

8

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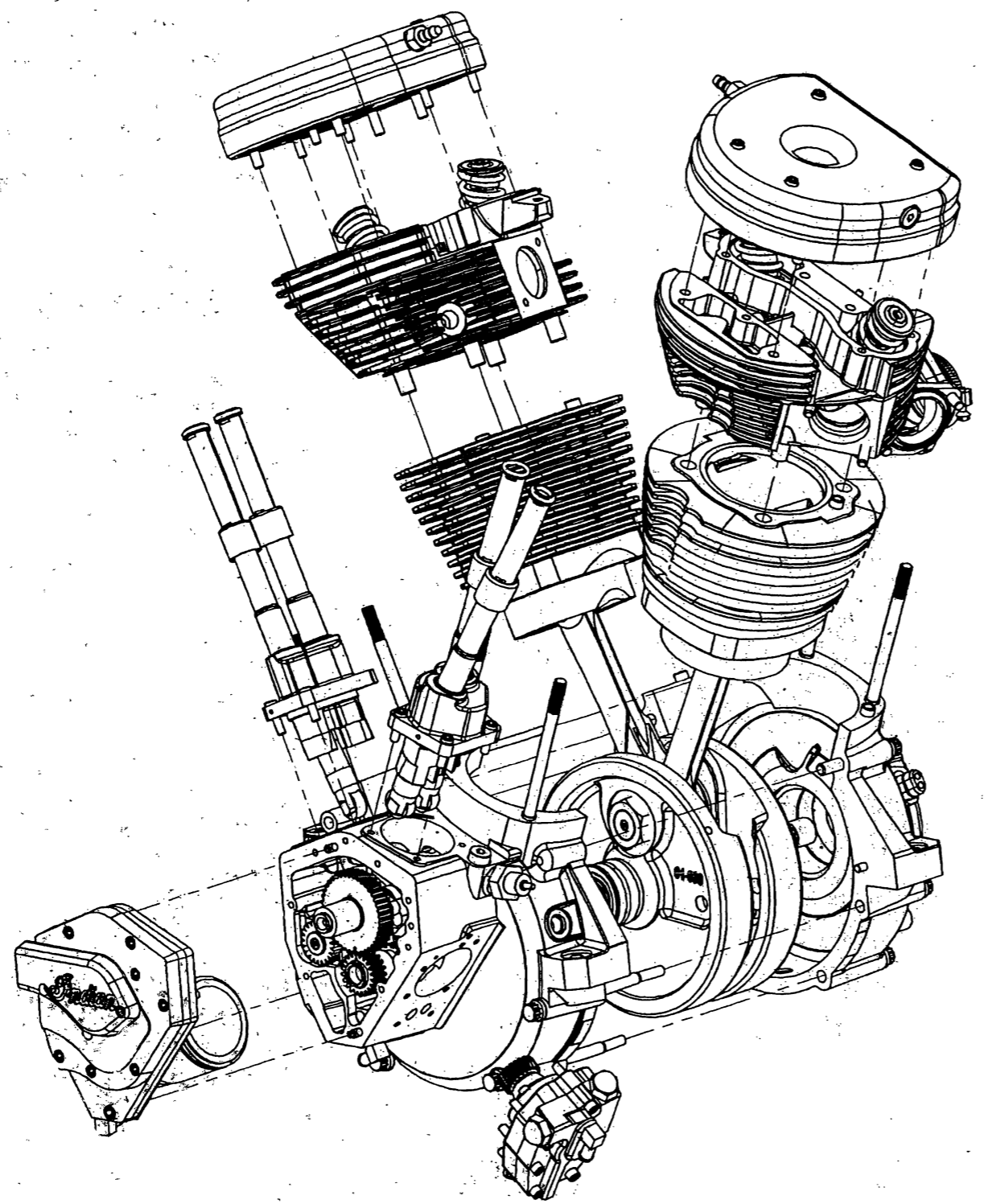
4

3

2

1

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED



D


C

B

A

**PROTOTYPE DESIGN**  
**NOT FOR USE ON PRODUCTION**  
**MOTORCYCLE MODELS**

SEE SEPARATE BILL OF MATERIAL

<p><b>TOLERANCE</b>          UNLESS OTHERWISE SPECIFIED:</p> <p>DECIMAL, INCHES   FRACTIONS   ANGLES</p> <p>X ±.04          XX ±.03   1/32   ±1/2°          XXX ±.010</p> <p>DECIMAL, mm</p> <p>X ±1.50          XX ±.75          XXX ±.254</p> <p>SURFACE ROUGHNESS:          125 UNLESS OTHERWISE SPECIFIED</p>		 <p>200 EAST TENTH STREET, GILROY, CA. 95020          PHONE 408-847-2221 FAX: 408-847-4752</p>	
<p><b>MATERIAL:</b></p>		<p><b>APPROVALS</b>   <b>DATE</b>   <b>TITLE:</b></p> <p>Drawn By: 12/31/2000   Noun Phrase, Adj 1, Adj 2</p>	
<p><b>FINISH:</b></p>		<p><b>CHECKED BY:</b>   <b>DATE</b>   <b>SIZE</b>   <b>DRAWING NO:</b>   <b>REV</b></p> <p>Name: 12/31/2000   D   NN_NNN-Name   1</p>	
<p><b>DO NOT SCALE DRAWING</b></p>		<p><b>ENGINEER:</b>   <b>DATE</b>   <b>SCALE:</b>   <b>SHEET 1 OF 1</b></p> <p>Name: 12/31/2000   1:1</p>	

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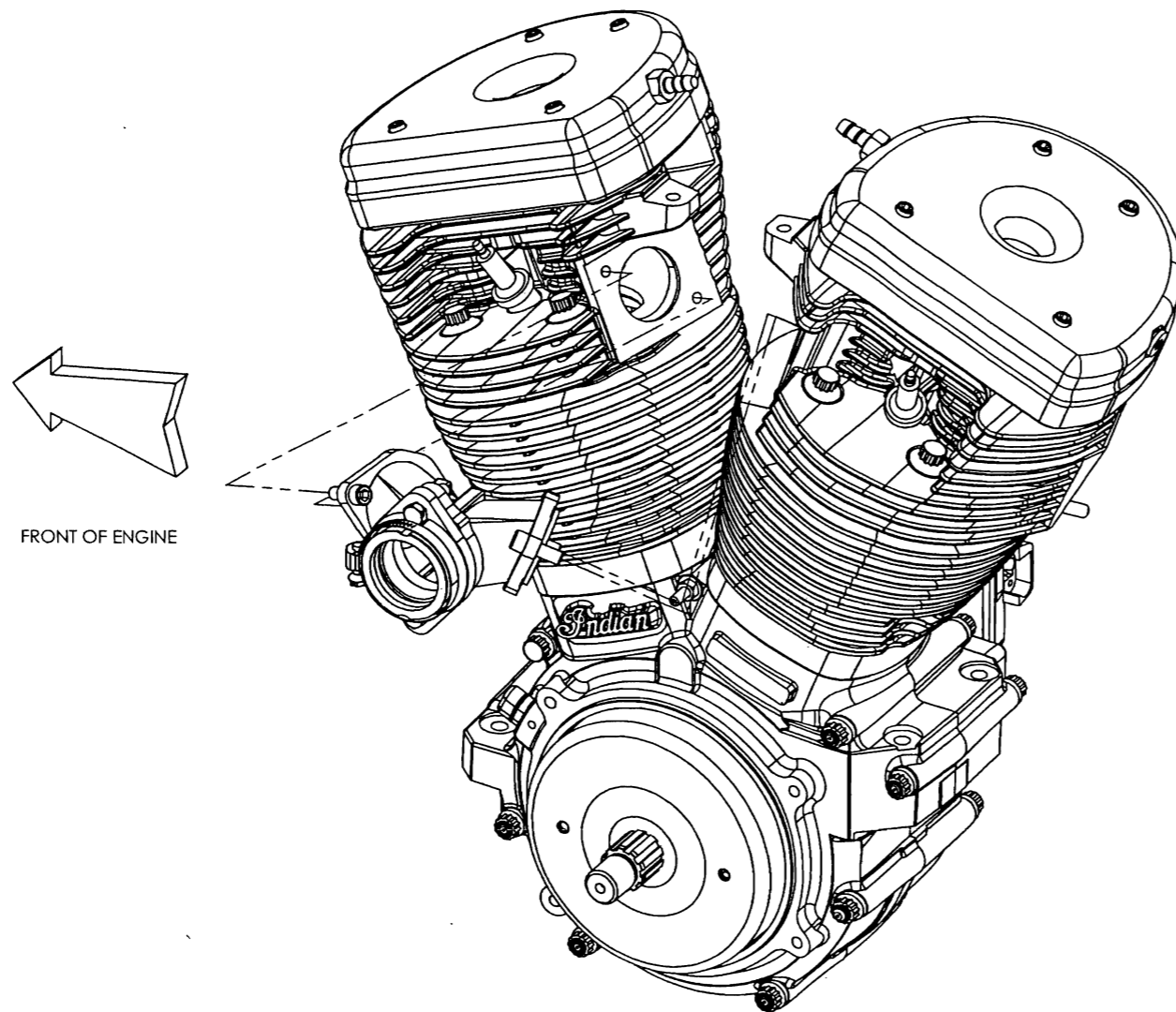
2

1

8 7 6 5 4 3 2 1

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED

D  
C  
B  
A



SEE SEPARATE BILL OF MATERIAL

TOLERANCE UNLESS OTHERWISE SPECIFIED:		
DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		
DECIMAL, mm		
X ±1.50		
.XX ±.75		
.XXX ±.254		
SURFACE ROUGHNESS: 125 UNLESS OTHERWISE SPECIFIED		



