



# INSTRUCTIONS

-J00979

REV. 8-1-94

Kit Number 68061-94B

## HEADLAMP HOUSING KIT

### General

The XLH Headlamp Housing Kit, HD Part No. 68061-94B, is designed for use on all 1994 and later XLH model vehicles. The kit contains the following items:

QTY	DESCRIPTION
1	Headlamp housing
1	Strain Relief grommet

#### ⚠WARNING

Do not modify ignition wiring to permit motorcycle operation with headlamp off. Operation without headlamp reduces your visibility to other motorists and may lead to an accident resulting in personal injury and/or property damage.

### Disassembly

#### ⚠WARNING

To protect against shock and accidental start-up of vehicle, disconnect the battery cables before proceeding.

#### ⚠WARNING

Always disconnect the negative battery cable first. If the positive cable contacts ground with the negative cable installed, sparks may cause a battery explosion resulting in serious personal injury and/or property damage.

1. Disconnect battery cables, negative cable first.
2. See Figure 1. Remove snap plug at top of headlamp bracket. Remove headlamp clamp nut, lockwasher and rounded washer to detach headlamp housing assembly from headlamp bracket.
3. See Figure 2. Remove screw and outer band clamp. Remove screw and inner band clamp. Pull headlamp assembly from rubber molding.
4. See Figure 3. Firmly depress lock release tabs on left and right sides of 3-place headlamp connector. While holding both lock release tabs down, carefully pull headlamp connector from male spade terminals on bulb.
5. See Figure 4. Pull rubber grommet from 1-3/4 inch diameter hole centered at back of headlamp housing.
6. Note the black and gray 12-place Deutsch connectors inside the headlamp housing. Holding the black connector, simultaneously depress the two external latches and use a rocking motion to separate pin and socket halves. Separate pin and socket halves of gray connector in the same manner.

