



## INSTALLATION INSTRUCTIONS

**3" SLIP-ON HP-PLUS® MUFFLERS**  
for 2004-13 H-D XL SPORTSTER® models  
Mfg. p/n 202300, 202390, 202400, 202800, 202890  
(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® 3" Slip-on HP-Plus® Mufflers on 2004-13 H-D XL Sportster® 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 – flat-blade screwdriver or 5/16" nut driver
- 1 – 9/16" combination wrench or socket
- 1 – 1/2" socket
- 1 – 3/8" drive torque wrench
- High-temp silicone (optional)

### PROCEDURE:

**NOTE:** Before beginning installation, note position and interaction of mufflers, heat shields, muffler clamps and brackets.

**NOTE:** The following assembly procedure is recommended to avoid gasket damage.

1. Loosen front and rear pipe heat shields, or remove temporarily to gain access to port nuts.
2. Slightly loosen port nuts of factory exhaust.
3. Loosen muffler clamp bolts. Remove the four (4) 5/16" screws that secure the mufflers to the interconnect mounting tube. Save. Remove 3/8" carriage bolt and acorn nut from rear header intermediate clamp. Save. Pull exhaust system out far enough to disengage mufflers from the interconnect tube. Remove mufflers from the exhaust pipes.

**NOTE:** If stock system will not disassemble easily, apply penetrating oil to loosen bond.

4. Remove clamps from the factory mufflers and loosely install them on the Khrome Werks® mufflers in the same position.

**NOTE:** To ensure sealing integrity of muffler clamps, and prevent the possibility of leakage, Harley-Davidson recommends that the muffler clamp assemblies be discarded and replaced each time they are removed. Silicone sealant is optional. We recommend KW clamp # 203030.

5. Carefully remove and inspect the gaskets from the crossover port or the tube for each factory muffler. If damaged, replace with H-D #65927-00. Install the gaskets on the crossover ports of the interconnect mounting tube (not in the muffler mounting port.)

6. Apply a bead of silicone inside the inlet end of each muffler (optional).

7. Install either the front or rear (with the EPA label) muffler onto the exhaust pipe and then onto the interconnect mounting tube carefully engaging the crossover port and gasket into the muffler tube. Install the two (2) 5/16"-18 screws through the mounting tube bracket and into the channel on the muffler and tighten to 15 ft-lb. Repeat for the remaining muffler.

8. Position and snug the muffler inlet clamps so they are accessible, inconspicuous, and do not interfere with the heat shields. Tighten snugly. Use of anti-seize on threads will ensure proper clamping.

9. Realign the complete system. When satisfied with alignment tighten the port nuts (96-120 in-lb.), the muffler inlet clamps (45-60 ft-lb.), and the flange nuts on the interconnect mounting tube (15-19 ft-lb.). Reinstall 3/8" carriage bolt and acorn nut in rear header intermediate clamp and tighten (30 ft-lb.).

10. Tighten or reinstall OEM pipe heat shields (align with muffler.)

11. 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. (No warranty.)

**NOTE:** These mufflers are designed for use on close course competition motorcycles only and do not conform to U.S. EPA noise emission standards. These mufflers are not replacements for motorcycles equipped with factory installed catalytic convertor style mufflers.

**KHROME WERKS®**

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