

SERVICE BULLETIN

Buell[®]
AMERICAN MOTORCYCLES

B-034

November 1, 2000

RECALL CAMPAIGN 0821 - RACE MUFFLER RETENTION KIT

GENERAL

Buell Motorcycle Company has learned that certain Buell Pro Series Race Systems contain a muffler that could break. This condition could allow the muffler to drag on the ground, which may adversely affect handling and could cause an accident. Accordingly, Buell Motorcycle Company is voluntarily conducting a recall campaign to formally recall all potentially affected mufflers.

This condition will be remedied by installing the race muffler retention recall kit on all potentially affected vehicles.

VEHICLES INVOLVED

This campaign involves all domestic and international model Buell motorcycles equipped with Buell Pro Race System mufflers (Part No. 65398-96Y and S2110.GA) which are contained in the following kits:

- Part No. 65398-96YA
- Part No. 91424-99Y
- Part No. 82000-96Y
- Part No. 82000-99Y
- Part No. 82001-99Y
- Part No. 82002-99Y

For instructions on handling existing inventory, see CREDIT PROCEDURES - DEALER STOCK PARTS.

DEALER ACTION

DO NOT SELL ANY RACE MUFFLER KITS YOU MAY HAVE IN STOCK. Furthermore, if any of these race muffler kits were installed by you or your customers, please advise the customer to schedule and have the recall service performed as soon as possible.

Because Buell Distribution Corporation has no record of who may have purchased/received these kits at the retail level, it is your responsibility to notify each of your customers. Buell Distribution Corporation will send you a sufficient supply of owner notification letters to assist you with the notification process. Since the recall involves parts and not a vehicle on record, your SPOC representative and/or the Recall Information Line, TALON and hd-net.com will NOT be able to assist you.

Recall kits will be available on or before October 31, 2000 and **must be ordered. There will be no wave shipments.** All kits will be shipped no charge, transportation paid. To order kits, please fill out the attached order form and send/fax it to the Warranty Department at (FAX) 414-343-8346.

The Race Muffler Retention Recall Kit (Part Number 94002Y) consists of:

- Retention Cable
- Clamp
- (2) Washers
- Socket Head Screw, 1/4-20 x 2 in.
- Hex Nut, 1/4-20
- Rivet, Stainless Steel

INSTALLATION

IMPORTANT NOTE

The kit installs with muffler left in place. Do NOT remove the muffler to install the retention kit.

1. Secure motorcycle on a suitable lift.

WARNING

To protect against shock and accidental start-up of vehicle, disconnect the negative battery cable before proceeding. Inadequate safety precautions could result in death or serious injury.

2. Disconnect negative battery cable from battery terminal.
3. See Figure 1. Using a Scotch-Brite pad, thoroughly clean front portion of muffler where clamp will be installed.
4. Inspect muffler for cracks or damage at inlet. **If muffler is cracked or damaged, STOP! Contact XL/Buell Technical Service at telephone (414) 343-4887.** You will be given a unique credit procedure, instructions and appropriate parts will be expedited to you, or available for you to order.
5. See Figure 2. Remove front allen screw on left lower side of the primary cover. Install retention cable eyelet with front allen screw finger tight. NOTE: On X1 models or models equipped with chin fairings, remove spacer between chin fairing and primary cover.
6. See Figure 2. Position **new** clamp on front of muffler so clamp hardware will be located on outboard side.
7. See Figure 1. Install **new** socket head screw and washer from bottom through unthreaded clamp half. Position retention cable wire loop between two clamp halves and finish installing socket head screw through wire loop and the threaded clamp half. NOTE: When properly installed, there should be no tension on the cable.
8. See Figure 1. Tighten clamp screw to 10-12 ft-lbs (14-16 Nm).

