



INSTRUCTIONS

-J02497

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100TH ANNIVERSARY SERVICE MEDALLION

GENERAL

Kit Number

24709-03

Models

This kit fits all 2003 models, and is designed to replace a missing or damaged 100th Anniversary medallion on the engine crankcase of these models.

NOTE

Harley-Davidson cannot verify the results when affixing this medallion to any other materials. Damage to surfaces may occur.

NOTE

Ambient application temperature should be between 70 and 100 degrees Fahrenheit (21 to 38 degrees Centigrade).

NOTE

The medallion uses a pressure sensitive adhesive backing developed for high temperature applications. The protective film must not be removed from the adhesive until the moment of application to avoid unnecessary exposure to grease, oil, dust, dirt and human skin oils.

Preparing the Crankcase Surface

For maximum bond strength of the medallion adhesive, the crankcase surface inside the cast cosmetic border surrounding the medallion mounting area must be clean and dry.

To verify surface cleanliness, clean the area with a mixture of 50 to 70% isopropyl alcohol and 30 to 50% distilled water.

Four to six vigorous strokes across the oval pad with a lint free cloth should be adequate to clean the surface.

NOTE

The cleaning mixture dries quickly by itself. However, the use of clean, forced air is recommended as this will speed the drying process and leave the surface free of lint particles that might weaken the adhesive bond strength.

Allow to dry thoroughly! To prevent recontamination of the surface, apply the medallion within several minutes of cleaning.



Figure 1. 100th Anniversary Crankcase Medallion

Applying the Medallion

1. Remove the protective film from the back of the medallion.

NOTE

Once the medallion makes contact with the oval pad on the crankcase it should not be "adjusted" into position. The medallion should make contact **ONE TIME ONLY** to avoid weakening the adhesive bond.

2. See Figure 1. Carefully center the medallion within the cosmetic border on the crankcase surface.
3. Press the medallion firmly into position. Hold the medallion in place, pushing hard with your thumb, for about five seconds. Take care not to shift the medallion within the border.
4. After releasing pressure, avoid direct contact with the medallion for about 20 minutes. The adhesive bond will reach about 50% of its final strength after this time. The adhesive bond will increase to maximum strength after about 72 hours at normal room temperatures. Applying a slight amount of heat will help the adhesive bond and cure, but the heat and vibration of engine operation should be avoided during this period for best results.

