



INSTRUCTIONS

J06562

2024-01-09



EXHAUST OXYGEN SENSOR (WIDE BAND O2) BUNG DRILL AND TAP TOOL KIT

GENERAL INFORMATION

Table 1. General Information

Kits	Suggested Tools	Skill Level ⁽¹⁾
14900105	Safety glasses, Drill press with 1/2 inch chuck, Drill press vise, Clean shop rags, Cutting fluid/oil, Grease	

(1) Only simple tools and techniques required

KIT CONTENTS

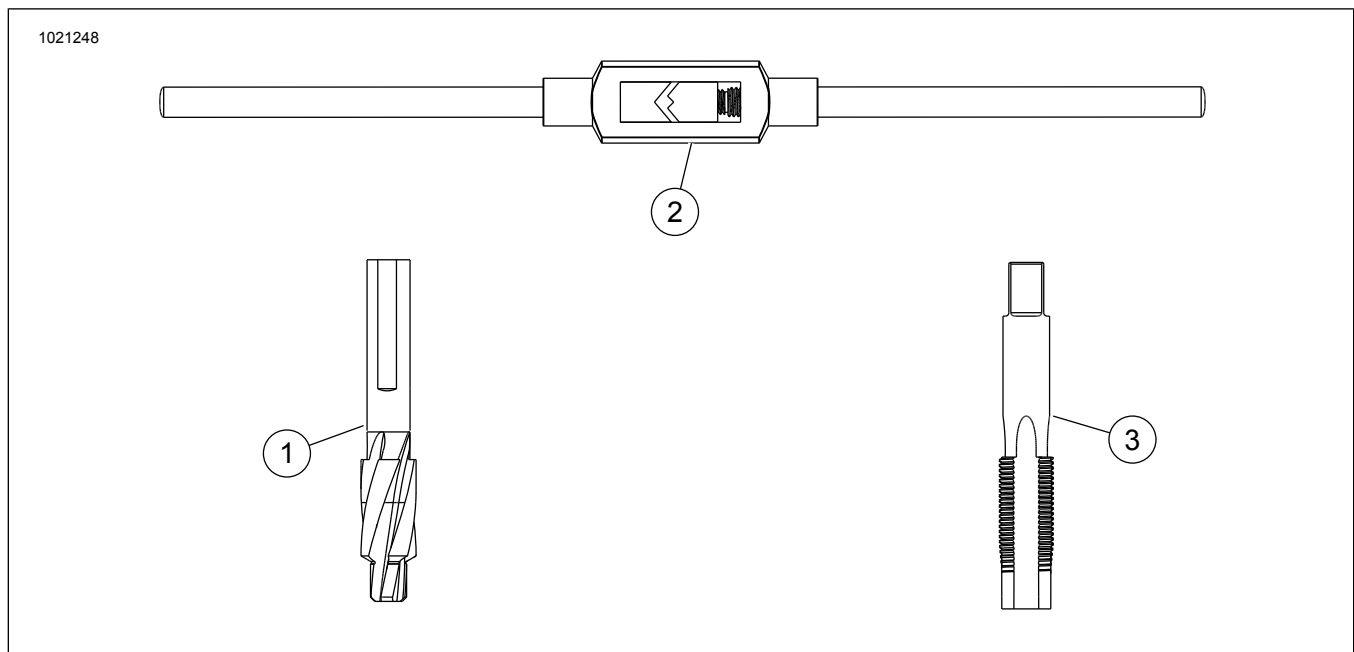


Figure 1. Kit Contents: Exhaust Oxygen Sensor (wide Band O2) Bung Drill And Tap Tool

Table 2. Kit Contents: Exhaust Oxygen Sensor (wide Band O2) Bung Drill And Tap Tool Kit

<input checked="" type="checkbox"/>	Verify that all contents are present in the kit before installing or removing items from vehicle.				
	Item	Qty	Description	Part No.	Notes
<input type="checkbox"/>	1	1	41/64- in Piloted drill bit, exhaust O2 sensor bung	14900104	
<input type="checkbox"/>	2	4	Tap handle	14900106	
<input type="checkbox"/>	3	1	M18 x 1.5 Piloted tap, exhaust O2 sensor bung	14900103	

GENERAL

Models

For model fitment information, see the Parts and Accessories (P&A) Retail Catalog or the Parts and Accessories section of www.harley-davidson.com.

Verify that the most current version of the instruction sheet is used. It is available at: h-d.com/isheets

Contact Harley-Davidson Customer Support Center at 1-800-258-2464 (U.S. only) or 1-414-343-4056.



⚠ WARNING

INSTALL

⚠ WARNING

NOTE

Drill the Hole

NOTE

1. Insert clean shop rag into each end of exhaust pipe past oxygen sensor bung. This will help stop and catch all drilling debris.
2. Set drill press spindle speed to **SLOWEST** setting.
3. Table 2 Install piloted drill bit (1) into drill press chuck.
4. Figure 2

a. Position exhaust pipe (3) into drill press vise (2).

NOTE

- b. Lower drill press chuck and position piloted drill bit (1) into exhaust pipe bung.
- c. Clamp down drill press vise to exhaust pipe.
- d. Raise and lower drill press chuck to check for drill pattern.

- Apply cutting fluid to drill bit and hole as necessary.
- Drill through oxygen sensor bung.

