

SERVICE BULLETIN



M-1225A

October 9, 2008

2007/2008 CVO 110 C.I. DISPLACEMENT ENGINE UPDATE PRODUCT PROGRAM 0905

Purpose

The purpose of this revision is to provide an option for those customers who choose to not have their original cylinder heads replaced with the cylinder heads included in kits 94675 and 94676

Harley-Davidson Motor Company, Inc. has chosen to upgrade 2007/2008 CVO 110 cubic inch engine equipped model motorcycles with current product enhancements to improve long term reliability.

In order to ensure the highest level of ownership experience for all owners of motorcycles equipped with 110 cubic inch engines, we are releasing two product programs designed to upgrade all 2007 and 2008 CVO Ultra model motorcycles built before April 9, 2008 to current design and production specifications.

Motorcycles Affected

2007 FLHTCUSE2 model motorcycles and 2008 FLHTCUSE3 model motorcycles built before April 9, 2008. Check VIN on h-dnet.com to determine program involvement and to confirm that the product program for the motorcycle is still open.

P&A registered Street-Legal Accessory 110 kit equipped 2007/2008 Ultra model motorcycles are also included.

h-dnet.com/Service Toolbox/Product Campaign and Open VIN Lists. Select 0905 campaign to view the VIN list.

NOTE

If the vehicle is not on your dealership VIN list, check the Safety and Product Campaign History by VIN link.

Customer Notification

Harley-Davidson will send a letter to registered owners notifying them of this non-safety related condition and instructing them to contact their dealer for the replacement service. Samples of the customer letters are attached.

Program Duration

This program is effective beginning July 28, 2008. Please be advised that the services delivered under this product program will no longer be rendered at factory expense after two years.

Kit Ordering Information

No wave shipments will be conducted for kit 94675. One wave shipment of kit 94676 will be conducted the week of July 28, 2008.

NOTE

Some motorcycles may have already had the enhancements installed during a previous repair. Verify the product program for the motorcycle in question is still open before placing order.

If additional kits are needed, fill in the attached order form and fax it to the Warranty Department (414-343-8346). You must include the dealer number and the VIN of the motorcycle being serviced.

IMPORTANT NOTES

- Kits will be available the week of July 28, 2008 in the domestic markets, and shortly afterwards worldwide. No orders for replacement part kits will be accepted prior to the availability date.
- You must have submitted claims for 75% of the kit quantities that have been shipped to your dealership before additional kit orders will be processed.

**Table 1. Replacement Kit Contents: 2007
FLHTCUSE2 (94676)**

Item	Part No.	Quantity
Front Cylinder Head With ACR	17251-07B	1
Rear Cylinder Head With ACR	17252-07A	1
Top End Gasket Kit	17349-07	1
Clamp	10038A	1
Screw, hex flange	1090A	1
Gasket	29313-95	1
Gasket	29583-01A	1
O-ring	11292	2

IMPORTANT NOTE

In the interest of preserving customer safety and satisfaction, always check for outstanding recalls whenever any motorcycle is brought into your dealership for either maintenance or service.

ROUTING	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	WARRANTY PROCESS MANAGER	LEAD TECHNICIAN	TECHNICIAN NO.1	TECHNICIAN NO. 2	TECHNICIAN NO. 3	RETURN THIS TO
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Table 2. Replacement Kit Contents: 2008 FLHTCUSE3 (94675)

Item	Part No.	Quantity
Front Cylinder Head With ACR	17336-08A	1
Rear Cylinder Head With ACR	17335-08A	1
Top End Gasket Kit	17349-07	1
Clamp	10038A	1
Screw, hex flange	1090A	1
Gasket	29645-08	1
Gasket	29718-08	1

Table 3. Replacement Kit Contents: 2007 FLHTCUSE2 and 2008 FLHTCUSE3 (use original cylinder heads) (94677)

Item	Part No.	Quantity
Top End Gasket Kit	17349-07	1
Clamp	10038A	1
Screw, hex flange	1090A	1
O-ring	10925	2
O-ring	11292	2
ACR Solenoid	28861-07A	2
Gasket	29313-95	1
Gasket	29059-88A	1
Gasket	29583-01A	1
Gasket	29593-05A	1
Gasket	29645-08	1
Gasket	29718-08	1

Required Dealer Action

NOTE

Installation of these new cylinder heads will allow a maximum of 0.596 in. (15.14 mm) valve lift. Vehicles with SE-260, SE-264, or any aftermarket cams having lift greater than this are considered race-only applications for non-street use and are not covered under this program. Installation of these components or replacement of camshafts will be at the owner's expense only. Owners of motorcycles with these modifications should be notified prior to repairs to discuss how they wish to proceed.

Owners choosing to not have the cylinder heads replaced may opt to have the remaining engine improvements installed on their motorcycle. For owners making that choice please use kit number 94677 and complete an electronic warranty claim using the Credit Procedure in Table 5.

1. Replace front and rear cylinder heads using the **new** cylinder heads and gaskets in the replacement kit. A basic outline follows but refer to the appropriate service manual or supplement for procedures, specifications, and safety practices.
 - a. Remove seat and disconnect battery.
 - b. Remove console and fuel tank.

