



INSTRUCTIONS

-J00046

REV. 7-1-95

Kit Number 27004-88A

883 AND 1200 ALUMINUM MANIFOLD KIT

General

This kit is designed for installation on 1988 - 1989 XLH Sportster vehicles.

Each kit contains the following parts:

| QTY | DESCRIPTION |
|-----|-----------------------|
| 1 | Intake manifold |
| 2 | Seal, intake manifold |
| 1 | Seal ring, carburetor |

Removal

⚠ WARNING

Gasoline is extremely flammable and highly explosive under certain conditions. Do not smoke or allow open flame or sparks anywhere in the area when refueling or servicing the fuel system.

1. Turn fuel supply to off. Remove fuel hose at the fuel valve.
2. See Figure 1. Remove the two bolts with hardware (2 through 13) that attach fuel tank to frame. Remove fuel tank (1).
3. Free enricher cable at mounting bracket by loosening nut at back of cable and sliding enricher cable out of slot.
4. See Figure 2. Remove two screws (1), air cleaner cover (2) and air cleaner element (3).

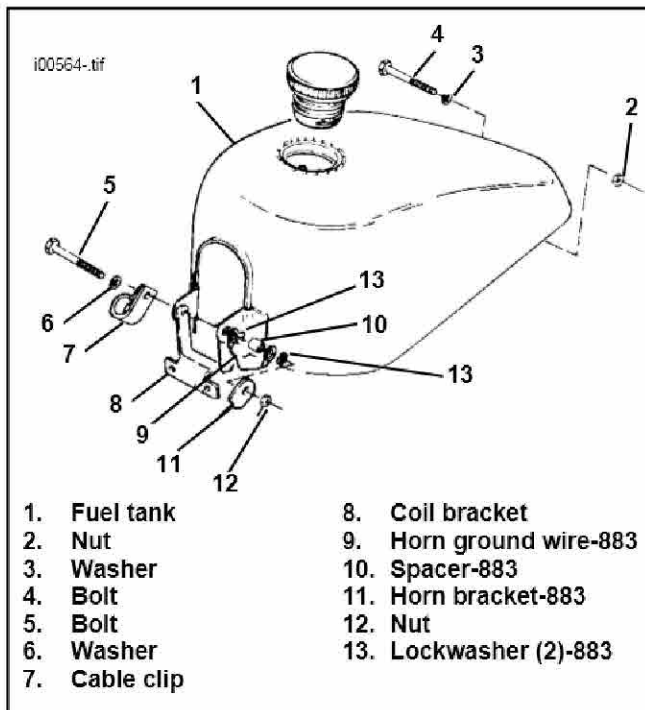


Figure 1. Fuel Tank Assembly

5. Remove two large Allen screws (4) and washers (5) that attach air cleaner backing plate to cylinder head.
6. See Figure 3. Loosen hose clamp (4) securing carburetor to manifold.
7. Disconnect VOES hose from carburetor.

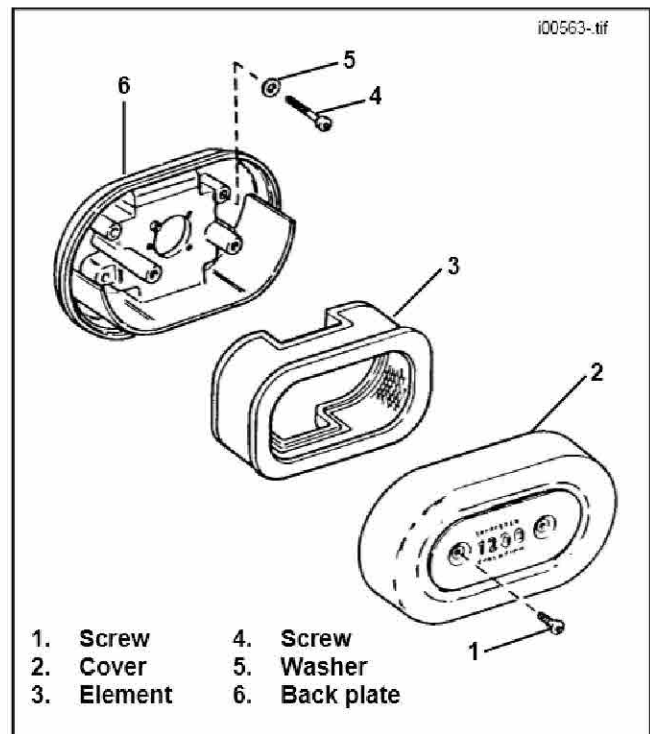


Figure 2. Air Cleaner Assembly

8. Swing carburetor and backing plate assembly free of manifold. Leave enricher and control cables attached. Remove and discard hose clamp (4).
9. On 1200cc vehicles only, remove the nut that secures the horn and ignition switch to the top center engine mount. Swing the ignition switch/horn assembly out of the way.
10. Remove manifold flange nuts (9), washers (8) from studs (7) in cylinder head.
11. Using 1/4 in. Bondhus driver, Snap-on Part No. FABL8, remove manifold socket head screws (5) securing manifold flanges to cylinder heads.
12. Remove manifold (3).
13. Pry out inserts (6) that are inserted inside manifold and remove manifold flanges (1) and (2).

