



INSTRUCTIONS

-J03112

REV. 2004-03-25

SPORTSTER CHROME PRIMARY TRIM COVER KIT

GENERAL

Kit Number

25233-04

Models

This kit fits 2004 and later XL (Sportster®) model motorcycles.

Additional Parts Required

WARNING

The rider's safety depends upon the correct installation of this kit. Use the appropriate service manual procedures. If the procedure is not within your capabilities or you do not have the correct tools, have a Harley-Davidson dealer perform the installation. Improper installation of this kit could result in death or serious injury. (00333a)

NOTE

This instruction sheet references Service Manual information. A Service Manual for your model motorcycle is required for this installation and is available from a Harley-Davidson Dealer.

Proper installation of this kit will also require a clutch-lever retaining ring (Harley-Davidson Part Number 11379) and a cable lower-end "O"-ring (Harley-Davidson Part Number 11179), each available separately from any Harley-Davidson dealer.

For a complete chrome appearance, ask your Harley-Davidson Dealer about chrome derby covers, derby cover screws, primary chain inspection cover and chain inspection cover screws. These items can be easily installed at the same time as this kit.

Kit Contents

See Figure 3 and Table 1.

INSTALLATION

WARNING

To prevent accidental vehicle start-up, which could cause death or serious injury, disconnect negative (-) battery cable before proceeding. (00048a)

1. Refer to the Owner's Manual and follow the instructions given to remove the seat and disconnect the negative battery cable at the engine crankcase. Retain all seat mounting hardware.
2. **Models with mid foot controls:** Remove the two screws retaining the left-side rider footrest and mounting bracket assembly.

3. **All models:** See Figure 1. Note the installed orientation of the transmission foot shift lever to aid in re-assembly. Use a 1/4 in. hex key to remove the socket head screw (5) holding the shift lever (3 or 4) to the transmission shift lever shaft (1). Remove the lever and rubber washer (2).

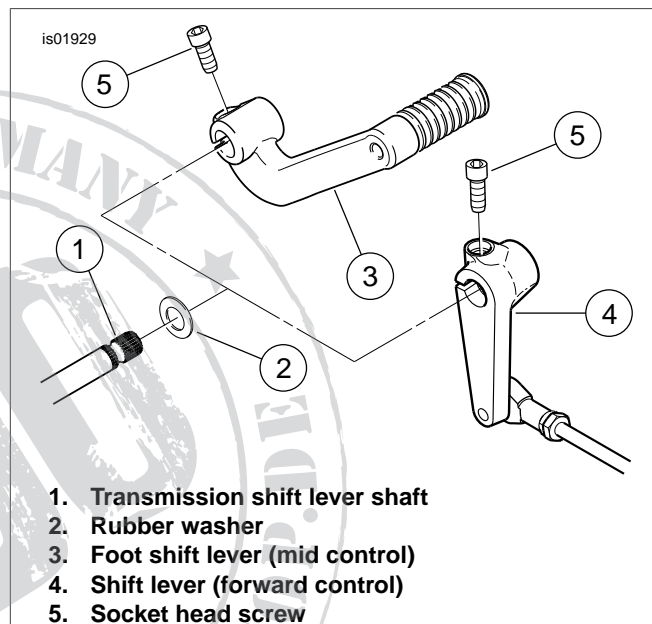


Figure 1. Shift Lever Removal

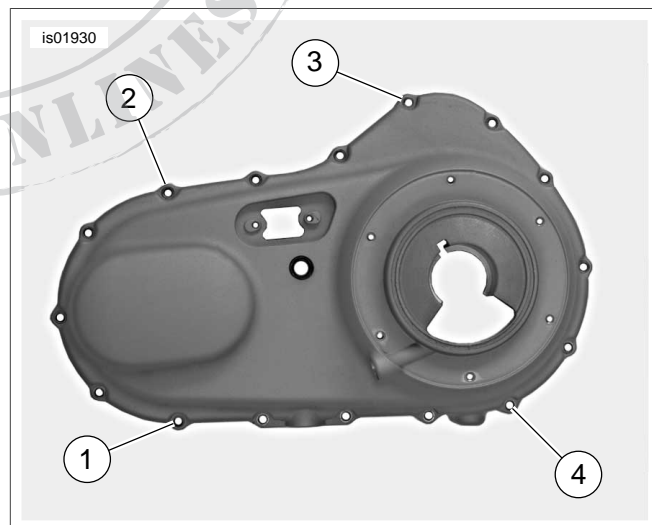


Figure 2. Primary Cover Mounting Screw Locations

NOTE

Remove **ONLY** the four screws shown.

4. See Figure 2 and Figure 3. Remove and discard the primary cover hex-socket head screws from the four locations shown.

5. Refer to CLUTCH CONTROL: REMOVAL: CLUTCH CABLE-LOWER in the Service Manual to remove the clutch cable at the lower end with these exceptions:
 - The negative battery cable has already been disconnected, and
 - On mid-control models, the rider footrest has already been removed.
6. See CLUTCH LEVER AND CLUTCH CABLE-UPPER to remove the clutch cable at the upper end.

NOTE

Be careful not to scratch the paint on the frame tube when removing the clips.

