



INSTALLATION INSTRUCTIONS

2-2 EXHAUST HEADERS
For 1993-2008 FLHT, FLHX, FLHR, FLTR
Mfg. p/n 200600B
(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 Exhaust Headers on 1993-2008 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 swing arm pivot suspension stabilizers.

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 – 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 – ¼" nut driver or flat screwdriver
1 – 7/16" ¼" socket	1 – 15mm box wrench
1 – 22mm box wrench	

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

PROCEDURE:

1. Remove right front floorboard.
2. Remove saddlebags.
3. 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.

4. Disconnect the O² sensor plugs (07-08). Remove heat shields and exhaust headers. Save the 5/16-24 hex flange port nuts.
5. Remove and save retaining rings and exhaust flanges from old exhaust headers (O² sensors on 07-08).

6. Remove and discard rear exhaust bracket mounted to transmission. Remove transmission end cover to access fasteners (99-06). Replace screws.

7. Remove and discard left side exhaust/starter bracket. Replace screws.

8. Remove and discard four of the ¼" socket heads closest to the rear of the oil pan (leave center rear screw intact). See the photo.

9. Remove and discard exhaust port gaskets. Install supplied new conical gaskets.

CAUTION: New conical type port gaskets (H-D 65324-83B or equivalent) must be used with KW exhaust headers to avoid leaks.

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

11. 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.

12. Install the supplied Torca/AccuSeal pipe clamp on the expanded end of the crossover pipe weldment with the open end down and the nut facing out (cannot be installed later).

13. Position the crossover weldment under the oil pan and slide its expanded end onto the end of the front header pipe.

14. Align the slots in the crossover pipe mounting brackets with the oil pan mounting holes. Install the four ¼-20 x 3.50" hex cap screws, ¼" flat washers and the two crossover spacer weldments. Use blue Loctite on the threads. Torque the fasteners to 90-108 inch lbs.

15. Torque the port flange nuts evenly. Do not tighten the Torca clamp until the heat shields are in place.

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

16. Clean header pipes and crossover (see step 22).

17. Install mufflers and clamps (hopefully new *Khrome 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.

18. 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.

19. Install heat shields. Connect and loosely tighten all worm gear clamps. Position screw heads for easiest access and tighten with a ¼" nut driver or screwdriver.

KHROME WERKS®

67 Fifth Street N.E. • Pine Island, MN 5596



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20. Reinstall front floorboard in the lowest position using the provided spacers between the frame and the floorboard supports.

21. Align and tighten the muffler and header/crossover clamps. Make sure header/crossover clamp does not contact frame. Reconnect oxygen sensor electrical plugs (2007-2008).

22. Before operating motorcycle, clean pipes 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. Re-jetting and or 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	200601A	HEADER WELDMENT	1
2	200602	CROSSOVER WELDMENT	1
3	3463314	PORT GASKET	2
4	203020	TORCA / ACCUSEAL CLAMP	1
5	200603A	FRONT HEAT SHIELD	1
6	200605	REAR HEAT SHIELD	1
7	200604	LEFT HEAT SHIELD	1
8	390335	HEAT SHIELD CLAMPS	10
9	200606	C-OVER SPACER WELDMENT	2
10	420443	1/4-20 X 3.50 OIL PAN BOLTS	4
11	420284	OIL PAN WASHERS	4
12	209018	O2 PLUGS	2
13	420405	O2 GASKET	2
14	3463404	FLOORBOARD SPACER	2



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