



INSTRUCTIONS

-J05214

2010-04-29

TOURING 2-INTO-1 HEAD PIPE KIT

GENERAL

Kit Number

65600078

Models

For model fitment information, see the P&A Retail Catalog or the Parts and Accessories section of www.harley-davidson.com (English only).

Additional Parts Required

Muffler clamp (P/N 65296-10)

Right side muffler

▲ 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.

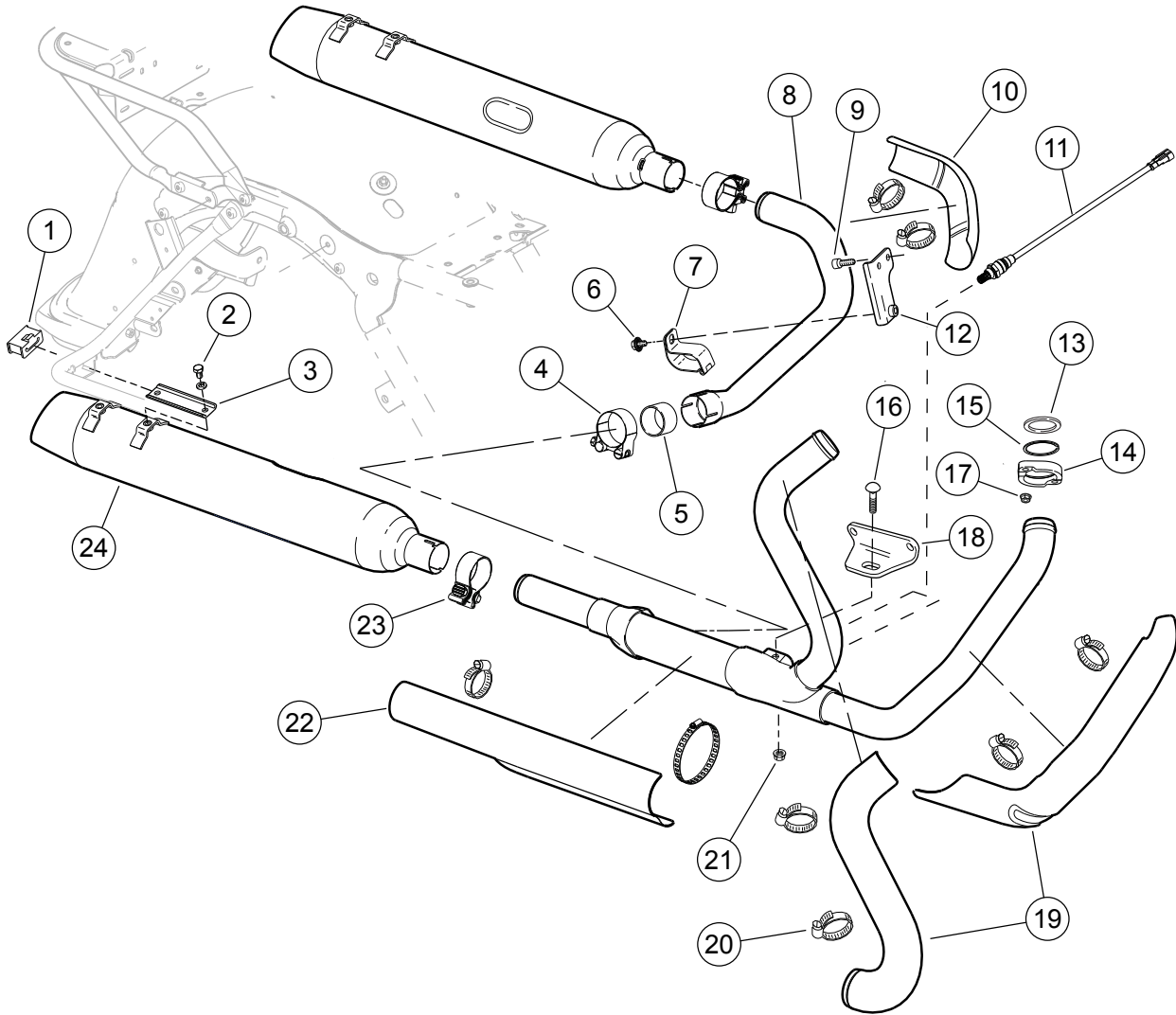
Kit Contents

See Figure 2 and Table 1.

