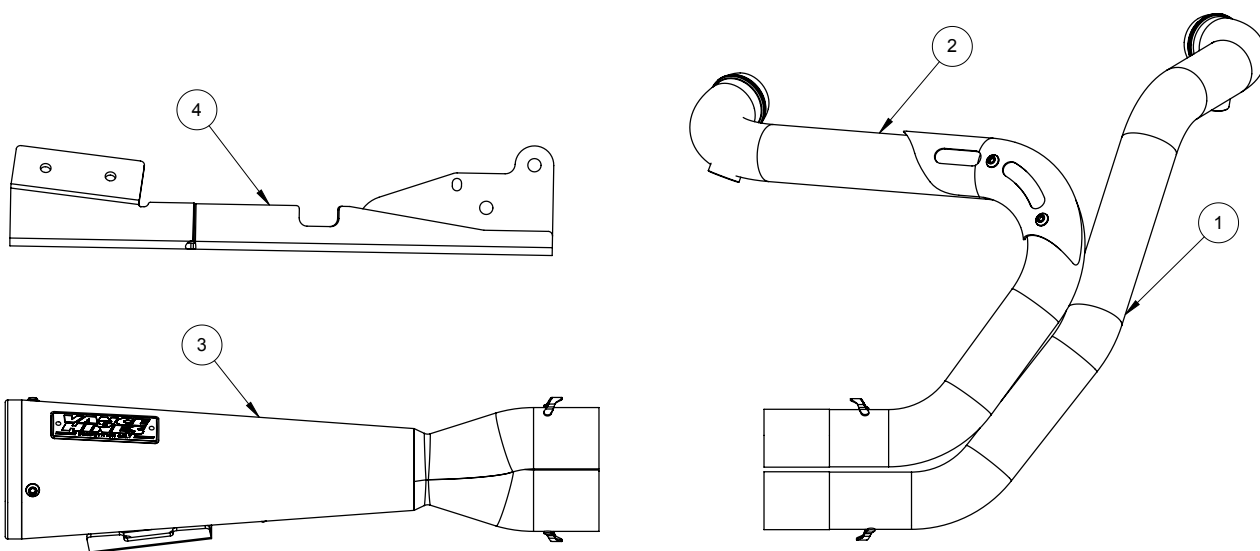


INSTALLATION INSTRUCTIONS: HARLEY-DAVIDSON SPORTSTER 2004-2013 2-INTO-1 PART# 27637

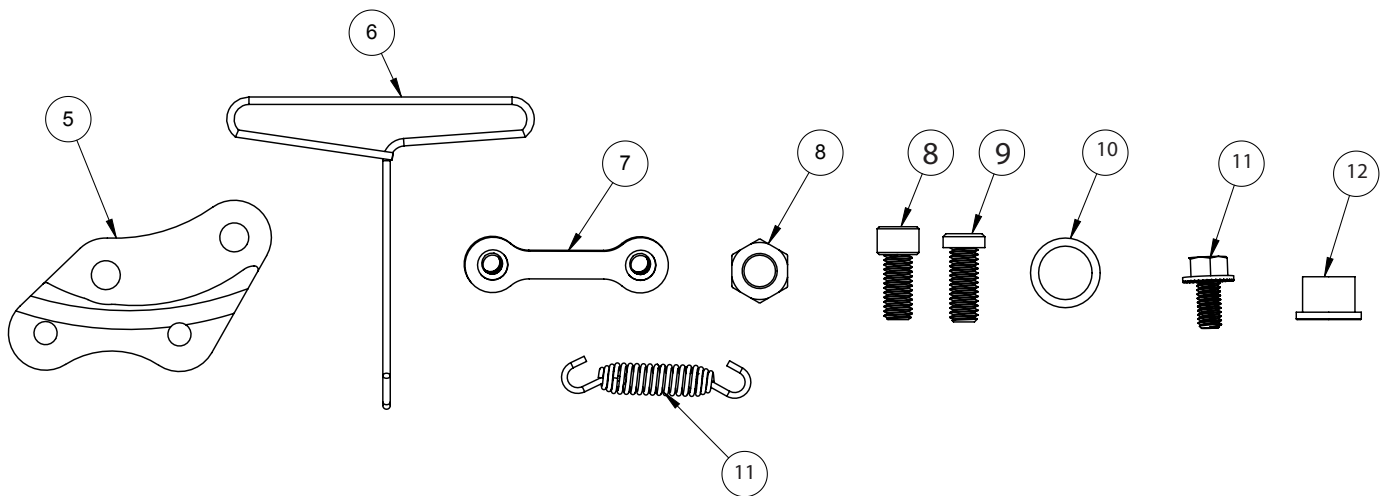
Congratulations, you have purchased the finest exhaust system available for your motorcycle. Your Vance & Hines exhaust is designed and crafted for performance, quality, and style. Please follow the instructions below, check exhaust system for missing or damaged parts and if you need any assistance please contact our technical support line (562) 921-7461.



