

INSTALLATION INSTRUCTIONS

True Dual Cross-Over w/Full Heat Shields FOR 1995 to 2006 HARLEY SOFTAILS Model S-330



WARNING PLEASE READ BEFORE INSTALLATION!

- Read all instructions thoroughly and confirm that all listed components are available for installation.
- Adding a free flowing exhaust systems may require rejetting of the carburetor. Lean carburetor settings are a major factor causing exhaust discoloration and potential engine damage.
- Samson® exhaust systems are designed to fit and work with OEM frames and motors.
- After installation thoroughly clean the new exhaust system before starting the motor.

REMOVAL PROCEDURE:

- Remove all existing heat shields. Remove the clamp on the crossover pipe, if so equipped.
- Remove the four flange nuts securing the exhaust to the cylinder heads.
- Remove the bolts holding the front and rear pipes to the exhaust mounting bracket.
- Remove the two bolts holding the mounting bracket to the frame. The mounting bracket is not needed to install this set of Samson® pipes.
- To remove the flanges and snap rings (will be re-used on new system) from old exhaust pipes. (Note: the snap rings may be lodged in the groove in the flange. Carefully pry the snap ring from the flange.)
- Do not remove the exhaust gaskets unless you intend to replace them. We recommend replacement with Genuine James thick gaskets. Samson® part # A-144.

**CAUTION: WITH SOME EXHAUST DESIGNS
GROUND CLEARANCE MAY BE REDUCED!**

TOOLS REQUIRED:

- 5/16" combination wrench
- 9/16" combination wrench
- 1/2" combination wrench
- ratchet, 6" extension and 1/2" swivel socket

PARTS LIST:

Qty.	Description
4	3/8-16 x 1-1/4" Hex head bolts
4	5/16" Flat washers
4	5/16-18x3/4" Carriage bolts
4	5/16-18 Nylock nuts
3	1 7/8" Barrel clamps
1	Right Side Muffler Brkt. (SP06-70)
1	Left Side Muffler Brkt. (SP06-71)
8	Hose clamps
4	3/8 Flat washers
4	Heat shields

INSTALLATION PROCEDURE:

NOTE: Do not tighten connections when first installing the system. To ensure proper fit and alignment all bolts and bracket are tightened at the end of the installation.

- Install the flange and snap rings on the front and rear exhaust pipes.
- Remove shift rod and install the new shift rod with bent end under the rear pipe.
- Hold the front pipe in place and loosely install the flange nuts.
- Hold the "U" pipe in place and loosely install flange nuts.
- Loosely slide a 1 7/8" Barrel clamp over the top end of the rear crossover pipe. Install the heat shield on both pipes Then slide the rear cross over pipe over the "U" pipe and tighten clamp.
- Install the right side muffler bracket to the frame in the stock location, using (2) 3/8-16x1-1/4" Hex head bolts and (2) 3/8" flat washers.
- Install the left side muffler bracket to the frame in the stock location, using (2) 3/8-16x1-1/4" Hex head bolts and (2) 3/8" flat washers.
- With a 1 7/8" Barrel clamp assembly over the front of the right side muffler, slide the right side muffler over the right head pipe. Loosely secure the muffler to the bracket using (2) ea. 3/4" carriage bolts, flat washers and 5/16 nylock nuts.
- Repeat procedure with left side of the bike. On some early model Softails, it is necessary to drill and thread holes in the left side on the frame to mount the muffler bracket.
- Tighten all hardware from front to back a little at a time. Carefully watch pipe alignment during tightening.
- Install the remaining heat shields using hose clamps.

Recheck all hardware after a 100 miles.

