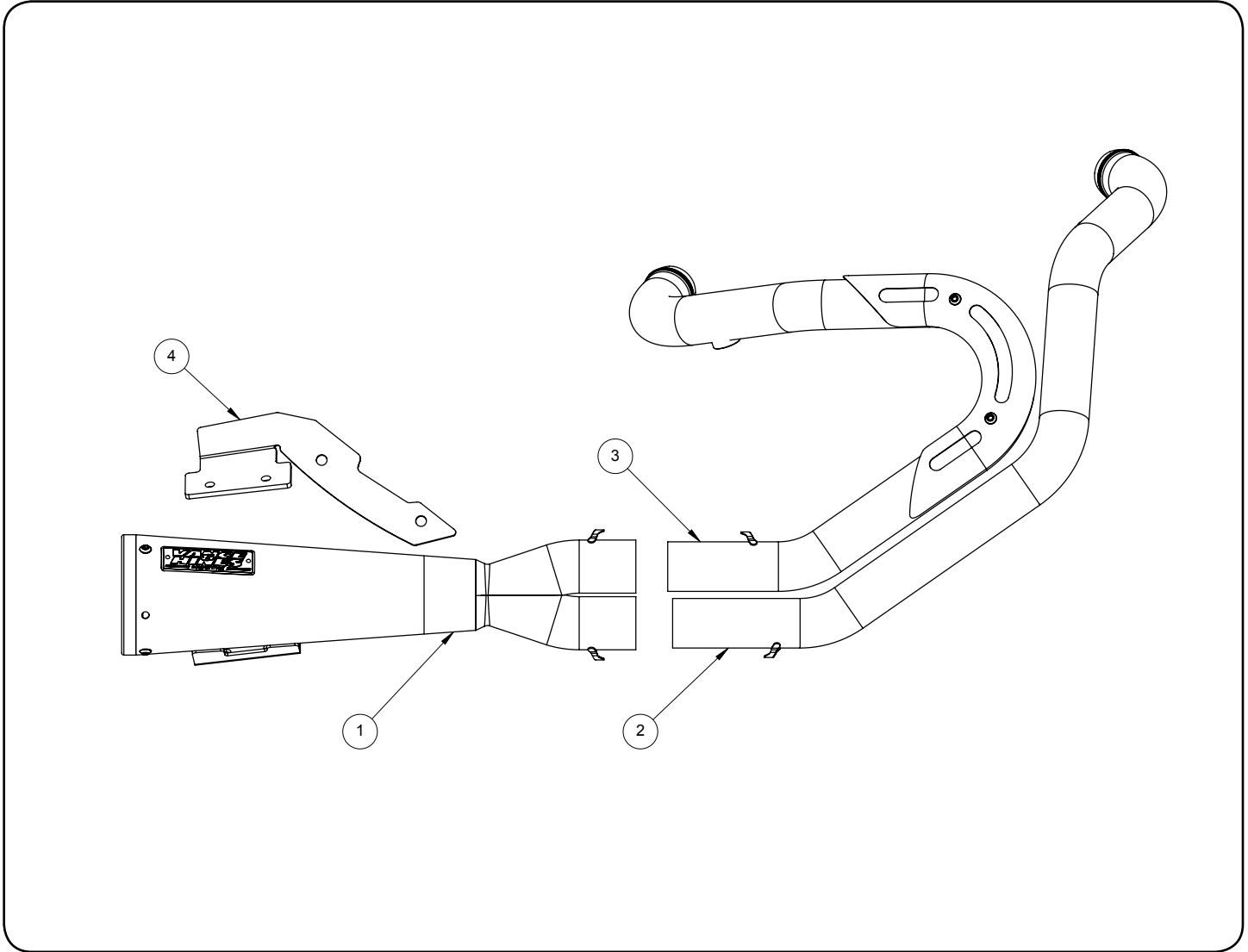


INSTALLATION INSTRUCTIONS: 2018 HARLEY-DAVIDSON SOFTAIL FAT BOB STAINLESS 2-1 PART# 27623

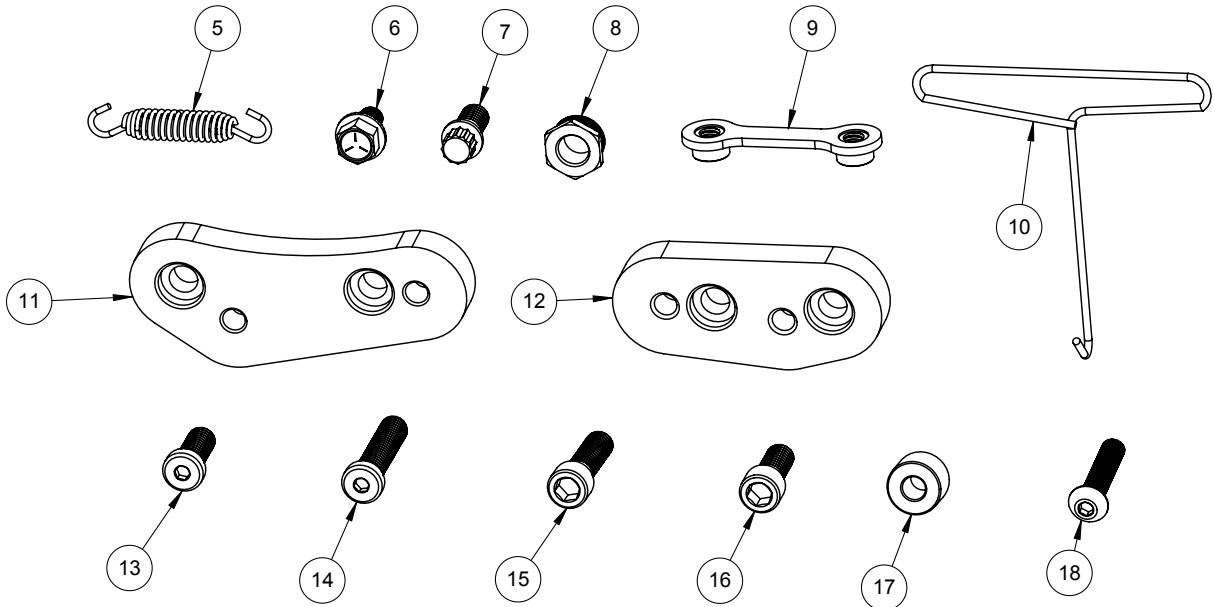
Congratulations, you have purchased the finest exhaust system available for your motorcycle. Your Vance & Hines exhaust is designed and crafted for performance, quality, and style. Please follow the instructions below, check exhaust system for missing or damaged parts and if you need any assistance please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



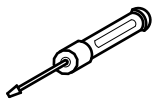
PARTS LIST

NO.	PART NO.	Description	Qty.
1	D370RB-S	MUFFLER CAN ASSY	1
2	D1120FB	FRONT HEAD PIPE	1
3	D1121FB	REAR HEAD PIPE	1
4	1167-P	BRACKET	1
5	A115SP	SPRING	2
6	A240HW	5/16"-18 X 5/8IN FHS	2
