INSTRUCTIONS

2024-01-09



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

GENERAL INFORMATION

J06562

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 flu- id/oil, Grease	Fiff
(1) Only simple tools and techniques required		

KIT CONTENTS

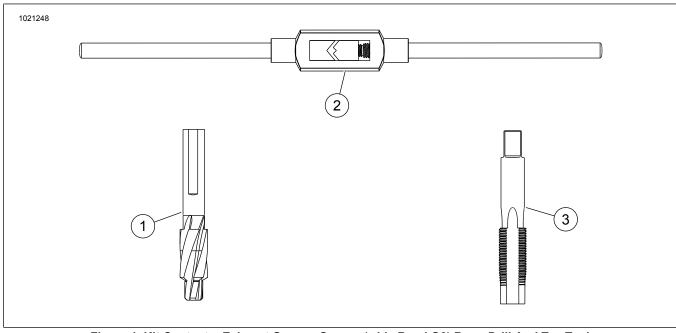


Figure 1. Kit Contents: Exhaust Oxygen Sensor (wide Band O2) Bung Drill And Tap Tool

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

	Verify that all contents are present in the kit before installing or removing items from vehicle.				
Item	Qty	Description	Part No.	Notes	
1	1	41/64- in Piloted drill bit, exhaust O2 sensor bung	14900104		
2	4	Tap handle	14900106		
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.

Installation Requirements

A WARNING

Rider and passenger safety depend upon the correct installation of this kit. If the procedure is not within your capabilities or you do not have the correct tools, have a Harley-Davidson dealer perform the installation. Improper installation of this kit could result in death or serious injury. (00308b)

INSTALL

DRILLING AND TAPPING PROCEDURE

WARNING

Wear safety glasses or goggles while drilling. Flying debris could result in serious eye injury. (00565b)

NOTE

Perform the following procedure on both front and rear oxygen sensor bungs.

Drill the Hole

NOTE

- Drilling material may cause damage to catalyst system if proper precaution IS NOT taken to prevent debris from entering exhaust system.
- The use of mechanical fingers, coat hanger or welding rod tied to shop rag will ease insertion and removal of rag.
- 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

With drill press NOT running:

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

NOTE

Pilot tip of drill bit must be completely square and fully-inserted into bung.

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

5. With drill press running:

- a. Apply cutting fluid to drill bit and hole as necessary.
- b. Drill through oxygen sensor bung.
- 6. Repeat procedure for other oxygen sensor bung.

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

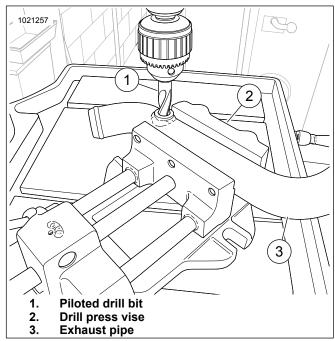


Figure 2. Drilling Exhaust Pipe

Tap the Hole

- 1. Figure 3 Assemble tap to tap handle:
 - Insert tap (3) into tap handle (1).
 - 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

Pilot tip of tap (2) must be completely square and fully-inserted into bung.

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

NOTE

Apply cutting fluid to tap and hole as necessary while tapping.

- 4. Start tap by applying slight downward pressure while turning in a clockwise direction.
- 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.
- Repeat Steps 5 and 6 until threads have been completely cut into oxygen sensor bung.

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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.

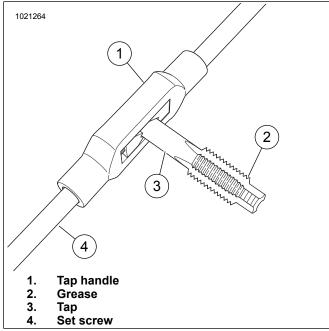


Figure 3. Tap Holder Assembly

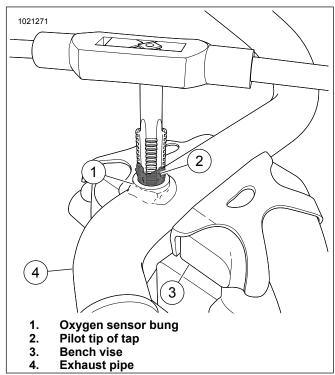


Figure 4. Tapping Exhaust Pipe

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