



## INSTALLATION INSTRUCTIONS

2-2 THREE STEP EXHAUST SYSTEM  
For 2017-up FLHT, FLHX, FLHR, FLTR  
Mfg. p/n **200400A, 200810A, 201810A**  
(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®** 2-2 Three Step Exhaust Headers and 4.50" Mufflers on **2017-up** 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.

### All Models:

**NOTE:** This system may not be compatible with suspension stabilizers.

**WARNING:** Ground and cornering clearance may be reduced. Clearance will be reduced when bikes are fitted with shorter shocks.

### TOOLS REQUIRED:

1 – ¼" drive ratchet	1 – 5/16" nut driver or flat screwdriver
1 – ¼" drive 7/16" & ½" sockets	1 – 7/16" box wrench
1 – ¼" "drive 6" extension	1 – 1/2" box wrench
1 – 3/16" Allen® wrench	1 – 9/16" box wrench
1 – ¼" Allen® wrench	1 – 14mm box wrench
1 – 5/16" Allen® wrench	1 – 15mm box wrench
1 – 6mm Allen® wrench	1 – 22mm box wrench
1 – 10mm ®Allen wrench	

Supplies: New muffler clamps, and anti-seize..

### PROCEDURE:

1. Remove right front footboard.
2. Remove saddlebags.
3. Remove and save the 5/16" bolts and washers from rear brackets on each muffler. Slide old mufflers off header pipes. Discard old mufflers and clamps.
4. Disconnect the O2 sensors. Remove heat shields, exhaust headers and crossover. Save the four 5/16"-24 hex flange port nuts and two ¼-20 x 11/16" crossover mount screws,
5. Remove and save retaining rings, O2 sensors and exhaust flanges from old exhaust headers.
6. Remove and discard exhaust port gaskets. Install supplied new conical gaskets.

**CAUTION:** Conical port gaskets must be used with KW exhaust headers to avoid leaks.

7. Install flanges (counterbore up) and retaining rings on new exhaust headers. 18mm or 12mm Oxygen sensors and/or supplied plugs/gaskets may be installed at this time. Use anti-seize on threads.

8. Remove the transmission outer side cover. Remove the 2 lower 5/16"-18 screws from the inner transmission side cover and install the supplied L-bracket with the existing screws. Torque to 22-25 ft-lbs. reinstall the outer cover. Torque to 100-120 in-lbs.

9. Install new header system 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.

10. Install the provided 3/8"-16 x 1.00" carriage bolt through the P-clamp and the L-bracket. The P-clamp sits on top of the L-bracket. Install the supplied 3/8"-16 flange nut. (see the illustration). Do not fully tighten until the four port flange nuts are torqued to 100-120 in-lbs. Final torque the P-clamp nut to 22-25 ft-lbs. This step aligns the system.

11. **Install one of the supplied 2.00" (50.8mm) AccuSeal pipe clamp on the slotted end of the crossover pipe weldment with the open end to the left and the nut facing down (cannot be installed later).**

12. Position the crossover weldment under the oil pan and slide its slotted end onto the end of the front header until the P-clamp is positioned flat against the transmission case. Install the two saved ¼-20 x 11/16" socket cap screws through the crossover P-clamp and into the back of the transmission case. Torque the P-clamp pinch screw first to 76 in-lbs. Torque the two upper P-Clamp fasteners to 84-132 in-lbs. **Torque the crossover/header clamp to 38-43 ft-lbs.**

**CAUTION:** The crossover P-Clamp must be flat against the transmission case after all fasteners are torqued.

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

13. Install the supplied 2.00" (50.8mm) clamps on the mufflers in the same position as the original clamps.

**NOTE:** The right side muffler has an indentation for axle clearance.

14. Slide mufflers onto header pipes into same position as original mufflers. The rear brackets on the mufflers should be positioned halfway between the rubber mounts on the saddlebag/muffler supports and rotated on the header pipes so they are evenly aligned in the rubber mount slot when viewed from the rear. If muffler-to-header fit is loose, use silicone to seal. Install 5/16"-18 bolts and washers removed in step 3 and tighten to 96-144 in-lbs.

Do not tighten the muffler clamps until the heatshields are in place.

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15. Clean header pipes and crossover (see step 23).

