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IH: Body Parts - Sub-01G

1973-1976 XLH, XLCH Sportster Frame Pics

[Click Here](#) to reference Sportster VIN Information in the History section of the Sportsterpedia.

Click on any pic to enlarge:

1973 models used 3 different frames; ¹⁾

- Early - used the cast (same as 70-72).
- Mid - used the 1st bent rectangular bar frame and retained the earlier brazed construction.
- Late - same as mid but now welded. This frame was also used on e74.

Late 1974 got the diagonal bracings added. Adding the diagonals was a factory safety recall for mid 73-E74 (there is a pn in the 76 and 78 parts catalogs for the kit).

Without the braces, the rectangular bar would bend. This allowed the tire to contact the fender. When that happened, the tail lite and tires got wrecked. That = recall.

See "1973 XL, XLCH Frame Reinforcement / Tail Lamp Mod" below for more information.

A bend in the frame backbone on the right above the motor mount bolt may be found on L1973-1976 Sportster frames and does appear to be factory induced.

It has been believed to be for easier access to the motor mount bolt but the threaded area around the right side petcock on the gas tank hangs down close to the bend in the frame.



²⁾

The one frame fits both XLH and XLCH applications.

The left seat post has a "C" channel welded on the lower end for battery tray brackets (threaded holes on upper and lower end, 1 lower for XLH, both for XLCH).

There are 4 squared holes in the middle of the bracket for little plastic expansion nuts (70574-68) used to attach wiring terminals.

These terminals were used for 1970-1972 models for the tail and turn lights before going to plug connectors in 1973.

But with some future year frames sold as replacement for certain older frames, the terminal strip could be used on 70-72 replacement or left alone for newer frames not needing them.

L73-76 frame was suggested as replacement back to 1967 XLH and 1970 XLCH. [Click Here](#) to see the main Ironhead frame page for details on replacement frames).

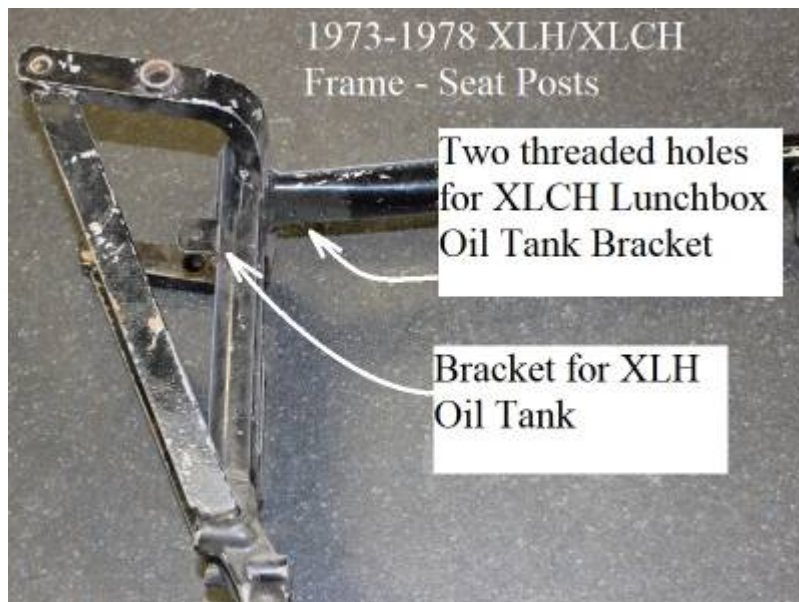
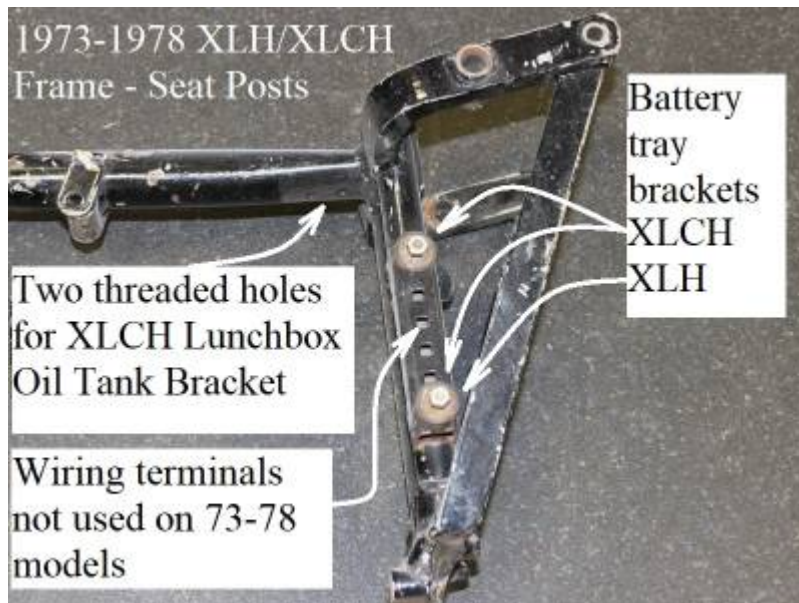




5)



6)





1973 XL, XLCH Frame Reinforcement / Tail Lamp Mod

[A service bulletin was issued for SAFETY DEFECT CODE 023, |](#)

[Click Here to download TSB# 656](#)

All EI973 XL and XLCH frames:

Corrective modification was required to prevent possible breakage at the welded junction of the frame tubes and the rear fender and shock absorber support bracket.

Some cases of breakage reported was caused by heavy stress concentration in this location.

In conjunction with this recall program, a further improvement in tail lamp wiring was to be made to correct the short circuit problem originally communicated in TSB# 650.

The rear fender support attaching bolts were to be relocated to raise the fender rear end and provide more clearance between the tire and taillight wires.

(to prevent possible short circuit caused by the tire rubbing through wire insulation under abnormal rear end loading)

A Frame Brace and Fender Support Kit (47420-74) was issued to make these changes. Below are contents of the kit.

47087-74	Brace (2)	For welding to each side of frame	10006	Strap fastener (1)	If required
59660-73	Plate (2)	For relocating fender support bolt	68204-74	Tail lamp wire (green) (1)	
59798-52	Fender Pad (1)		68203-74	Stop lamp wire (red) (1)	

6702	Washer (1)	To space out oil tank (if required)	68202-74	Rubber boot (1)	For lamp socket
10013	Oil hose clamp (2)	If required	72039-71	Pin Terminal (3)	For tail and stop lamp wires
10014	Oil hose clamp (1)	If required			



11)



12)



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Dr Dick of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/170265-frame-change?t=1826493>

2)

photo by Jtrapass of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/80046-frame-repair?t=584357>

3) 4) 5) 6) 11) 12) 13)

photo courtesy of Ebay seller, animalhouse2010, [Link to Ebay store:](#)

7) 8)

photo courtesy of Ebay seller, Acme Motorcycle Parts. [Link to Ebay Store:](#)

9) 10)

photo courtesy of Ebay seller, Motorcycle Dreams. [Link to Ebay Store:](#)

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