



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL No.931 & 932



No.931 PARTS AVAILABLE SEPARATELY

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	931-1
2	1	TOP TORQUE PLATE	931-2
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	931-IS

No.932 PARTS AVAILABLE SEPARATELY

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	932-1
2	1	TOP TORQUE PLATE	932-2
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	931-IS

TORQUE PLATES FOR CUSTOM CHROME REV-TECH MOTORS

No.931 - Use on 100" motors with 4-3/8" stroke using 3.8125" bore cylinders.

No.932 - Use on 100" or 110" motors with 4" stroke using 4" bore cylinders.

Note: To check cylinder measurements accurately these torque plates are essential. These plates simulate stress conditions when boring and honing.

See JIMS catalog for a complete listing of all Engine and Transmission Tools

**NOTE: PLEASE READ ALL INSTRUCTIONS COMPLETELY BEFORE PERFORMING ANY WORK!
IF YOU DO NOT KNOW WHAT YOU ARE DOING, DO NOT DO IT!**

No information in this instruction sheet pertaining to motorcycle repair is represented as foolproof or even altogether safe. Even something safe, done incorrectly or incompletely can and will backfire. You and only you are responsible for the safety of your repair work and for you understanding the application and use of repair equipment, components, methods and concepts.

Each and every step this tool is designed to do must be carefully and systematically performed safely by you. All information listed in this instruction sheet has been tested, re-tested and used daily in JIMS® Research and Development Department.

ALWAYS WEAR SAFETY GLASSES OR OTHER FACE AND EYE PROTECTION SUCH AS FULL FACE SHIELD. JIMS® IS NOT RESPONSIBLE FOR DAMAGE, INJURY, OR THE QUALITY AND SAFETY OF YOUR WORK.

Warning: Disconnect the negative ground cable at the battery or Maxi-fuse as indicated in service manual.

Note: Below you find just one example of how to use JIMS Torque Plates.

Prepare cylinders for mounting torque plates.

- A. Remove cylinders from motor according to your H-D® or Clymer service manual.
- B. Thoroughly clean cylinders after removing o-ring (If applicable). Be sure cylinders are free of any residual sealing material.
- C. Check the gasket-sealing surface of both cylinders for flatness according to your H-D service manual.

Performance Parts For Harley-Davidson Motorcycles



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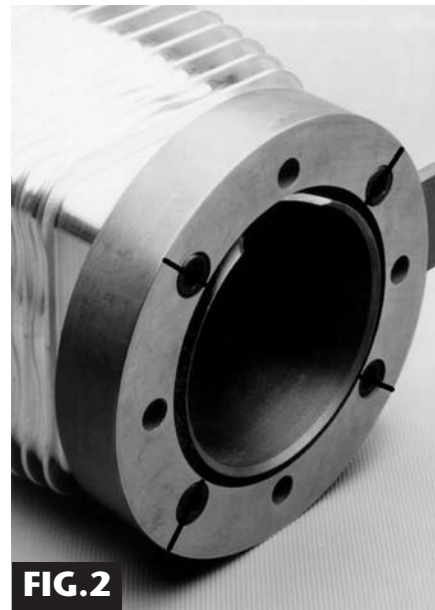
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Mounting Torque Plates

- A. Install the vice tab No. **1073-2** to the bottom plate or laser lettered side of the plate No **932-1** (for 3.8125") or No **931-1** (for 4"). Next apply clean oil or lube to the two 5/16" Allen bolts No. **2405**. Torque to 12 ft-lb.
- B. Place a used head gasket, and used o-rings (If applicable) over the ring dowels if removed from torque plates from previous hone job.
- C. Hold (mount) lower torque plate No **932-1** (for 3.8125") or No **931-1** (for 4"). in vise by clamping on tab No.1073-2. **See FIG 1**

Note: *Laser side must face you.*

- D. Next apply clean oil or lube to all 4 Allen bolts No. **1208**. Apply clean oil or lube to under side of all bolt heads and to bottom side of washers No. **1265**.
- E. Apply clean oil or lube to all four bolt holes in top plate. Slip all four bolts and washers thru the four holes in bottom plate and thread into top plate.
- F. Tighten bolts alternately in a clockwise pattern until snug.
- G. Tighten bolts to 8 ft-lb using the sequence show in service manual for headbolts.
- H. Follow the torque sequence for headbolts in service manual and tighten bolts again to 18 ft-lb.
- I. With grease pencil or a marking pen, mark a line on the top or side of all four bolts, continue this line onto the plate, and mark all four bolts. **See FIG 2.**
- J. Using marks as guides, turn each bolt 1/4 turn or 90° following same torque sequence.
- K. Remove from vise. Cylinder is now ready for boring or honing.

**FIG.1****FIG.2**

CAUTION: WEAR SAFETY GLASSES OVER YOUR EYES.
SEE JIMS® CATALOG FOR HUNDREDS OF TOP QUALITY PROFESSIONAL TOOLS.
THE LAST TOOLS YOU WILL EVER NEED TO BUY.

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