x)

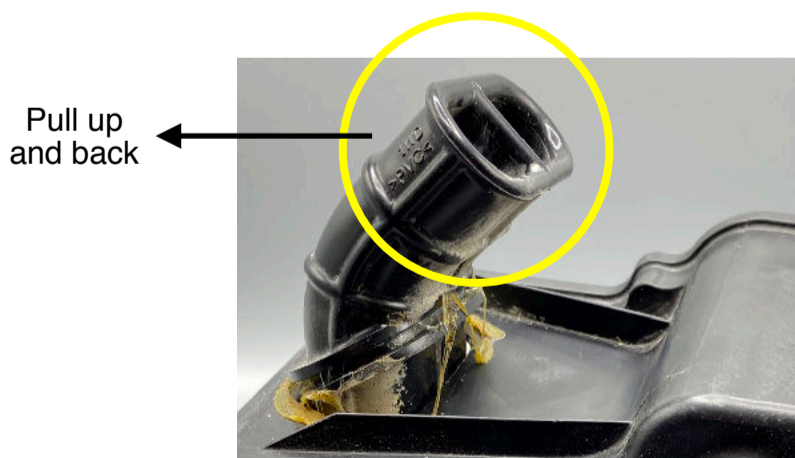


Filter cover screws (3x)

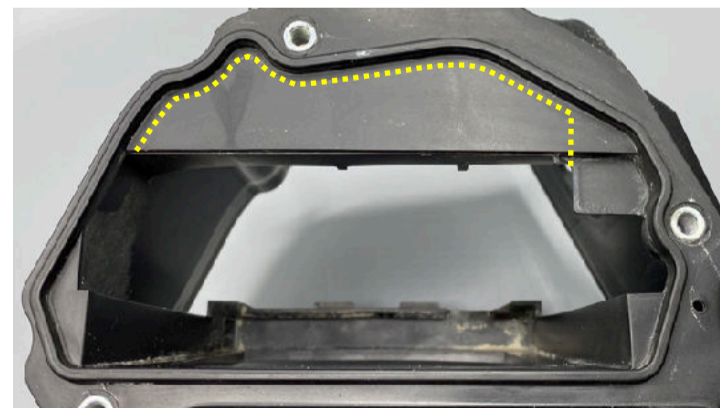


Stock intake manifolds with clamps

Step 1: Remove the 8x side cover screws and the side cover, set aside. Remove the 3x filter cover screws, filter cover and air filter, set aside. Remove stock clamps and manifolds. Clean any glue residue left on the airbox surfaces.



Step 2: Remove the intake snorkel. This is most easily done by pulling the snorkel up and back (see image above).



Step 3: Cut away the upper portion of the air filter opening (see image above). A Dremel or jigsaw is recommended. Clean the cut edges and airbox thoroughly to remove all debris.

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Figure 1: Air filter cover cut line.



Figure 2: Air filter cover hold-down ribs exposed after cutting.

Step 4: Using a band or hand saw, cut away the outer portion of the air filter cover. Make the cut 3/8" (10mm) above the top of the base flange (see Figure 1 above). Be sure your cut will leave the air filter hold-down ribs intact (see Figure 2 above). Clean the cut edges to remove any loose debris.



Figure 3: Location for silicone rubber sealant.

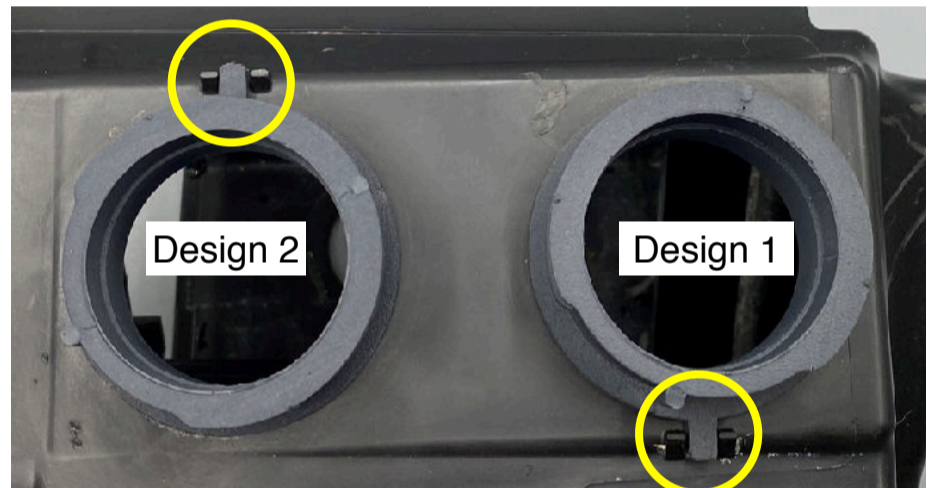


Figure 4: New manifold alignment tabs mated with the airbox alignment tabs.

Step 5: Run a thin bead of silicone rubber sealant (included in box) around the groove in each of the new manifolds (see Figure 3 above). Install the new manifolds in the airbox, lining up the manifold alignment tabs and the airbox alignment tabs (see Figure 4 above). Allow silicone rubber sealant to cure.



Step 6: Insert the Snap Stacks™ velocity stacks into the intake manifolds, be sure they are fully seated.

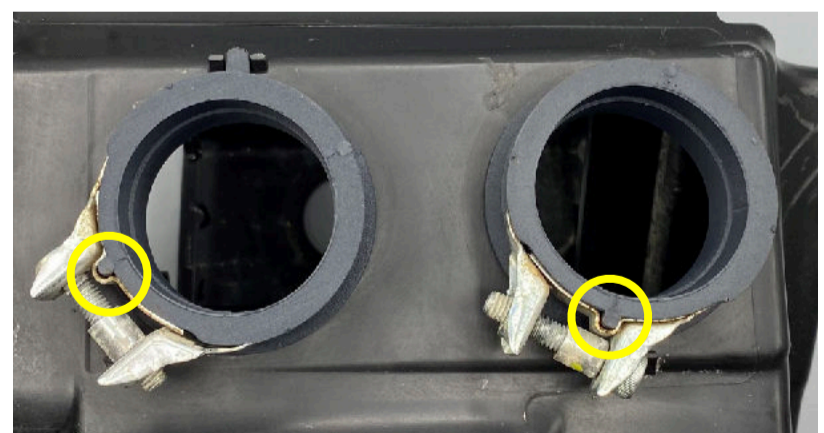


Figure 5: New manifold alignment ribs mated with stock clamp slots. Stock clamp screw heads facing out.

Step 7: Reinstall the air filter, air filter cover, airbox side cover and manifold clamps (see Figure 5 above).