

## REAR BRAKE MASTER CYLINDER PUSH ROD / XLCR-1000

All XLCR-1000 motorcycles produced during the 1977 and 1978 model season were shipped with rear brake master cylinder push rods having insufficient contact area with the rear brake master cylinder plastic piston. In this condition it is possible that during extremely high brake pedal effort such as during an emergency stop, the brake rod could penetrate the master cylinder plastic piston, with possible loss of hydraulic pressure.

If the operator of such a motorcycle applied the rear brake only and punctured the piston and there was not sufficient time for front brake application in an emergency stop, a possible accident could result because of loss of rear brake effectiveness. The front brake would still be fully operational.

In compliance with the National Traffic and Motor Vehicle Safety Act, this has been declared a safety defect and the affected motorcycles must be corrected before sale or use.

To take care of your immediate requirements, we are shipping a quantity of Rear Brake Master Cylinder Repair Kits, part No. 93269, no charge -- transportation prepaid. This is approximately 60% of your requirements. Over and above these requirements, you must order additional kits to correct the balance of motorcycles shipped to your dealership.

Determine the balance of Kits you will require, and order immediately using the enclosed special order blank. These Kits will be shipped no-charge transportation prepaid.

The no-charge shipment of this program will expire on November 15, 1979. After that time, any Kits which you order under special number 93269 will be charged to your account. Kit consists

of Master Cylinder Repair Kit, part No. 42374-77 and larger Master Cylinder Push Rod, part No. 42312-80.

Instructions for installing these parts are included at the end of this bulletin.

Registered owners of record will be notified by mail to contact you to have this service performed at no charge (see enclosed letter). Each letter to the registered owner will include Dealer Service Card 040, which must be completed, dated, and signed by the customer and dealer.

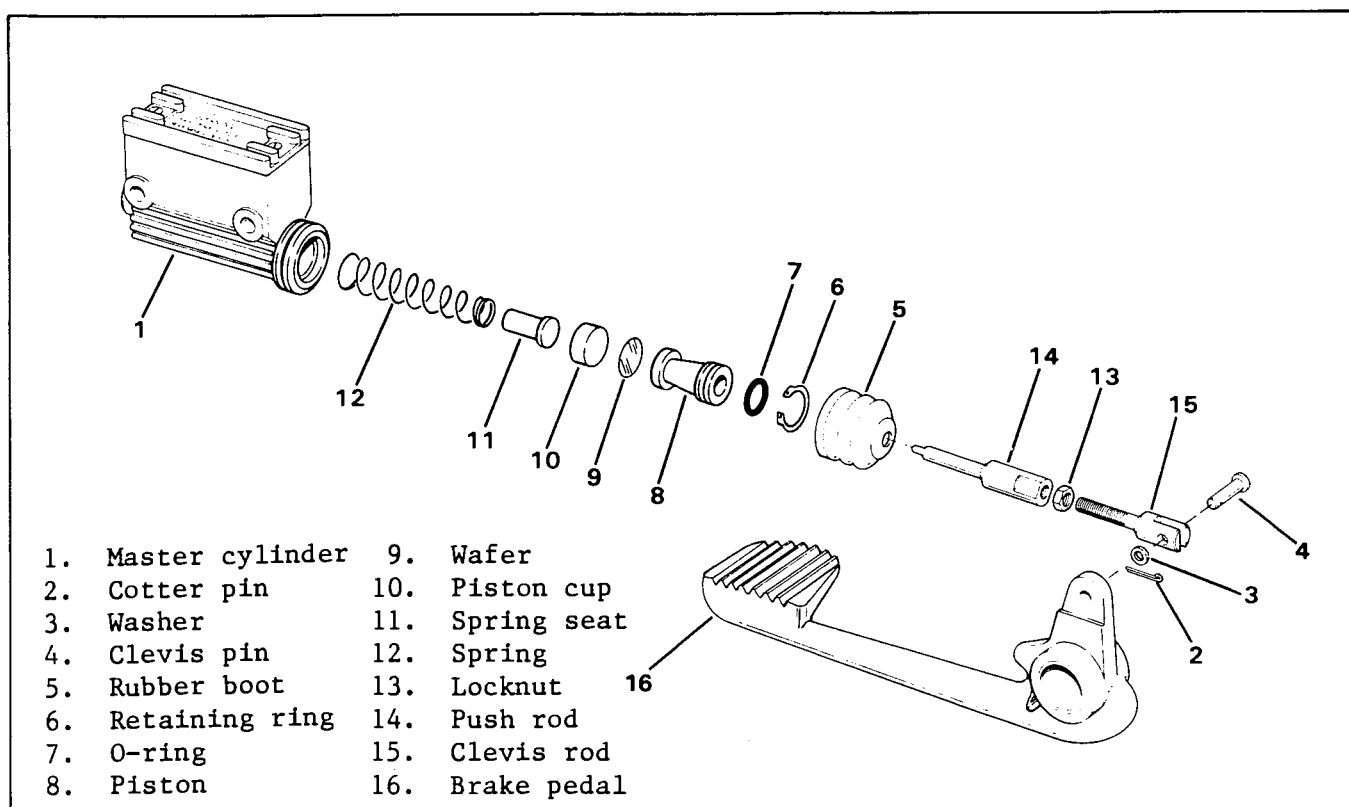
A list of registered owners and a list of unregistered vehicles involved in this campaign, which have been delivered to your dealership, are included with this bulletin. It is your responsibility to perform the required service on all affected vehicles, including those which you did not sell originally or which may not show on the lists. We are enclosing sufficient blank Dealer Service Cards for those vehicles.

