



# INSTRUCTIONS

-J00369

REV. 4-1-96

Kit Number 61618-96B

## SPORTSTER 3-1/4 GALLON GAS TANK KIT

### General

This kit is designed to provide a direct replacement fuel tank for all 1995 and later SPORTSTER models.

#### NOTE

The fuel tank in this kit will fit all 1986 - 1994 SPORTSTER models, provided the appropriate hardware kit is also purchased. The hardware kit Part No. and model applicability is listed below.

Hardware Kits (Must be purchased separately)

Part No.	Model Usage
61212-94A	1986-1991 All XLH Models
61958-94A	1992-1994 All XLH Models

### Kit Contents

Qty	Description
3	Cable straps
1	Hose clamp
4	Grommets
1	90° Elbow for tank vent
1	Straight fitting for tank vent
1	Gasket, fuel valve
1	Fuel tank

The following parts are only used on 883 cc models:

1	Carriage bolt
1	Locking acorn nut
1	Washer
1	Enrichener cable bracket
1	Enrichener cover

#### NOTE

Service Parts for this kit are listed on the last page.

### Removing the stock fuel tank

#### WARNING

To avoid accidental start-up of vehicle and possible personal injury, disconnect the battery cables before proceeding. Always disconnect the negative cable first. If the positive cable should contact ground with the negative cable installed, the resulting sparks may cause a battery explosion resulting in personal injury.

#### WARNING

Gasoline is extremely flammable and highly explosive under certain conditions. Be sure engine is cold and do not smoke or allow open flames or sparks anywhere in the area while removing the stock fuel tank.

1. Turn fuel supply valve handle to OFF. Cut fuel hose clamp at bottom of fuel supply valve and remove hose.

2. Remove vacuum hose from fuel supply valve.

#### NOTE

To allow access to rear fuel tank mounting bolt on left side, cut the existing cable strap securing the main harness to the frame backbone. Move main harness as necessary to allow wrench clearance.

3. See Figure 1. Remove front and rear mounting bolts (1 and 2) and the associated hardware. Note the position of all parts so they will be reassembled correctly when new tank is mounted.
4. Disconnect vent elbow fitting from bottom right side of tank.

#### NOTE

The tank vent fitting is located on the bottom, right-front of all 1995 model tanks and 1996 2-1/4 gal tanks. The vent fitting is located on the bottom, right-rear of 1996 3-1/4 gal tanks. Therefore, on 1996 3-1/4 gal tanks the existing vent elbow fitting will connect to the tank in this kit without any modification.

5. See Figure 1. On all 1995 models, and 1996 883 cc models, remove the plastic tubing (17) from vent hose (18). The plastic tubing (17) and the attached 90° elbow may be discarded.
6. Remove the stock fuel tank. Drain any gasoline in stock tank into a suitable, clean container. Remove fuel tank cap and retain for use on new tank.
7. See Figure 1. Remove four T-spacers (4) and retain for use on new tank.