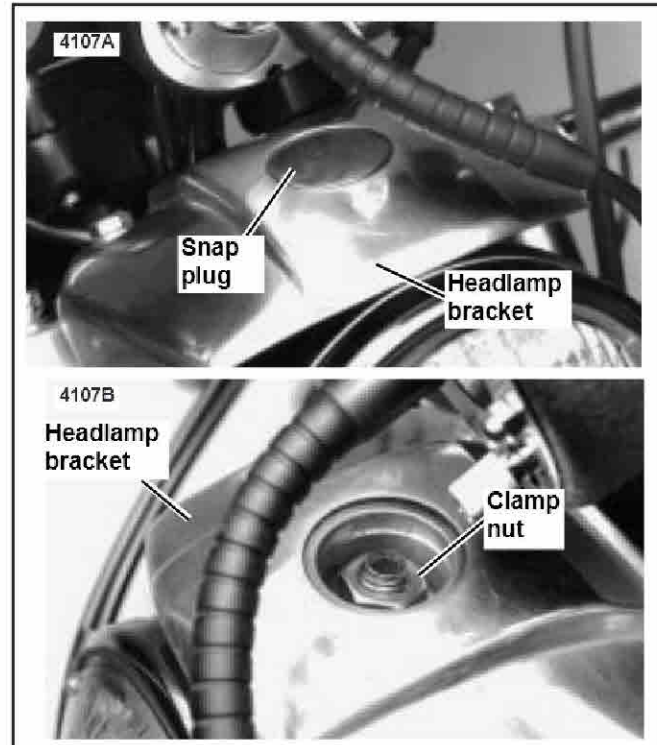


Figure 1. Detach Headlamp From Bracket

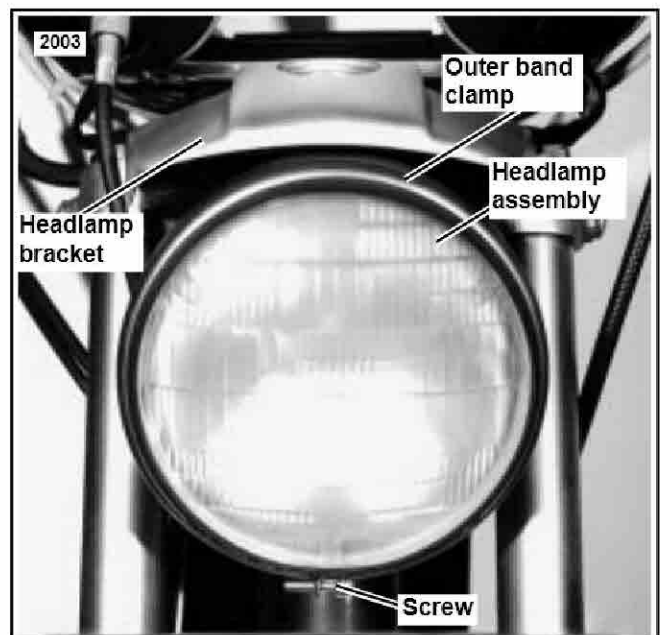


Figure 2. Headlamp Assembly

7. Feed the socket housings of both connectors through the 1-3/4 inch diameter hole centered at the back of the headlamp housing.
8. See Figure 5. Remove the secondary locking wedge from the pin housing of the black connector. Use a pick or the hooked end of a stiff piece of mechanics wire.
9. See Figure 6. Gently depress the terminal latches inside the pin housing and remove pin terminals through holes in wire seal. Leave the seal pins (or plugs) in place. Set the pin housing aside.

