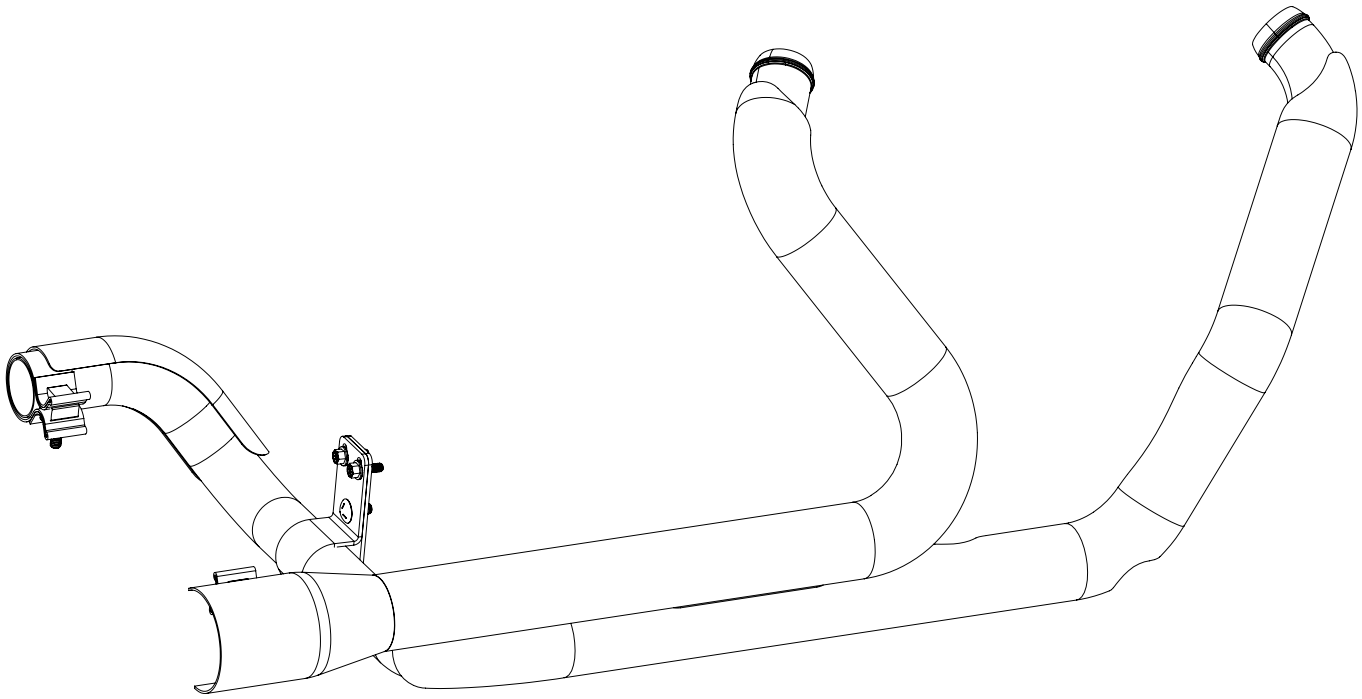
Ripsaw 2-2 Header

for 2017-2024 H-D® M8 Touring Models

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Instruction # 510-1473



Tools Needed:

- ¼ " drive ratchet
- ¼" drive ½" socket
- ¼" drive 7⁄16" socket
- ¼" drive 6" extension
- 3⁄16" Allen wrench
- ¼" Allen wrench
- 5⁄16" Allen wrench
- 6mm Allen wrench
- 10mm Allen wrench
- 5⁄16" nut driver or flat screwdriver
- 7⁄16" box wrench
- ½" box wrench
- 9⁄16" box wrench
- 14mm box wrench
- 15mm box wrench
- 22mm box wrench

PROCEDURE

The following installation procedure assumes that a stock exhaust system is being removed. If the bike you are working on has something other than the factory exhaust system, you may need to source some of the fasteners listed below.

1. Remove saddlebags.
2. Remove mufflers.
3. Remove right front floorboard and mounting brackets.
4. Remove heats shields and disconnect the oxygen sensors.
5. Remove the factory crossover pipe clamp and bracket from the back of transmission. Only the ¼" socket head screws will be re-used. The other parts are no longer needed.
6. Remove the exhaust port flange nuts, and flange nut that secures the header to the side clamp. Remove the exhaust header. Save the 5⁄16-24 hex flange nuts and the stock side clamp from the front pipe.
7. Remove and save oxygen sensors, retaining rings and exhaust flanges from old exhaust header.
8. Remove and discard exhaust port gaskets. Install new conical gaskets supplied in the kit.

