



## INSTALLATION INSTRUCTIONS

KHROME WERKS HIDE-AWAY  
EXHAUST HEADERS For  
2017-2020 FLHT, FLHX, FLHR, FLTR  
Mfg. p/n 200100  
(See pkg. label for Dist. p/n)

### ATTENTION INSTALLER (if other than owner):

Please forward this instruction sheet and the warranty card to the purchaser of this product. These instructions also contain valuable information necessary to the end user.

### INTRODUCTION:

These instructions describe the procedure for properly installing KHROME WERKS® Hide-Away Headers on 2017-2020 FLHT, FLHR, FLHX or FLTR models. Review instructions carefully before beginning, as they contain important information. Please retain for future reference.

Particularly important information is distinguished in these instructions by the following notations:

**NOTE:** A NOTE provides key information to make procedures easier or clearer.

**CAUTION:** A CAUTION indicates special procedures that must be followed to avoid damage to the motorcycle or accessories.

**WARNING:** A WARNING indicates special procedures that must be followed to avoid injury or death to a motorcycle operator or person inspecting or repairing the motorcycle.

### TOOLS REQUIRED:

- |                             |   |
|-----------------------------|---|
| 1 – ¼" drive ratchet        | 1 – 1/2" box wrench                     |
| 1 – ¼" drive ½" socket      | 1 – 9/16" box wrench                    |
| 1 – 3/16" Allen wrench      | 1 – 5/16 Allen wrench                   |
| 1 – ¼" drive 6" extension   | 1 – 5/16 nut driver or flat screwdriver |
| 1 – 7/16" x ¼" drive socket | 1 – 15mm box wrench                     |
| 1 – 22mm box wrench         |   |

Supplies: New exhaust gaskets, 12 & 18mm O<sup>2</sup> port plugs & copper sealing washers.

### PROCEDURE:

1. Remove right front floorboard and saddle bags
2. Remove mufflers, save clamps (H-D states clamps are not reusable). **Tip:** Use anti-seize on threads of used muffler clamps. If they clamp down securely they don't need to be replaced, however they may be stretched and require replacement.  
**Note:** If reusing mufflers: Loosen clamps and force mufflers up and down and side to side (while still on the pipes) until they loosen up enough to reinstall easily.
3. Disconnect the O<sup>2</sup> sensor plugs. Remove heat shields exhaust header and crossover. Save shields hardware and mount brackets.
4. Remove and save retaining rings, exhaust flanges and O<sup>2</sup> sensors from old exhaust headers.
5. Remove and discard exhaust port gaskets. Install supplied new gaskets.  
**CAUTION:** New conical type port gaskets (H-D 65324-83B or equivalent) must be used with KW exhaust headers to avoid leaks.
6. Install flanges and retaining rings on new exhaust headers. Install 12mm or 18mm O<sup>2</sup> sensors and/or supplied O<sup>2</sup> port plugs and gaskets. Use anti-seize on threads

7. Install new head pipe using saved 5/16-24 hex flange nuts. Seat front pipe first then rear. A firm pull rearward on the rear header, while keeping the front header seated, may be necessary to clear the rear head casting. Be careful not to damage gaskets. Do not fully tighten nuts yet.

8. Reinstall head pipe mid-mount bracket and tighten.

9. Tighten Head pipe port flange nuts evenly

10. Reinstall the crossover onto new header using the original hardware and clamps. Do not tighten 1-3/4" clamp yet.

**CAUTION:** To ensure there are no leaks and the system is properly aligned the front and rear port nuts must be evenly torqued.

11. Clean header pipes and crossover.

12. Install mufflers and clamps (hopefully new *Khrôme Werks*®). Mufflers' rear brackets should align side to side and up and down with saddlebag supports rear mounting bracket without stress. Do not tighten the muffler or crossover/header clamps until the heat shields are in place.

13. Reinstall heat shields. Adjust shields for best fit and tighten.

14. Align the mufflers and crossover for best fit and tighten all 1-3/4" and 2-1/2" clamps to 38-43 ft. lbs.

15. Reinstall saddle bags and front floorboard.

16. Before operating motorcycle, clean heat shields and mufflers with soap and water or window cleaner. Any grease or oil will permanently burn onto pipes. Dry thoroughly.

**CAUTION:** Carefully read the enclosed Important Notice sheet. recalibration may be required.

**WARNING:** Check all mounting hardware to be sure it is tight before and after first operation of motorcycle. Periodically, check tightness of all mounting hardware.

**USE AND CARE:** Wash your accessories with the same care you use when washing your motorcycle. Use mild soap and water. DO NOT use abrasive chemicals or cleaners, or high pressure washers.

**CAUTION:** Cover ends of mufflers when washing motorcycle. Mufflers may internally corrode if saturated with water and allowed to sit.

BOM			
ITEM #	PART #	DESCRIPTION	QTY
1	200101	HEADER WELDMENT	1
2	209012	12MM O2 PLUGS	2
3	209018	18MM O2 PLUGS	2
4	346870	PORT GASKET	2
5	420403	12mm O2 GASKET	2
6	420405	18MM O2 GASKET	2

**KHROME WERKS®**

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