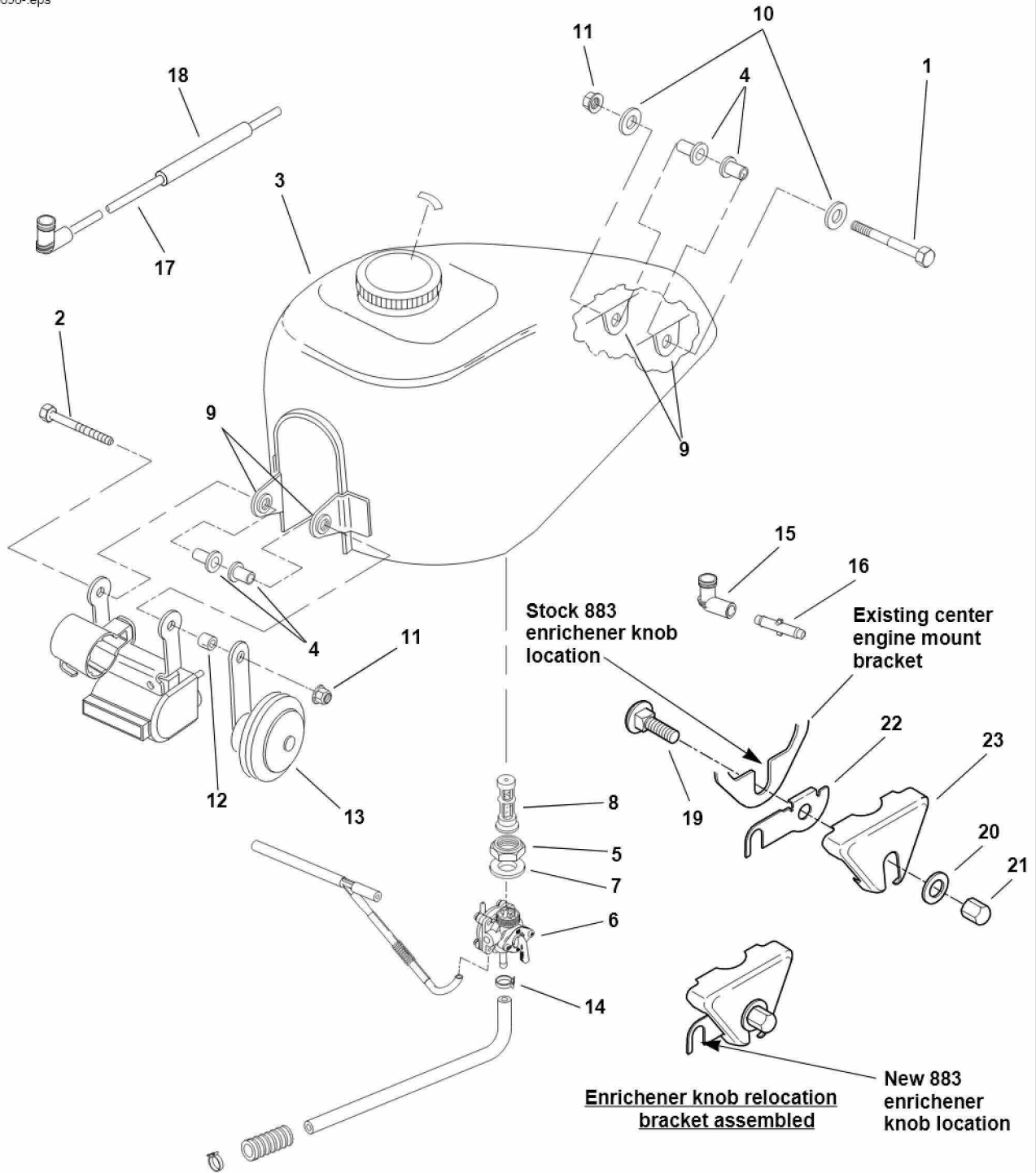
#### NOTE

The valve fitting (nut) has right hand threads in the portion that attaches to fuel tank and left hand threads that mate with threads on the valve.

8. Note position of fuel supply valve. Turn the hex fitting (5) that attaches the valve (6) to the fuel tank counter-clockwise and remove the valve, gasket (7), and filter assembly (8). Discard gasket (7), a new gasket is in kit.
9. Retain all parts removed in step 8, except gasket (7), for use on new tank.

### Installing parts removed from old tank on new tank

1. Remove protective sleeves from vent tube and fuel valve fitting on bottom of tank, if present.
2. See Figure 1. Install new grommets (9) from kit in holes of mounting tabs.



- 1. Rear bolt
- 2. Front bolt
- 3. Fuel tank
- 4. T-spacers (4)
- 5. Hex fitting (nut)
- 6. Fuel supply valve
- 7. Gasket
- 8. Filter
- 9. Grommets (4)

- 10. Washers (2)
- 11. Nut (2)
- 12. Horn spacer (1995, 883 cc models only)
- 13. Horn (1995, 883 cc models only)
- 14. Hose clamp
- 15. 90° elbow
- 16. Straight fitting

- 17. Plastic tubing
- 18. Vent hose
- 19. Carriage bolt
- 20. Washer
- 21. Locking acorn nut
- 22. Enricher cable bracket
- 23. Enrichener cover

Figure 1. Fuel Tank Mounting Hardware

3. Install T-spacers (4) in grommets as shown in Figure 1.
4. Remove hex fitting (5) from valve. Coat the valve and fuel tank threads with Loctite PIPE SEALANT WITH TEFLON.
5. Install new gasket (7) on valve (6) and install filter strainer (8) on gasket.
6. Thread hex fitting (5) on right hand threads of fuel tank two turns. Hold hex fitting and thread valve into left hand threads of hex fitting for two turns.

#### **⚠WARNING**

Do not thread fitting onto valve more than two turns to avoid “bottoming” fitting on valve. This could cause a gasoline leak and/or fire hazard, and possible personal injury.

