



FEULING

M-EIGHT TOURING ANTI REVERSION EXHAUST INSTRUCTIONS

FEULING ANTI-REVERSION EXHAUST with AR CHAMBERS and DOGBALL MUFFLERS

Hand Crafted Stainless, Tuned Length 2 into 1 exhaust system for Milwaukee Eight touring models. FEULING Exhaust Systems are custom, made to order, hand tig welded, hand brushed finished and or hand polished for a show finish.

Removable perforated stepped muffler baffle with Feuling dogball insert, wrapped with stainless mat then fiberglass packing, finished with a highflow billet end cap tapered on the inside for optimal flow and sound. Exhaust comes standard with 18mm O2 bungs and reducer fittings for OEM style 12mm O2 sensors.

Made in the USA

INSTRUCTIONS

1. To avoid scratching, mask off the upper portion of each exhaust port before installing flanges and locking clips. Then slide flanges onto exhaust.

'17-'24 Touring Models



Mask off portion above AR chamber to avoid scratching



Slide flanges onto each end of exhaust

2. Use retaining ring plyers to expand and install retaining rings onto exhaust port spigots. Slide flanges into place on top of retaining clips.



Use retaining ring plyers to expand and install retaining rings onto exhaust port spigots



Slide flanges into place on top of retaining clips

IF USING 12MM OXYGEN SENSORS, INSTALL 18MM TO 12MM REDUCERS INTO BUNGS



Apply high heat anti-seize, thread reducer into O2 sensor bung



Hand tighten reducer into O2 bung, final torque reducer to 14 ft/lbs



4. Loosely install collector clamp onto headpipe. With clamp still loose, insert header pipe into collector section. Do not torque down clamp yet, final torque once pipe is fully installed



Loosely install head pipe clamp onto collector section

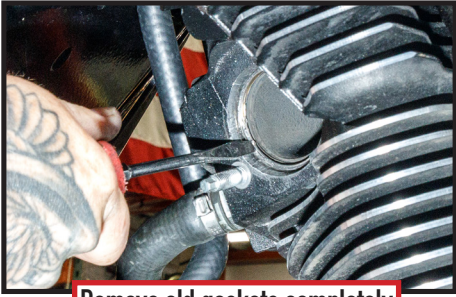


Insert head pipe section, do not tighten clamp



5. Remove old exhaust gaskets, ensuring to remove all previous gasket material. Install new flat style gaskets into the exhaust port. Be sure to fully seat new gaskets into port to avoid potential leaks. Using a flat edge or extension & socket set may help fully set gaskets into exhaust ports. Clean and apply anti seize to exhaust studs

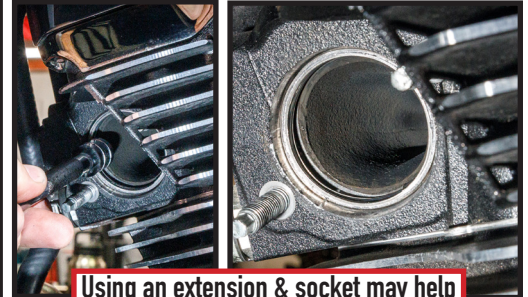
NOTE: Be sure to use included exhaust gaskets when installing, factory style tapered gaskets will not work.



Remove old gaskets completely

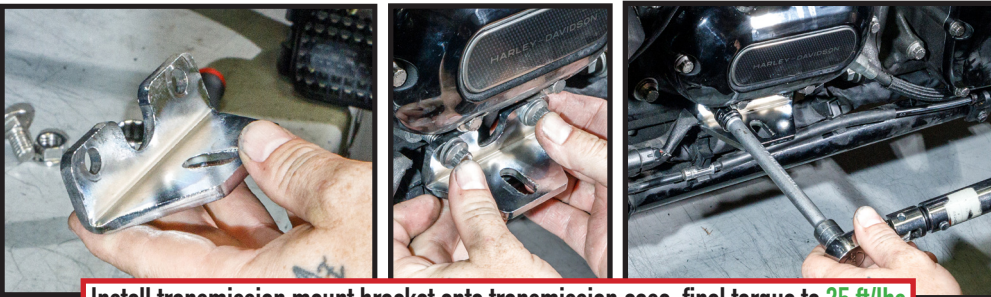


Install included flat style exhaust gaskets



Using an extension & socket may help fully seat gaskets in exhaust port

6. Install exhaust system bracket to transmission case, apply red Loctite to bolts & final torque to **25 ft/lbs**. Mask off the front cylinder frame rail to avoid scratching during install.

