

INSTALLATION INSTRUCTIONS

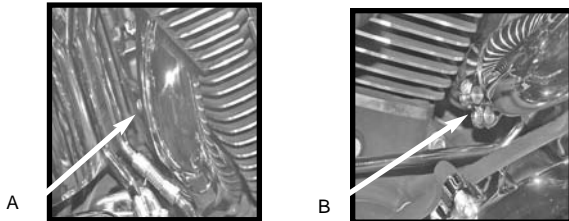
True Dual Cross-over Head Pipes For 1995-2009 HARLEY SOFTAILS Model S2-400



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 reused 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
- 3/16" allen 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	5/16-18 x 3/4" Hexhead bolts
3	1-7/8" Barrel clamps (SP11-17)
1	Coil Mounting Brkt (SP06-80)
1	Right Side Muffler Brkt. (SP06-70)
1	Left Side Muffler Brkt. (SP06-71)
8	Hose clamps
4	5/16" Lock washers
4	3/8 Flat washers
1	Shifter Rod
3	Heat shields

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.**

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 towards the rear pointing up.
- Remove the coil and the coil mounting bracket located under the seat. Install the new bracket provided (SP06-80) and reattach the coil using the stock hardware.
- 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. The bolt on the hose clamp holding the heat shield on the "U" pipe on the right side of the bike must be at the situated at the back of the pipe. *Figure A*. Now slide the rear cross over pipe over the "U" pipe and secure loosely with a 1-7/8" barrel clamp, placing the bolts at an eight o'clock angle. *Figure B* (High enough to clear the shifter rod and low enough to not hit the barrel.)
- Install the right side muffler bracket (SP06-70) 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 (SP06-71) to the frame in the stock location, using (2) 3/8-16x1-1/4" hex head bolts and (2) 3/8" flat washers.
- Slide a 1-7/8" barrel clamp over the front of the right side muffler, slide the right side muffler over the right head pipe. Loosely secure the muffler to the head pipe. Starting on the inside of the muffler mounting bracket, use (2) 5/16-18 x 3/4" hexhead bolts and (2) 5/16" lock washers to loosely attach the mufflers
- Repeat procedure with left side of the bike. .
- Install the front heat shields using hose clamps.
- Tighten all hardware from front to back a little at a time. Carefully watch pipe alignment during tightening.
- Reinstall O2 Sensors in the front and rear head pipes. If you do not wish to operate this system with the factory O2 Sensors you will need to consult your local dealer for tuning options as operation without these Sensors can result in engine damage. The Sensor thread size is 18mm x 1.5 pitch.

Recheck all hardware after a 100 miles.