7. Position valve as it was on stock tank and tighten hex fitting (clockwise) to 18 ft-lbs (24 Nm).

### Relocating enricher knob on 883 models

#### *NOTE*

On 883 cc models only, a bracket must be installed to relocate the enricher knob approximately 1-1/2 inches forward of its original location. To relocate the enricher knob, perform the steps below:

1. Loosen hex nut on backside of enricher knob and remove enricher cable from bracket.
2. See Figure 1. Install enricher cable bracket (22), enricher cover (23), carriage bolt (19), washer (20), and locking acorn nut (21), in original enricher cable hole as shown. Tighten acorn nut to 24 in-lbs (2.7 Nm).
3. Reinstall enricher knob in slot of new enricher cable bracket.

### Installing new tank

1. See Figure 1. Place fuel tank on frame. Install one washer (10) on rear bolt (1) and slide bolt through T-spacers (4) and frame from left side.
2. Install a second washer (10) on rear bolt and install nut (11) on rear bolt (1), but do not tighten.
3. Install front bolt (2) and hardware removed in step 3 of “Removing the stock fuel tank”

#### *NOTE*

If this kit is being installed on a 883 cc model, make certain the horn spacer (12) and horn (13) are reinstalled correctly.

#### **⚠CAUTION**

Check that wiring and hoses are not pinched between fuel tank and frame. Damaged wiring or hoses will result if they are pinched between fuel tank and frame.

4. Before tightening the fuel tank mounting bolts, refer to Figure 1 to assure that all parts attached with fuel tank mounting bolts are properly positioned.

5. Tighten fuel tank mounting bolts to 8–16 ft-lbs (11–22 Nm).

#### **⚠CAUTION**

Check clearance between front directional lights and fuel tank by turning handlebars full left and right. If directional lights contact tank, loosen mounting screws and rotate light forward. Damage to paint on fuel tank will result if directional lights contact fuel tank.

6. Install vacuum line on fuel supply valve.
7. Slip hose clamp (14) over fuel line, leaving clamp loose. Install fuel line on fuel supply valve and tighten clamp.

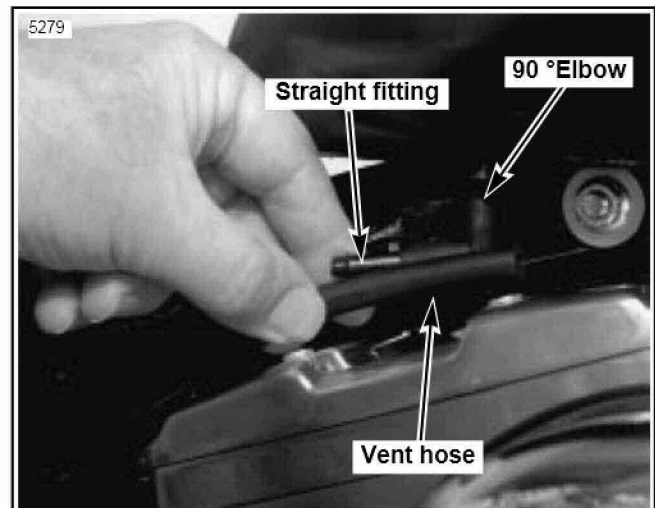


Figure 2. Cutting Vent Hose To Needed Length

#### **⚠WARNING**

Make certain fuel line will not contact hot or moving throttle parts. Fuel line contact with hot or moving parts could cause a fire hazard and possible personal injury.

8. On 1996 1200 cc models, reconnect large end of stock vent line elbow to tank vent fitting. For all other models, go to step 9.
9. On all 1995 XL models and only 1996 883 models with 2-1/4 gal tanks, see Figure 2. Install large end of 90° vent line elbow to tank vent fitting at right rear of tank.
10. Install straight fitting into 90° fitting. Cut vent tube to proper length and install on straight fitting.
11. If cable strap was removed, install a cable strap at rear of tank to secure main wiring harness to frame backbone.
12. Fill tank with gasoline and install cap from previously removed stock tank. Check valve and fuel line for leaks.
13. Reconnect battery cables, positive cable first.