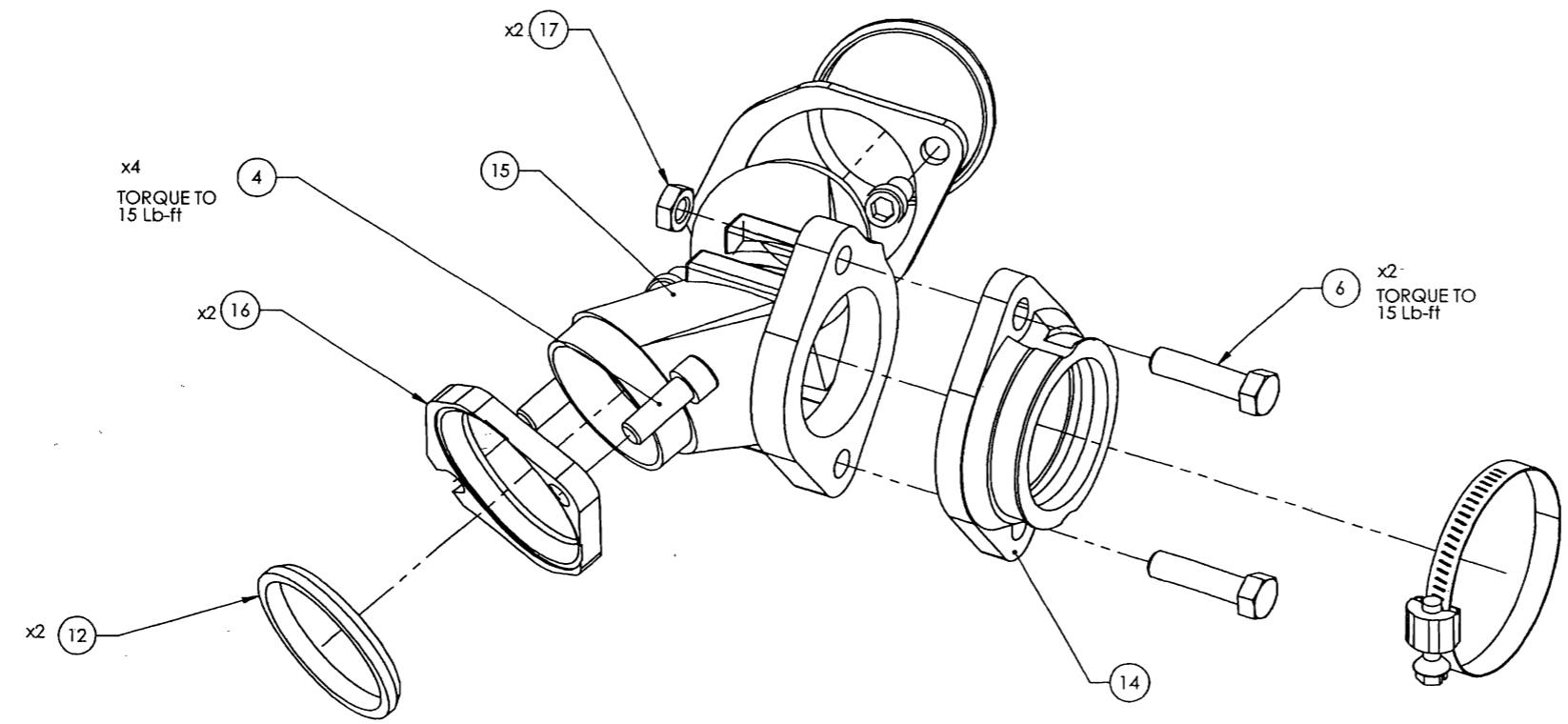
200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

MATERIAL:		<small>THIS DRAWING IS THE PROPERTY OF INDIAN MOTORCYCLE CORPORATION AND CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. THIS DRAWING MAY NOT BE COPIED, PUBLISHED OR DISCLOSED TO OTHERS, OR USED FOR ANY PURPOSE, WITHOUT THE EXPRESS WRITTEN CONSENT OF INDIAN MOTORCYCLE. THIS DRAWING MUST BE KEPT IN CONFIDENTIAL FILES WHEN NOT IN USE AND MUST BE RETURNED ON DEMAND.</small>	
APPROVALS	DATE	TITLE:	
DRAWN BY: Drawn By	12/31/2000	Noun Phrase, Adj 1, Adj 2	
CHECKED BY: Name	12/31/2000	SIZE	DRAWING NO:
ENGINEER: Name	12/31/2000	D	NN_NNN-Name
DO NOT SCALE DRAWING		SCALE: 1:1	REV 1
			SHEET 2 OF 2

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	FIRST PRODUCTION RELEASE	23/11/01	AW	
B	ADDED NUT (BUBBLE 14) AND TORQUE REQUIREMENTS; ADDED ORIENTATION DIMENSION FOR BRACE (BUBBLE 14)	1/28/02	LWW	
C	CONVERTED TO SOLIDWORKS, REMOVED BRACE	3/12/03	WB	



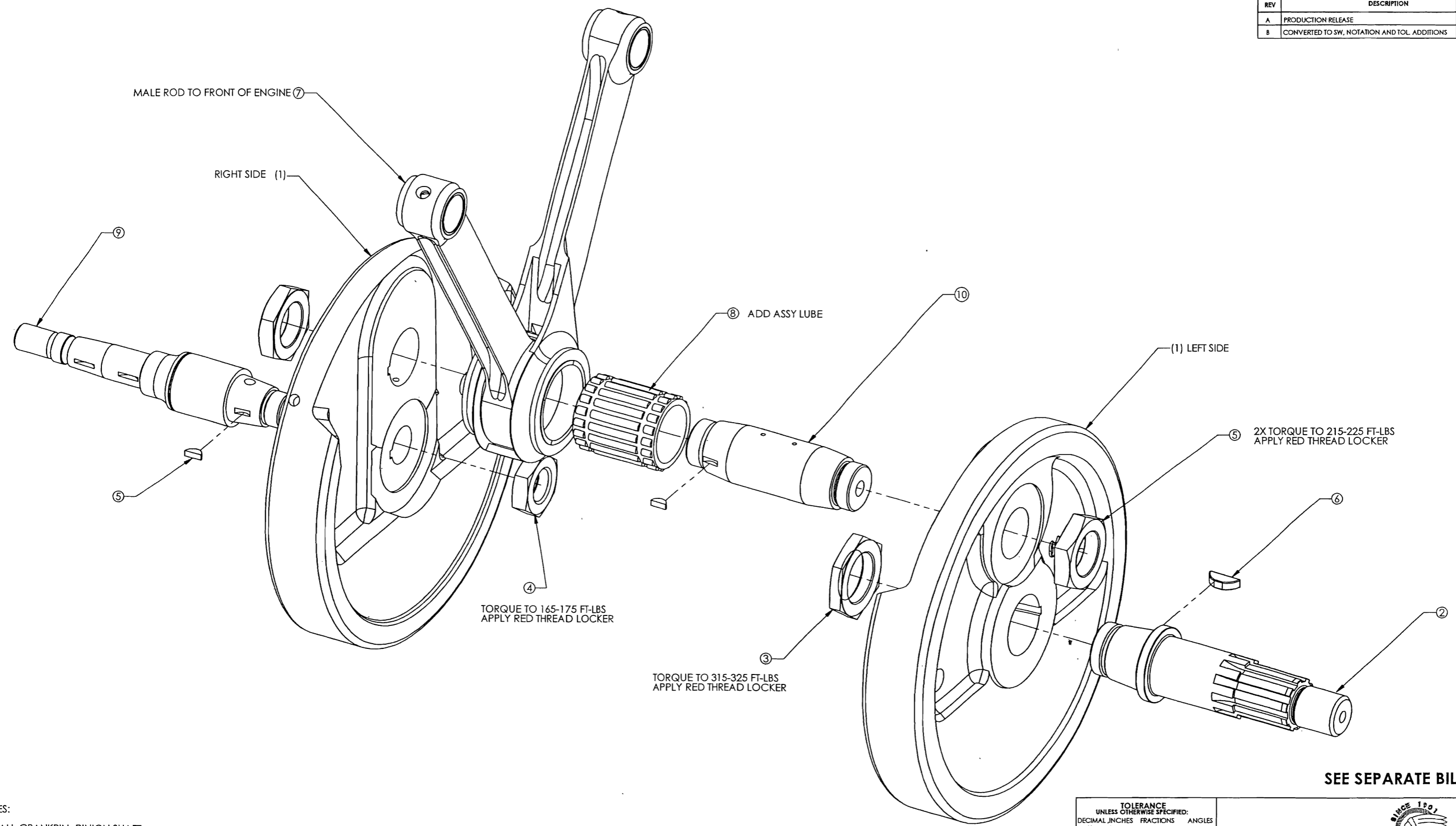
SEE SEPARATE BILL OF MATERIAL

<p><b>TOLERANCE UNLESS OTHERWISE SPECIFIED:</b></p> <p>DECIMAL INCHES FRACTIONS ANGLES</p> <p>X ±.06 ±1/32 ±1/2°</p> <p>.XX ±.03</p> <p>.XXX ±.010</p> <p>DECIMAL, mm</p> <p>X ±1.50</p> <p>.XX ±.76</p> <p>.XXX ±.254</p> <p>SURFACE ROUGHNESS:</p> <p>125 UNLESS OTHERWISE SPECIFIED</p> <p>MATERIAL:</p> <p>-----</p> <p>FINISH:</p> <p>-----</p> <p><b>DO NOT SCALE DRAWING</b></p>	<p>200 EAST TENTH STREET, GILROY, CA. 95020 PHONE: 408-847-2221 FAX: 408-847-4752</p>	
	<p>THIS DRAWING IS THE PROPERTY OF INDIAN MOTORCYCLE CORPORATION AND CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. THIS DRAWING MAY NOT BE COPIED, PUBLISHED OR DISCLOSED TO OTHERS, OR USED FOR ANY PURPOSE, WITHOUT THE EXPRESS WRITTEN CONSENT OF INDIAN MOTORCYCLE. THIS DRAWING MUST BE KEPT IN CONFIDENTIAL FILES WHEN NOT IN USE AND MUST BE RETURNED ON DEMAND.</p>	
<p>APPROVALS</p> <p>DRAWN BY: AW</p> <p>CHECKED BY: SW</p> <p>ENGINEER: L WILEY</p>	<p>DATE</p> <p>11/22/2001</p> <p>11/22/2001</p> <p>1/2/2002</p>	<p>TITLE:</p> <p><b>CARBURETOR MOUNTING COMPONENTS</b></p> <p>SIZE <b>D</b> DRAWING NO: <b>00-223-ASSY</b></p> <p>SCALE: 1:1</p>
		<p>REV <b>C</b></p> <p>SHEET 1 OF 2</p>

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	02/20/2002	ROUGH	
B	CONVERTED TO SW, NOTATION AND TOL. ADDITIONS	03/02/2003	WB	



- NOTES:
1. ALL CRANKPIN, PINION SHAFT, OUTPUT SHAFT, AND FLYWHEEL TAPERS MUST BE CLEAN AND FREE OF OIL, LUBE AND/OR DEBRIS.
  2. ASSEMBLY SHOULD HAVE OIL PASSED THROUGH ITS INTERNAL PASSAGES BEFORE BEING TESTED.
  3. ALL NUT THREADS SHOULD BE DEGREASED AND BLOWN BEFORE INSTALLATION.