7	A742HW	3/8"-16 X 1.0 12PT SCREW	2
8	A644ST	18-12MM O2 ADAPTOR	2
9	A195HW	DOGBONE NUT PLATE	1
10	A260SP	SPRING PULLER	1
11	1164-P	RHS RELOCATOR	1
12	1168-P	LHS RELOCATOR	1
13	A908HW	3/8"-16 X 1IN SHCS	2
14	A909HW	3/8"-16 X 1.75IN SHCS	2
15	A912HW	3/8"-16 X 1-3/8IN SHCS	2
16	A914HW	3/8"-16 X 7/8IN SHCS	2
17	A868HW-P	.750 OD X .500IN SPACER	1
18	A874HW	5/16"-24 X 1.50IN BHCS	1

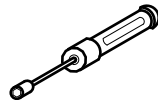
HARDWARE



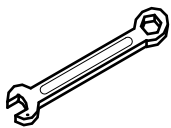
TOOLS REQUIRED



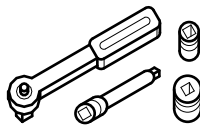
Flat Head Screwdriver



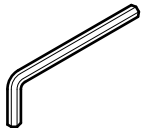
5/16 Nut Driver



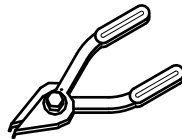
Combination Wrenches:
1/2", 9/16", 14mm,
19mm



3/8" Drive Ratchet w/ 4" extension
1/2", 9/16" Deep Sockets
1/4" Allen Socket
10mm, 19mm Socket