IMPORTANT

If any 1977 or 1978 XLCR motorcycles have been sold by you, we request that you contact the purchasers immediately, warn them of the inherent safety hazard, and make arrangements for installing the new, larger diameter push rod, and master cylinder repair kit.

The parts that are removed from corrected motorcycles must be returned to Harley-Davidson Motor Co. with properly completed Dealer Service Card(s).

Fill out the cards completely for each motorcycle, including Code 040, vehicle identification number (VIN), your dealer account number and mark "Replace" box only. Upon receipt of properly completed Dealer Service Card with re-



Rear Brake Master Cylinder - Exploded View

moved parts, your account will be credited 0.7 hours for each motorcycle serviced to cover your cost for labor, brake fluid, and processing.

A return address P-label is enclosed with parts furnished to you. Please put this label on the outside of the box of removed parts you are returning to us.

Rear brake push rods, part number 42312-77, in your parts order stock should be returned to Harley-Davidson Motor Co, Inc. for credit using properly completed warranty claim form.

INSTRUCTIONS FOR REPLACING MASTER CYLINDER PUSH ROD AND INSTALLING MASTER CYLINDER KIT--(See illustration).

#### Disassembling Rear Disc Brake Master Cylinder

The master cylinder (1) is mounted to the rear chain sprocket cover, just above the rear brake pedal. Disassemble as follows. Remove master cylinder cover and gasket.

Disconnect brake linkage by removing cotter pin (2), washer (3) and clevis

pin (4). Pull linkage assembly out of master cylinder. Remove the following: rubber boot (5), retaining ring (6), O-ring (7), piston (8) wafer (9), piston cup (10), spring seat (11) and spring (12).

Examine master cylinder wall for grooves and scratches. Top cover gasket should be replaced if torn or punctured.

#### Assembling Rear Brake Master Cylinder

Dip all internal parts from supplied piston kit in DOT 5 type brake fluid prior to assembly. Insert these new parts from kit into master cylinder in order shown in illustration. Make sure O-ring is positioned in groove of piston before inserting piston into cylinder.

Loosen jamnut (13) and unscrew old push rod (14) from clevis rod (15). Install new push rod, part No. 42312-80 supplied to you, on clevis rod. Do not tighten jamnut until brake linkage is properly adjusted later.

Reposition push rod linkage in master

cylinder and secure to brake pedal with clevis pin (4), washer (3) and cotter pin (2).

Work brake pedal lever up and down by hand to determine free play before push rod contacts piston in master cylinder. Free play of push rod should be approximately 1/8 inch to be sure that master cylinder pressure is relieved. To adjust free play, push rod on clevis rod threads - forward to decrease free play or rearward to increase free play. Adjustment should be made starting with linkage very loose, then adjusting push rod until 1/8 inch free play in the push rod is obtained. Tighten locknut (13).

#### Bleeding Hydraulic System

Fill master cylinder reservoir with DOT 5 type brake fluid. Reservoir may be filled using pressurized equipment if available. Bleed system as described in "BLEEDING HYDRAULIC SYSTEM."

