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2021 H-D PAN AMERICA

S1R Slip-On System Part # 005-5380409-B



BILL OF MATERIALS

1	S1R Black Stainless Steel Muffler	005-538M
1	S1R Muffler Clamp	005-2C-S1
1	Slip-Tube	005-53804S
1	Hardware Kit	005-538-HK
2	45mm Swivel Hook Springs	005-S45
1	8mm Flange Nut	006-FN8
1	63mm Barrel Clamp	005-27-71MSH
1	Spring Puller	005-SP

INSTALLATION INSTRUCTIONS

1. Make sure the motorcycle is completely cool before installation, and make sure it is secure on a stand or service lift.
2. Remove heat bolt and barrel clamp to remove heat shield. **(Reference image 1)**
3. Loosen Barrel clamp. **(Reference image 2)**



4. Remove OEM muffler support bolt. **(Reference image 3)**
5. Remove muffler from motorcycle. **(Reference image 4)**



6. Loosen Resonator hose clamp. **(Reference image 5)**
7. Remove sound resonator box from motorcycle. **(Reference image 6)**



IMPORTANT - PLEASE READ CAREFULLY: We recommend that this performance part be installed by a qualified motorcycle technician. If you have any doubts as to your ability to install this performance part, please consult with your local motorcycle dealer. Read all instructions first before starting installation. Make sure the motorcycle and exhaust system are completely cool before starting the installation. Also, make sure the bike is secure on a center stand or ideally a service lift during installation. Be sure to save all stock components for possible use later.

WARRANTY: Two Brothers Racing products are intended for closed course competition purposes only, and therefore are sold "as is" without warranty. Two Brothers Racing specifically disclaims any warranties of merchantability or fitness for a particular purpose and disclaims all responsibility for consequential and incidental damages or any other losses arising from the use of these products or parts.

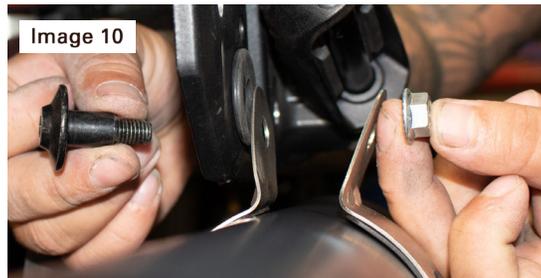
8. Install TBR Slip-tube to OEM header pipe with supplied barrel clamp attached to header end, leaving loose for now. **(Reference image 7)**

9. Install TBR Muffler to slip-tube. **(Reference image 8)**



10. Slide Muffler clamp and rubber liner onto muffler. **(Reference image 9)**

11. Install barrel clamp using OEM bolt and supplied flange nut in order shown. **(Reference image 10)**



12. Install provided 45mm springs from muffler to slip-tube. **(Reference image 10)**



13. Tighten all loosely installed components and double check your work.

14. Before you run the bike, clean off all fingerprints and dirt, oily residue will etch the metal and become somewhat permanent when the system gets hot. Run the bike and enjoy. it is normal for some white smoke to appear the first time you start the bike. This is packing/manufacturing oil burning off. Check for gaps or leaks. If you find a leak, use a little high temperature silicon sealant. after 50-100 miles recheck all fasteners.

Care & Cleaning

Keep system free of dirt and moisture. Store in a cool, dry place. Make sure vehicle is completely cool before maintenance.

Stainless Header System: Polished stainless steel pipes will turn a light golden hue after a few heat cycles, this is a normal characteristic of high quality stainless steel. Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

Titanium Header System: Polished titanium pipes will experience color shift ranging from deep blue/purple through amber after a few heat cycles. This is a normal characteristic of high quality titanium. Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

Polished Aluminum Canisters: Use an aluminum or mag wheel polish to restore the bright finish to factory spec.

Brushed Aluminum Canisters: Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth.

Carbon Fiber Canisters: Clean using a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth. Always make sure the fiberglass packing inside is in good condition and not burned out, as exhaust heat inside an empty canister will deteriorate the carbon fiber sleeve. TBR sells repack kits (Road - #005-10038, Offroad - #005-10038MX) that include everything you need to easily do it yourself.

Titanium Mufflers: For cleaning use a mild water based spray cleaner. Always apply cleaner or polish with a soft, clean cloth. Always make sure the fiberglass packing inside is in good condition and not burned out, as exhaust heat inside an empty canister will deteriorate the carbon fiber sleeve.

TBR sells repack kits (Road - #005-10038, Offroad - #005-10038MX) that include everything you need to easily do it yourself.

Repack all road canisters at the first signs of packing material deterioration. Part #005-10038

Repack all offroad canisters after every 10 hours of use. Part #005-10038MX

NEVER dyno test your bike with carbon fiber or titanium canisters installed - the intense heat and lack of cooling air can quickly burn through the canister material. Two Brothers Racing does not provide a warranty for burned canisters.



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1	Spring Puller	005-SP
2	M6x16 Socket Head Cap Screw	005-SH616