Allen Wrenches:
1/4", 5/32", 3/16", 5/16"
Torx: T45



Snap Ring Pliers

STOCK EXHAUST SYSTEM REMOVAL

- 1.** Locate the rear O2 sensor connector. Remove the two bolts holding the right side cover in place and gently pull cover off bike. NOTE: Pay attention to the wire routing for re-installation.
- 2.** Locate the front O2 sensor connector. Unplug the sensor and feed the end of the wire through the frame, freeing it from the motorcycle.
- 3.** On Floor board models, loosen the right-hand floor board mounting bolts to gain clearance for the exhaust removal and installation.
- 4.** On Mid Mount models, remove the forward brake rod bolt and remove the mid mount foot peg bracket.
- 5.** Loosen the heat shield clamps on both the front and rear exhaust pipes.
- 6.** Remove the two mounting nuts from each head pipe, located at the cylinder head.
- 7.** Remove the bolts attaching the mufflers to the mounting bracket.
- 8.** Remove the entire exhaust system and set it aside.
- 9.** Remove the stock mounting bracket.
- 10.** Carefully remove the exhaust port flanges and circlips from the stock exhaust system using the snap ring pliers. NOTE: Replace bent or damaged circlips.
- 11.** Carefully remove the O2 sensors from the stock head pipes and save for re-use with the new system.
- 12.** Check the condition of the exhaust gasket and replace if worn or damaged. Harley-Davidson part number 65324-83B.

VANCE & HINES EXHAUST INSTALLATION

NOTE: Use appropriate Harley-Davidson service manual procedures when referring to exhaust installation.

1. Position the mounting bracket 1167-P over the stock mounting bracket location. Attach the mounting bracket to the frame using the supplied 12pt ARP flange head bolt. Hand tighten only at this time **(Figure 1)**.
2. Remove head pipes from their protective packaging. Place each head pipe on a non-abrasive surface such as a blanket or carpet.
3. Install circlips and flanges from the stock system onto both the new head pipes.
4. Apply a small amount of anti-seize compound to the threads of the O2 sensors and install them into the new head pipe. Install supplied 18mm to 12mm oxygen sensor adapter then install 12mm oxygen sensors.
5. Install the front header assembly into the front exhaust port first. Use the stock flange nuts, do not tighten at this time.
6. Install the rear header assembly into the exhaust port. Use the stock flange nuts, do not tighten at this time. **(Figure 2)**.
7. Slide the dog bone nute plate onto the mounting bracket and slip muffler can onto front and rear head pipes. Hand tighten muffler can using supplied 5/16-18 flange head bolts **(Figure 3)**.
8. Tighten the exhaust system nut, bolts, and clamps in the following sequence: (1) Head flange nuts (x4), (2) Muffler body 5/16-18 flange head bolts, (3) Mounting bracket 3/8-16 12pt bolts(A742HW, x2) . Make sure the head pipes and mufflers are aligned parallel, and ensure proper & even spacing between cam cover and rear head pipe **(Figure 4)**.
9. Install springs using supplied spring puller; there should be about 2" between spring tabs **(Figure 5)**.
10. Route O2 sensor wires away from hot areas of the motorcycle. Plug the O2 sensor wires back into the wiring.
11. Steps 12- 17 are for mid mount models, where the mid control spacer kit is required.
12. Install right hand side relocater (1164-P) using 3/8-16 X 1.75IN (A909HW, x2) **(Figure 6)**.
13. Loosely install mid control using using 3/8-16 X 7/8IN SHCS (A914HW, x2) **(Figure 7)**.
14. Install spacer (A868HW-P) and attach brake rod using 5/16-24 X 1.50IN BHCS (A874HW) **(Figure 8)**.
15. Fully tighten hardware from step 13.
16. Install left hand side relocater (1168-P) using 3/8-16 X 1IN (A908HW, x2) **(Figure 9)**.
17. Install mid control using 3/8-16 X 1-3/8IN SHCS (A912HW, x2).
18. Be sure to tighten all hardware before starting motorcycle. After installation and before starting the motorcycle, completely clean pipes and mufflers with soapy water and a clean soft cloth. NOTE: Any residue, oil, or fingerprints will stain the finish when the metal heats up.

FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4



FIGURE 5

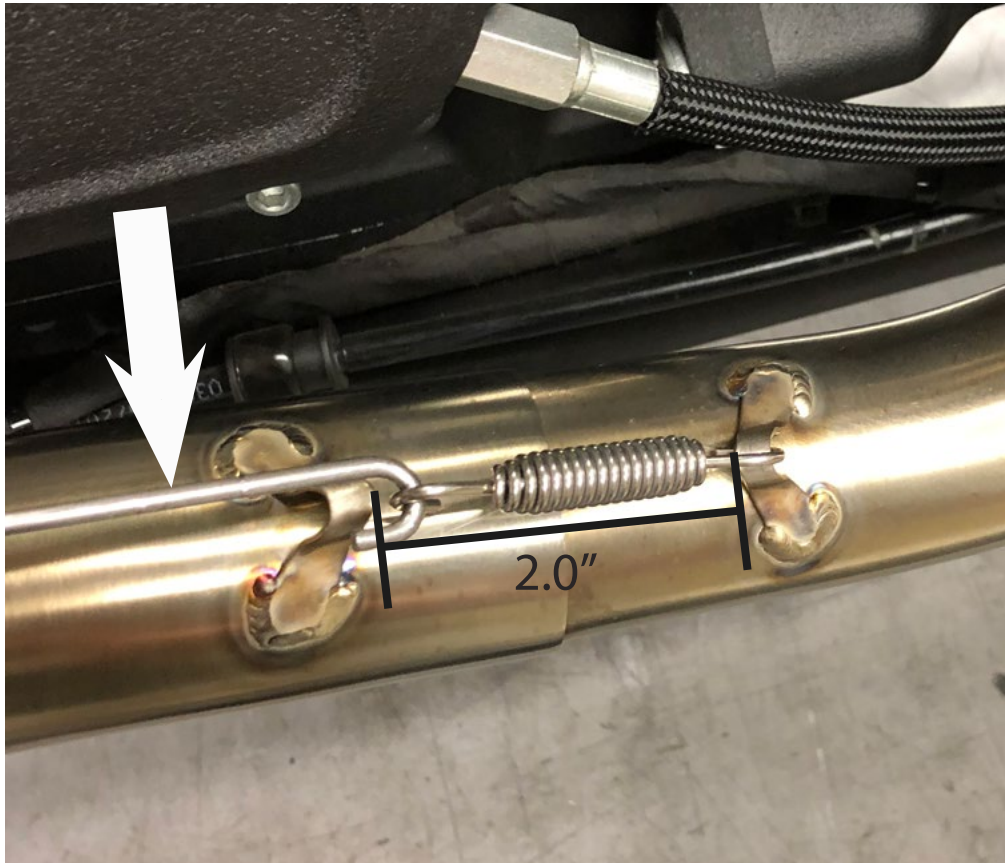


FIGURE 6

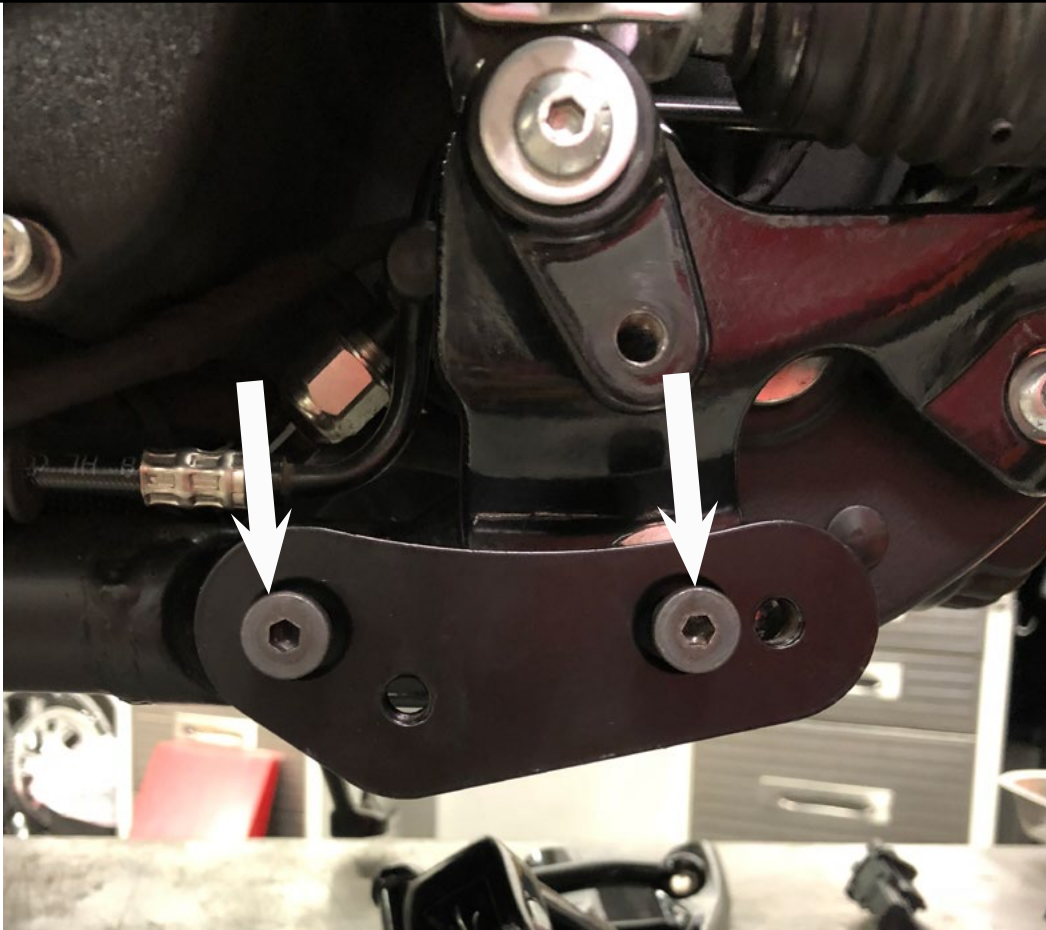


FIGURE 7



FIGURE 8

