

SERVICE BULLETIN



M-1235

December 04, 2008

XR1200 EXHAUST INSTALLATION

Purpose

This service bulletin is to inform dealers of an update to the exhaust installation procedure on XR1200 models. The new procedure is designed to prevent exhaust contact with the drive belt idler pulley and to allow sufficient clearance for proper operation of the rear brake pedal.

Motorcycles Affected

All 2008 and 2009 XR1200 models.

Required Dealer Action

Photocopy following page and replace existing XR1200 exhaust INSTALLATION text in the 2008 and 2009 SPORTSTER SERVICE MANUALS with text from this bulletin. Use the following updated torque procedure when installing the exhaust system on all XR1200 models.

IMPORTANT NOTE

In the interest of preserving customer safety and satisfaction, always check for outstanding recalls whenever any motorcycle is brought into your dealership for either maintenance or service.

ROUTING	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	WARRANTY PROCESS MANAGER	LEAD TECHNICIAN	TECHNICIAN NO.1	TECHNICIAN NO. 2	TECHNICIAN NO. 3	RETURN THIS TO
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INSTALLATION

Header pipes

1. See Figure 4-72. If removed, install flanges (15) and retaining rings (13).
2. If removed, install rear mount (22), front mount (7), and interconnect bracket (11).
 - a. Tighten fasteners (2) to 15-20 ft-lbs (20.3-27.1 Nm).
 - b. Tighten fasteners (6) to 45-50 ft-lbs (61.0-67.8 Nm).
 - c. Tighten fasteners (10) to 30-33 ft-lbs (40.7-44.7 Nm).

NOTE

Use care not to damage exhaust port gaskets (14) when positioning header pipes in exhaust port area.

3. Install **new** exhaust port gaskets (14).
4. Place head pipe assembly in position and loosely secure lower clamp (18) with carriage bolt (16) and flange nut (17).
5. Install flanges (15) and secure with nuts (12) finger tight. Do not tighten until mufflers are installed.
6. Install mufflers.

Mufflers

1. Place lower muffler (20) on header pipe. Rotate until rear mount fastener (1) can be installed. Loosely install fastener (1).
2. Place upper muffler (21) on header pipe.
3. Install muffler-to-muffler bolts (23) finger tight.
4. Install grommets (5), sleeve (9), fastener (3), washer (4) and washer nut (8). Tighten assembly finger tight.
5. Tighten the exhaust flange nuts (12) in the following sequence:
 - a. Tighten the front exhaust pipe lower exhaust flange nut to 96-120 **in-lbs** (10.8-13.6 Nm).
 - b. Tighten the front exhaust pipe upper exhaust flange nut to 96-120 **in-lbs** (10.8-13.6 Nm).
 - c. Tighten the rear exhaust pipe lower exhaust flange nut to 96-120 **in-lbs** (10.8-13.6 Nm).
 - d. Tighten the rear exhaust pipe upper exhaust flange nut to 96-120 **in-lbs** (10.8-13.6 Nm).
6. Verify the exhaust header pipes do not contact the drive belt idler pulley and that there is sufficient clearance for proper operation of the rear brake pedal. Tighten nut (17) to 30-33 ft-lbs (40.7-44.7 Nm).
7. Tighten fastener (3) to 120-180 **in-lbs** (16.9-20.3 Nm).
8. Tighten muffler-to-muffler bolts (23) to 120-180 **in-lbs** (16.9-20.3 Nm).
9. Tighten rear mount fastener (1) to 120-180 **in-lbs** (16.9-20.3 Nm).
10. Install heat shields.
11. Install and connect the O2 sensors. See 4.14 OXYGEN SENSOR.