

Table of Contents

IH: Engine Mechanicals - Sub-01D	1
Ironhead Primary/Chain Cover Pics	1
1952-1953 K Model Primary Cover	1
1954-1956 K Model Primary Cover	2
1957-1966 XL/XLH Primary Cover	3
1958-1969 XLCH Primary Covers	5
1958-1963 version	6
1964-1969 version	6
1967-1970 XLH Primary Cover	7
1970 XLCH Primary Cover 34948-70	9
1973 XLH/XLCH Primary Cover 34949-73	9
1983-E1984 XLX Primary Cover 25433-83	10
L1984-1985 XLX Primary Cover 25433-84	11

[Go To Technical Menu](#)

IH: Engine Mechanicals - Sub-01D

Ironhead Primary/Chain Cover Pics

1952-1953 K Model Primary Cover

The HD part number is (34951-52) and the casting number is (34950-52).

Gasket: (34955-52).

Fasteners: (3) cover screws and no dowel pins. Case has pin bosses but they are not drilled out.

The original cover finish is natural (as cast).

Cover has a divot in the lower bottom to clear the sidestand mount.

There is an oil level plug boss behind the divot but the boss was not drilled and tapped for a screw.

Rear brake switch boss on the rear of cover.

Oil filler plug (34742-52) screws into the cover. It has a small hole through the center to vent the primary compartment.





3)



4)

1954-1956 K Model Primary Cover

The HD part number is (34951-54) and the casting number is (34950-52A).

Gasket: (34955-52A).

Fasteners: (3) cover screws, (4) 3/16" dia roll pins to locate the cover to the case.

The oil level plug boss was moved in front of the lower cover divot, hole was tapped for a screw (3728) and a washer (6218W).

Half moon divot added to lower rear near brake switch boss to clear brake lever return spring.

Rear brake switch boss on the rear of cover.

Oil filler plug (34742-52) screws into the cover. It has a small hole through the center to vent the primary compartment.

Click on a pic to enlarge: ⁵⁾





1957-1966 XL/XLH Primary Cover

The first primary cover for Sportsters. Cast aluminum with the "Sportster" script cast into it. It was replaced in 1967 when the electric start was added to the H model. It is similar to the K-Model (also KH and KHK) primary which preceded it, with two notable differences. The K-Model primary didn't have the scrips and the Sportster primary protrudes out further accommodating the compensating spring on the motor sprocket. ⁶⁾ HD part number is (34951-57) and the casting number is (34950-57).



Click on a pic to enlarge: ⁸⁾





1957-1966 XL/XLH Primary Cover (34951-57)



1957-1966 XL/XLH Primary Cover (34951-57)



1957-1966 XL/XLH Primary Cover (34951-57)

1958-1969 XLCH Primary Covers

The XLCH primary “tin” cover has several versions. Below are the two used on production models from 1958-1969. ⁹⁾

There are no casting numbers on these covers as they are stamped steel.

The 1958-1963 version is very similar to the 1964-1969 version. The only difference can be seen from the back.

Notice that the inside of the derby on the 1958-1963 version is smooth because of the two-piece construction.

The '58-'63 XLCH primary covers are sometimes referred to as “double derbies”.

Click on a pic below to enlarge:



1958-1963 version

HD part number is (34949-58) and it's made of stamped steel.



1964-1969 version

HD part number is (34949-64) and it's made of stamped and chromed steel.

Click on a pic below to enlarge: [12\)](#)



1967-1970 XLH Primary Cover

The HD part number is (34947-67) and the casting number is (34950-67).

This is the first electric start chain cover.

The hump-back on the rear of the cover mates up to the hump on the left case where the starter is mounted.

The boss near the hump holds a Torrington B1210 bearing (9063) for the starter shaft.

The tiny hole below front mounting bolt on the hump (as installed) is for a locating pin to the case for bearing alignment.

Click on a pic to enlarge: [13\)](#)



1970 XLCH Primary Cover 34948-70

Click on a pic to enlarge. ¹⁴⁾



1973 XLH/XLCH Primary Cover 34949-73

Click on a pic to enlarge: ¹⁵⁾

1973 XLH/XLCH Primary Cover 34949-73



1973 XLH/XLCH Primary Cover 34949-73



1973 XLH/XLCH Primary Cover 34949-73



1983-E1984 XLX Primary Cover 25433-83

Click on a pic to enlarge: [16\)](#)



1983-E1984 XLX Primary Cover 25433-83



1983-E1984 XLX Primary Cover 25433-83



L1984-1985 XLX Primary Cover 25433-84

Click on a pic to enlarge: ¹⁷⁾





Go To Technical Menu

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photos courtesy of Dawg's HD Parts. [Link to Ebay Store](#)

6)

Moon Wolf of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/112326-a-photo-catalog-of-ironhead-parts?t=1062720>

7)

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<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/112326-a-photo-catalog-of-ironhead-parts?t=1062720>

8)

photos courtesy of Ebay seller, panknuckpartsandtreasures. [Link to Ebay Store](#)

9)

Moon Wolf of the XLFORUM <http://xlforum.net/forums/showthread.php?t=1062720>

10) , 11)

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12) , 14) , 15) , 17)

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photos courtesy of Eugene Rouse of River Side Cycle, [Link to site](#)

16)

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