7. Carefully remove the two vinyl-coated spring steel clips that retain the clutch cable to the frame downtube.
8. Obtain all of the items from the kit.
9. See Figure 2. Insert a chrome screw (3), from the outside, through the hole in location 3 on the chrome trim cover. Place the **thinner** steel spacer (4) onto the threads of the screw from the inside of the trim cover.
10. Use a 5/32 inch hex key on the screw head, and grip one of the Nylon keeper washers (6) with a pliers. Install the washer onto the screw until several threads extend from the washer, capturing the screw and spacer on the trim cover.
11. Insert the remaining chrome screws, from the outside, through the holes in locations 1, 2 and 4 on the chrome trim cover. Place a **thicker** steel spacer (5) onto the threads of each screw from the inside of the trim cover.
12. Thread a Nylon keeper washer onto each of the screws as described in Step 10.
13. Position the trim cover over the primary cover with the transmission shift lever shaft extending through the clearance hole (A) in the chrome trim cover.
14. Thread one of the chrome screws into the mating primary cover mounting hole for several threads, taking care not to cross-thread the screw in the hole.
15. Carefully start the remaining screws partially into their mating holes. Continue tightening the screws in turn until

the trim cover is firmly in place. Tighten the screws, in the sequence shown in Figure 2, to 100-120 **in-lbs** (11.3-13.5 Nm).

16. Refer to CLUTCH CONTROL: INSTALLATION: CLUTCH LEVER AND CLUTCH CABLE-UPPER to reconnect the upper end of the clutch cable. Secure with a **new** retaining ring (Harley-Davidson Part Number 11379).
17. See CLUTCH CABLE-LOWER to re-connect the lower end of the clutch cable, using a **new** "O"-ring (Harley-Davidson Part Number 11179).

NOTE

Be careful not to scratch the paint on the frame tube when attaching the clips.

18. Capture the clutch cable in the pocket of one of the vinyl-coated spring steel clips removed in Step 7, and carefully attach the clip to the frame downtube, in line with the engine front cylinder rocker cover.
19. Repeat with the second clip, attaching to the downtube near the bottom of the engine oil filter.
20. See Figure 1. Assemble the rubber washer (2) to the transmission shift lever shaft (1). Orient the shift lever (3 or 4) to the angle noted in Step 3, and install the lever onto the shaft.
21. Using a 1/4 inch hex key, thread the screw (5) into the shift lever. Tighten to 16-20 ft-lbs (21.7-27.1 Nm).
22. **Models with mid foot controls:** Attach the left-side rider footrest and mounting bracket assembly to the frame with the two screws removed in Step 1, taking care to not cross-thread the screws in the holes. Tighten to 45-50 ft-lbs (61.1-67.9 Nm).
23. Refer to the Owner's Manual and follow the instructions given to re-attach the negative battery cable and install the seat.

⚠ WARNING

After installing seat, pull upward on seat to be sure it is locked in position. While riding, a loose seat can shift causing loss of control, which could result in death or serious injury. (00070b)

SERVICE PARTS

is01931

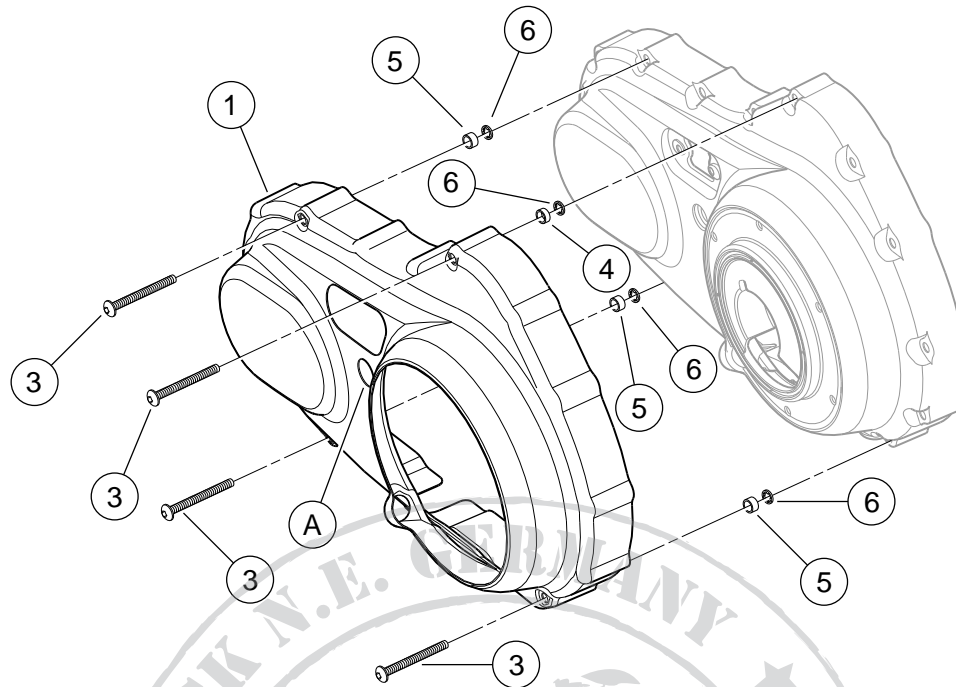


Figure 3. Service Parts: Chrome Primary Trim Cover

Table 1. Service Parts Table

Item	Description (Quantity)	Part Number
1	Trim cover, primary (chrome)	Not Sold Separately
2	Primary trim cover hardware kit (includes items 3 through 6)	94436-04
3	Hex socket screw, button head 1/4-20 x 2-1/4 inch (57 mm) long (4)	Not Sold Separately
4	Spacer (steel), .240 inch (6.1 mm) thick	Not Sold Separately
5	Spacer (steel), .290 inch (7.4 mm) thick (3)	Not Sold Separately
6	Keeper washer, Nylon (4)	Not Sold Separately
Items identified in text:		
A	Transmission shift lever shaft clearance hole	