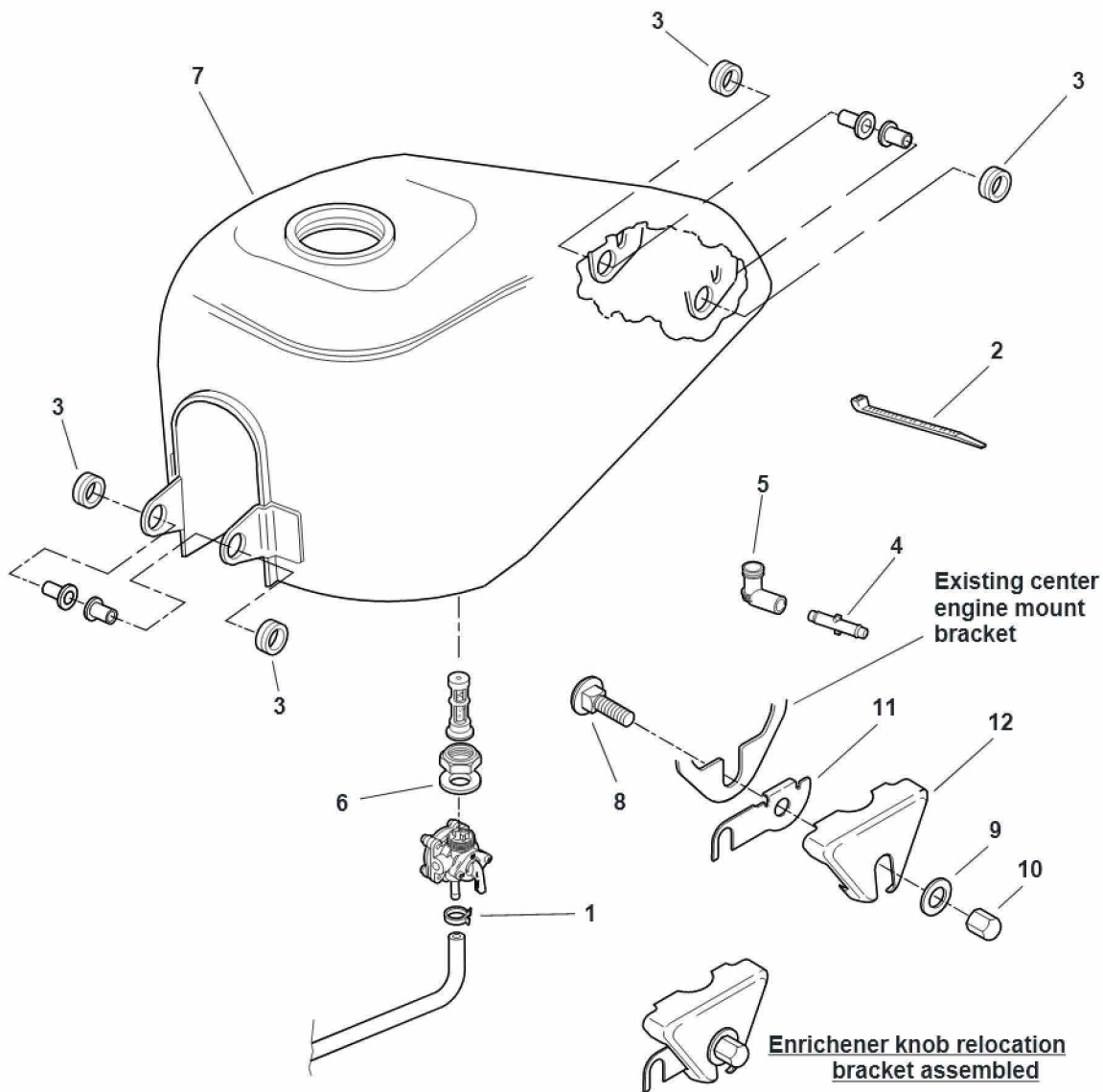
# Service Parts

Part No.61618-96B

Date 4/96

Sportster 3-1/4 gal Gas Tank

sp61618B



Item	Description	Part No.	Item	Description	Part No.
1	Hose clamp, worm drive	9946	8	Carriage bolt	5440
2	Cable strap (3)	10006	9	Washer	6702
3	Grommet (4)	11473	10	Locking acorn nut	7549A
4	Straight hose fitting	27249-96	11	Enrichener cable bracket	69035-95
5	90°elbow	27250-96	12	Enrichener cover	69037-95A
6	Gasket, fuel valve	62172-75			
7	Fuel tank kit, primed	61348-96A			

(See your dealer for fuel tanks in painted-to match colors.)