Installation

1. See Figure 4. Place flanges (1) and (2) removed from original manifold onto aluminum manifold (8).
2. Place new intake manifold seals (3) onto each spigot of manifold with chamfered edge against flanges (1) and (2).
3. Place channel of seal ring (9) over inlet end of manifold.
4. Position manifold (8) against intake ports of cylinder head with slotted hole in flanges (1) and (2) around studs (4) in cylinder head. Place washers (5) on studs (4). Loosely thread nuts (6) on studs (4). Insert Allen screws (7) through manifold flanges (1) and (2) and loosely thread into tapped holes in cylinder head.

NOTE

The fit between the carburetor and the seal ring is tight. For ease of installation, it is recommended that the mating surfaces, carburetor body and seal ring, be lubricated prior to assembly to reduce surface friction. Use liquid dish soap or tire mounting lube for this purpose.

5. Lubricate only the inside surface of seal ring (9) that will be in contact with the carburetor. Also apply a light coat of lubricant to the spigot of the carburetor body. Push carburetor body into seal ring (9). Carburetor and air cleaner back plate are still assembled.
6. Reconnect VOES hose.
7. See Figure 2. Install Allen screws (4) through air cleaner backing plate (6) and thread into tapped holes in cylinder head. Tighten to 10-12 ft-lbs.

8. See Figure 4. Tighten manifold flange nuts (6) and Allen screws (7) to 6-10 ft-lbs.
9. On 1200cc models, attach horn/ignition switch assembly to motor mount and torque to 20-25 ft-lbs.
10. Slide enricher control in slot in bracket and tighten nut.
11. See Figure 1. Install fuel tank and secure to frame with bolts and hardware (2 through 13). Tighten fuel tank mounting bolts to 19 ft-lbs. Connect fuel supply hose to fuel valve and install new hose clamp.
12. See Figure 2. Place element (3) in air cleaner backing plate (6) and position cover (2) over element. Secure with screws (1) and tighten to 3-5 ft-lbs.

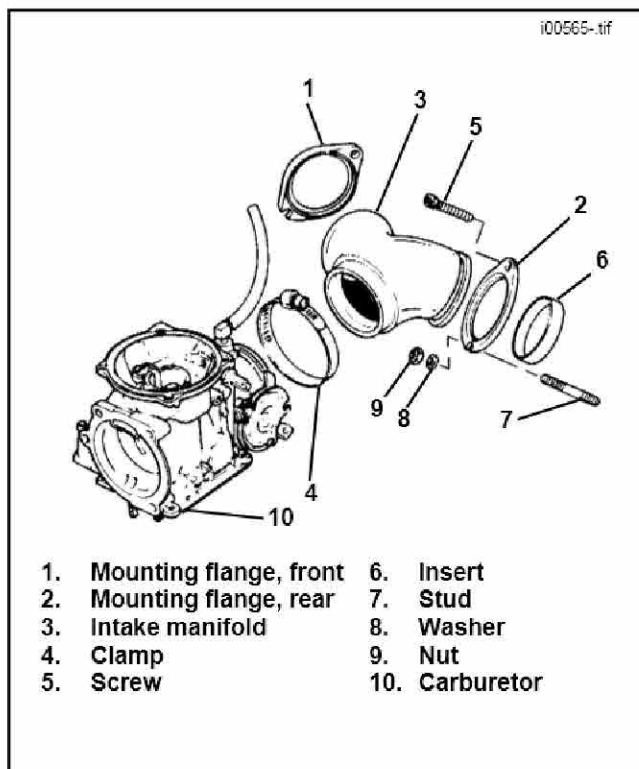


Figure 3. Carburetor Assembly

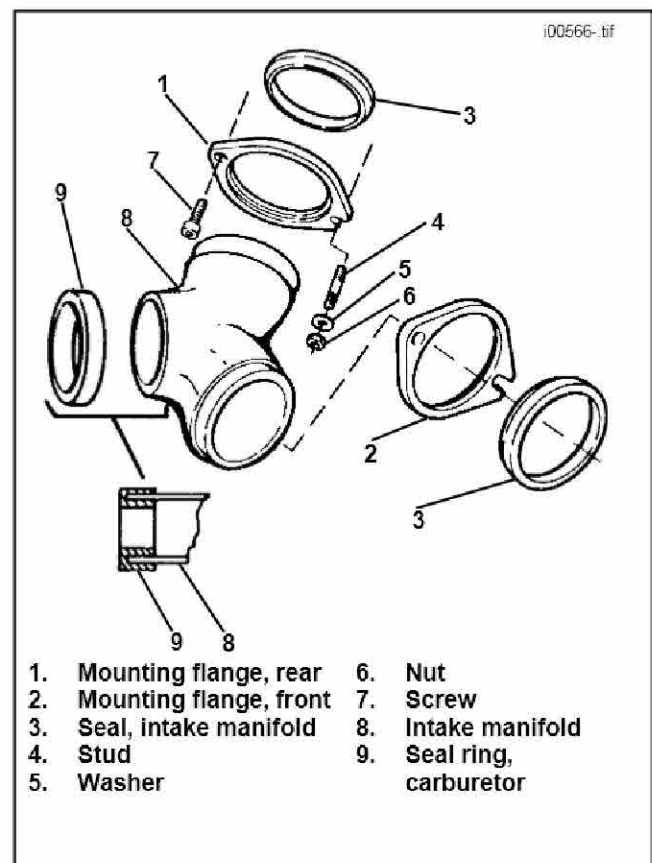


Figure 4. Aluminum Manifold Assembly