7. Wipe off excessive drilling debris. Leave shop rags in exhaust pipe.

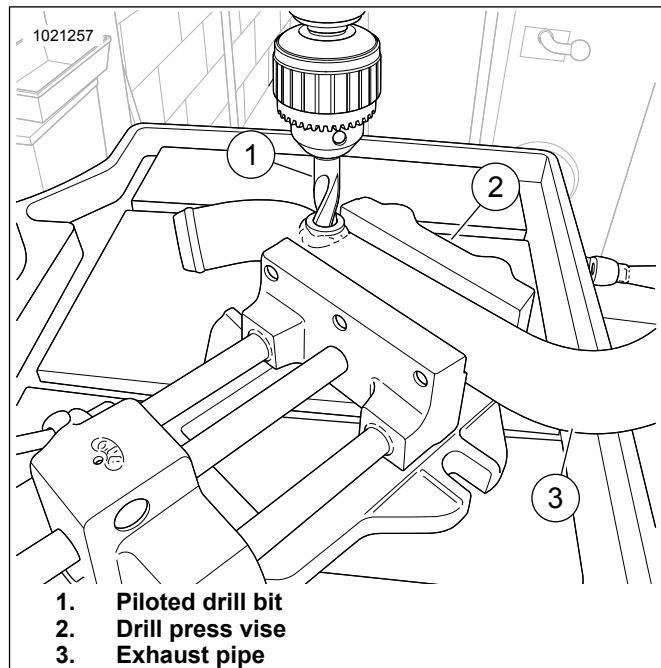


Figure 2. Drilling Exhaust Pipe

1. Figure 3 Assemble tap to tap handle:

- a. Insert tap (3) into tap handle (1).
 - b. Secure tap with set screw (4) of tap handle. Ensure tap is oriented so that set screw engages the flat of the tap.
 - c. Apply grease (2) to end of tap.
2. Figure 4 Position and clamp exhaust pipe (4) into bench vise (3).

NOTE

3. Insert pilot tip of tap (2) into oxygen sensor bung (1).

NOTE

4. Start tap by applying slight downward pressure while turning in a clockwise direction.

5. Continue to turn tap clockwise until tap has bottomed out, as indicated by increased resistance. Do **NOT** force tap.
6. Back tap out by turning tap counterclockwise, 1 - 2 turns, then blow out debris using low-pressure compressed air.
7. Repeat Steps 5 and 6 until threads have been completely cut into oxygen sensor bung.

8. Turn tap counterclockwise and remove tap.

NOTE

Tip end of exhaust pipe toward the ground when removing shop rags. This will assure cutting material debris will not fall into exhaust system.

9. Blow off debris using low-pressure compressed air and remove exhaust pipe from bench vise.
10. Remove shop rags from exhaust pipe.
11. Clean off cutting fluid and grease:
 - a. Position exhaust so fluid runs out of pipe.
 - b. Use PJ1® cleaner or equivalent to remove all traces of contaminants from thread area.

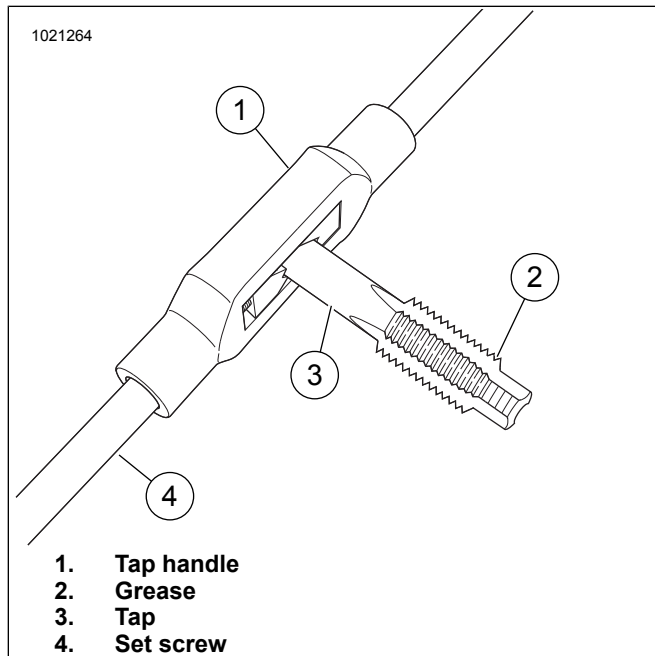


Figure 3. Tap Holder Assembly

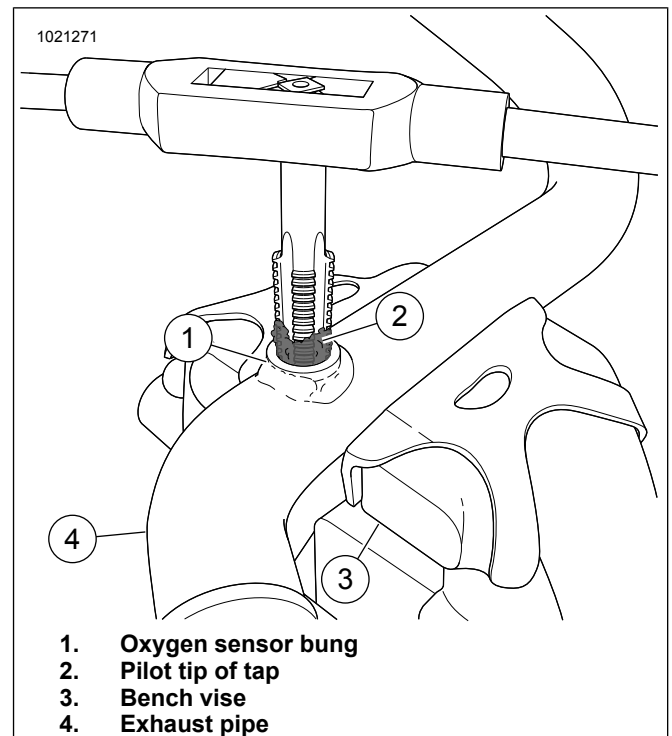


Figure 4. Tapping Exhaust Pipe