EXHAUST SYSTEM REMOVAL

1. Remove saddlebags. See 2.25 SADDLEBAGS.
2. Remove mufflers. See 4.19 EXHAUST SYSTEM, Mufflers.
3. Remove seat. See 2.24 SEAT.
4. Remove right side front footboard and brackets from frame. See 2.48 FOOTBOARDS AND FOOTRESTS, Rider Footboards.
5. Disconnect front and rear O2 sensor connectors.
6. See Figure 1. Remove heat shields (10, 19, 22) from pipes.
7. Loosen clamp (4).
8. Remove fastener (6) and bracket (7).
9. Pull and twist on crossover pipe to remove (8).
10. Remove two flange nuts (17) to release front header pipe from studs of front cylinder head. Slide exhaust flange down header pipe to improve clearance around exhaust port.
11. Remove two flange nuts (17) to release rear header pipe from studs of rear cylinder head.
12. Remove flange nut (21) and carriage bolt (16).
13. Remove exhaust system from motorcycle.
14. Remove and discard gaskets (13) from front and rear exhaust ports.
15. Inspect retaining rings (15) and flanges (14). Replace as necessary.





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|----------------------------------|-----------------------------|
| 1. Rubber mount | 13. Gasket (2) |
| 2. Fastener (4) | 14. Exhaust flange (2) |
| 3. Bracket (2) | 15. Retaining ring (2) |
| 4. Clamp | 16. Carriage bolt |
| 5. Gasket | 17. Flange nut (4) |
| 6. Flange bolt | 18. Exhaust bracket |
| 7. Exhaust support clamp | 19. Heatshields, front pipe |
| 8. Crossover pipe | 20. Worm clamps |
| 9. Fastener (2) | 21. Flange locknut |
| 10. Heat shield, crossover pipe | 22. Heat shield, rear pipe |
| 11. O2 sensor (2) | 23. Muffler clamp |
| 12. Transmission exhaust bracket | 24. Muffler |

Figure 1. Exhaust Removal

EXHAUST SYSTEM INSTALLATION

1. Install new gaskets (3) in both the front and rear cylinder head exhaust ports with the tapered side out.
2. Place exhaust pipes (1) with clamps (17) and retaining rings (18) into position and start two exhaust flange nuts (16) to each pipe to fasten to studs.
3. Install bracket (12) to exhaust pipe tab using bolt (11) and nut (10).
4. Connect front and rear O2 sensor (20, 21) connections.
5. Install muffler (5) to exhaust pipe and fasten to pipe with clamp (7).
6. Align rear exhaust to rubber mounting bracket (8) in saddlebag guard and install bracket (4), screws (15), and lockwashers (19).
7. Install heat shields (6,13) to pipes using small worm drive clamps (14).
8. Install heat shield (2) exhaust pipe using worm drive clamps (9).

9. Tighten the exhaust system as follows:
 - a. Tighten the bottom nut of the rear cylinder head exhaust flange to 9-18 **in-lbs** (1-2 Nm). Tighten the top nut to 100-120 **in-lbs** (11.3-13.6 Nm). Final tighten the bottom nut to 100-120 **in-lbs** (11.3-13.6 Nm).
 - b. Tighten the top nut of the front cylinder head exhaust flange to 9-18 **in-lbs** (1-2 Nm). Tighten the bottom nut to 100-120 **in-lbs** (11.3-13.6 Nm). Final tighten the top nut to 100-120 **in-lbs** (11.3-13.6 Nm).

NOTE

Make sure that the heat shields do not contact the motorcycle frame or any mounted components

- c. Tighten the flange locknut (10) to 20-25 ft-lbs (27.1-33.9 Nm).
10. Position each worm drive clamp so that screw is on the outboard side in the most accessible position and tighten to 2.3-4.5 N·m (20-40 **in-lbs**).
11. Install right side front footboard and brackets. Refer to service manual instructions
12. Install seat. Refer to service manual instructions.
13. Install saddlebags. Refer to service manual instructions.