CAUTION! - New conical port gaskets (H-D 65324-83B) (S&S 106-5029) must be used to avoid leaks.

9. Install flanges and retaining rings on new exhaust header. Oxygen sensors and supplied adaptors should be installed at this time. Use anti-seize on all threads.
10. Clean header pipes and crossover
11. Apply anti-seize to exhaust studs, and loosely install the new header using new 5⁄16-24 hex flange nuts. Seat rear pipe first then the front. Exert a firm pull forward on the front pipe, while keeping the rear pipe seated. Be careful not to damage gaskets. Do not fully tighten the flange nuts yet.
12. Install the factory side clamp on the front header. Apply thread locking compound to the bolt and loosely install the flange nut, but do not fully tighten at this time.
13. Locate the crossover pipe (5) and install two clamp pieces (7 and 8) onto crossover tube. Insert carriage bolt, but do not tighten at this time, to allow left to right adjustment of the clamp.
14. Install the supplied pipe clamp on the expanded end of the crossover pipe with the bolt facing forward and the bolt head facing down (cannot be installed later).



Picture 1

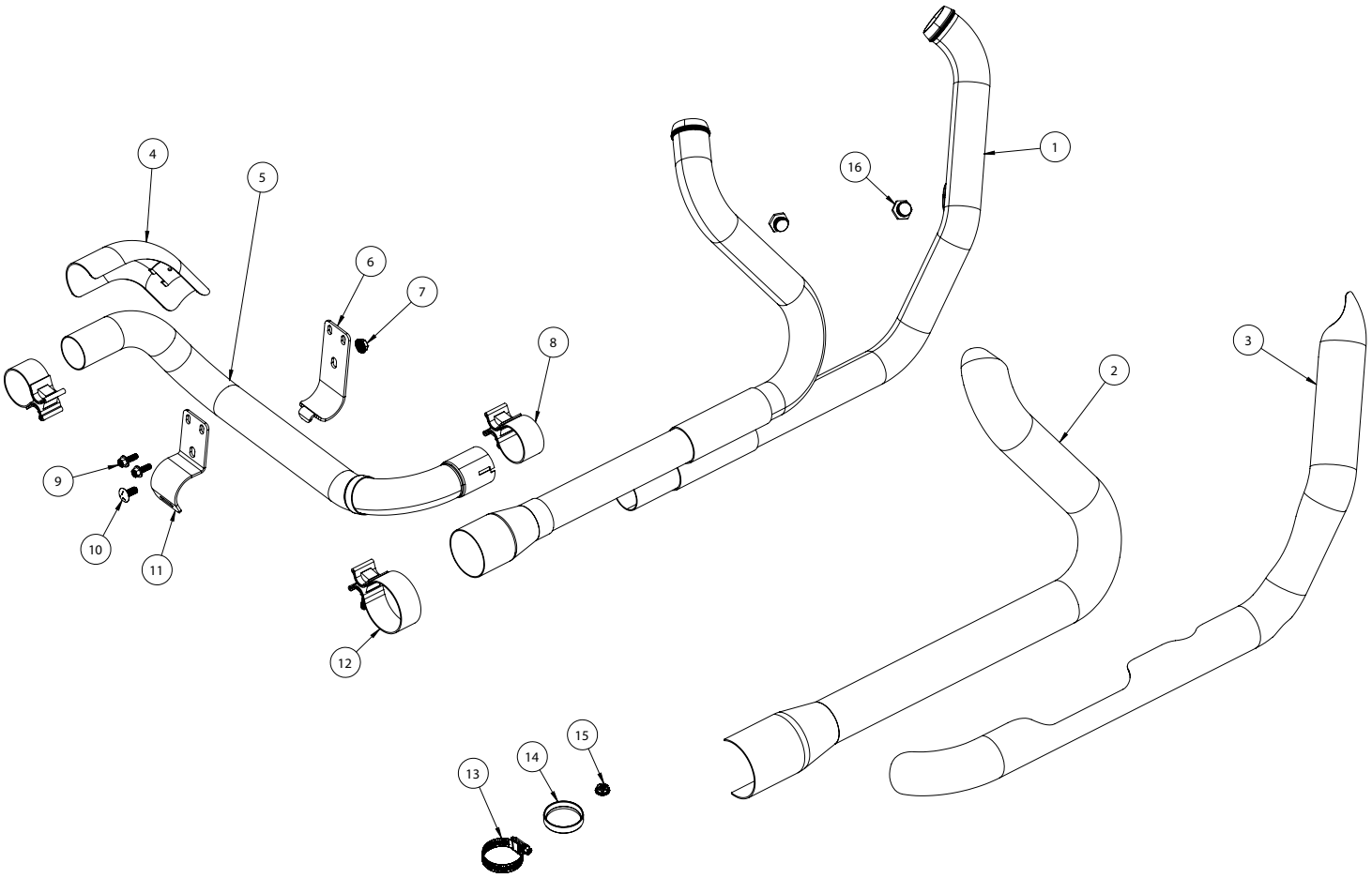
15. Position the crossover pipe under the oil pan and slide its expanded end onto the end of the front header pipe. Do not fully tighten the pipe clamp at this time.
16. Locate the ¼" socket head cap screws from Step 5, apply thread locking compound, and secure the crossover P-clamp to the back of the transmission. Torque screws to 100–120 in*lbs.
17. Locate the 5⁄16" bolts and muffler clamps from Step 2, apply thread locking compoundto the bolts and anti seize to the threads of the muffler clamps, install muffler clamps, and install the mufflers. Muffler rear brackets should align side to side and up and down with the saddle bag support rear mounting brackets without stress, adjustment of the crossover pipe slip joint may be necessary.
18. Align mufflers, making sure front to back and rotational alignment is equal. Tighten muffler exhaust clamps to 18 lb/ft. Tighten P-clamp carriage bolt to 18 lb./ft.
19. Tighten the pipe clamp on the crossover pipe. For proper seal, the clamp should slightly (~1⁄16") overhang the end of the expanded crossover pipe. Make sure the clamp does not contact the frame.
20. Tighten the flanged nut on the factory side clamp to 15 to 18 ft-lb.
21. Torque the port flange nuts evenly to 100-120 in-lbs. To ensure there are no leaks and the system is properly aligned the front and rear port nuts must be evenly torqued.
22. Insert worm gear clamps into slots on the back side of the heat shields. All clamp screws except the upper two on the rear shield should be positioned so the screw heads can be accessed from the front or bottom of the headers. Tip: Insert clamps halfway into the slots and bend the ends outward to ease installation over header pipes.
23. Install heat shields. For the rear shield it is helpful to start with the "bell" end of the shield, slipping it over the muffler clamp and header and then pivoting the shield into place. Connect and loosely tighten all worm gear clamps. Position screw heads for easiest access and tighten with a 5⁄16" nut driver or screwdriver. Adjust shields for best fitment and aesthetics and tighten clamps.