- c. Remove right side footboard.
 - d. Remove heat shields.
 - e. Remove saddlebags.
 - f. Disconnect mufflers and exhaust system.
 - g. Remove rear cylinder heat shield.
 - h. Remove air cleaner.
 - i. Remove top front stabilizer and both upper rocker boxes.
 - j. Remove spark plugs.
 - k. Elevate rear wheel.
 - l. Remove front and rear rocker carriers.
 - m. Remove push rods and tubes.
 - n. Remove both lower rocker boxes.
 - o. Disconnect connectors from induction module.
 - p. Remove horn and bracket.
 - q. Remove head temp sensor.
 - r. Remove throttle body.
 - s. If the motorcycle is high mileage, or if there are other concerns regarding the cylinder condition, perform a three phase leakdown test on each cylinder; TDC, mid-stroke, and BDC. Engage the transmission in a high gear and hold the rear brake to perform the mid-stroke test. Leakage greater than 10% may indicate the cylinders will need to be deglazed and new piston rings installed. Contact Harley-Davidson Technical Service with test results for direction and approval.
 - t. Remove both cylinder heads.
 - u. Remove both cylinders.
2. Clean all gasket surfaces and verify head gasket surface of cylinder is flat within 0.006 in (0.152 mm) or less.
 3. Visually inspect the cylinder bores for damage.

NOTE

If additional warranty parts or labor are needed, Harley-Davidson Technical Service must be contacted to obtain approval before proceeding.

4. Assemble engine in reverse of disassembly. Refer to the appropriate service manual or supplement for proper assembly procedures and specifications.
5. See Figure 1. Replace the crankcase bolt using part number 1090A supplied.
 - a. Remove front shift linkage fastener (1) to gain access to the crankcase bolt (2).
 - b. Remove bolt (2) and replace with **new** one supplied. Tighten to 15-19 ft-lbs (20.3-25.8 Nm).
 - c. Install linkage fastener and tighten to 70-90 in-lbs (7.9-10.2 Nm).

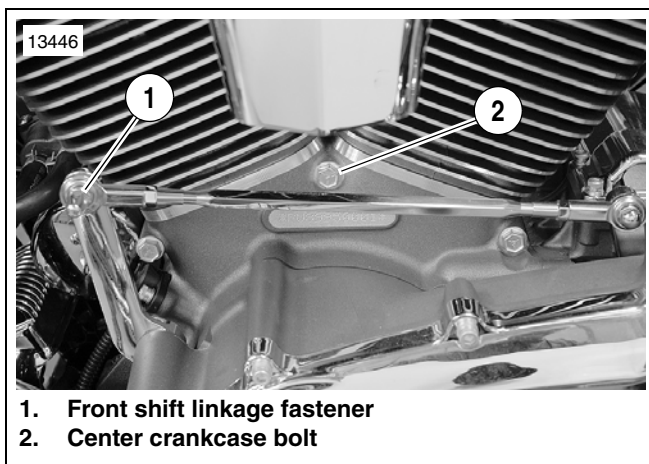


Figure 1. Crankcase Bolt

Credit Procedure - U.S. Market/Non-U.S. Market

Complete an electronic warranty claim referencing Service Bulletin M-1225A. Fill in the rest of the claim as follows:

Table 4. Credit Procedure-U.S. Market/Non-U.S. Market-2007 FLHTCUSE2

Claim Type	PPC
Event Problem Part No.	16801-07
Quantity	Leave blank
Replacement Part No.	94676
Quantity	1
Primary Labor Code*	3114
Time	5.2
Customer Concern Code*	0905
Condition Code	9981

* These codes may need to be downloaded into your system.

Table 5. Credit Procedure-U.S. Market/Non-U.S. Market-2008 FLHTCUSE3

Claim Type	PPC
Event Problem Part No.	16801-07
Quantity	Leave blank
Replacement Part No.	94675
Quantity	1
Primary Labor Code*	3115
Time	5.2
Customer Concern Code*	0905
Condition Code	9982

* These codes may need to be downloaded into your system.

If a customer chooses to not replace their existing cylinder heads, please use part number 94677 and file the electronic claim as follows:

Table 6. Credit Procedure-U.S. Market/Non-U.S. Market-2007 FLHTCUSE2 and 2008 FLHTCUSE3

Claim Type	PPC
Event Problem Part No.	16801-07
Quantity	Leave blank
Replacement Part No.	94677
Quantity	1
Primary Labor Code*	3120
Time	5.2
Customer Concern Code*	0905
Condition Code	9983

* These codes may need to be downloaded into your system.

Upon the timely receipt of the claim, you will be credited 5.2 hours of labor for performing the repair above. Hold all replaced parts for 60 days from the date that credit was issued to allow for possible field inspection and/or return of parts to the factory. After 60 days, destroy and discard the parts.

HARLEY-DAVIDSON MOTOR COMPANY
P.O. BOX 594, MILWAUKEE, WI U.S.A 53201
RECALL AND PRODUCT CAMPAIGN ORDER FORM

M-1225A PRODUCT CAMPAIGN 0905

TYPE CODE	ORDER TYPE	VEHICLE IDENTIFICATION NUMBER(S)
RC	RECALL	
PC	PRODUCT CAMPAIGN	

ORDER DATE
DEALER NUMBER

QUANTITY	PART NUMBER	ITEM
	94675	Code 0905: FLHTCUSE3
	94676	Code 0905: FLHTCUSE2
	94677	Code 0905: CVO 110 Gasket Kit
		NOTE: All orders are subject to approval. You may not receive the total quantity of kits ordered due to parts availability. If this happens, please submit another order for the balance, following all order procedures indicated in the Service Bulletin. Fax orders to the warranty department: 414-343-8346. You must include VIN number (if required) and your dealer number.

ALL ORDERS SUBJECT TO ACCEPTANCE AT MILWAUKEE, WI USA 53201

NOTE: An order acknowledgement is automatically generated and faxed to your dealership's fax number as listed in GDIS the same day as your order is entered at HDMC. This acknowledgement will provide you with the order status and order number. To retrieve order information based on the Harley-Davidson order number, go to P&A Order Inquiry on h-dnet.com under the Parts and Accessories link, select H-D Order Number, enter the order number and click "Submit". At the bottom of the page, click on "Track Part" to view tracking information for the order.