



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*® 2-1 Exhaust Header and Muffler on 2009-up FLHT, FLHR, FLHX or FLTR models. (1993-2006 models will fit with transmission bracket P/N 209925, sold separately.) 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: Right side floorboard must be mounted in the lowest position.

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 – 1/2" box wrench
1 – ¼" drive 6" extension	1 – 9/16" box wrench
1 – 3/16" Allen® wrench	1 – ¼" Allen® wrench
1 – 14mm box wrench	1 – 15mm box wrench
1 – 5/16" Allen® wrench	1 – 22mm box wrench
1 – 6mm Allen® wrench	
1 – 10mm Allen® wrench	

Supplies: Anti-seize.

PROCEDURE:

1. Remove right front footboard.
2. Remove saddlebags.
3. Remove mufflers, save one rear bracket and 2 of the 5/16" screws and washers.
4. Disconnect the O2 sensors. Remove heat shields, exhaust headers and crossover. Save the four 5/16"-24 hex flange port nuts and the L-bracket flange nut.
5. Remove and save retaining rings, O2 sensors and exhaust flanges from old exhaust headers.
6. Remove and discard exhaust L-bracket mounted under the transmission side cover. Save the socket screws.

INSTALLATION INSTRUCTIONS

2-1 EXHAUST SYSTEM

For 2009-up FLHT, FLHX, FLHR, FLTR

Mfg. p/n 200780, 200785

(See pkg. label for Dist. p/n)

7. 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.

8. Install flanges 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

9. Install the new L-bracket under the transmission side cover with the saved screws. Torque to 22-25 ft-lbs.

10. 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.

11. Install the provided 3/8"-16 x 7/8" carriage bolt through the P-clamp and the L-bracket. The P-clamp sits on top of the L-bracket. Install the saved 3/8"-16 flange nut. Do not fully tighten until the four port flange nuts are torqued to 100-120 inch lbs. Final torque the P-clamp nut to 20-25 ft lbs. This step aligns the system.

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

12. Clean header pipes (see step 21).

13. 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.

14. Install header heat shields. Connect and loosely tighten all worm gear clamps. Align collector ends of the shields. Position clamp screw heads for easiest access and tighten with a 5/16" nut driver or screwdriver.

15. Install collector heat shield with the larger worm gear clamp. Hold collector shield tightly against the header shields and loosely tighten the worm gear clamp.

16. Reinstall front floorboard in the lowest position.

CAUTION: Make sure no part of the exhaust system or shields contacts the frame or any components that are connected to the frame (except for the rear muffler bracket).

17. Align the muffler for best fit with the collector heat shield and the heat shields. Tighten the muffler inlet and header clamps to 38-43 ft lbs. The header clamp must not contact frame. Tighten the collector heat shield worm clamp.

CAUTION: Muffler clamp must be tight on the header pipe or damage may occur to either the header and or the muffler. If clamp is stretched it will not torque properly and must be replaced.

***KHROME WERKS*®**

Div. of Lincoln Industries • 67 Fifth Street N.E. • Pine Island, MN 55963



INSTALLATION INSTRUCTIONS

2-1 EXHAUST SYSTEM

For 2009-up FLHT, FLHX, FLHR, FLTR

Mfg. p/n 200780, 200785

(See pkg. label for Dist. p/n)

18. Reconnect oxygen sensor electrical plugs.

19. 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.

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

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.

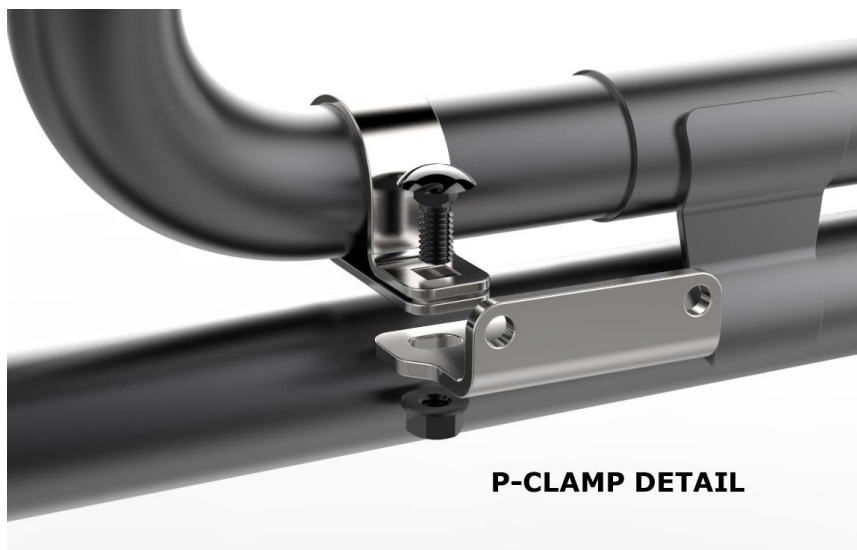
WARNING: Check all mounting hardware to be sure it is tight before and after first operation of motorcycle. Periodically, check tightness of all mounting hardware and examine system for cracks.

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 end of muffler 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 emission standards. This system is not a replacement for motorcycles equipped with factory installed catalytic converter style systems. Not for sale or use in California

BOM			
ITEM #	PART #	DESCRIPTION	QTY
1	200701	2-1 HEADERS WITH P-CLAMP	1
2	3463314	PORT GASKET	2
3	2030301	2.50" ACCUSEAL CLAMP	1
4	200703	FRONT HEAT SHIELD, CHROME	1
5	200873	FRONT HEAT SHIELD, BLACK	1
6	201873	FRT HEAT SHIELD, BLK CHROME	1
7	200702	REAR HEAT SHIELD, CHROME	1
8	200872	REAR HEAT SHIELD, BLACK	1
9	201872	REAR HEAT SHIELD, BLK, CHR	1
10	200704	TRANSITION SHIELD, CHROME	1
11	200874	TRANSITION SHIELD, BLACK	1
12	201874	TRANSITION SHIELD, BLK CHR	1
13	390370	HEADER SHIELD CLAMP	8
14	390375	TRANSITION SHIELD CLAMP	1
15	209920	P-CLAMP L-BRACKET	1
16	203060	HEADER P-CLAMP	1
17	421017	3/8"-16 x 7/8" CARRIAGE BOLT	1
18	204150	MUFFLER W/TIP, CHROME	1
19	204250	MUFFLER W/TIP, BLACK	1
20	299012	12mm O2 PLUG	2
21	209018	18mm O2 PLUG	2
22	420403	12mm O2 GASKET	2
23	420405	18mm O2 GASKET	2



P-CLAMP DETAIL

KHROME WERKS®

Div. of Lincoln Industries • 67 Fifth Street N.E. • Pine Island, MN 55963