



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL No.930 & 951



No.930 PARTS AVAILABLE SEPARATELY

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	1287-1
2	1	TOP TORQUE PLATE	930-2
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	930-IS

No.951 PARTS AVAILABLE SEPARATELY

NO.	QTY.	DESCRIPTION	PART NO.
1	1	BOTTOM TORQUE PLATE	1287-1
2	1	TOP TORQUE PLATE	951-2
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	930-IS

No. 930 - Use to bore or hone, 4" to 4.060" on JIMS Big Bore cylinders, H-D Bigger Bore 4.060" Cylinders with O.E.M. bolt pattern, 99-present Twin Cam.

No. 951 - Use to bore or hone, 3.75" to 3.875" H-D Twin Cam 88", 96", or 103" with O.E.M. bolt pattern, 99 to present.

These torque plates, when installed on cylinders, will simulate a cylinder in a running condition. In this state you will be able to accurately check for out of round and straightness of the cylinder bore.

**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 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 YOUR WORK. JIMS® IS NOT RESPONSIBLE FOR THE QUALITY AND SAFETY OF YOUR WORK.

**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.**

Performance Parts For Harley-Davidson Motorcycles



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL No.930 & 951

Important!

To check cylinder measurements accurately these torque plates are essential. These plates simulate stress conditions when boring and honing. The plates are laser marked with the correct torquing sequence.

Note: Some engine builders like to use used head gaskets with o-rings around the top dowels and base gaskets when using torque plates. New gaskets are also ok to use. JIMS® has not seen any harm in using them, nor have we seen any harm in not using them.

INSTRUCTIONS: Please read all instructions before performing work.

Step-1 Prepare cylinders for mounting:

- A. Remove cylinders from motor according to your H-D® service manual.
- B. Thoroughly clean cylinders free of any residual sealing material.
- C. Check cylinder-sealing surface for flatness and cracks according to your H-D service manual.

Step-2 Mount Torque Plates:

- A. Install vice tab plate to the lasered side of the bottom torque plate with the two JIMS No 2405, 5/16" allen bolts. Use two drops of blue Loctite® and torque to 15 ft-lb.
- B. Install a used head gasket, and used base gasket over the dowels if not removed.
- C. Install the lower plate No.1281-1 in the vise by clamping on tab.

Note: Laser side should face you and machined strip facing away from you. Apply lube to all threads on the face of bolts and washers. Slip four No.1208 bolts with No.1265 washers, through lower plate.

- D. Install cylinder and top torque plate by aligning holes with bolt threads.
- F. Tighten bolts in a clockwise pattern until snug.
- G. With this assembly held safely, tighten bolts to 8 ft-lbs using the sequence lasered on the bottom plate.
- H. Follow the sequences lasered on bottom plate and tighten bolts again to 18 ft-lbs.
- I. Use a marker pen to mark a line on the bolt heads and continue this line on to the plate for all 4 bolts.
- J. Using marks as reference turn each bolt 1/4 turn or 90 degrees. Use same torque sequence.
- K. Remove from vise for inspection purposes. Cylinder is now ready for honing.
- L. Do all boring, honing and inspection with torque plates installed.

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.

Performance Parts For Harley-Davidson Motorcycles