



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL #1208-1316 OR 1308-1316



**No.1208-1316 120" PARTS
AVAILABLE SEPARATELY**

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	1208-1602
2	1	TOP TORQUE PLATE	1208-1601
3	4	ALLEN BOLTS	1208
4	1	TORQUE PLATES, TAB	1073-2
5	2	SOCKET HEAD SCREW	2405
6	4	3/8" WASHER	1265
7	1	INSTRUCTION SHEET	1208-1350

**No.1308-1316 131"or 135" PARTS
AVAILABLE SEPARATELY**

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	1308-1602
2	1	TOP TORQUE PLATE	1308-1601
3	4	ALLEN BOLTS	1208
4	1	TORQUE PLATES, TAB	1073-2
5	2	SOCKET HEAD SCREW	2405
6	4	3/8" WASHER	1265
7	1	INSTRUCTION SHEET	1208-1350

No.1208-1316 - Torque Plates were designed to be used with JIMS® Twin Cam 120", 4- 1/8" bore Race Kit or Engine Assembly Alpha or Beta cylinders.

No.1308-1316 - Torque Plates were designed to be used with JIMS® Twin Cam 131" or 135", 4- 5/16" bore Race Kit or Engine Assembly Alpha cylinders.

**NOTE: PLEASE READ ALL INSTRUCTIONS COMPLETELY PERFORMING ANY WORK!
IF YOU DO NOT KNOW WHAT YOU ARE DOING, DO NOT DO IT!
ALWAYS WEAR SAFETY GLASSES OR OTHER FACE AND EYE PROTECTION SUCH AS FULL FACE SHIELD.
JIMS® IS NOT RESPONSIBLE FOR DAMAGE, INJURY, OR YOUR WORK.
JIMS® IS NOT RESPONSIBLE FOR THE QUALITY AND SAFETY OF YOUR WORK.**

Important!
To check cylinder measurements accurately these torque plates are essential. These plates simulate stress conditions when boring and honing. These plates are lasered with the correct torquing sequence.

INSTRUCTIONS

Please read all instructions before performing work.

Note: Apply lube to all threads, also to under side of bolt head, and washers.

Step-1 Prepare cylinders for mounting.

- a. Remove cylinders from motor according to your H-D® manual.
- b. Thoroughly clean cylinders free of any residual sealing material.
- c. Check cylinder sealing surface for flatness and cracks according to your H-D® manual.

Step-2 Mount Torque Plates

- a. Install vice tab plate to the lasered side of the bottom torque plate with the two 5/16" allen bolts, No.2405.
- b. Install a used head gasket, and used base gasket over the dowels if removed.
- c. Install lower plate No.1208-1602 for 120" or 1308-1602 for 131" or 135". Use in vise by clamping on tab.

NOTE: Laser side should face you and machined strip facing away from you.

- d. Apply lube to bolt heads and threads. Slip four bolts with washers, through lower plate until washer contacts the out-board side of the lower plate.
- e. Install cylinder with gasket in place, and install upper plate by aligning holes with bolts, No.1208-1601 for 120" and No.1308-1601 for 131" or 135".
- f. Tighten bolts alternately in a clockwise pattern until snug.
- g. Tighten bolts to 8 ft. lbs. using the sequence lasered on the bottom plate.
- h. Follow the sequence lasered on bottom plate and tighten bolts again to 18 ft. lbs.
- i. Use a marker pen to mark a line on the bolts and continue this line on to the plate. Repeat step for remaining bolts.
- j. Using marks as guides, turn each bolt 1/4 turn or 90 degrees. Use same torque sequence.
- K. Remove from vise for inspection purposes, cylinder is now ready for boring, honing, or measuring.

CAUTION: Wear safety glasses. Excessive force may damage parts and tool.

Performance Parts For Harley-Davidson Motorcycles