#### NOTE

Before adding hydraulic fluid to reservoir, check to see that relief port in master cylinder is uncovered when brake pedal is released.

After servicing hydraulic brake system where any hydraulic line or cylinder is opened, it is necessary to bleed the system to expel all air.

**WARNING --** Brake fluid can cause irritation of eyes and skin and may be harmful if swallowed. If fluid is swallowed, induce vomiting by administering two tablespoons of salt in a glass of warm water. Call a doctor. In case of contact with skin or eyes, flush with plenty of water. Get medical attention for eyes. **KEEP BRAKE FLUID OUT OF THE REACH OF CHILDREN!**

Slip a length of appropriate size plastic tubing over rear wheel cylinder bleeder valve with other end submerged in brake fluid in a clean container.

Place motorcycle in a straight ahead, upright position. Open bleeder valve by rotating counterclockwise about one half turn. With master cylinder full of fluid at all times, slowly operate brake repeatedly until fluid flows from tubing free of air bubbles. Close bleeder valve. Add fluid to master cylinder to bring to original level. Do not reuse fluid.

Check for pressure relief indication by watching for fluid squirt when pedal is depressed. Reinstall gasket and cover - be sure cover vent hole is open.

#### NOTE

Hydraulic brake fluid pressure equipment can be used to fill brake master cylinder through the wheel caliper bleeder fitting, providing master cylinder cover is removed so that system cannot pressurize.

After bleeding system, test ride motorcycle. If brake feels spongy, repeat bleeding procedure. Check linkage adjustment for proper free play of push rod. See "ADJUSTING BRAKE LINKAGE."

HARLEY-DAVIDSON MOTOR CO., INC.

ROUTING:	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	CHIEF MECHANIC	MECHANIC NO. 1	MECHANIC NO. 2	MECHANIC NO. 3	MECHANIC NO. 4	RETURN THIS TO:
INITIAL HERE									



HARLEY-DAVIDSON MOTOR CO., INC.  
3700 W. Juneau Ave., P.O. Box 653, Milwaukee, WI 53201 • 414/342-4680  
Subsidiary of AMF INCORPORATED

SAMPLE COPY

June 11, 1979

Dear Harley-Davidson Owner:

This notice is sent to you in accordance with the requirements of the National Traffic & Motor Vehicle Safety Act.

Harley-Davidson Motor Co., Inc. has determined that a defect which is related to motor vehicle safety exists in the rear brake master cylinder located on the engine right sprocket cover of all motorcycles with model designation: XLCR-1000 (V.I.N. prefix 7F). These motorcycles were manufactured during the 1977 and 1978 model season (V.I.N. suffix H7 and H8).

Your motorcycle is one of the above models produced with a rear brake master cylinder push rod which has insufficient contact area with the rear brake master cylinder piston. This condition could result in the rod penetrating the piston during extremely high pedal effort such as during an emergency stop, possibly resulting in an accident due to loss of the rear brake. This could occur suddenly without prior warning.

You would still have full use of the front brake.

We advise you to not operate your motorcycle until the master cylinder and push rod can be replaced and please contact your dealer immediately to arrange for this service.

The necessary parts to correct your motorcycle will be available at your dealer approximately June 15, 1979. Replacement will take approximately 1/2 hour and will be done at no cost to you.

To verify that the corrective work has been completed, the enclosed dealer service card must be presented to the dealer when service is performed and signed by you and the dealer and returned to us. If you have sold your motorcycle, please accurately fill out and mail the enclosed motorcycle owner card giving information on your purchaser which will enable us to contact and advise that person of this recall.

If you take your motorcycle to your dealer on the mutually agreed upon service date, and he does not perform the required service at no cost to you on that date or within a reasonable period of time, please contact our Service Department at the address or telephone number on this letterhead for our assistance.

(OVER)

If service assistance is not provided to your satisfaction after contacting us, you also have the opportunity under law to inform the Secretary of Transportation using the following address: Administrator, National Highway Traffic Safety Administration, U.S. Department of Transportation, Washington D.C. 20590.

Thank you for your cooperation. We regret that this recall may cause you inconvenience, however, we have taken this action in the interest of your personal safety and satisfaction with our product.

Harley-Davidson Motor Co., Inc.

Enclosure: