



INSTALLATION INSTRUCTIONS
AR[®] EXHAUST SYSTEMS FOR RIGID MOUNT
EVOLUTION and TWIN CAM BIG TWIN 1984-2006
Mfg. p/n 200215
(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 KHRÔME WERKS[®] Exhaust Pipes onto 1984-2006 Harley-Davidson models with rigid mount Evolution and Twin Cam engines (except Fat Boy[®] style: FLSTF, FLSTN). 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 . ½+combination wrench | 1 . Flat blade screwdriver |
| 1 . ratchet, ¼+drive | 1 . ½+socket, ¼+drive |
| 1 . 9/16+socket, ¼+drive | |
| 1 . Long extension, ¼+drive | |

PROCEDURE:

NOTE: Khrôme Werks[®] P/N 200215 is for 1995-99 direct model fit due to different mounting hole locations. Will fit 1984-94 models if the OEM hanger bracket H-D P/N 65459-95 or comparable aftermarket hanger bracket is used. 2000-06 models will require Khrôme Werks[®] Custom Hanger Bracket P/N 209956A.

1. Remove OEM front and rear heat shields, mufflers and header pipes. Save the nuts, bolts and washers; some will be reused.
2. Before installing new pipes, inspect OEM gaskets to be sure they are in place, not distorted, and properly seated. Replace if badly distorted.
3. Loosely attach front and rear pipes to cylinder heads. **Use new 5/16"-24 nuts provided with no washers; do not reuse flanged nuts on AR[®] pipes.**

CAUTION:

Exhaust studs are often bent when previous installers over-tightened the flange nuts. If this has happened, studs will have to be straightened or replaced. Use extreme caution not to break off bent studs. They are strong enough to withstand straightening, but do not use excessive force.

Attach end of the mounting brackets with the round hole to pipe studs and offset facing outward. Use bracket with smaller slot on rear pipe. Use nuts and star washers provided. Attach lower portion of brackets to OEM muffler hanger, using OEM bolts, flat and lock washers. Finger tighten only.

4. Align pipes parallel to each other and visually check to see that pipes are not toed in or out at rear. If installing with new gaskets, extra caution during tightening of port nuts is required. Tightening a little on each nut and alternating tightening frequently between the nuts will crush the gasket uniformly, create a proper seat, and maintain stress-free alignment to all mounting points. Tighten nuts at ports securely. Tighten all hanger bracket mounting hardware.

NOTE: If pipes cannot be aligned, it may be necessary to loosen and reposition OEM muffler hanger.

NOTE: OEM heat shields may now be reinstalled, if desired. Khrôme Werks[®] heat shields for models with Khrôme Werks[®] AR[®] exhaust systems are available, P/N 203140.

5. Before operating motorcycle, pipes must be cleaned thoroughly with a good window cleaner or soap and water. Any grease, oil or fingerprints will permanently burn onto chrome surface.

CAUTION:

Carefully read the enclosed sheet with tips on how to reduce bluing to a minimum. A few safeguards on initial start-up can result in a long-lasting new look.

WARNING:

Check all pipe and bracket mounting hardware to be sure it is tight before and after first operation of motorcycle. Periodically check this hardware for tightness.

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.

KHRÔME WERKS[®]
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