

SERVICE BULLETIN



M-963 - Replaces M-956

May 2, 1988

ALIGNMENT - C.V. CARBURETOR MANIFOLD AND FLANGES

This service bulletin is a correction for the C.V. carburetor alignment procedure in service bulletin M-956.

The manifold alignment marks have been changed since Service Bulletin M-956.

See figure 1. The hard rubber manifold now has molded-in nubs 1/8 in. off the bottom parting line.

Both flanges have a small cast-in bump.

Align the flange bumps with the manifold nubs when installing current production XLH carburetors.

NOTE

- There are now two types of C.V. carburetor manifolds on XLH vehicles:
Manifold with molded-in nubs (late 1988 - current production).
Manifold without molded-in nubs (early 1988 - previous production).
- The **cast-in bumps** on the flanges have been designed to align with the **molded-in nubs** on the manifold.
- On XLH vehicle manifolds without nubs, align so the flange bumps are 1/8 in. **PAST** the parting line on the manifold.

To install the carburetor and manifold, follow the instructions in the 1986 to 1988 XLH Models Service Manual, except:

When you position the manifold on the cylinder head studs, be sure the flanges are correctly installed on the manifold. Be sure the steel inserts are in place.

- Place the manifold and flange assembly in position on the cylinder head studs.
- On late 1988 XLH vehicles, align the bumps on the flanges with the nubs on the manifold.
On early 1988 XLH vehicles that have manifolds without the nubs:
 - Align the flange bumps and manifold parting line.
 - Rotate the manifold **up** until the parting line is 1/8 in. **PAST** the bumps.
- Install the stud washers and nuts. Install the cylinder head washers and socket head bolts.
- Check to be sure the manifold and the flanges are still aligned.

CAUTION

DO NOT tighten the nuts and bolts and then try to align the manifold and flange bumps. The manifold will be damaged.

- Tighten the flange stud nuts and socket head bolts to 6 - 10 ft-lbs torque.
- Check to be sure the manifold and the flanges are still aligned.
- Install the carburetor as described in the 1986 to 1988 XLH Models Service Manual.

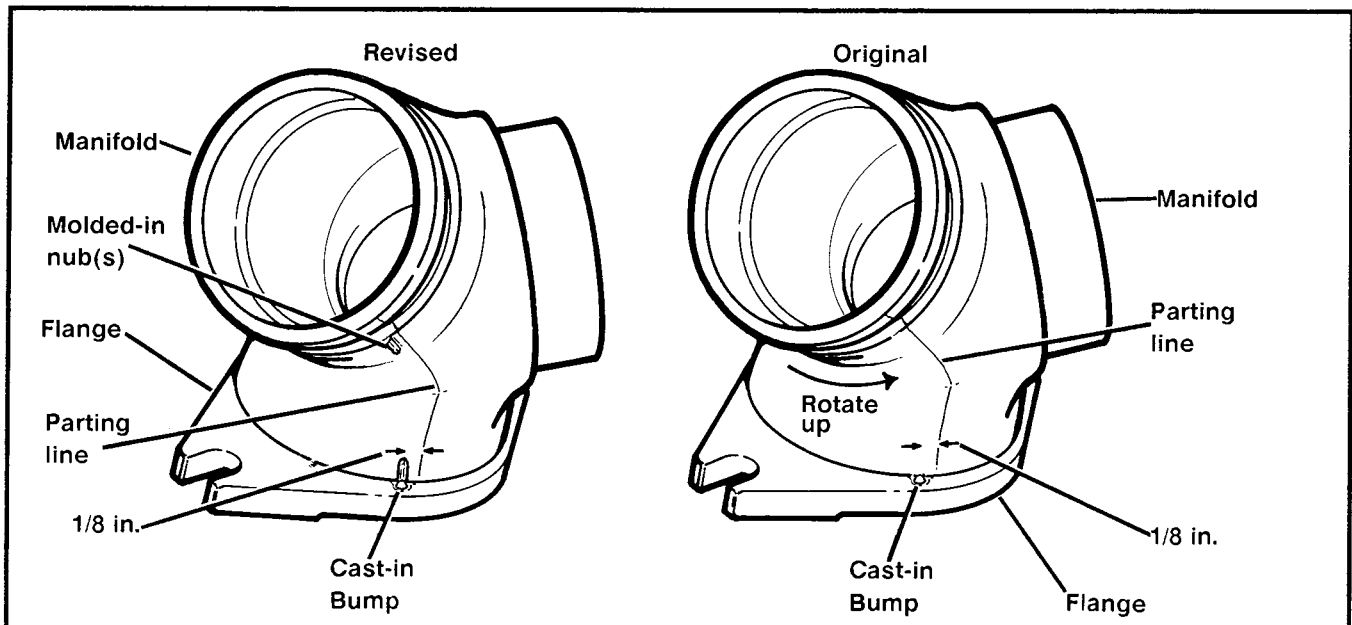


Figure 1. Alignment - XLH Manifold and Flange(s)

ROUTING:	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	LEAD TECHNICIAN	TECHNICIAN NO. 1	TECHNICIAN NO. 2	TECHNICIAN NO. 3	TECHNICIAN NO. 4	RETURN THIS TO:
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