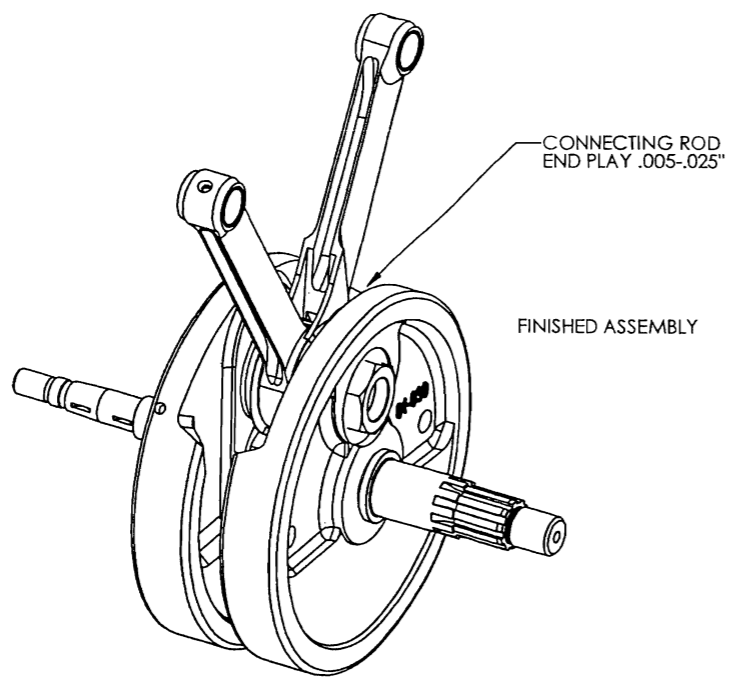
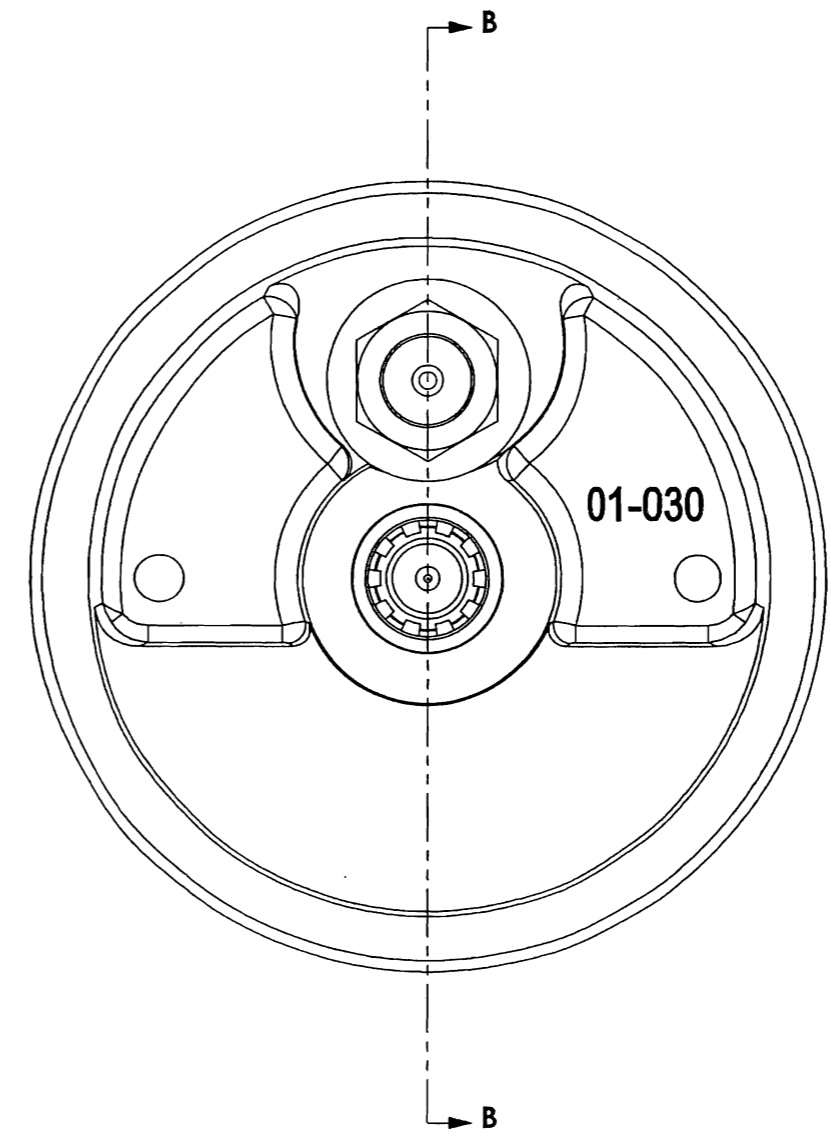
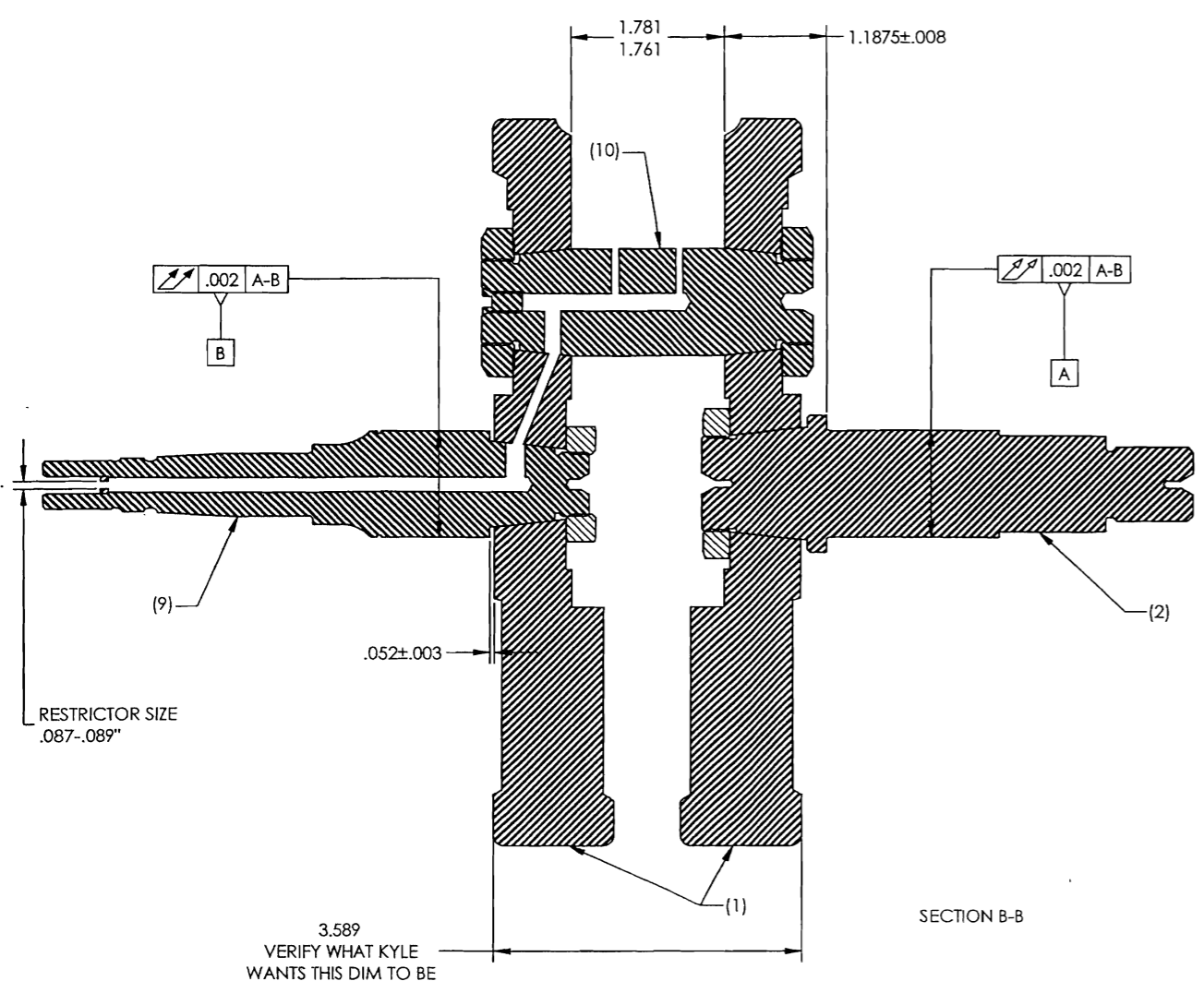
BALANCING PROCEDURE:  
LEFT AND RIGHT FLYWHEELS ARE TO BE STATICALLY BALANCED TO 100% OF FLYWHEEL ASSEMBLY ROTATING COMPONENTS WEIGHT PLUS 60% OF RECIPROCATING COMPONENTS WEIGHT

SEE SEPARATE BILL OF MATERIAL

<p>UNLESS OTHERWISE SPECIFIED:</p> <p>DECIMAL INCHES FRACTIONS ANGLES</p> <p>X ±.06 ±1/32 ±1/2°</p> <p>.XX ±.03</p> <p>.XXX ±.010</p> <p>DECIMAL mm</p> <p>X ±1.50</p> <p>.XX ±.75</p> <p>.XXX ±.254</p> <p>SURFACE ROUGHNESS: 125 UNLESS OTHERWISE SPECIFIED</p>		<p>200 EAST TENTH STREET, GILROY, CA. 95020 PHONE: 408-847-2221 FAX: 408-847-4752</p>	
<p>APPROVALS</p> <p>DATE</p> <p>TITLE:</p>		<p>APPROVALS</p> <p>DATE</p> <p>TITLE:</p>	
<p>FINISH:</p>		<p>DRAWN BY: W BARNETT</p> <p>CHECKED BY: -</p> <p>ENGINEER: K LANGLANDS</p>	
<p>DO NOT SCALE DRAWING</p>		<p>DATE: 3/2/2003</p> <p>DATE: 3/2/2003</p> <p>DATE: 3/2/2003</p>	
<p>SIZE: D</p>		<p>SCALE: 1:1</p>	
<p>DRAWING NO: 01-002-ASSY</p>		<p>REV B</p>	
<p>SHEET 1 OF 2</p>		<p>SHEET 1 OF 2</p>	

8 7 6 5 4 3 2 1

D  
C  
B  
A



NOTE:  
MAKE SURE THAT ALL OIL  
PASSAGEWAYS ARE OPEN  
AND CLEAR

SEE SEPARATE BILL OF MATERIAL

<p>UNLESS OTHERWISE SPECIFIED:</p> <p>DECIMAL INCHES FRACTIONS ANGLES</p> <p>X ±.04     1/32     ±1/2°</p> <p>.XX ±.03</p> <p>.XXX ±.010</p> <p>DECIMAL, mm</p> <p>X ±1.50</p> <p>.XX ±.75</p> <p>.XXX ±.254</p> <p>SURFACE ROUGHNESS:</p> <p>125 UNLESS OTHERWISE SPECIFIED</p>		<p>200 EAST TENTH STREET, GILROY, CA. 95020 PHONE: 408-847-2221 FAX: 408-847-4752</p>	
<p>APPROVALS</p> <p>DRAWN BY: W BARNETT</p> <p>CHECKED BY:</p> <p>ENGINEER: K LANGLANDS</p>		<p>DATE</p> <p>3/2/2003</p> <p>3/2/2003</p> <p>3/2/2003</p>	
<p>FINISH:</p> <p>DO NOT SCALE DRAWING</p>		<p>TITLE: FLYWHEEL ASSEMBLY COMPONENTS IMC 100 CI MOTOR</p> <p>SIZE D</p> <p>DRAWING NO: 01-002-ASSY</p> <p>SCALE: 1:1</p>	
		<p>REV B</p> <p>SHEET 2 OF 2</p>	

8 7 6 5 4 3 2 1

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1

D

D

C

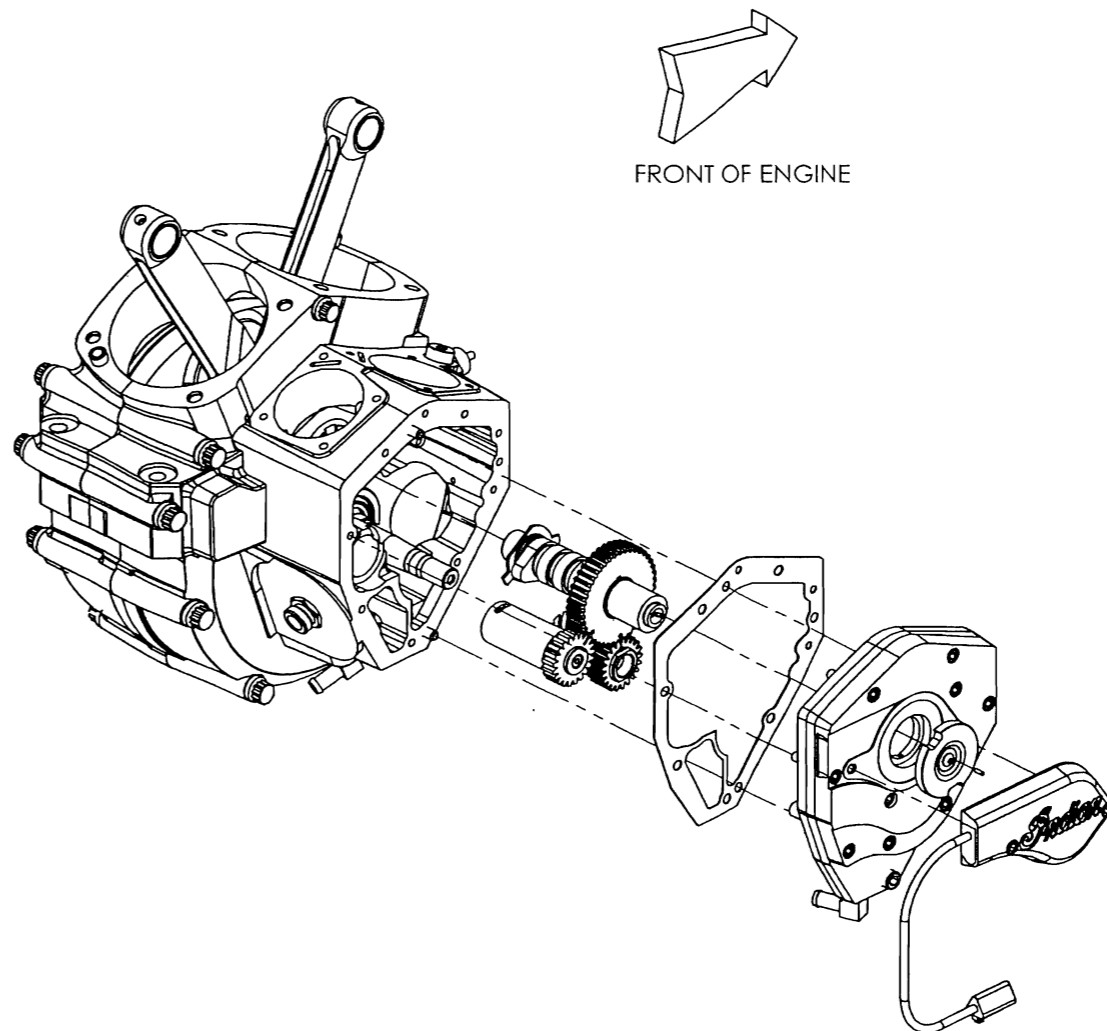
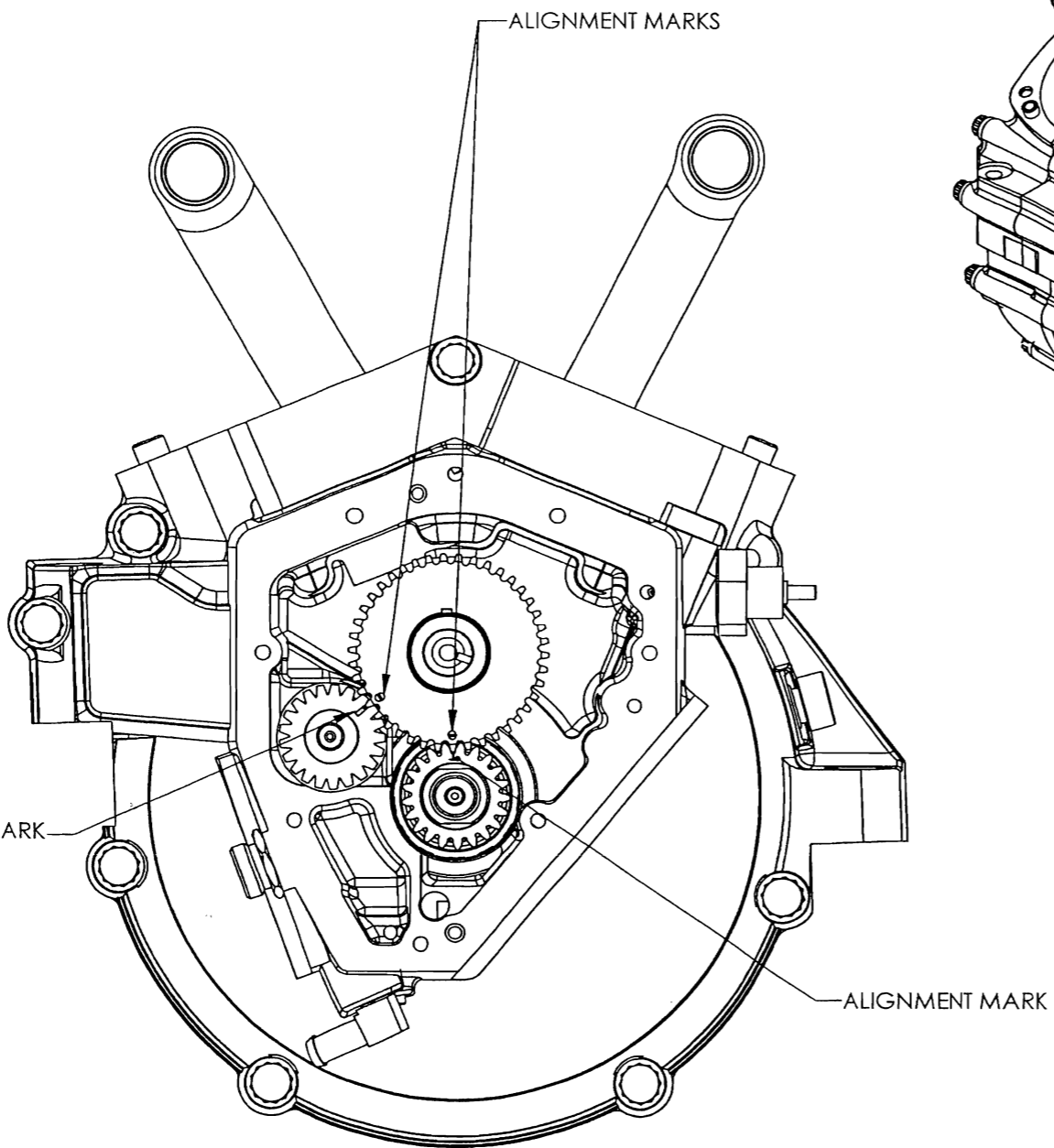
C

B

B

A

A



SEE SEPARATE BILL OF MATERIALS

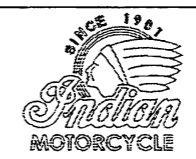
**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL mm

.X ±1.50
.XX ±.76
.XXX ±.254

SURFACE ROUGHNESS:  
125 / UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

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**FINISH:**

APPROVALS	DATE
DRAWN BY: W. BARNETT	3/2/3003
CHECKED BY: -	3/2/3003
ENGINEER: K. LANGLANDS	3/2/3003

TITLE		SIZE	DRAWING NO:	REV
CAM CASE COMPONENTS IMC 100 CI MOTOR		C	01-004-ASSY	B
SCALE: 1:1			SHEET 4 OF 4	

DO NOT SCALE DRAWING

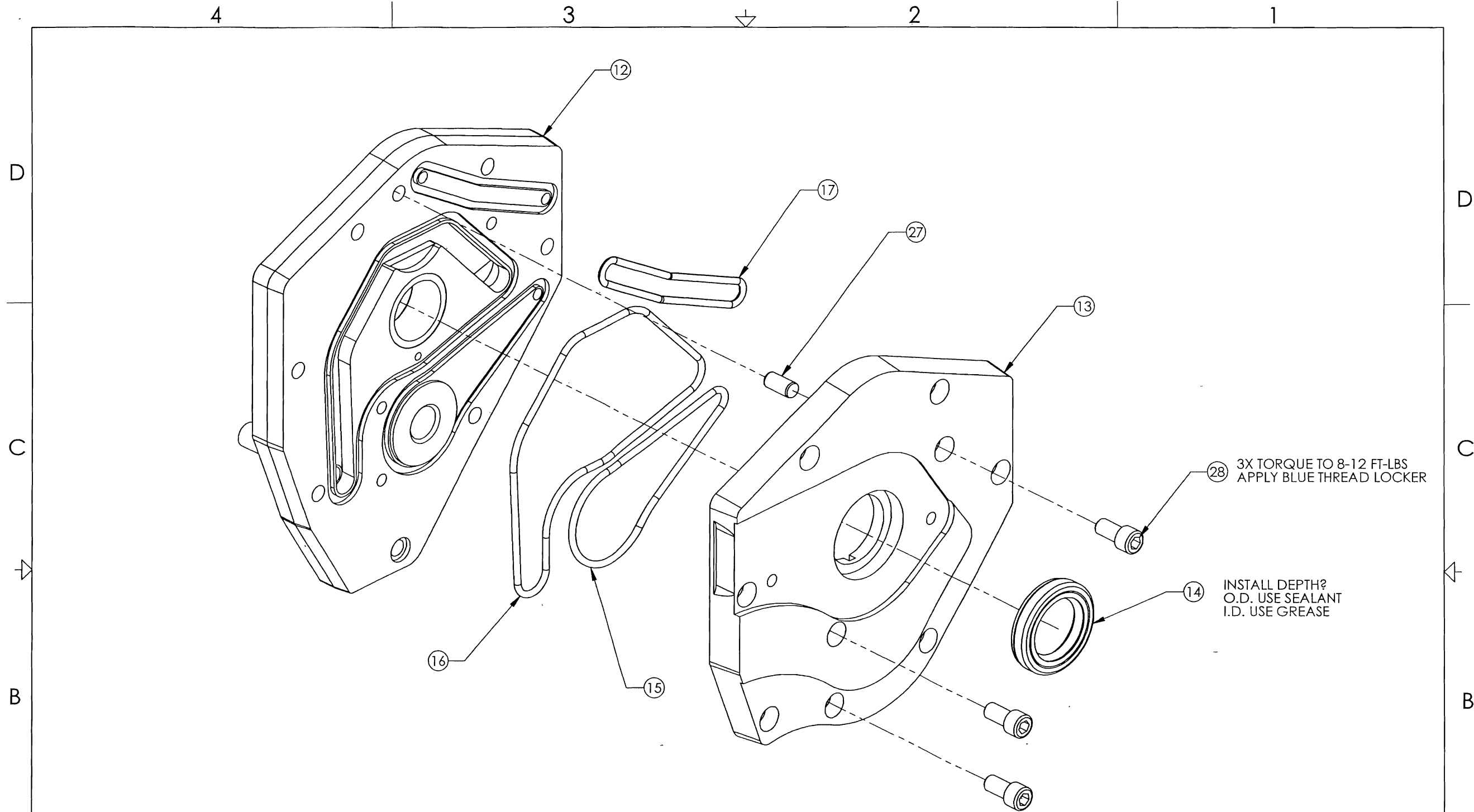
GEAR POSITION  
CAM TIMING

4

3

2

1



SUB ASSEMBLY CAM-CASE

SEE SEPARATE BILL OF MATERIALS

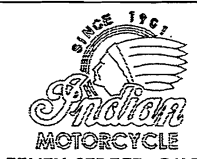
**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.04	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.75
XXX ±.254

SURFACE ROUGHNESS:  
125 UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

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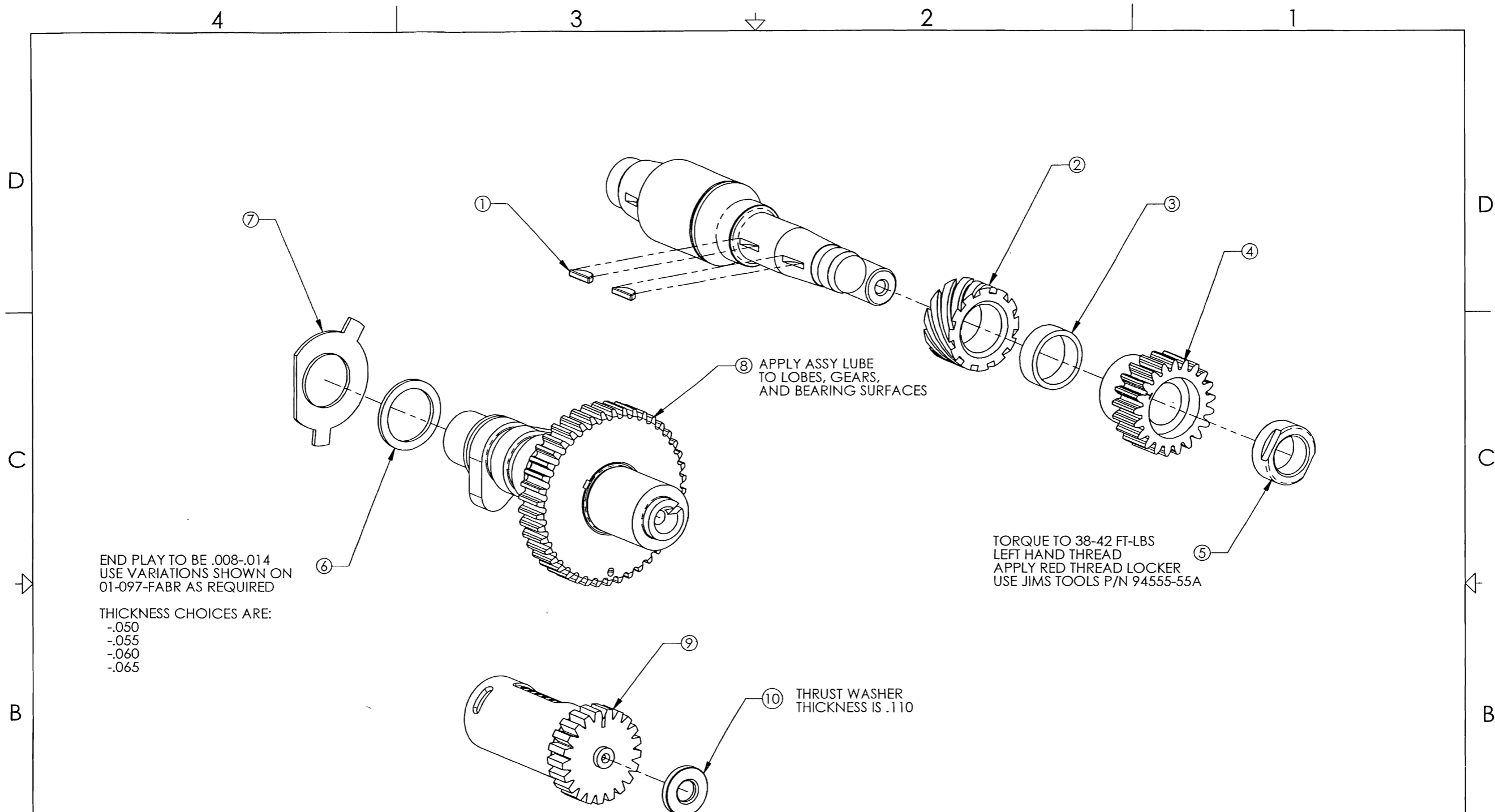
**FINISH:**

**DO NOT SCALE DRAWING**

APPROVALS	DATE
DRAWN BY: W BARNETT	3/2/3003
CHECKED BY: -	3/2/3003
ENGINEER: K LANGLANDS	3/2/3003

<b>TITLE</b>	
CAM CASE COMPONENTS, IMC 100 CI MOTOR	
SIZE <b>C</b>	DRAWING NO: <b>01-004-ASSY</b>
SCALE: 1:1	SHEET 3 OF 4

A



SEE SEPARATE BILL OF MATERIALS

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

**SURFACE ROUGHNESS:**  
125 UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

**FINISH:**

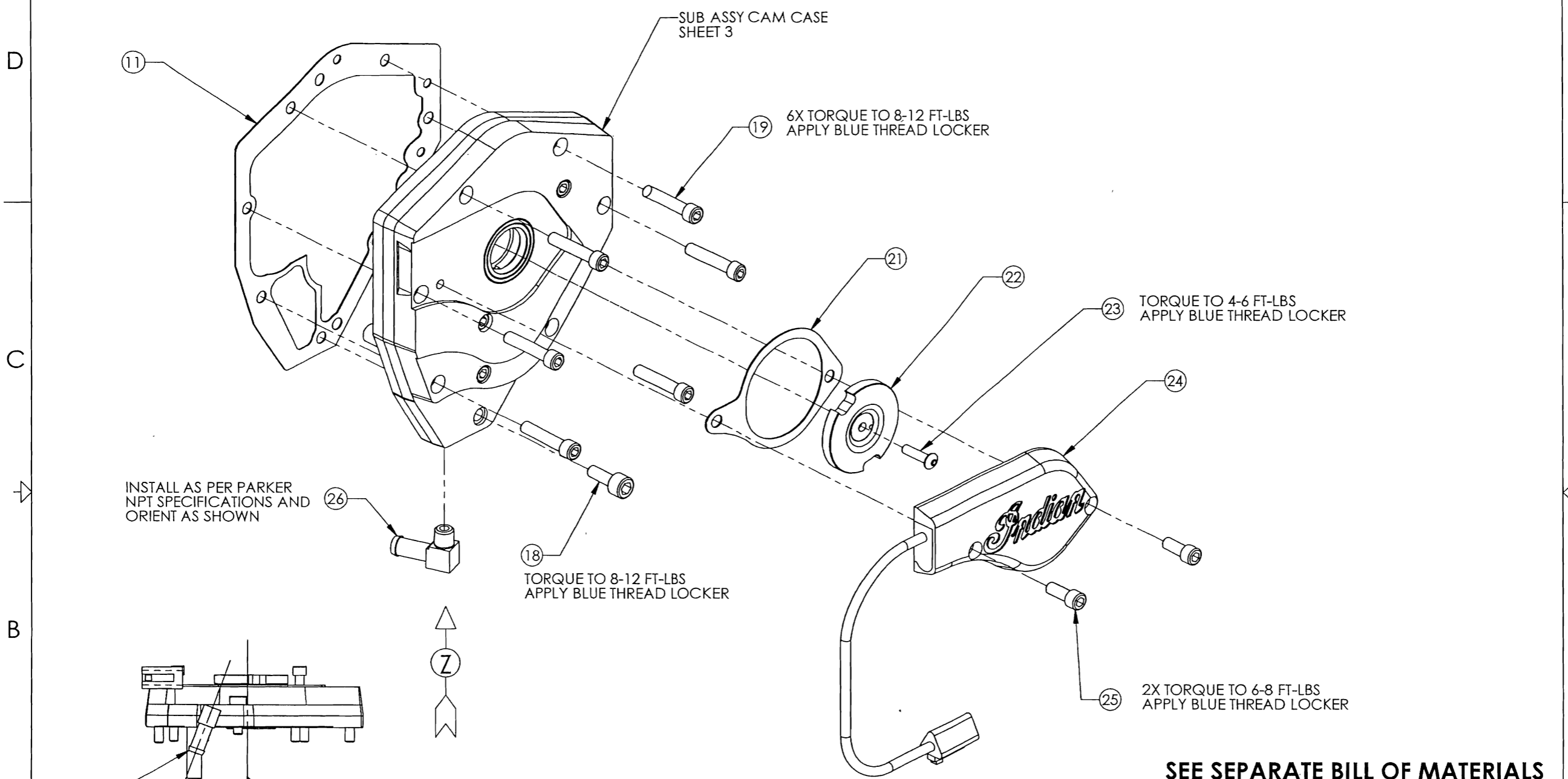
**DO NOT SCALE DRAWING**

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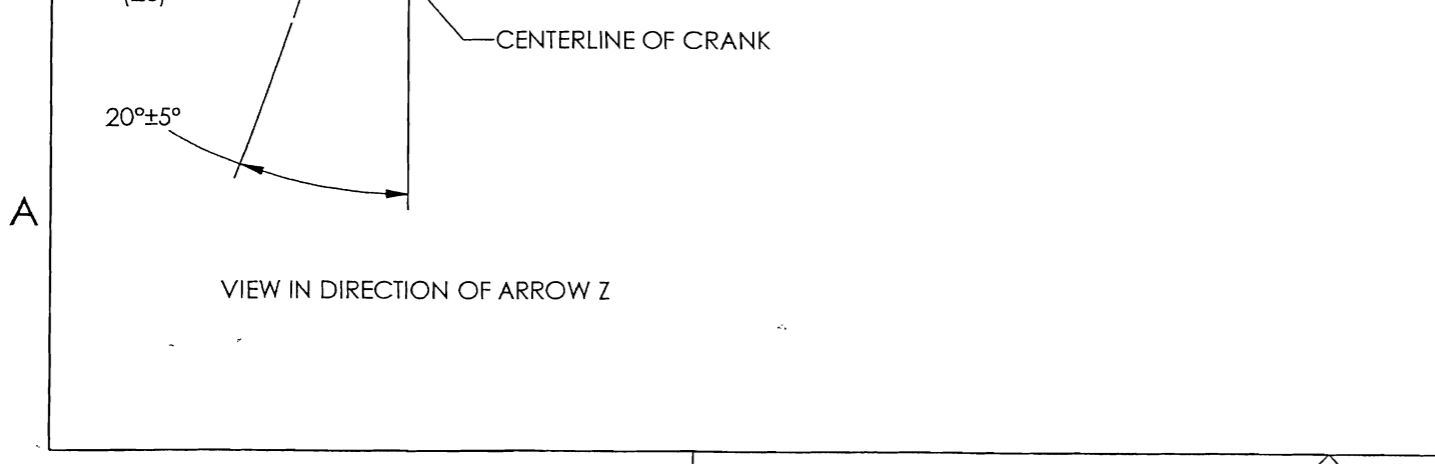
APPROVALS	DATE	TITLE
DRAWN BY: W BARNETT	3/2/2003	<b>CAM CASE COMPONENTS, IMC 100 CI MOTOR</b>
CHECKED BY: -	3/2/2003	
ENGINEER: K LANGLANDS	3/2/2003	

SIZE <b>C</b>	DRAWING NO: <b>01-004-ASSY</b>	REV <b>B</b>
SCALE: 1:1		SHEET 2 OF 4

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	03/14/02	ROUSH	
B	CONVERT TO SW, ADD NOTES AND CNG. VIEWS	03/02/03	WB	



**SEE SEPARATE BILL OF MATERIALS**



**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

**DECIMAL mm**

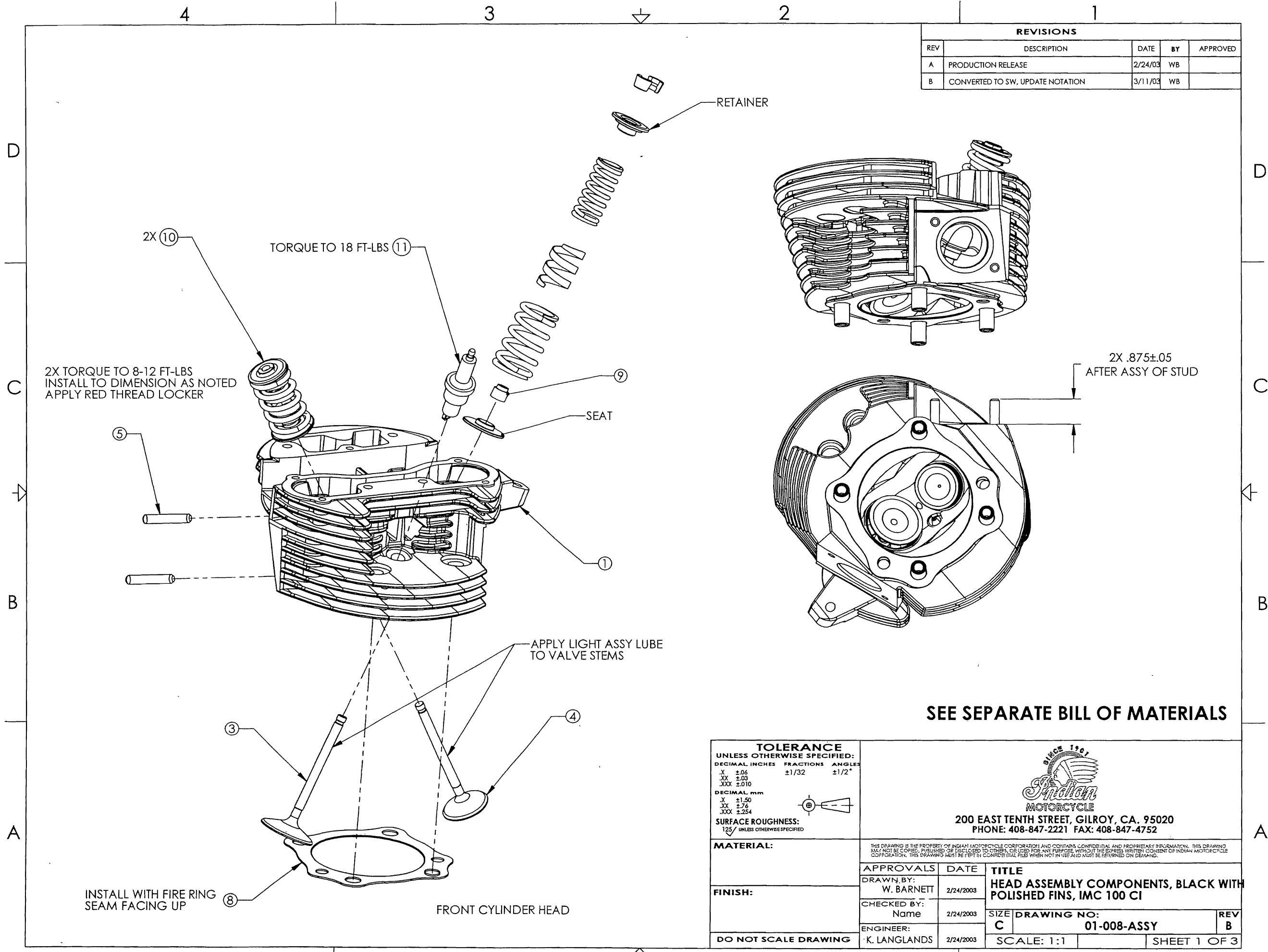
X ±1.50
.XX ±.76
.XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED

  
**200 EAST TENTH STREET, GILROY, CA. 95020**  
**PHONE: 408-847-2221 FAX: 408-847-4752**

<b>MATERIAL:</b>	<small>THIS DRAWING IS THE PROPERTY OF INDIAN MOTORCYCLE CORPORATION AND CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. THIS DRAWING MAY NOT BE COPIED, PUBLISHED OR DISCLOSED TO OTHERS, OR USED FOR ANY PURPOSE WITHOUT THE EXPRESS WRITTEN CONSENT OF INDIAN MOTORCYCLE CORPORATION. THIS DRAWING MUST BE FILED IN CONFIDENTIAL FILES WHEN NOT IN USE AND MUST BE RETURNED ON DEMAND.</small>	
	<b>APPROVALS</b> DRAWN BY: W BARNETT CHECKED BY: - ENGINEER: K LANGLANDS	<b>DATE</b> 3/2/2003 3/2/2003 3/2/2003
<b>FINISH:</b>  <b>DO NOT SCALE DRAWING</b>	<b>TITLE</b> <b>CAM CASE COMPONENTS, IMC 100 CI MOTOR</b>	<b>REV B</b> <b>SCALE: 1:1</b> <b>SHEET 1 OF 4</b>

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	2/24/03	WB	
B	CONVERTED TO SW, UPDATE NOTATION	3/11/03	WB	



