



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL #4015 & 4017

JIMS® CONNECTING RODS

PRODUCED FROM FORGED 4340 AEROSPACE QUALITY STEEL

Solid Bronze Bushing for .927 wrist pin
Also Available



JIMS® Connecting Rods start out as forged aerospace quality 4340 Chromoly steel blanks, then the rods are CNC machined on our high tech mills. Each rod is heat treated, magnafluxed and shot peened, then inspected. From there, each rod goes back into the CNC mill to bore both the rod race and wrist pin bushing bores to within .0003" of each other. A 32 bore finish is achieved for the best possible bushing and race adhesion. The wrist pin bushing oiling hole has been optimized for utilizing lubrication of wrist pins, and an increase in the strength. JIMS® chooses "H-Beam" rods for stability and strength, for both drag racing and any street application, over the standard "I-beam" rods. Although we realize that "H-beam" rods are very difficult and time consuming to manufacture, JIMS®

believes that it is well worth the extra effort. Each rod set has JIMS® wrist pin bushings installed and are sized for .927" pins. JIMS® "H-beam" rods are available in two different lengths of centerline dimensions that are: 7.667" or 7.600". **Before installing these rods, please read and follow the instructions and information.**

No.4017 - Use on Twin Cam®, 1999-2006 7.600" length.

No.4015 - Use on Twin Cam®, 1999-2006 7.667" length (stock length).

Note: Rod races must be finished sized per application by engine builder.

FINISH SIZING RACES:

The rod races must be sized (honed) to a RA finish of 16, with a .001 to .0013 running fit over crank pin and bearings.

Note: If this rod assembly is used in a racing application where new engine break in is not possible, rods must be honed an additional .0005" to .0007.

CHECKING FOR TWIST AND BEND

Check rods for twist and bend from the centerline of wrist pin bushing to the centerline of races. Twist maximum .002 and bend maximum .001.

Note: Do all your twisting and bending measurement from the wrist pin end of rods with JIMS tool No.1148.

1. All connecting rods will need to be checked for case clearance.
2. Do not remove any material from the rods to gain clearances.

BALANCING:

JIMS H-beam rods are stronger and heavier than stock rods, therefore JIMS recommends rebalancing of the flywheels.

Note: Rebalancing is a must; use the percentage of balance that was used for the flywheel assembly you will be installing rods into. To check this you will need to match the total reciprocating weights of your parts i.e. pistons, rings, wrist pins, keepers and the upper half of both rods.

Performance Parts For Harley-Davidson Motorcycles