



Installation Instructions

03 & Earlier Sportster Crashbar

Tools Needed:

- Wrench set
- Torque wrench
- Welding equipment
- Marking tools
- Paint/powder coat removal tools

Step 1: Install Center Mount Bolt

- Begin by using the **longer bolt** with the **1/2" long spacer**. This bolt will be used in the **center mount** of the crashbar, attaching it to the **crossbar** of the front section of the frame.
- Insert the bolt through the **slotted hole** in the crossbar welded onto the crashbar.
- Place the **spacer** between the crashbar and the frame.
- Tighten this bolt first to temporarily hold the crashbar in place, ensuring it is positioned correctly for setting up the bungs.

Step 2: Attach Coped Bungs to Crashbar

- Position the **supplied copied bungs** between the frame and the mounting holes on the crashbar side plates.
- Once the bungs are in place, **mark their locations** on the frame. This will indicate where paint or powder coat needs to be removed for welding.

Step 3: Prepare Frame for Welding

- Remove the crashbar to access the marked locations on the frame.
- **Remove the paint or powder coat** from the marked areas on the frame where the bungs will be welded. This will provide a clean surface for the welds.

Step 4: Reinstall Crashbar and Tack Weld Bungs

- After cleaning the frame, reinstall the crashbar and ensure it is **level**.
- **Tack weld** the copied bungs in place on the frame at the marked locations.

Step 5: Fully Weld Coped Bungs

- Remove the crashbar again and **fully weld** the copied bungs to the frame.
- Allow the welds to cool before proceeding.

Step 6: Final Installation

- Once the welds are fully cooled, reinstall the crashbar.
- Use the supplied hardware to secure the crashbar in place, ensuring all bolts are tightened to **35 ft-lbs** torque specification.