SERVICE PARTS

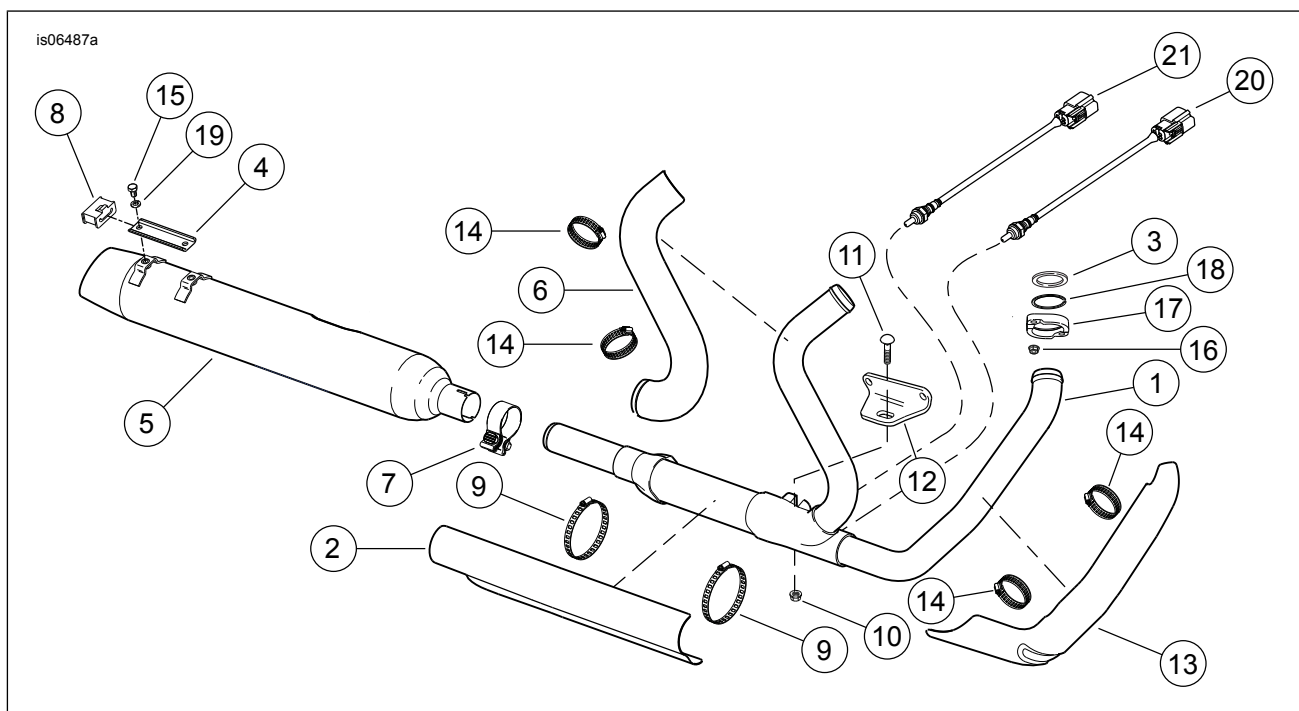


Figure 2. Service Parts: 2-Into-1 Head Pipe Kit

Table 1. Service Parts Table

Item	Description (Quantity)	Part Number
1	Exhaust pipe, chrome	66857-10
2	Collector shield	66896-10
3	Gasket, exhaust port (2)	65324-83B
Items mentioned in text, but not included in kit:		
4	Bracket, rear exhaust mount	
5	Muffler, right, chrome	
6	Heat shield, rear pipe	

Table 1. Service Parts Table

Item	Description (Quantity)	Part Number
7	Muffler clamp	
8	Mounting bracket	
9	Clamp, worm drive (2)	
10	Locknut	
11	Bolt	
12	Bracket, rear exhaust mount	
13	Shield, right exhaust pipe, front	
14	Clamp, worm drive (4)	
15	Screw	
16	Nut (4)	
17	Clamp, exhaust manifold (2)	
18	Retaining ring, exhaust gasket (2)	
19	Lockwasher	
20	Sensor, oxygen, front	
21	Sensor, oxygen, rear	