    Note - install the left heat shield so that the straight end is toward the muffler and the rounded end faces forward and down.

24. Reinstall front floorboard in lowest position.
25. Reconnect oxygen sensor electrical plugs.
26. Before operating motorcycle, clean pipes and mufflers with soap and water or window cleaner. Any grease or oil will permanently burn onto pipes. Dry thoroughly
27. Check all mounting hardware to be sure it is tight before and after first operation of motorcycle. Periodically, check tightness of all mounting hardware.

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.
- Cover ends of mufflers when washing motorcycle. Mufflers may internally corrode if saturated with water and allowed to sit.



1. Header, Assembly, Weldment
2. Heat Shield, Rear, 2 Into 2, 2017-Up M8 Touring, Fuel Moto
   A. Powder Coated, Black
   B. Chrome
3. Heat Shield, Front, 2 Into 2, 2017-Up M8 Touring
   A. Powder Coated, Black
   B. Chrome
4. Heat Shield, Left, 2 Into 2, Black, Touring
   A. Powder Coated, Black
   B. Chrome
5. Tube, Crossover, Weldment, M8 2017 Touring
6. Clamp, Exhaust, Male, Double Hole, 1.75" Diameter
7. Nut, HSFH, 5⁄16-18 UNC-2b X .283", Zinc, Steel
8. Clamp, Muffler, Band Style, 1.75" Diameter, 10mm X 38mm Bolt
9. Screw, HH, Flanged, Serrated, ¼-20 X ¾", Zinc Plated, Steel
10. Bolt, Carriage, 5⁄16-18 X ¾"
11. Clamp, Exhaust, Female, Double Hole, 1.75" Diameter
12. Clamp, Muffler, Band Style, 2.5"
13. Clamp, Hose, Worm Drive, Sae #20
14. Gasket,Exhaust,Tapered,Stainless Steel
15. Nut, HSFH, 5⁄16-24 UNF-2b X .283", Zinc, Steel
16. Plug, M18 X 1.5 Thread