




INSTRUCTIONS

94100065

2019-09-05

INNER PRIMARY VENT SERVICE KIT

Table 1. General Information

Kits	Suggested Tools	Skill Level ⁽¹⁾	Time
26500027	Safety Glasses, Torque Wrench, Electric Drill, 11/32-in Drill Bit		2017 - 2018 Models: 1.4 h 2019 Models: 2.1 h
<i>(1) Special tools or techniques required for installation</i>			

KIT CONTENTS

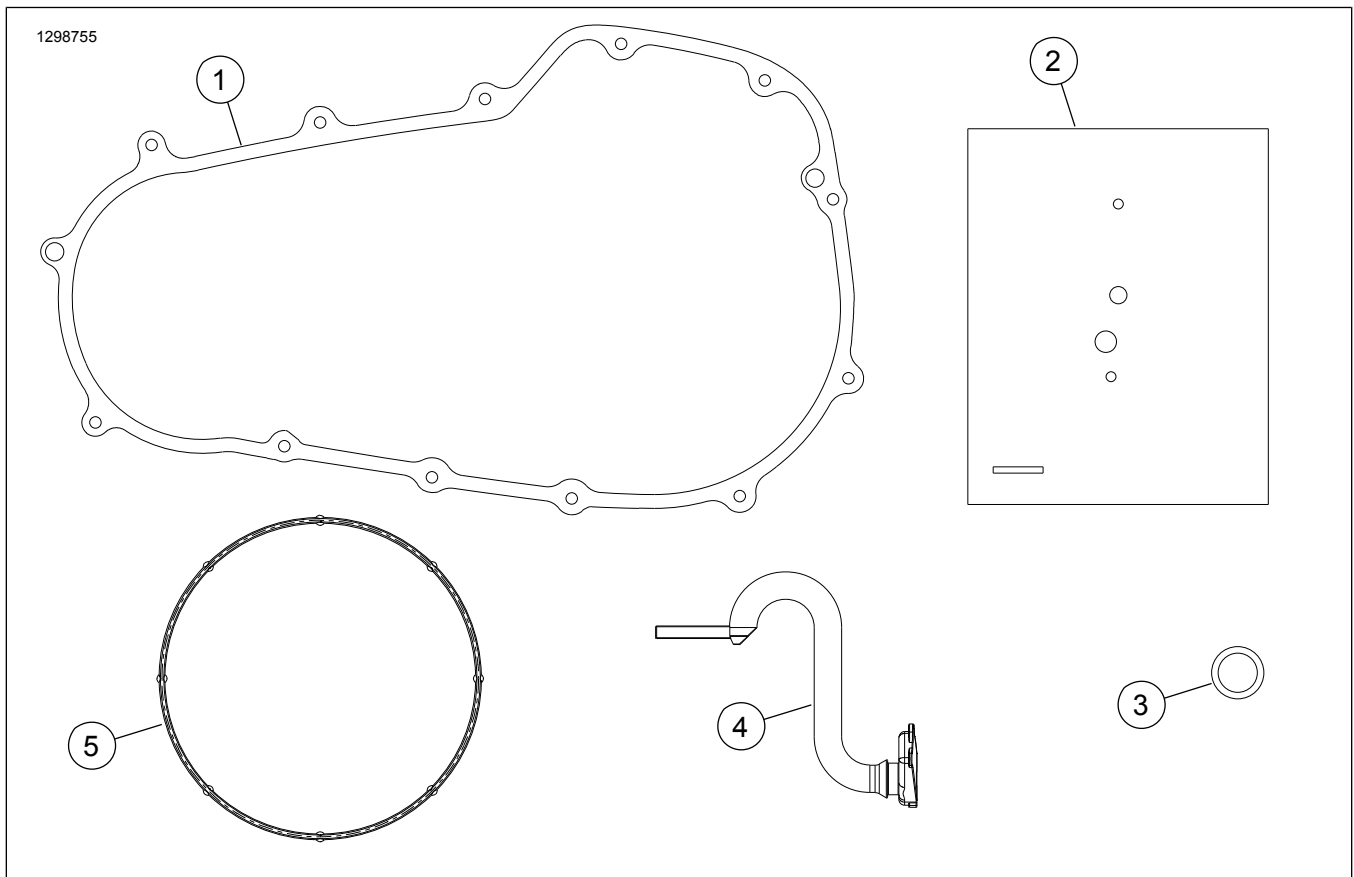


Figure 1. Kit Contents: Inner Primary Vent Service Kit Components

Table 2. Kit Contents: Inner Primary Vent Service Kit Components

<input checked="" type="checkbox"/>	Item	Qty	Description	Part No.	Notes
<input type="checkbox"/>	1	1	Gasket, primary cover	25700378	
<input type="checkbox"/>	2	1	Template, drill vent	Not sold separately	
<input type="checkbox"/>	3	1	O-ring	11105	
<input type="checkbox"/>	4	1	Hose, primary vent	Not sold separately	
<input type="checkbox"/>	5	1	Seal, clutch cover	25418-06	

NOTE

Verify all contents are present in the kit before installing or removing items from vehicle.

GENERAL

Models

This kit fits 2017-2019 Touring and Trike models.

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

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

Installation Requirements

▲ WARNING

Rider and passenger safety depend upon the correct installation of this kit. Use the appropriate service manual procedures. 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. (00333b)

NOTE

This instruction sheet references service manual information. A service manual for this year and model motorcycle is required for this installation and is available from:

- A Harley-Davidson dealer.
- H-D Service Information Portal, a subscription-based access available for most 2001 and newer models. For more information see *Frequently ask questions about subscriptions*

PREPARE

1. Remove main fuse. See service manual.
2. Remove left rider and passenger footrests with bracket. See service manual.
3. If equipped, remove screw securing jiffy stand interlock sensor. See service manual.
4. If equipped, remove heel shift lever. See service manual.

5. Drain primary chaincase. See service manual.
 - a. Remove and discard O-ring from plug.
6. Remove primary chaincase cover. See service manual.
 - a. Remove and discard primary cover gasket.
 - b. To avoid metal shavings in the drive components, cover chaincase assembly with cloth.

INSTALL

1. See Figure 2. Drill hole in primary case.
 - a. Punch or cut out holes in drill template (1).
 - b. Install drill template (1) onto hollow dowel (2).

NOTE

Screws can be loosely installed to help with template alignment.

- c. Align drill template with screw holes in primary case.
- d. Use a center punch to mark drill location.

NOTE

*Make sure when drilling that the drill bit is **perpendicular** to the inner primary gasket surface.*

- e. Drill a pilot hole through inner primary surface using a 1/8-in drill bit.
- f. Use a 11/32-in drill bit to enlarge pilot hole.
- g. Remove drill template.
- h. Deburr hole on both sides of primary case.
- i. Clean all debris from inside of cover.

NOTE

Lubricate hose with a mixture of 50 percent isopropyl alcohol and 50 percent distilled water.

2. See Figure 3. Carefully install and route vent hose (4) through case hole (3). Avoid cutting hose during installation.

NOTE

Make sure that vent hose is installed per illustrations.

3. Secure vent hose into primary case.
 - a. See Figure 4. Base of vent hose (5) should be properly aligned in case pocket.
 - b. See Figure 5. Crown of vent hose (6) should protrude over primary case and locked in place.
4. Cut flag (7) from vent hose.
5. Clean off any residual fluid from vent hose installation.

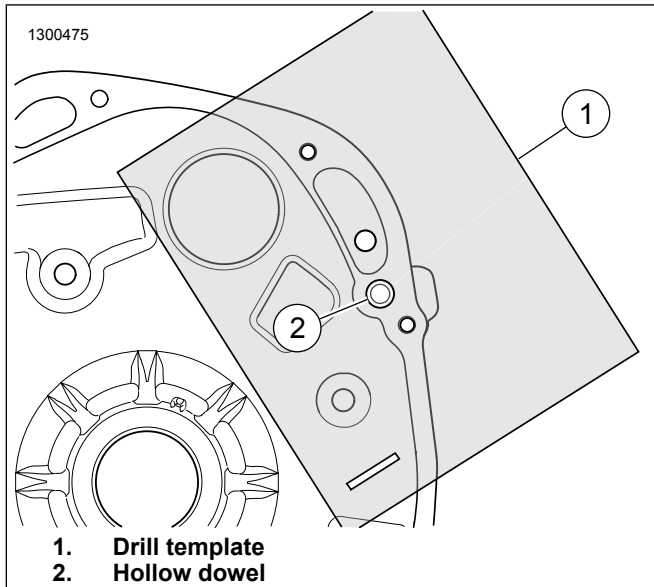


Figure 2. Drill Template

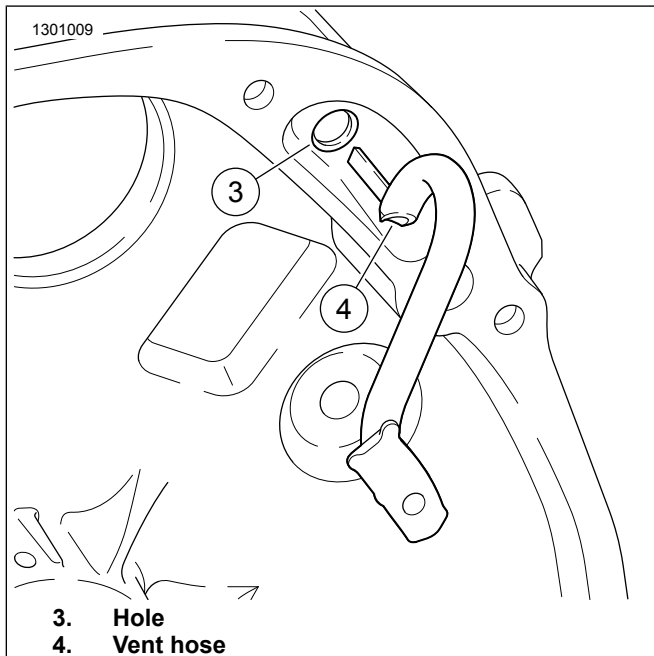


Figure 3. Install Vent Hose

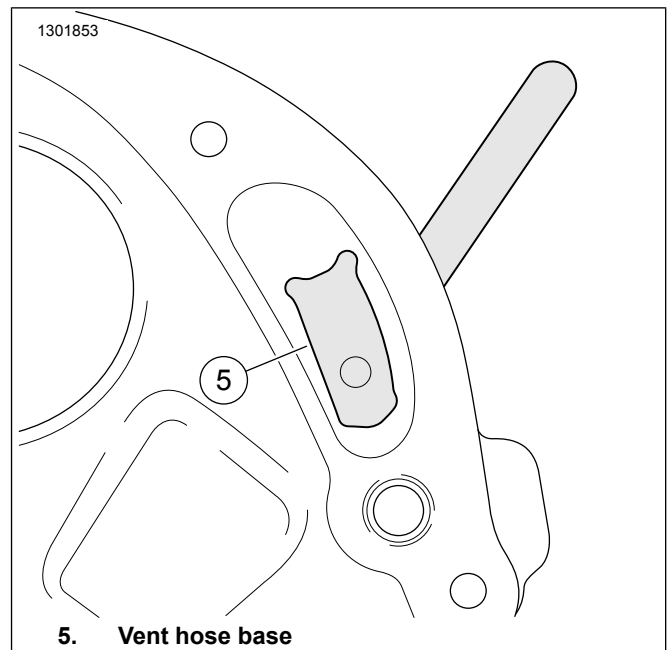


Figure 4. Vent Hose Position

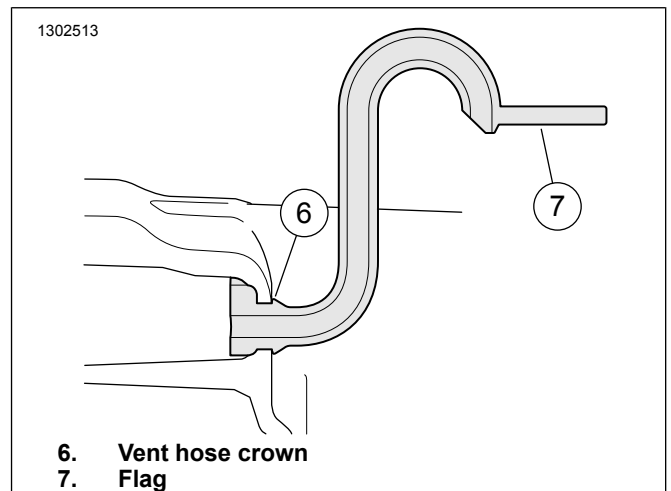


Figure 5. Section View of Vent Hose Installed

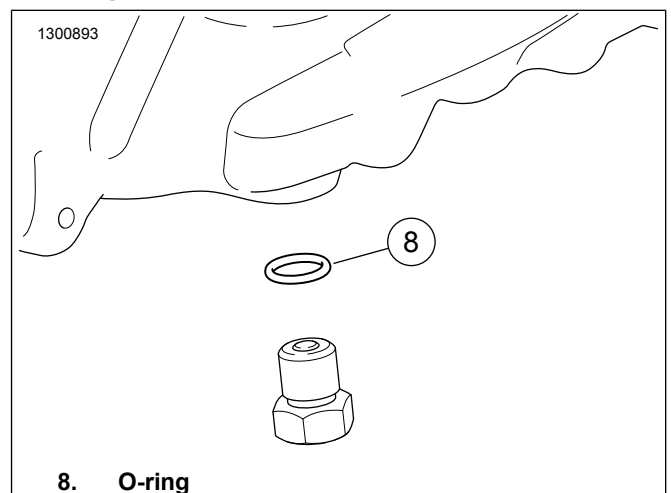


Figure 6. Primary Plug O-Ring

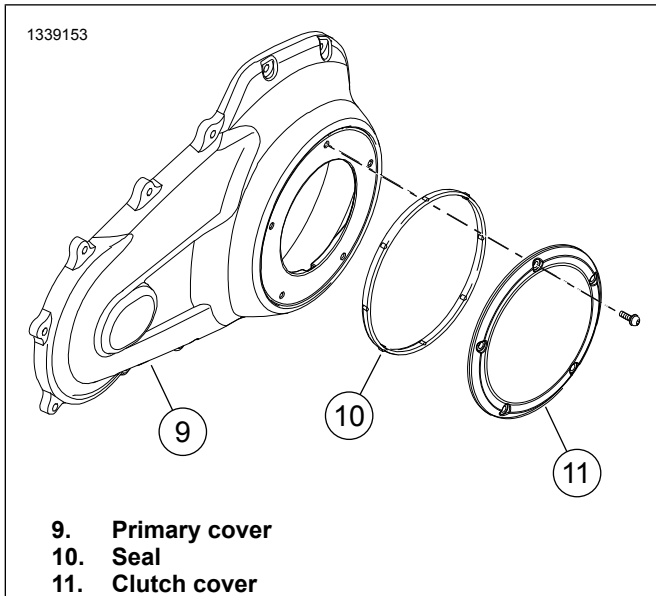


Figure 7. Clutch Cover Seal

COMPLETE

NOTE

Make sure primary case is clean of all metal shavings and debris.

Make sure vent hose is not pinched or obstructed after installation is complete.

1. Install primary chaincase cover. See service manual.
 - a. Install **new** primary cover gasket.
2. Fill primary chaincase. See service manual.
 - a. See Figure 6. Install **new** O-ring (8) to plug.
 - b. See Figure 7. Install **new** seal (10) to clutch cover (11). See service manual.
 - c. Tighten screws in sequence. See service manual.
3. Install heel shift lever. See service manual.
4. If equipped, install screw securing jiffy stand interlock sensor. See service manual.
5. **2017 - 2018 Models:** STOP kit installation is completed.
6. See Figure 8. **2019 Models:** Remove oil deflector (1).
 - a. Remove transmission inner side cover. See the service manual.
 - b. Remove mainshaft transmission oil deflector (Part No. 36300026).
 - c. Install transmission side covers. See service manual.

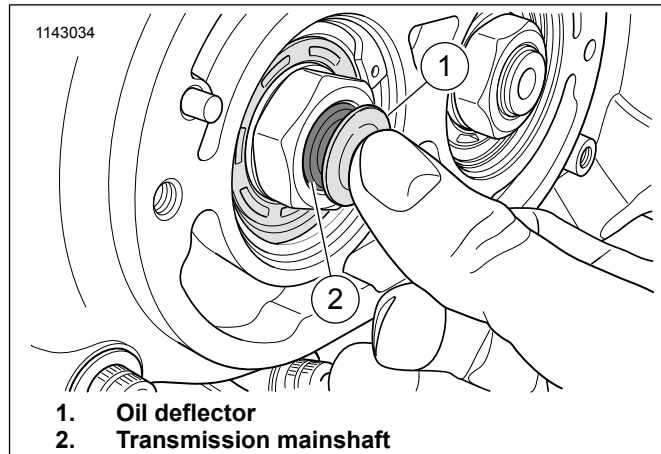


Figure 8. Removal of Oil Deflector

7. Install left rider and passenger footrests with bracket. See service manual.
8. Install main fuse. See service manual.
9. Verify transmission fluid level. Service as needed. See service manual.