16. Insert worm gear clamps into slots on the back side of the heat shields. All clamps screws except the upper two on the rear shield should be positioned so the screw heads can be accessed from the front or bottom of the headers. **Tip:** Insert clamps evenly into the slots and bend the ends outward to ease installation over header pipes. Lube clamp threads if shields are removed and reinstalled.

17. Install heat shields. Connect and loosely tighten all worm gear clamps. Align shields on header pipes for best fit. Position screw heads for easiest access and tighten with a 5/16" nut driver or screwdriver.

18. Reinstall front floorboard with the supplied 1/4" spacers.

**CAUTION:** Make sure no part of the exhaust system or shields contacts the frame or any component that is connected to the frame (except for the rear muffler brackets).

19. Position and orient the muffler clamps in the original position, making sure the clamps cover the rear edge of the clamping slots. **Align and tighten the muffler clamps to 38-43 ft-lbs**

**CAUTION:** Muffler clamps must be tight on the header pipes or damage may occur to either the header and or the mufflers. If clamps are stretched they will not torque properly and must be replaced. **See replacement clamps at [www.khromewerks.com](http://www.khromewerks.com)**

20. Reconnect oxygen sensor electrical plugs.

21. Install the saddlebags.

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

**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 and cleaners, or high pressure washers. We have had success using the following products to polish and maintain our Styleline Eclipse and Icon finishes: Wizards Mist n Shine and Turtle Wax Chrome Polish. Use per manufacturer's recommendations. Please contact us if you have further questions.

**CAUTION:** Carefully read the enclosed Important Notice sheet. Recalibration may be required depending on engine modifications.

**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 and examine system for cracks.

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

**NOTE:** This exhaust system is designed for use on closed course competition motorcycles only and does not conform to U.S. EPA noise and emission standards. This system is not a replacement for motorcycles equipped with factory installed catalytic convertor style systems. **NOT LEGAL FOR SALE OR USE IN CALIFORNIA ON ANY POLLUTION CONTROLLED MOTOR VEHICLES**

BOM			
ITEM#	PART #	DESCRIPTION	QTY
1	200401A	2-2 HEADERS WITH P-CLAMP	1
2	3463314	PORT GASKET	2
3	200402A	CROSSOVER WITH P-CLAMP	1
4	3463489	2.00" (50.8mm) ACCUSEAL CLAMP	3
5	200403A	FRONT HEAT SHIELD, CHROME	1
6	200813A	FRONT HEAT SHIELD, BLACK	1
7	201813A	FRONT HEAT SHIELD, ECLIPSE	1
8	200404	REAR HEAT SHIELD, CHROME	1
9	200814	REAR HEAT SHIELD, BLACK	1
10	201814	REAR HEAT SHIELD, ECLIPSE	1
11	200405	LEFT HEAT SHIELD, CHROME	1
12	200815	LEFT HEAT SHIELD, BLACK	1
13	201815	LEFT HEAT SHIELD, ECLIPSE	1
14	390370	HEAT SHIELD CLAMP	9
15	209923A	P-CLAMP L-BRACKET	1
16	203070	HEADER P-CLAMP	1
17	203080	CROSSOVER P-CLAMP	1
18	420426	1/4-20 X .75 HEX CAP SCREW	1
19	420064	1/4-20 BIWAY NUT	1
20	420284	1/4" B NARROW FLAT WASHER	2
21	421016	3/8"-16 x 1.00" CARRIAGE BOLT	1
22	120085	3/6-16 FLANGE NUT	1
23	3463404	1/4" FLOORBOARD SPACERS	2
24	299012	12mm O2 PLUG	2
25	209018	18mm O2 PLUG	2
26	420403	12mm O2 GASKET	2
27	420405	18mm O2 GASKET	2
28	200406	LEFT MUFFLER W/TIP, CHROME	1
29	200816	LEFT MUFFLER W/TIP, BLACK	1
30	201816	LEFT MUFFLER W/TIP, BLK CHR	1
31	200407	RIGHT MUFFLER W/TIP, CHROME	1
32	200817	RIGHT MUFFLER W/TIP, BLACK	1
33	201817	RIGHT MUFFLER W/TIP, BLK CHR	1