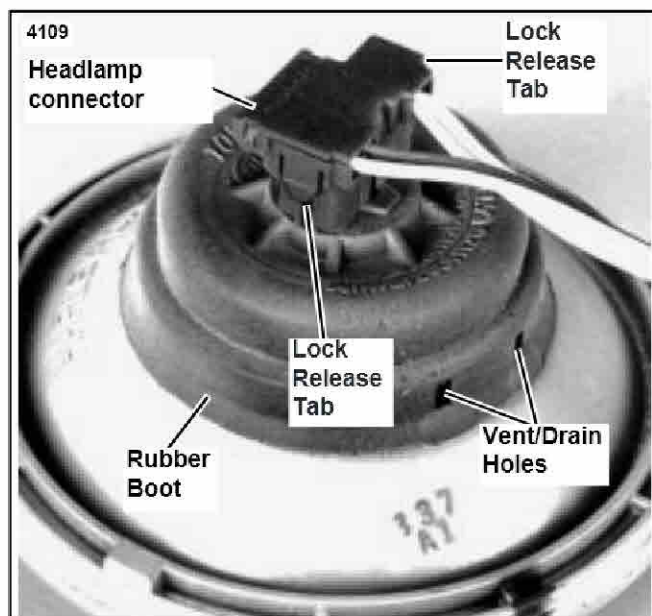


Figure 3. Remove Headlamp Connector From Bulb Assembly

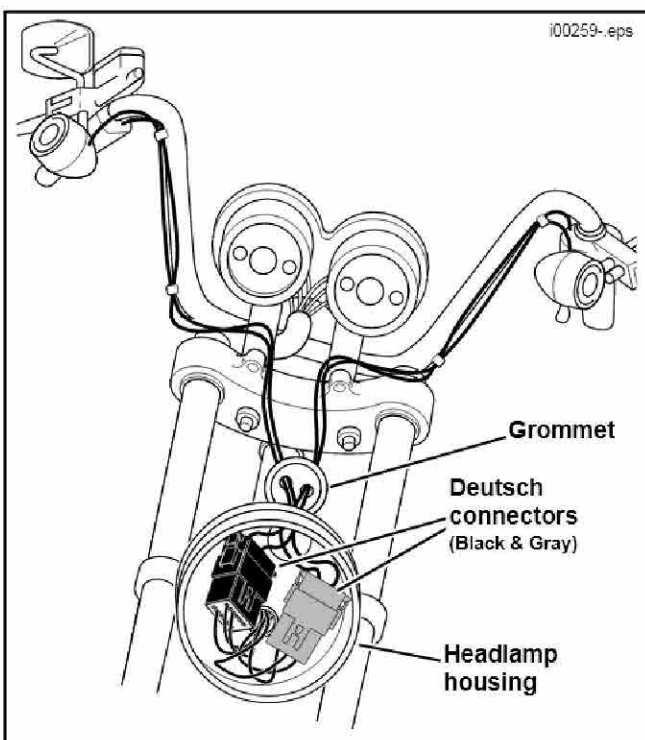


Figure 4. Headlamp Deutsch Connector Location

10. Wrap a piece of masking tape around all pin terminal wires so that they can be distinguished from the wires of the gray Deutsch connector (when both are disassembled).
11. Repeat steps 8 through 10 to remove the pin terminals from the gray Deutsch connector.
12. See Figure 7. Unsnap the three external latches and open the cover of the 3-place headlamp connector.
13. Insert a slightly parted needle nose pliers into the headlamp connector chamber and grasp the metal tang of the black wire spade terminal. While depressing the double headlamp connector tangs with side of pliers, pull the spade terminal out of the headlamp connector chamber. Repeat the procedure to remove the white wire spade terminal. Set the headlamp connector aside.
14. From inside the headlamp housing, push on the strain relief grommet in smaller diameter hole until it pops out the back side. Feed all wires back through the hole to empty the headlamp housing. Remove and discard strain relief bushing.

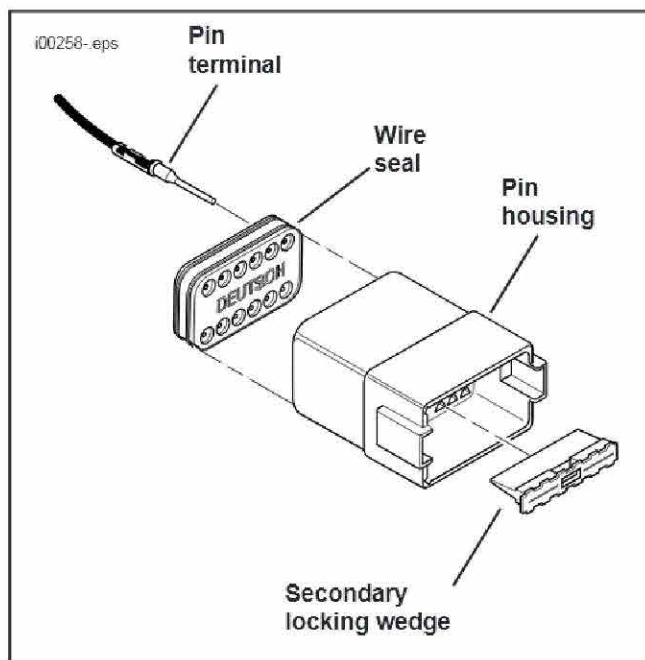


Figure 5. 12-Place Deutsch Connector (Pin Side)

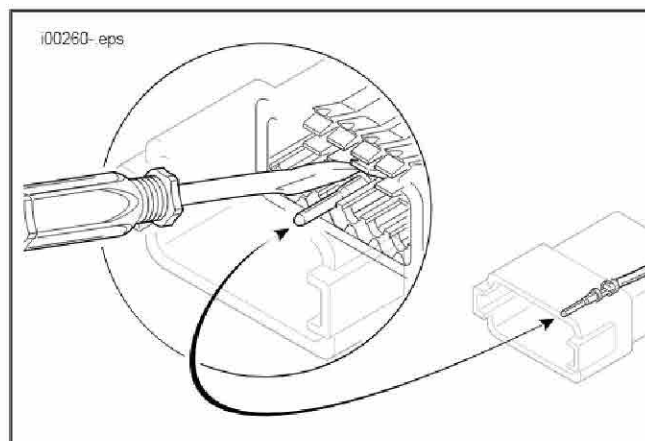


Figure 6. Depress Terminal Latches and Remove Pins



15. On 1994 models; from inside headlamp housing, use the needle nose pliers to compress the ends of the speedometer cable retainer. With the ends compressed, push the clip toward the outside to remove from housing. Do not discard the retainer or the rubber washer.
16. Remove headlamp housing from motorcycle. Remove rubber molding from outer rim.
17. On early 1994 models, slide back cable conduit (in the area of the strain relief grommet removed from the smaller diameter hole in the headlamp housing) and remove packing material. Reinstall conduit.

### Pre-assembly - 1994 Vehicles

On 1994 vehicles you will have to drill a 1/4 in. hole in the left side of the headlamp housing for the speedometer cable retaining clip.

1. See Service Parts Illustration. Place a 2 in. square piece of masking tape half way down the LEFT side of the headlamp housing.
2. Measure 2-5/8 in. down from the top of the housing. Draw a horizontal line on the tape, at 2-5/8 in.
3. Measure 13/16 in. from the front of the housing to the rear, near the horizontal line. Draw a vertical line on the tape, so it intersects the horizontal line.
4. Use a center punch and make a small indentation at the point where the two lines intersect on the tape.
5. Use a 1/16 in. drill bit and drill a starter hole through the indentation. Use a 1/4 in. drill bit and drill the finished hole. Remove tape.

6. Use fine emory cloth and carefully clean the hole's rough edges. Apply black touch-up paint to edge of hole.
7. Install the grommet.

### Assembly

1. Fitting square rubber peg on ID of rubber molding into notch in rim of new headlamp housing, work molding onto housing. Fitting front edge of inner band clamp into rear groove of rubber molding, install clamp orienting screw 180 degrees from mounting bolt. Snug band clamp screw.
2. Feed all pin terminal wires through smaller diameter hole at back of headlamp housing. Wrap new strain relief bushing around cable conduit at back of headlamp housing with smaller OD facing housing. Insert smaller OD end into hole in housing until external surface of housing contacts bushing shoulder.
3. With seal pins occupying positions 1, 2 and 12, fit wire seal into back of black pin housing (see Figure 5).

#### NOTE

Remove masking tape previously wrapped around wire bundle of black Deutsch connector.

4. Grasp crimped pin approximately 1 inch (25.4 mm) behind contact barrel. Gently push pins through holes in wire seal into their respective numbered chambers (see Figure 8 for wire color locations). Feed pin into chamber until it "clicks" in place. Verify that pin will not back out of chamber; a slight tug on the wire will confirm that it is properly locked in place.

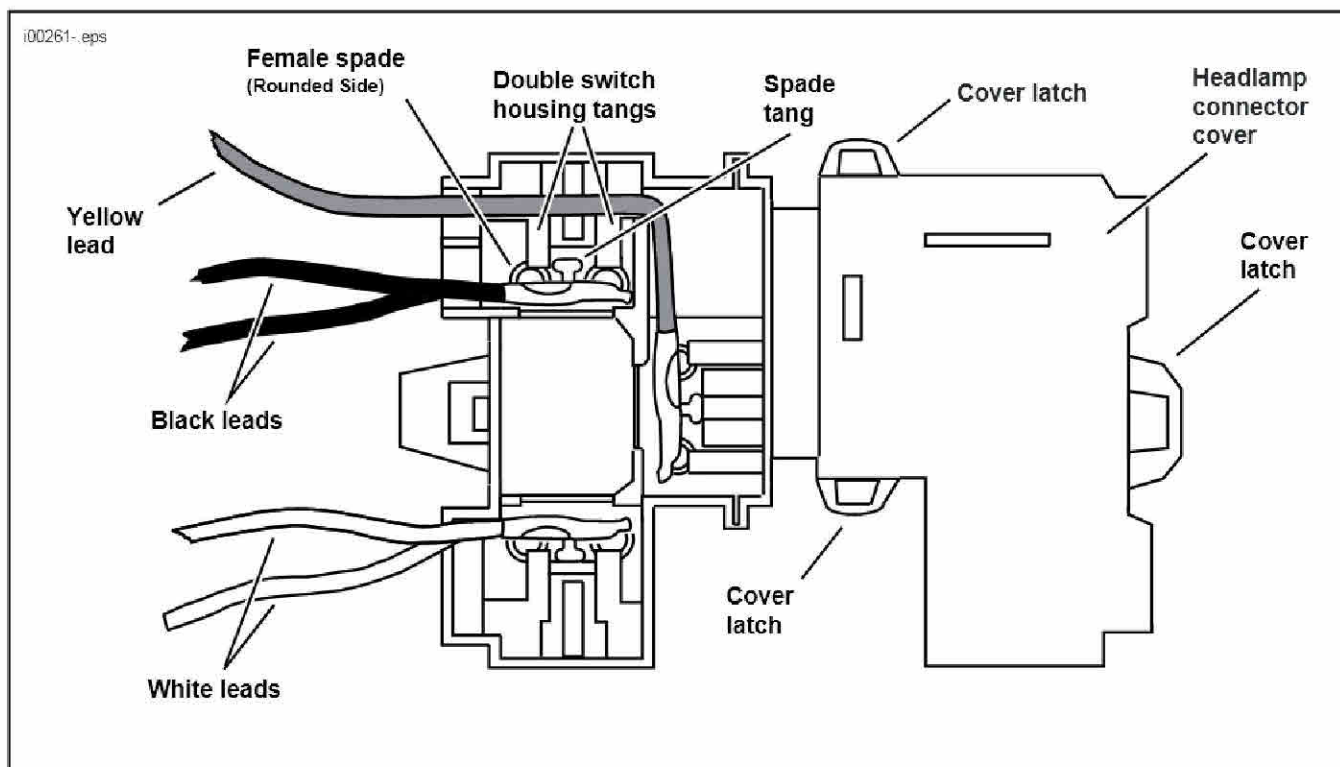


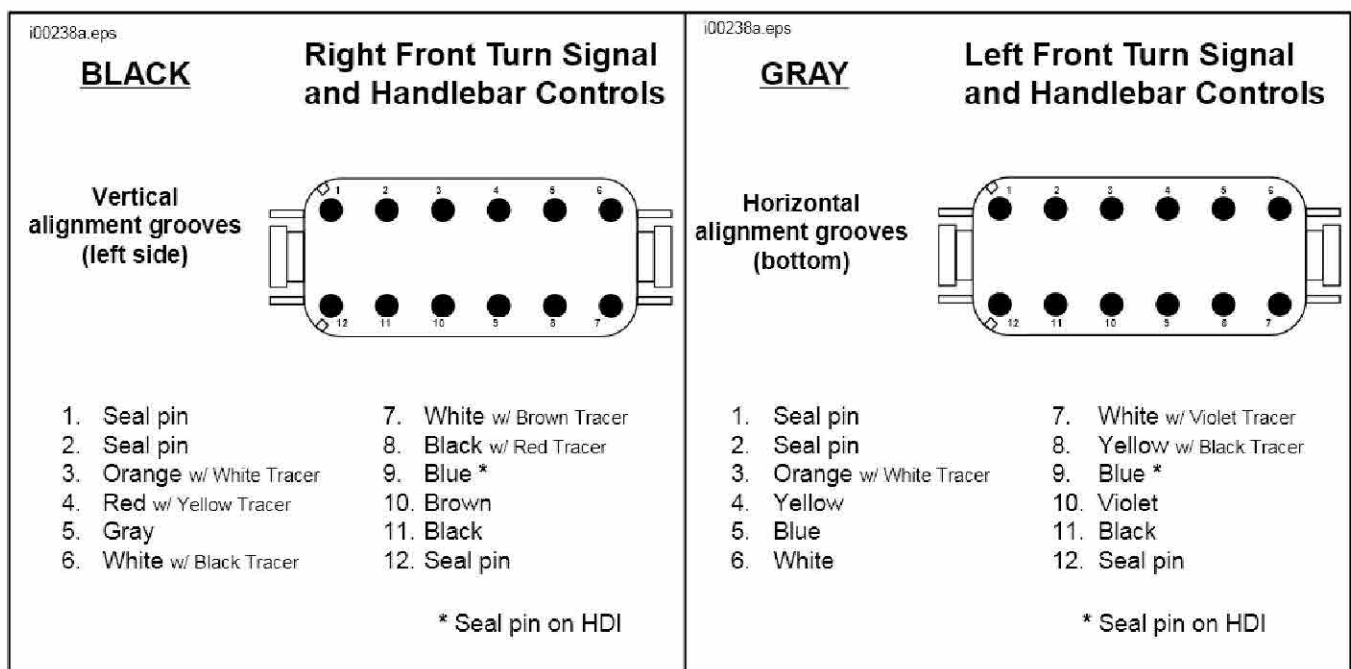
Figure 7. 3-Place Headlamp Connector

5. See Figure 5. Insert tapered end of secondary locking wedge into pin housing and press down until it snaps in place. The wedge fits in the center groove within the pin housing and holds the terminal latches tightly closed.
6. Feed black and gray socket halves of Deutsch connectors through 1-3/4 inch diameter hole centered at back of headlamp housing. Fit grommet into hole so that housing occupies slot between front and rear flats.
7. See Figure 8. Align the tabs on the socket housing with the grooves on the pin housing. Push the connector halves together until the latches "click." If latches do not click (latch), press on one side of the connector until that latch engages, then press on the opposite side to engage the other latch.
8. Install right hand female spade type terminals into 3-place headlamp connector. Insert rounded side of female spade terminal into chamber, so that it faces the double tang in the headlamp connector (see Figure 7 for wire color locations). Feed the spade terminal into the chamber until it "clicks" in place. Verify that the terminal will not back out; a slight tug on the wire will confirm that it is properly locked.
9. Repeat steps 4 through 7 to assemble gray Deutsch connector.
10. See Figure 4. Position 12-place Deutsch connectors at the back of the headlamp housing. Place the gray connector on the left side, the black connector on the right.
11. Slide the 3-place headlamp connector onto the male spade contacts at the back of the headlamp bulb.
12. See Figure 3. With the vent/drain holes on rubber boot positioned at the bottom, push bulb into headlamp housing. Move bulb within housing, so that rubber molding is evenly distributed around the face of the bulb.
13. Fitting edge of front band clamp into groove of rubber molding, install clamp orienting screw so that it is parallel to the inner band clamp screw (180 degrees from mounting bolt). Snug outer band clamp screw.
14. Slide bolt of headlamp housing through slot in headlamp bracket. (Position 12-place Deutsch connector to indicator lamps/speedometer/tachometer beneath bracket at back of headlamp housing assembly.) Install rounded washer over bolt end with flat side up. Install lockwasher and snug clamp nut.

**⚠WARNING**

Always connect the positive battery cable first. If the positive cable should contact ground with the negative cable installed, sparks may cause a battery explosion resulting in serious personal injury and/or property damage.

15. Connect battery cables, positive cable first.
16. Turn the Ignition switch to ON and verify proper headlamp operation. Align headlamp as described under LAMPS, ADJUSTMENT, HEADLAMP in the XLH Service Manual.
17. See Figure 1. Tighten clamp nut to 10-20 ft-lbs (14-27 Nm). Install snap plug at top of headlamp bracket.
18. On early 1994 models, insert ends of speedometer cable retainer into rubber washer and small hole on left side of headlamp housing. Retainer will snap into place when fully installed.



**Figure 8. 12-Place Deutsch Electrical Connectors - Wire Colors (Pin Receptacle Side)**



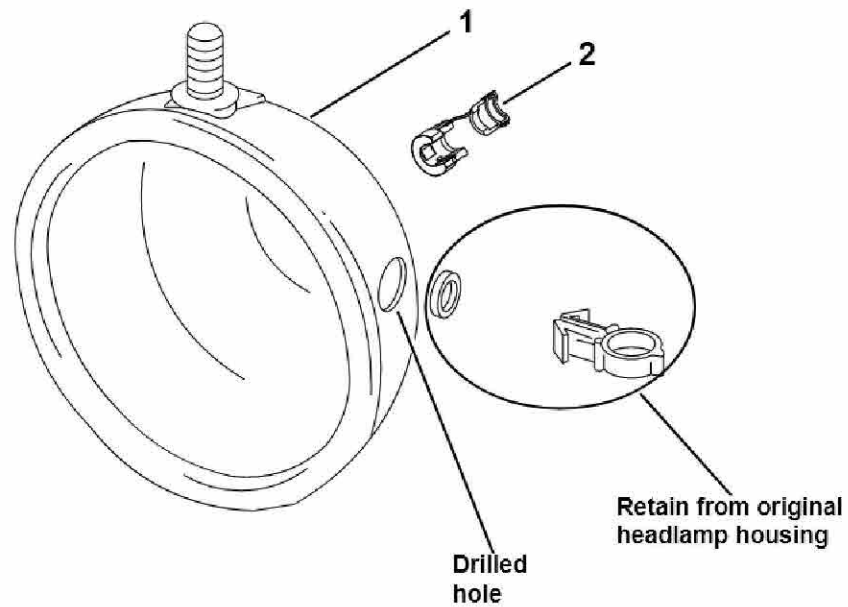
# Service Parts

Part No. 68061-94B

Date 8/94

Headlamp Housing - XLH

sp6601



ITEM	DESCRIPTION	PART NO.
1	Headlamp housing	(Not sold separately)
2	Grommet, strain relief	72507-94