

# ***B R I T I S H*** ***C U S T O M S***

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***Thruxton 900 (2004-2016)***

***2 into 1 Air Cooled Heritage Bend***

**PART NUMBER: BC902-153-BR**



*You must know how to remove and replace your stock exhaust in order to install this product otherwise have it installed by a professional mechanic. Keep all stock parts from your existing system as some components may be necessary to install your new British Customs exhaust depending on the application. Read through all instructions before beginning installation. Exhaust system can be extremely hot. Let motorcycle cool down before beginning installation. Always wear hand and eye protection and take precautionary measures to avoid injury.*

***Tools Required:***

***12mm Wrench  
17mm Wrench  
5mm Allen  
6mm Allen***

***8mm Allen  
Torque Wrench  
Microfiber Towel  
Rubbing Alcohol***

**CAUTION:** Exhaust system can be extremely hot. Let motorcycle cool down before beginning installation. Always wear hand and eye protection and take precautionary measures to avoid injury.

**WARNING:** Always properly support vehicle with a stand and/or lift when servicing or performing any work.

Unstable vehicles may present dangerous conditions and may cause property damage and/or personal injury.

**NOTE:** Read through all instructions before beginning installation.

## Removal

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**NOTE:** Factory Exhaust removal is the same for both sides.

1. Use 6mm allen and loosen the clamp holding the muffler to head pipe.



2. Use 12mm wrench to remove nut securing muffler to passenger peg.



3. Remove muffler from head pipes. Repeat on other side.

4. Use 17mm wrench and remove O<sub>2</sub> sensors from head pipes. (EFI Model Only)



5. Use 8mm allen and remove bolt from rear of head pipes.





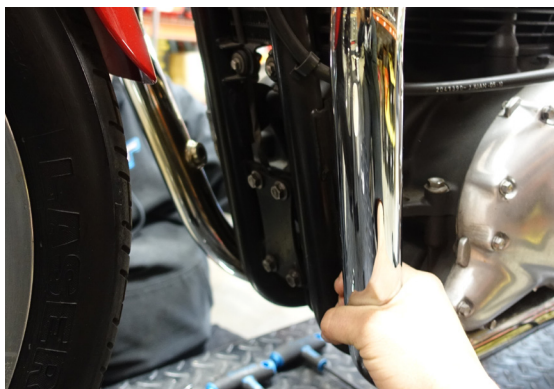
7. Use 6mm allen and loosen the crossover clamp between the head pipes, located under the engine.



8. Use 12mm socket and remove the flange nuts at the exhaust port.



9. Separate the head pipes at the crossover pipes.



### **PRO-TIP**

Use a rubber mallet and tap the insides of the head pipes to help separate them at the crossover.



## **Installation**

1. Install new exhaust gaskets.



### **PRO-TIP**

Put a small amount of RVT Silicone Sealant on the back of the exhaust gasket before inserting into the head. This will keep gasket from falling out while installing head pipes.

2. Install British Customs Left-hand header to exhaust port and lightly snug flange nuts.



3. Place the Right-Hand header end through the area between the frame and engine, then install the collar end to the exhaust port and lightly snug flange nuts.



4. Align the ends of the head pipes and fit the British Customs merge pipe over them.



#### **PRO-TIP**

**Apply RVT Silicone Sealant to the ends of the head pipes and inside of the merge pipe to help seal the slip fit connection. This is not necessary, but recommended.**

5. Install supplied exhaust spring on the upper slip connection.





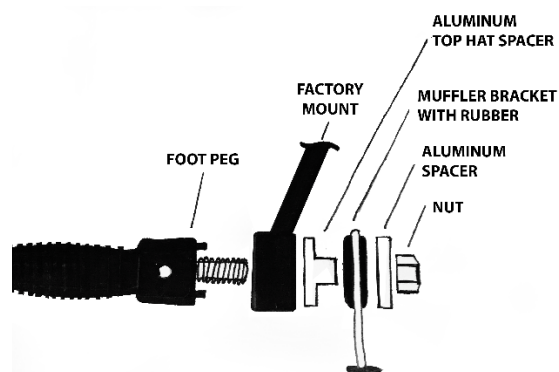
6. Install rubber grommet to muffler tab. Install aluminum insert into grommet, with insert placed on the backside of the mounting tab.



7. Install supplied clamp on the end of the muffler. Slip muffler onto the end of the tail-pipe and lightly tighten clamp.



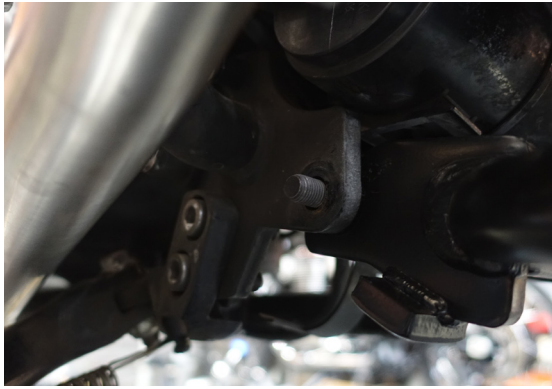
8. Lift muffler into position on the backside of passenger peg mount. Insert passenger peg and use 12mm socket to secure nut and torque to **19 Nm (14.0 ft-lb)**



9. Use 5mm allen and tighten muffler clamp to tail-pipe.
10. Use 12mm socket and tighten flange nuts at the exhaust ports. Torque to **19 Nm (14.0 ft-lb)**
11. Locate the center-stand mounts under the rear of the frame.

If installing with no center-stand, place bracket into position so kickstand does not hit the muffler when retracted. Once positioned, secure with 8mm allen and 17mm socket. Torque to **45 Nm (33.19 ft-lb)**

If using center-stand, remove left-hand side nut, install kickstand bracket, replace nut and snug. Position bracket so kickstand does not touch muffler when retracted. Once positioned, secure with 8mm allen and 14mm socket. Torque to **45 Nm (33.19 ft-lb)**



12. Before starting motorcycle, check for proper clearance between exhaust system with the frame, suspension, wiring, etc. If any problem is found, please carefully follow through the installation steps again. If problem still persists, please call **British Customs Customer Support at (877) 999-2748**.

**The entire exhaust system should be wiped down with rubbing alcohol to remove oil and fingerprints before starting the motorcycle. This will help prevent tarnishing of the finish after the exhaust is heated up.**