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INSTRUCTION SHEET FOR TOOL #1457 AND #1458

No.1457 CENTER THROUGH BOLT KIT

No.1458 TOP CENTER CASE BOLT SPOT FACER TOOL



This tool has been designed to spot face the right engine case, before boring engine spigot bore's for the installation of big bore cylinders. Use with the optional top center case bolt JIM'S No. 1457 as stock replacement case bolt.



See Fig 1

This new replacement case bolt No. 1457 is 1/4"-20 x 4- 3/4". The diameter of this bolt will clear the case boring tool for big bore cylinder spigots up to 4- 5/16" bore. Use on all big bore kits with bores from 4.000" to 4-5/16". When performing any case bolt hole modifications always remove any case material that may fall or crack off during engine operation. See Instruction sheet No. 1551-IS or sheet No. 1177-IS for more information about removing spigot case material. You will need to drill through the right case to use this bolt kit.

ATTENTION!

Please read all instructions completely and thoroughly before performing any work. Prior to use of this tool read and follow the procedures and safety precautions to reduce the risk of personal injury. Read instructions completely so you understand before performing any steps. Always disconnect battery cables to prevent injury. Your work place should be clean and well lit. Wear safety glasses and protective clothing when working around power tools and compressed air. Follow instructions in H-D® Service Manual for removal and disassembly of engine for your year and model.

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, QUALITY OR SAFETY OF YOUR WORK.

Tools required when using with this tool.

Drill press or a good (no run-out drill chuck) 3/8" drill motor. Use a 17/64" drill bit and WD 40.

Keep all parts and tools clean. Also keep bearings and oil passages masked off and or covered at all times. See instruction sheet No.1451-IS for torque specifications and instruction. See web site or call sales for more center case bolt information.

Tool instruction

- A. You will be using the right case center bolt hole as a guide for 17/64" drill bit. All drilling will be from the inside surface of the case. If you are using a drill press, support your right case half using a non-marring material and position with the inside of the right case facing up. **See Fig 2**



FIG.2



FIG.3

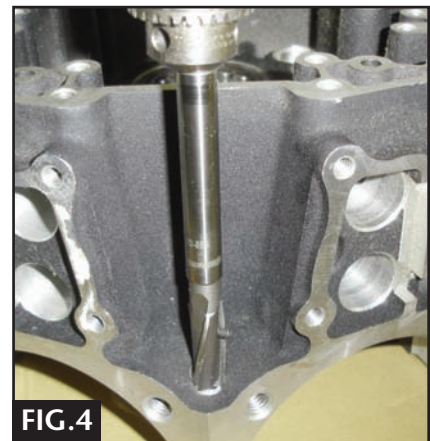


FIG.4

CAUTION: WEAR SAFETY GLASSES OVER YOUR EYE'S.
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- B. Clamp it to the drill press table after you have aligned the drill bit with the center case bolt hole.
- C. If you will be using a 3/8" hand drill, be sure to clamp the case to a non-marring surface.
- D. Apply a small amount of WD 40 to the inside of the case hole and with light pressure on the hand drill, drill straight through the case. **See Fig 2**
- E. Flip case over on the same non-marring surface and secure on a flat surface.
- F. Next, using your No.1458 Spot Face tool, you will need to insert the pilot guide into the end of spot face cutter. Next you will need to position pilot by locking the set screw with a .375" gap between cutter and pilot. **See Fig. 3**
- G. Next apply a small amount of W-D 40 to the pilot end of tool No.1458-2 and cutter No. 1458-1.
- H. Now you need to load No.1458 tool assembly into your drill press or hand drill then perform your spot face cut.
- I. Insert the spot face pilot No.1458-2 slightly into the 17/64" drilled hole. Using light pressure spot face the case just until a full cleanup is established. (Approx .03" deep Max.) **See Fig 4. & Fig 5**
- J. You should now have a good flat surface for No.1453 Allen Case bolt to seat on. **See Fig 6.** Your case is now ready for boring the cylinder spigots. Follow instruction sheet No. 1551- IS for all installing information including all torque information.



FIG.5



FIG.6

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