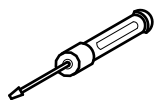
PARTS LIST

NO.	Part No.	Description	Qty.	NO.	Part No.	Description	Qty.
1	D1126FB	Front Head Pipe	1	8	A914HW	3/8-16 x 7/8" SHCS	2
2	D1127FB	Rear Head Pipe	1	9	A908HW	3/8-16 x 1" SHCS	2
3	D370RB-S	Muffler Can	1	10	A121HW	18mm x 24mm Washer	2
4	1166-P	Mount Bracket	1	11	A240HW	5/16-18 x 5/8" FHS	2
5	1171-P	Footpeg Relocator	1	12	A527HW	M18 O2 Bung Plug	2
6	A260SP	Spring Puller	1	13	A115SP	Dirt Sport Spring	2
7	A195HW	Dogbone Nut Plate	1				

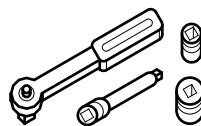
HARDWARE



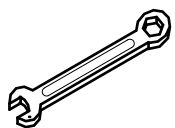
TOOLS REQUIRED



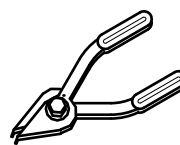
**Screwdrivers - Flat
blade, #3 Phillips Head**



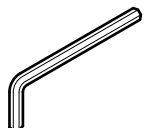
**Ratchet & Extensions
Sockets - 1/2", 9/16" deep,**



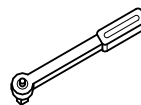
**Combination Wrench -
1/2", 9/16", & 7/8" or
22mm, 14mm, 19mm**



Snap Ring Pliers



**Allen Wrench - 3/16",
5/16"
Torx - T30**



Torque wrench

STOCK EXHAUST SYSTEM REMOVAL

1. Locate and unplug the O2 sensor wires from the wiring harness and remove nylon cable tie holding front wire to frame. Feed the end of the wires through the frame so they are free from the motorcycle. **NOTE:** Pay attention to wire routing for re-installation.
2. Loosen the heat shield clamps on both the front and rear exhaust pipes. This allows easier access to the head pipe mounting nuts.
3. Remove the two head pipe mounting nuts from each flange, located at the cylinder head.
4. Remove the clamp bolt which mounts the rear head pipe to the belt drive cover bracket.
5. Remove the two bolts from each muffler body where they attach to the mounting bar. Carefully remove exhaust pipes from the motorcycle and set aside.
6. Remove the drive belt cover and take the bracket off the rear cover bolt, the bracket will not be re-used.
7. Remove the brake rod at the rear eyelet. Remove foot controls.
8. Remove the three mount bolts and washers attaching the exhaust mounting bar and remove bar. (Save hardware for re-use)
9. Carefully remove exhaust port flanges and circlips from the stock exhaust system using snapping pliers. **NOTE:** Replace bent or damaged circlips.
10. Check condition of exhaust gaskets and replace if worn or damaged. (Harley P/N - 65324-83B)

