



Instruction Sheet For #96740-36



Rod Lapping Set

Use on all Big Twin, Sportster,
K-Model s, 45" and Indian rods.

Arbor Assembly Includes: 1-1/2" and 1-5/8" Laps
Use Jims® Tool No.1003 for removing and installing races.

Refer to H.D.® Service Manual for specifications.

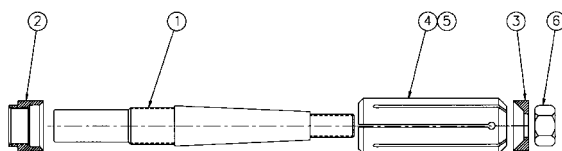
When new rods are installed, or when fitting oversize rollers, they must be lapped to fit. There are two reasons for this:

First the race is supplied undersize.

Secondly the race may become somewhat distorted during installation.

Install the rod race lapping tool in a lathe. Coat the tool with a thin coat of lapping compound (#220 grit) and set it so that the rod is a snug, NOT TIGHT, fit on the lap. A loose lap will bell-mouth the rod. Rotate the lap at 150-200 RPM being sure that you:

1. Frequently reverse the rod on the lap.
2. Move the rod back and forth across the full length of the lap.
3. Do only one rod at a time.
4. Check size frequently.
5. When rod is lapped true and all traces of pit marks have been removed, your races should have a soft velvet appearance and be free of shiny spots.
6. Wash and blow dry.
7. See your H.D.® Service Manual for instructions on fitting the bearings.



PARTS AVAILABLE SEPARATELY			
No.	Qty.	Description	Part No.
1	1	MAIN BODY	96740-36-1
2	1	ADJUST COLLAR	96740-36-2
3	1	COLLAR	2131
4	1	LAP HEAD 1-1/2" OD	96740-36-4
5	1	LAP HEAD 1-5/8" OD	96740-36-5
6	1	HEX HEAD NUT	2000

CAUTION: Use safety glasses, Excessive force may damage parts or tools.

"FROM THE TRACK... TO THE STREET!"