ROUTING	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	LEAD TECHNICIAN	TECHNICIAN NO. 1	TECHNICIAN NO. 2	TECHNICIAN NO. 3	TECHNICIAN NO. 4	RETURN THIS TO:
INITIAL HERE									

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9. Remove front allen screw and retention cable eyelet from primary cover to allow access for performing steps 10-13.
10. See Figure 2. Install hex nut and washer to clamp screw and tighten nut.

NOTE

The pre-drilled hole in the clamp may be used as a guide when performing steps 11 and 12.

11. Using a center punch, dimple the muffler at the center of the pre-drilled clamp hole at the 2 o'clock position.
12. See Figure 2. Using a #11 drill bit (0.190 in.), drill through the muffler at the 2 o'clock position.
13. Using a pop rivet gun, install rivet provided in kit to locate clamp on muffler.
14. See Figure 2. Install retention cable eyelet to primary cover with allen screw. On X1 models or models equipped with chin fairings, remove 0.120 in (3 mm) of material from inboard (non-stepped) side of spacer with a lathe or file. Reinsert spacer between eyelet and chin fairing, stepped side outboard. Eyelet will be located between the primary cover and the spacer. Tighten allen screw to 100-120 **in-lbs** (11-14 Nm).
15. Connect negative battery cable to negative battery terminal. Tighten to Service Manual specifications.
16. See CREDIT PROCEDURE.

CREDIT PROCEDURE- VEHICLE REPAIR (INSTALLING RETENTION KIT ONLY)

Because this is a P&A recall, no electronic claims can be accepted at this time. A paper claim form (Part No. 99520-95Y) must be used. You must provide a VIN (Vehicle Identification Number) and a separate claim form for each vehicle serviced. Reference Service Bulletin B-034 in the "Description of Repair" section of the claim. Fill in the rest of the claim as follows:

Table 1. Recall 0821

Claim Type	BPI
Quantity	0
Event 1, Problem Part No.	94002Y
Part Description	Retention Kit
Time (includes 0.1 hr admin time):	0.5 hrs
Primary Labor Code	2640
Customer Concern Code	0821
Condition Code	9205

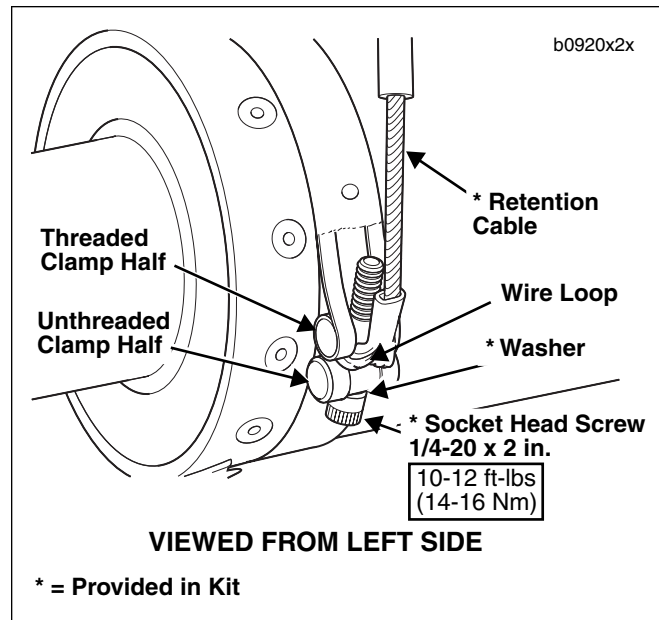


Figure 1. Installing Retention Cable and Clamp

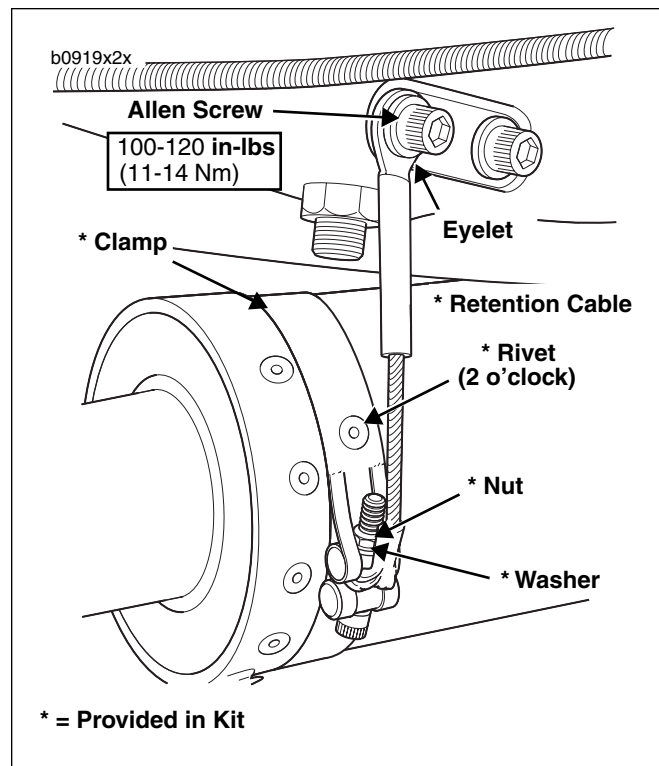


Figure 2. Retention Cable Installed

CREDIT PROCEDURES - DEALER STOCK PARTS

To receive credit, complete a warranty claim form (Part No. 99520-95Y) referencing Service Bulletin B-034 in the "Description of Repair" section. Fill in the rest of the claim as follows.

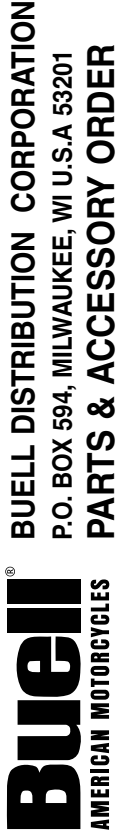
Table 2. Credit for Parts

Claim Type	BRS
Quantity	See Note Below
Problem Part No.	65398-96YA 91424-99Y 82000-96Y 82000-99Y 82001-99Y 82002-99Y
Part Description	Pro Race System Muffler/ Kits
Customer Concern Code	0821
Condition Code	9205

NOTE

"Quantity" and "Problem Part No." may vary depending upon what you have in stock.

Upon receipt of properly completed claim form, you will receive a bar coded warranty part return label. You will be required to return the kits in order to receive the appropriate credit for the parts. Upon receipt of the parts, you will receive the appropriate credit for parts and return postage.



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NAME _____

ADDRESS _____

T
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CITY/STATE/ZIP _____

S H - P T O

TYPE CODE	ORDER TYPE	VEHICLE IDENTIFICATION NUMBER
R	REGULAR	
P	POLICE	
D	DOWN VEHICLE	
W	WARRANTY	

FOR OFFICE USE ONLY
ACCT: 111-632.4
FRT: 111-632.4 ACCT:

[illegible]

ALL ORDERS SUBJECT TO ACCEPTANCE AT MILWAUKEE. WI 53201

All goods covered by this order, including goods back-ordered, will be billed at prices current at the time of shipment. Goods are purchased for resale and delivery is made to purchaser F.O.B. factory, Milwaukee, Wisconsin or other point of origin. If accepted this order as accepted shall be subject to availability of goods to seller for delivery to purchaser. Any delay in shipment shall not relieve purchaser of responsibility for the accepted order and seller shall not be liable for any loss or damage due to delay in shipment or failure to deliver. Any request for cancellation of this order or any part thereof must be received by seller prior to the time of shipment, and in case of reacceptance or return of goods to seller, purchaser shall pay the entire cost connected therewith, plus ten or twenty-five percent of selling price, as determined by Company policy from time to time. Purchases will be responsible for collection and payment of all Federal, State and local taxes that apply on the sale of goods.

PLEASE USE PART NUMBERS

DO NOT USE FOR

CORRESPONDENCE

F-1040

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