



## Instruction Sheet For #18607-57ar

### racing Tappet Guide Use on 4 cam XL



*Please read all instructions thoroughly before starting work.*

**\*\*NOTE:** These blocks are designed for running open pushrods with tappets having an O.D. of .731 to use in Iron Head style tappet block bore. \*\*

1. Make sure bike cannot start by removing ground wire from frame. Have a clean working environment including clean rags, clean engine and a place to set everything.
2. If not already done, remove factory original blocks and tappets using JIMS® puller #95724-57.
3. Keep all foreign material out of tappet block holes.
4. Note that each tappet block is numbered on the top. Blocks marked with "1" are for cam #1 and #3 and those marked "2" are for cams #2 and #4.
5. NOTE: These blocks are designed to accommodate a lift of about .800 at valve, or about .500 lift at cam. But still check the clearance. You will need at least .035 roller to block clearance with any cam being used. To check for this do the following: With tappet in rear block, no o-ring, one tappet at a time, Cam lobe for the one that you are checking at the highest point of lift. Slide the assembly into the motor (NOTE: If the tappet block flange does not touch the motor case during this trial assembly, remove material as needed to give the necessary .035" of up and down tappet movement). With assembly still in motor snug, screw to about 30 in. lbs. Now check for .035" free movement. Do the same for the other tappets. If more clearance is needed remove the least amount of material from the tappet blocks as needed. (NOTE: Make sure to remove any burrs after modifying the blocks, wash and dry).
6. Apply a light film of motor oil or sealer to o-ring, install on blocks. Apply assembly lube to tappets and rollers. Slip tappets into blocks, you can hold tappets in place with your fingers.
7. With all blocks in place (NOTE: Putting all blocks into motor case will keep the screws from falling into case), tighten to H.D.® specifications.

**CAUTION:** Wear safety glasses. Excessive force may damage parts!  
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