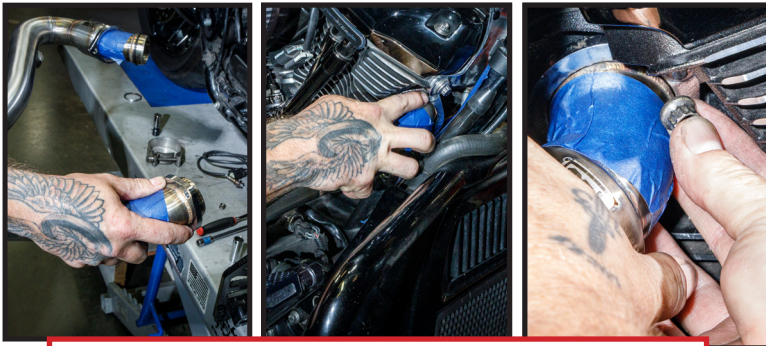


Install transmission mount bracket onto transmission case, final torque to **25 ft/lbs**

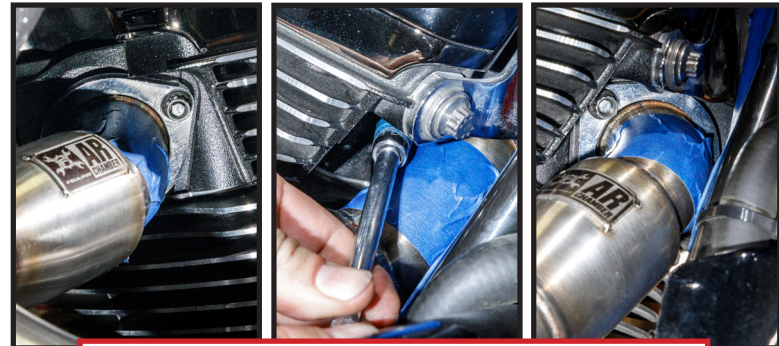


Mask off frame rails to avoid scratches

7. Lift assembled system to engine case, holding flanges in place to set onto exhaust studs. Once pipe and flanges are set into exhaust ports, begin threading each nut onto studs to hold pipe in place. Be sure to leave nuts loose during fitment of entire exhaust system before final torque down.

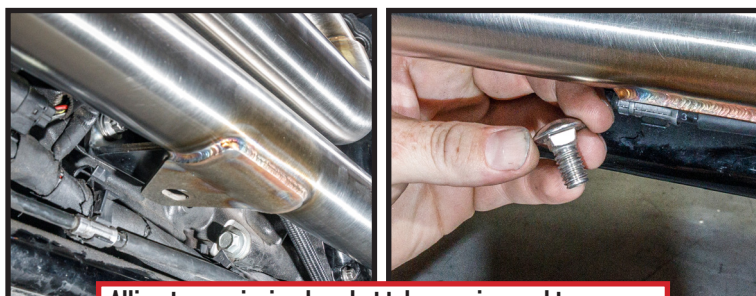


Place system into engine case, hand threading nuts over flanges

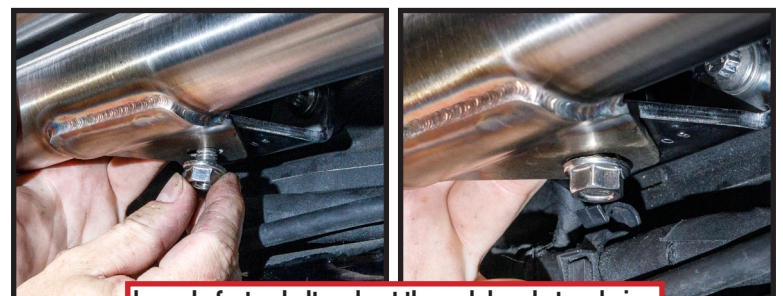


Loosely thread in exhaust nuts, repeat on front and rear heads

8. Slide transmission bracket tab on pipe **BELOW** bracket tab attached to transmission case, install bolt from the top down through both tabs. Loosely thread nut onto bolt hole, wait until entire pipe is fitted to final torque.



Align transmission bracket tabs on pipe and trans case



Loosely fasten bolt and nut through bracket and pipe

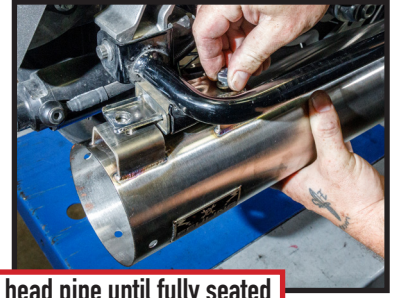
9. To install muffler can, first place muffler clamp onto muffler and apply high heat anti seize to inside diameter of muffler can. Slip muffler can onto head pipe, slow rotate muffler while pushing towards head pipe until the muffler can is fully seated. Loosely fasten rear muffler bracket bolts.



Install muffler to head pipe clamp, apply high temp anti seize



Slip fit muffler can onto head pipe until fully seated
Loosely install Muffler bracket bolts



10. Begin final torque procedure alternating evenly between both front and rear cylinder exhaust nuts. See torque step sequence chart.



Slowly begin tightening down exhaust nuts, alternating between front & rear final torque to 120 in/lbs

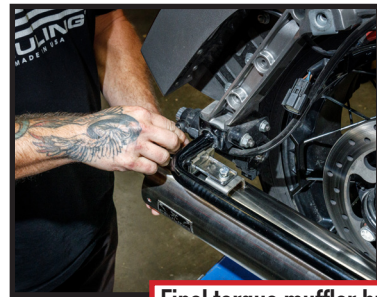
FINAL TORQUE STEP SEQUENCE & VALUES

1.) EXHAUST STUD NUTS	120 in/lbs
2.) TRANSMISSION BRACKET BOLT	20 ft/lbs
3.) HEAD PIPE/COLLECTOR CLAMP	9 ft/lbs
4.) MUFFLER/HEAD PIPE CLAMP	22 ft/lbs
5.) REAR MUFFLER BRACKET BOLTS	18 ft/lbs
6.) O2 SENSORS	14 ft/lbs

11. Continue securing the rest of the exhaust system bolts alternating between the transmission mount, head pipe clamp, muffler clamp & rear muffler bracket bolt. Final torque transmission bracket bolt to 20 ft/lbs. Final torque muffler bracket bolts to 18 ft/lbs. Final torque muffler to collector clamp to 22 ft/lbs.



Final torque transmission bracket bolt to 20 ft/lbs.



Final torque muffler bracket bolts to 18 ft/lbs



Final torque head pipe to muffler clamp to 22 ft/lbs.



12. Apply high heat anti seize to O2 sensor threads, thread each O2 sensor into pipe bungs. Final torque sensors to 14 ft/lbs.



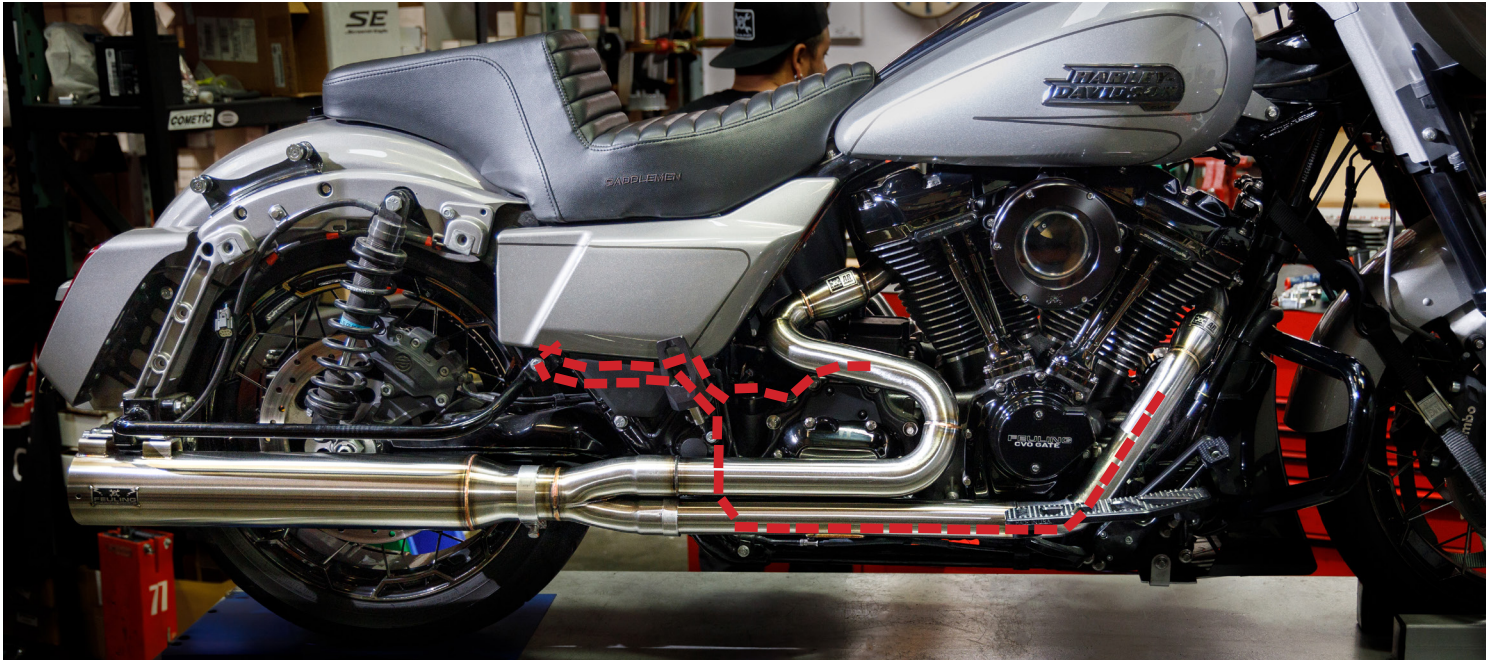
Use high heat anti seize on threads of each O2 sensor, thread into pipe



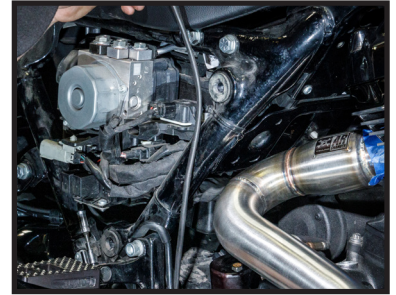
Final torque O2 sensors to 14 ft/lbs.



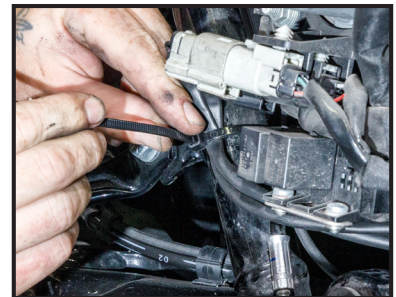
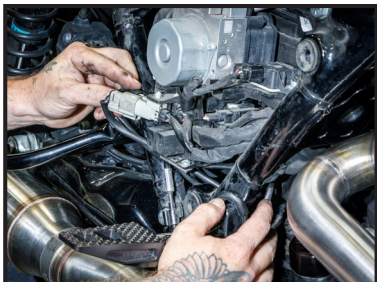
02 SENSOR WIRE ROUTING DIAGRAM



13. Route O2 sensor wires following routing diagram. Ensure to use OEM frame rail clips in factory locations, use zipties to secure excess slack in wires.



Carefully route and secure O2 sensor wires before reconnecting plugs



Secure using factory frame rail clips and zipties for any excess wire length

* STANDARD 1 YEAR WARRANTY:

- WARRANTY COVERS MANUFACTURE DEFECTS.
- DOES NOT COVER PARTS THAT HAVE FAILED DUE TO IMPROPER INSTALLATION, MAINTENANCE, EXCESSIVE CRANKSHAFT RUNOUT, OR MISUSE.
- DOES NOT COVER ANY CONSEQUENTIAL DAMAGE RESULTING FROM A FAILURE OF A FEULING PRODUCT.

* OPTIONAL 2 YEAR WARRANTY:

- ADDITIONAL YEAR WARRANTY IS ONLY AVAILABLE IF PARTS ARE INSTALLED BY A PROFESSIONAL INSTALLER.
- THE ONLINE WARRANTY FORM MUST BE COMPLETED BY THE DEALER PRIOR TO BIKE DELIVERY.
- OIL TANK MUST BE DROPPED & CLEANED.
- CRANKSHAFT RUNOUT MUST BE BELOW 0.005"

NOTE: FOR FULL WARRANTY INFORMATION VISIT WWW.FEULINGPARTS.COM/WARRANTY



DISCLAIMER: NOT LEGAL FOR SALE OR USE IN CALIFORNIA ON ANY POLLUTION CONTROLLED MOTOR VEHICLE.