VANCE & HINES EXHAUST INSTALLATION

1. Install and tighten supplied mounting bracket (stamped 1169-P) using stock bolts and washers. Torque to 30-33 Ft/Lbs.
2. Re-install drive belt cover. Torque 1" x 3/8" bolt to 30-33 Ft/Lbs. and 2" x 1/4" bolts to 80-120 In/Lbs.
3. On bikes equipped with forward controls, install footpeg relocater (1171-P) using 2X A914HW and 2X A908HW. **(Figure 1)**
4. Re-install at brake rod eyelet using removable thread locking compound (Loctite® 243 recommended). Torque to 120-180 In/Lbs.
5. Remove head pipes from protective packaging. Apply a small amount of anti-seize compound to the threads of the O2 sensors and install them into the new head pipe. **NOTE: 2004 - 2006** and models not using O2 sensors install supplied 18mm plug with copper crush washer. **2007 - 2013** models or models using 18mm wideband oxygen sensors install sensor directly into head pipe.
6. Install exhaust port flanges and circlip from stock system onto the Vance and Hines head pipes.
7. Using stock flange nuts, carefully install head pipes into exhaust ports, starting with the rear cylinder. Assistance may be required. **NOTE:** Do not tighten at this time.
8. Install muffler assembly onto head pipes. Attach muffler assembly to installed bracket and secure with 5/16-18 flange bolt and dog bone nut plate (supplied).
9. Install springs using supplied spring puller. There should be about a 2" gap between the spring tabs **(Figure 2)**.
10. Tighten exhaust port flange nuts and 5/16" flange head bolts at the bracket.

VANCE & HINES EXHAUST INSTALLATION CONTINUED

11. Plug O2 sensors back into wiring harness and route wires away from hot areas of the motorcycle.
12. Check rear brake pedal function. If needed adjust rear brake linkage to increase clearance between brake pedal and rear cylinder heat shield.
13. Check for adequate clearance between all exhaust system components and motorcycle accessories prone to heat damage.
14. Be sure to tighten all hardware before starting your motorcycle.

EXHAUST CARE (STAINLESS)

1. When installing a new set of stainless pipes, make sure your hands are clean and free of oil. After installation, thoroughly clean pipes with a soft cloth and cleaning solvent that will leave no residue (glass cleaner, alcohol, acetone, etc...) before starting the motorcycle.
2. It is considered normal for stainless steel exhaust systems to discolor due to heat.
3. High performance engine tuning utilizing a dyno will likely result in severe discoloration.
4. Avoid long periods of idling as this can cause discoloration. Intake leaks can cause the engine to run lean and overheat and this could lead to discoloration.
5. Make sure there are no exhaust leaks at the junction of the exhaust pipes and cylinder head. We recommend replacing gaskets if they are worn.

EXHAUST CARE (BLACK)

1. When installing a new set of black pipes, make sure your hands are clean and free of oil. After installation, thoroughly clean pipes with warm soapy water and a soft cloth. Dry with a clean towel to remove any residue before starting the motorcycle. Do NOT use anything abrasive to clean the pipes.
2. Avoid long periods of idling as this can cause discoloration.
3. Intake leaks can cause the engine to run lean and overheat, this could lead to discoloration.

FIGURE 1



FIGURE 2



FIGURE 3



Emissions Notice:

In California, in order to meet Air Resources Board emissions requirements, certain aftermarket part applications have been identified as replacements, and others have received ARB Executive Orders. All other emissions related aftermarket parts are for competition use only. A list of replacement parts and EO parts, and corresponding fitment is provided at vanceandhines.com/california.

Warranty:

All Vance & Hines products are warranted against defects in material and workmanship for a period of 90 days. This warranty does not cover discoloration or rust. This warranty shall be limited to the repair or replacement of the product, which may be proven defective under normal use. Vance & Hines will not warranty any system that has been abused, misused, improperly installed or modified.

Dealers or distributors are not authorized to make dispositions binding upon Vance & Hines. Vance & Hines will not be responsible for any labor charges incurred in removing or replacing any system under warranty. A return authorization number and a copy of the original purchase invoice must accompany all returns. Parts returned without a return authorization may be refused.



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