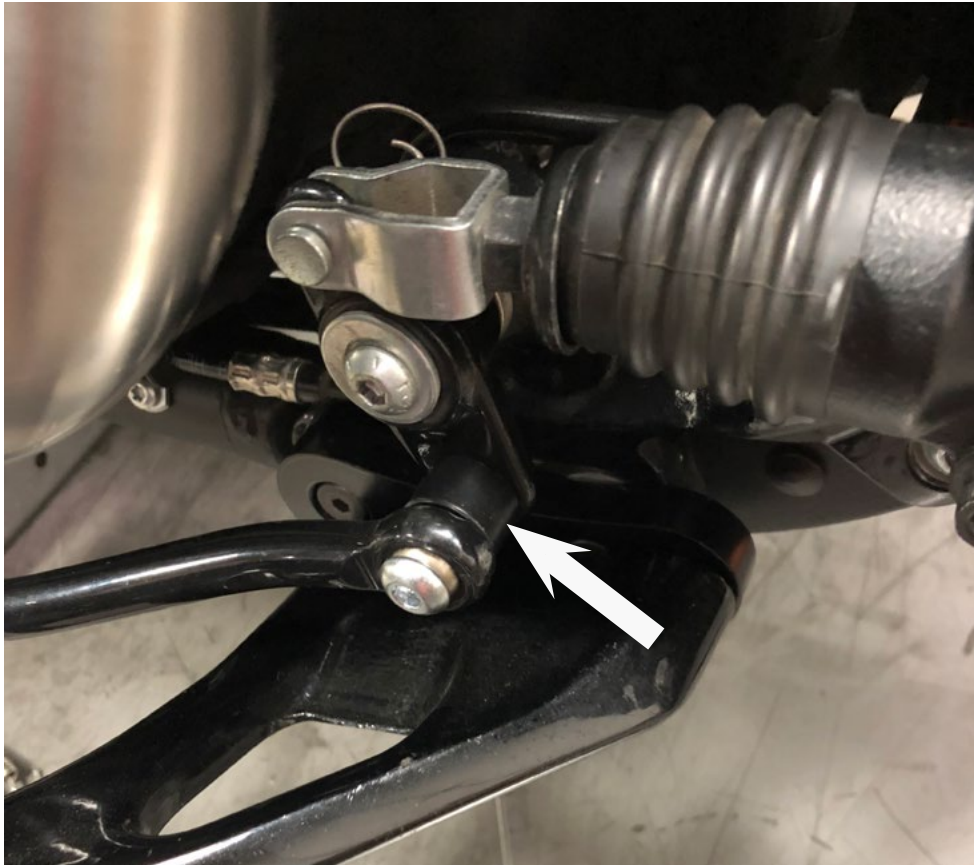


FIGURE 9



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.

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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