



INSTRUCTIONS

J03469

2006-05-05



CHROME BILLET DERBY COVER KIT

GENERAL

Kit Number

25504-04

Models

This kit fits 1999 and later Evolution 1340 and Twin Cam equipped models.

Additional Parts Required

Installation on 2006 and later Dyna, 2007 Softail, and 2007 Touring models requires separate purchase of Gasket, Part Number 25416-99C.

NOTE

A Service Manual for your model motorcycle is available from a Harley-Davidson Dealer.

Kit Contents

See Figure 2 and Table 1.

INSTALLATION

For models equipped with left side exhaust pipe:

▲ WARNING

Perform this installation when the engine is cool. Working on or near the exhaust system when the engine is hot could result in severe burns. (00311b)

NOTE

Remove clutch inspection (derby) cover with motorcycle upright, not on side stand. If cover is removed with motorcycle on side stand, primary fluid will leak out of primary chaincase.

1. On models so equipped, remove the **left-side** passenger footboard. Using a T27 TORX® drive head, remove the derby cover from the primary chaincase. Discard the derby cover and fasteners.

NOTE

The gasket between the clutch inspection cover and the chaincase cover must be removed and all oil must be wiped from the gasket and groove in chaincase cover each time the cover is removed.

2. Remove the gasket from the groove in the chaincase cover and mounting surface.

3. Inspect gasket for tears or damage. Replace as required with gasket 25416-99C (sold separately).

NOTE

If installing the Derby cover on 2006 and later Dyna, 2007 Softail, and 2007 Touring model, the original equipment gasket **must** be discarded and replaced with Derby Cover Gasket 25416-99C (sold separately).

4. To avoid punching holes in the clutch inspection cover gasket or enlarging the existing holes, install the new derby cover and gasket as follows:
 - a. Align the triangular shaped hole in the gasket with the top hole in the derby cover. Be sure the rubber molding and the words "towards clutch" face the motorcycle.
 - b. See Figure 2. Place a washer (2) from the kit onto the threads of one of the **new** screws (3). Insert the screw threads through the top hole in the derby cover, and carefully thread it all the way through the triangular shaped hole in the gasket. Do not push the screw through the hole.
 - c. Hang the derby cover on the primary chaincase cover flange by starting the top cover screw.
 - d. Start the remaining four screws and washers.

5. Install gasket and derby cover (1) on primary chaincase cover using screws and washers from the kit. Tighten screws to 10–12 N·m (84–108 **in-lbs**) in the sequence shown in Figure 1.

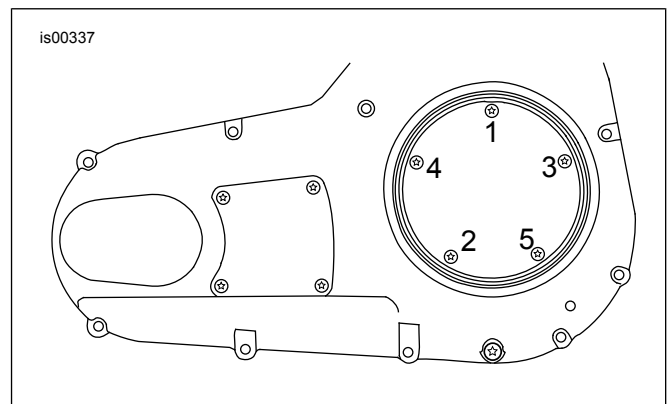


Figure 1. Torque Sequence, Clutch Inspection Cover



SERVICE PARTS

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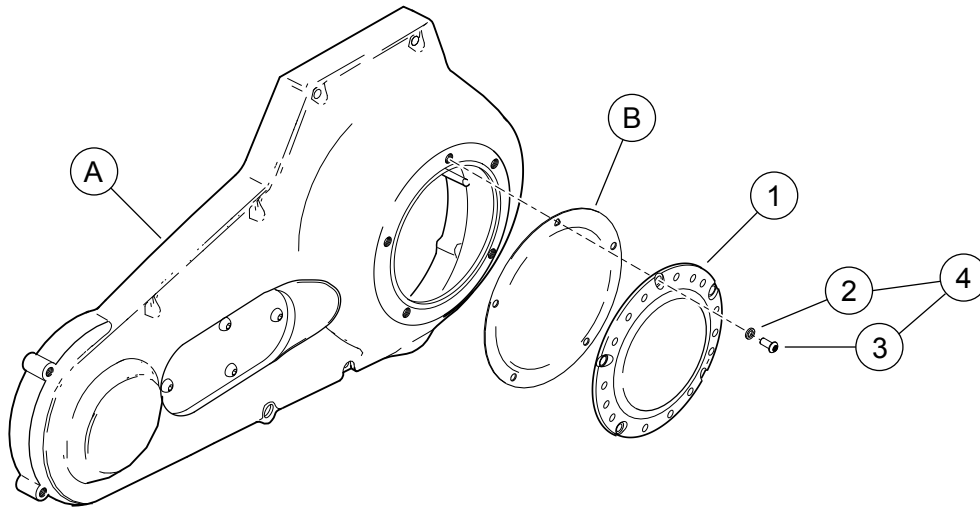


Figure 2. Service Parts: Chrome Billet Derby Cover Kit

Table 1. Service Parts Chrome Billet Derby Cover

Item	Description (Quantity)	Part Number
1	Derby cover, chrome billet, dimpled	Not Sold Separately
2	Washer, 1/4 in. stainless steel (5)	Not Sold Separately
3	Screw, Torx, chrome (5)	94633-99
4	Hardware Kit, Derby Cover (includes items 2 and 3)	25913-99
Items not included in kit:		
A	Original equipment primary chaincase cover	
B	Clutch inspection cover gasket, part number 25416-99C	