2X TORQUE TO 8-12 FT-LBS  
INSTALL TO DIMENSION AS NOTED  
APPLY RED THREAD LOCKER

TORQUE TO 18 FT-LBS

APPLY LIGHT ASSY LUBE  
TO VALVE STEMS

2X .875±.05  
AFTER ASSY OF STUD

SEE SEPARATE BILL OF MATERIALS

INSTALL WITH FIRE RING  
SEAM FACING UP

FRONT CYLINDER HEAD

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

SURFACE ROUGHNESS:  
125 UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

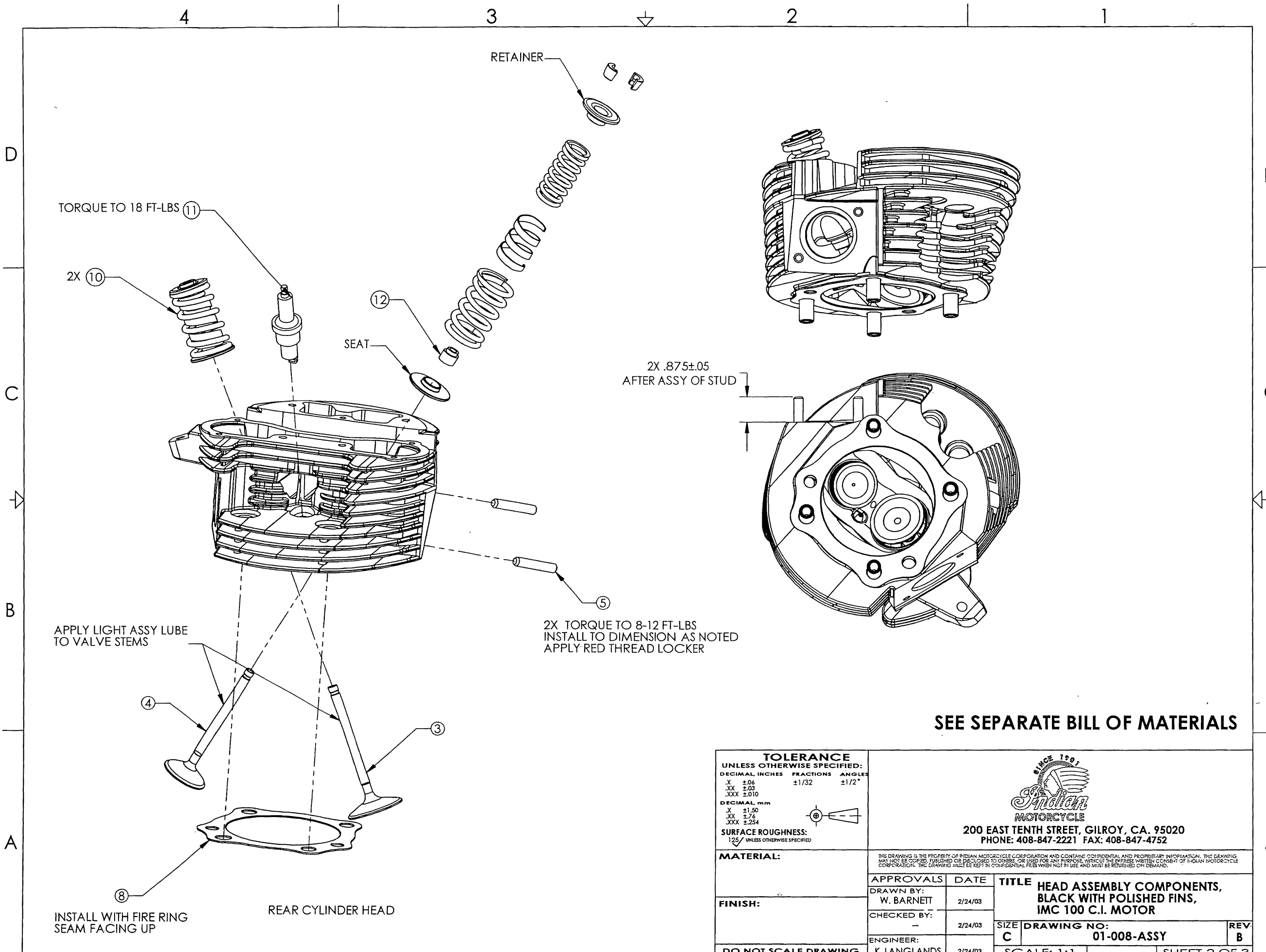
**MATERIAL:**

**FINISH:**

**DO NOT SCALE DRAWING**

APPROVALS	DATE
DRAWN BY: W. BARNETT	2/24/2003
CHECKED BY: Name	2/24/2003
ENGINEER: K. LANGLANDS	2/24/2003

TITLE		REV
HEAD ASSEMBLY COMPONENTS, BLACK WITH POLISHED FINS, IMC 100 CI		B
SIZE	DRAWING NO:	
C	01-008-ASSY	
SCALE: 1:1	SHEET 1 OF 3	



TORQUE TO 18 FT-LBS (11)

2X (10)

SEAT (12)

RETAINER

2X .875±.05  
AFTER ASSY OF STUD

2X TORQUE TO 8-12 FT-LBS  
INSTALL TO DIMENSION AS NOTED  
APPLY RED THREAD LOCKER

APPLY LIGHT ASSY LUBE  
TO VALVE STEMS

INSTALL WITH FIRE RING  
SEAM FACING UP

REAR CYLINDER HEAD

**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

**DECIMAL mm**

X ±1.50
.XX ±.76
.XXX ±.254

**SURFACE ROUGHNESS:**  
125 UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

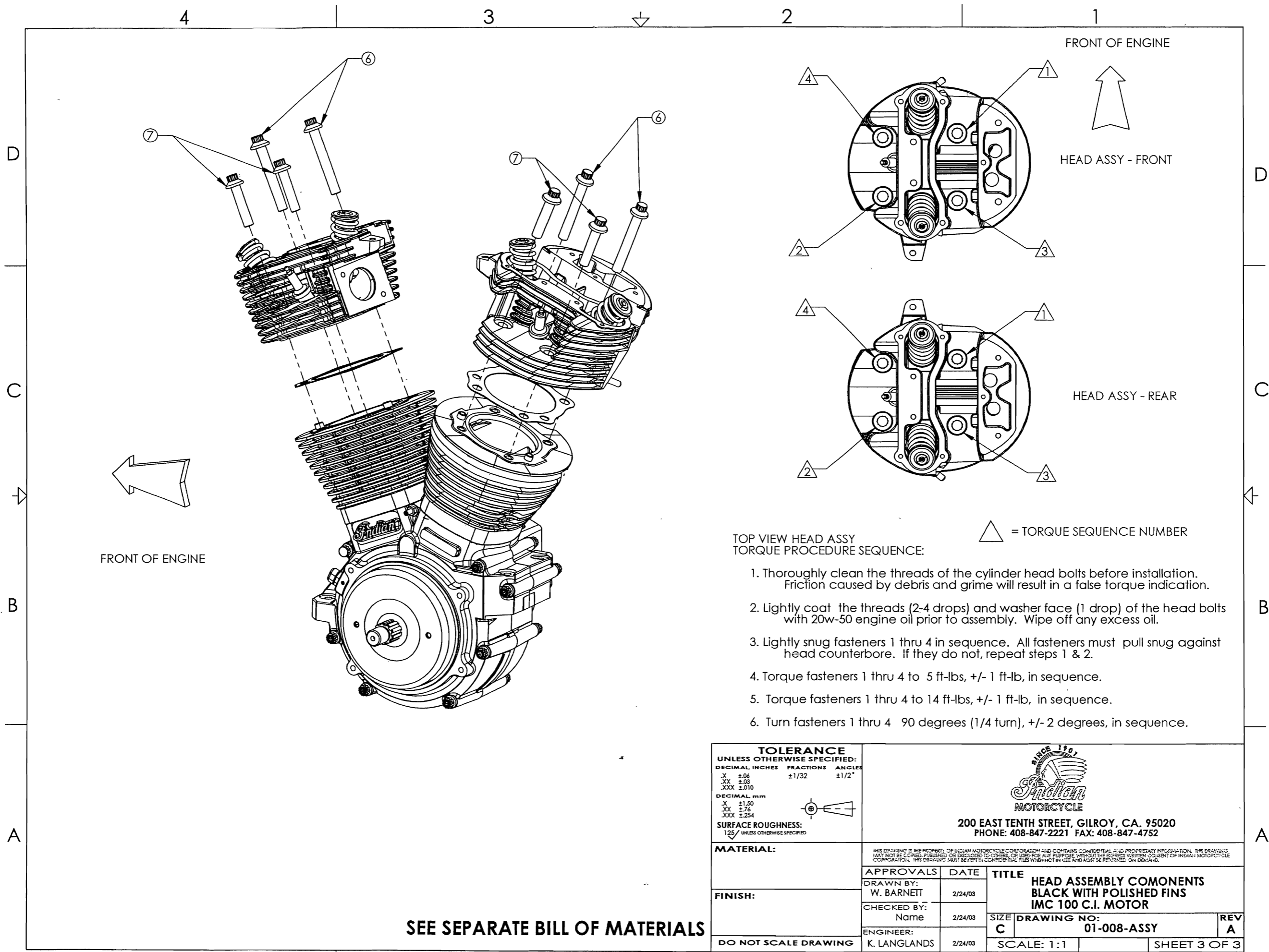
**MATERIAL:**

**FINISH:**

**DO NOT SCALE DRAWING**

APPROVALS	DATE
DRAWN BY: W. BARNETT	2/24/03
CHECKED BY: -	2/24/03
ENGINEER: K. LANGLANDS	2/24/03

TITLE		REV
HEAD ASSEMBLY COMPONENTS, BLACK WITH POLISHED FINIS, IMC 100 C.I. MOTOR		B
SIZE	DRAWING NO:	
C	01-008-ASSY	
SCALE: 1:1	SHEET 2 OF 3	



FRONT OF ENGINE

FRONT OF ENGINE

HEAD ASSY - FRONT


HEAD ASSY - REAR

TOP VIEW HEAD ASSY TORQUE PROCEDURE SEQUENCE:

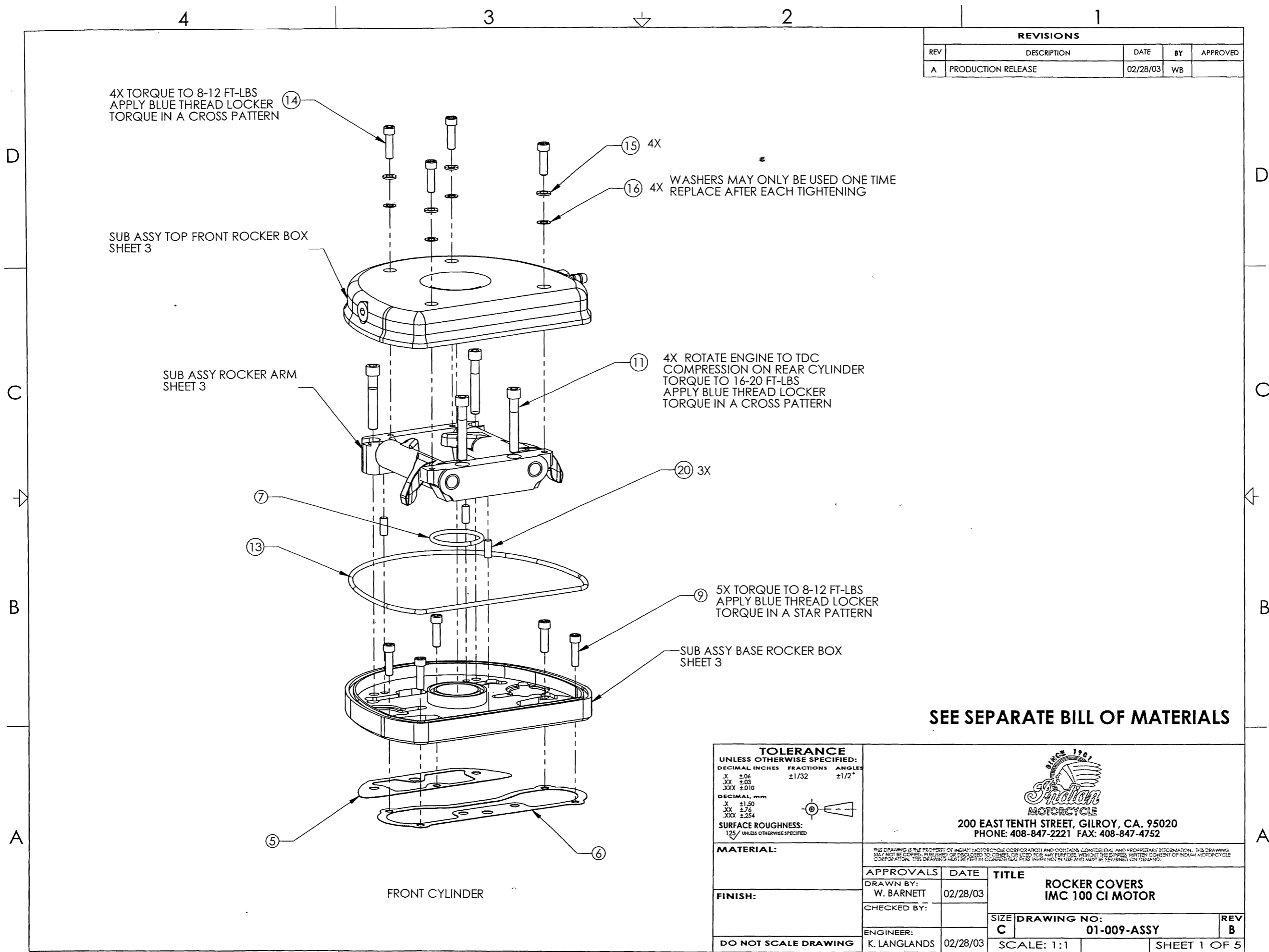
△ = TORQUE SEQUENCE NUMBER

1. Thoroughly clean the threads of the cylinder head bolts before installation. Friction caused by debris and grime will result in a false torque indication.
2. Lightly coat the threads (2-4 drops) and washer face (1 drop) of the head bolts with 20w-50 engine oil prior to assembly. Wipe off any excess oil.
3. Lightly snug fasteners 1 thru 4 in sequence. All fasteners must pull snug against head counterbore. If they do not, repeat steps 1 & 2.
4. Torque fasteners 1 thru 4 to 5 ft-lbs, +/- 1 ft-lb, in sequence.
5. Torque fasteners 1 thru 4 to 14 ft-lbs, +/- 1 ft-lb, in sequence.
6. Turn fasteners 1 thru 4 90 degrees (1/4 turn), +/- 2 degrees, in sequence.

SEE SEPARATE BILL OF MATERIALS

<p><b>TOLERANCE</b> UNLESS OTHERWISE SPECIFIED:</p> <p>DECIMAL INCHES FRACTIONS ANGLES</p> <p>X ±.04 ±1/32 ±1/2°</p> <p>XX ±.03</p> <p>XXX ±.010</p> <p>DECIMAL MM</p> <p>X ±1.50</p> <p>XX ±.76</p> <p>XXX ±.254</p> <p>SURFACE ROUGHNESS: 125 UNLESS OTHERWISE SPECIFIED</p>	 <p>200 EAST TENTH STREET, GILROY, CA. 95020 PHONE: 408-847-2221 FAX: 408-847-4752</p>		
	<p>THIS DRAWING IS THE PROPERTY OF INDIAN MOTORCYCLE CORPORATION AND CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. THE DRAWING MAY NOT BE COPIED, PUBLISHED, OR DISCLOSED TO OTHERS, OR USED FOR ANY PURPOSE, WITHOUT THE EXPRESS WRITTEN CONSENT OF INDIAN MOTORCYCLE CORPORATION. THIS DRAWING MUST BE KEPT IN CONFIDENTIAL FILES WHEN NOT IN USE AND MUST BE RETURNED ON DEMAND.</p>		
<b>MATERIAL:</b>	<b>APPROVALS</b>	<b>DATE</b>	<p><b>TITLE</b> HEAD ASSEMBLY COMONENTS BLACK WITH POLISHED FINIS IMC 100 C.I. MOTOR</p>
<b>FINISH:</b>	DRAWN BY: W. BARNETT	2/24/03	
	CHECKED BY: Name	2/24/03	
	ENGINEER: K. LANGLANDS	2/24/03	
<b>DO NOT SCALE DRAWING</b>	<b>SIZE</b> C	<b>DRAWING NO.:</b> 01-008-ASSY	<b>REV</b> A
	<b>SCALE: 1:1</b>		<b>SHEET 3 OF 3</b>

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	02/28/03	WB	



4X TORQUE TO 8-12 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A CROSS PATTERN

15 4X

16 4X WASHERS MAY ONLY BE USED ONE TIME  
REPLACE AFTER EACH TIGHTENING

SUB ASSY TOP FRONT ROCKER BOX  
SHEET 3

SUB ASSY ROCKER ARM  
SHEET 3

11 4X ROTATE ENGINE TO TDC  
COMPRESSION ON REAR CYLINDER  
TORQUE TO 16-20 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A CROSS PATTERN

20 3X

9 5X TORQUE TO 8-12 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A STAR PATTERN

SUB ASSY BASE ROCKER BOX  
SHEET 3

**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL, mm

.X ±1.50
.XX ±.76
.XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

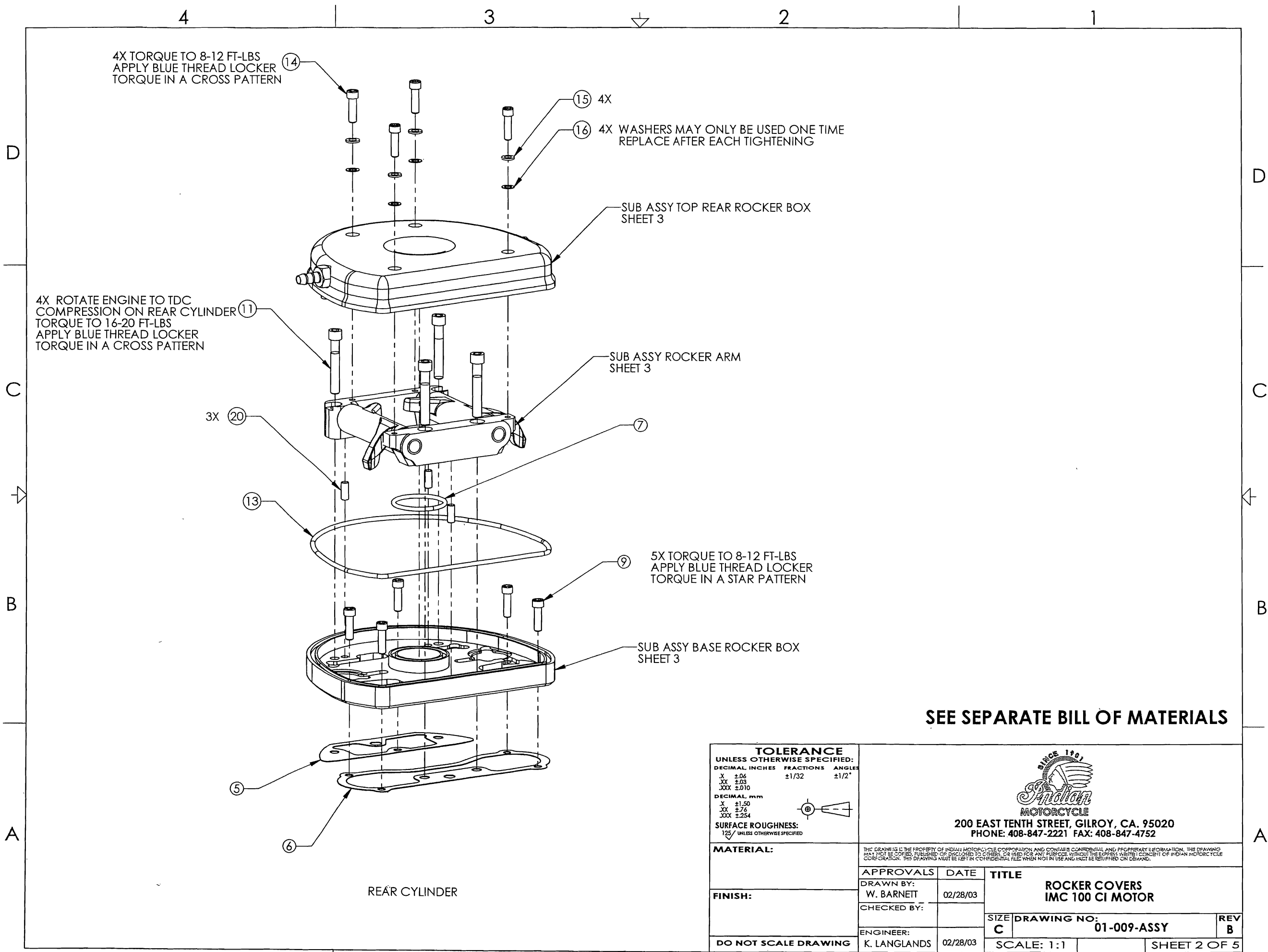
**FINISH:**

**DO NOT SCALE DRAWING**

APPROVALS	DATE
DRAWN BY: W. BARNETT	02/28/03
CHECKED BY:	
ENGINEER: K. LANGLANDS	02/28/03

TITLE	
ROCKER COVERS IMC 100 CI MOTOR	
SIZE C	DRAWING NO: 01-009-ASSY
SCALE: 1:1	SHEET 1 OF 5

REV B



4X TORQUE TO 8-12 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A CROSS PATTERN

15 4X  
16 4X WASHERS MAY ONLY BE USED ONE TIME  
REPLACE AFTER EACH TIGHTENING

4X ROTATE ENGINE TO TDC  
COMPRESSION ON REAR CYLINDER  
TORQUE TO 16-20 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A CROSS PATTERN

9 5X TORQUE TO 8-12 FT-LBS  
APPLY BLUE THREAD LOCKER  
TORQUE IN A STAR PATTERN

**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL: mm

X ±1.50
XX ±.75
XXX ±.254

SURFACE ROUGHNESS:  
125/ UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

**FINISH:**

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APPROVALS	DATE	TITLE
DRAWN BY: W. BARNETT	02/28/03	<b>ROCKER COVERS IMC 100 CI MOTOR</b>
CHECKED BY:		
ENGINEER: K. LANGLANDS	02/28/03	SIZE: <b>C</b>

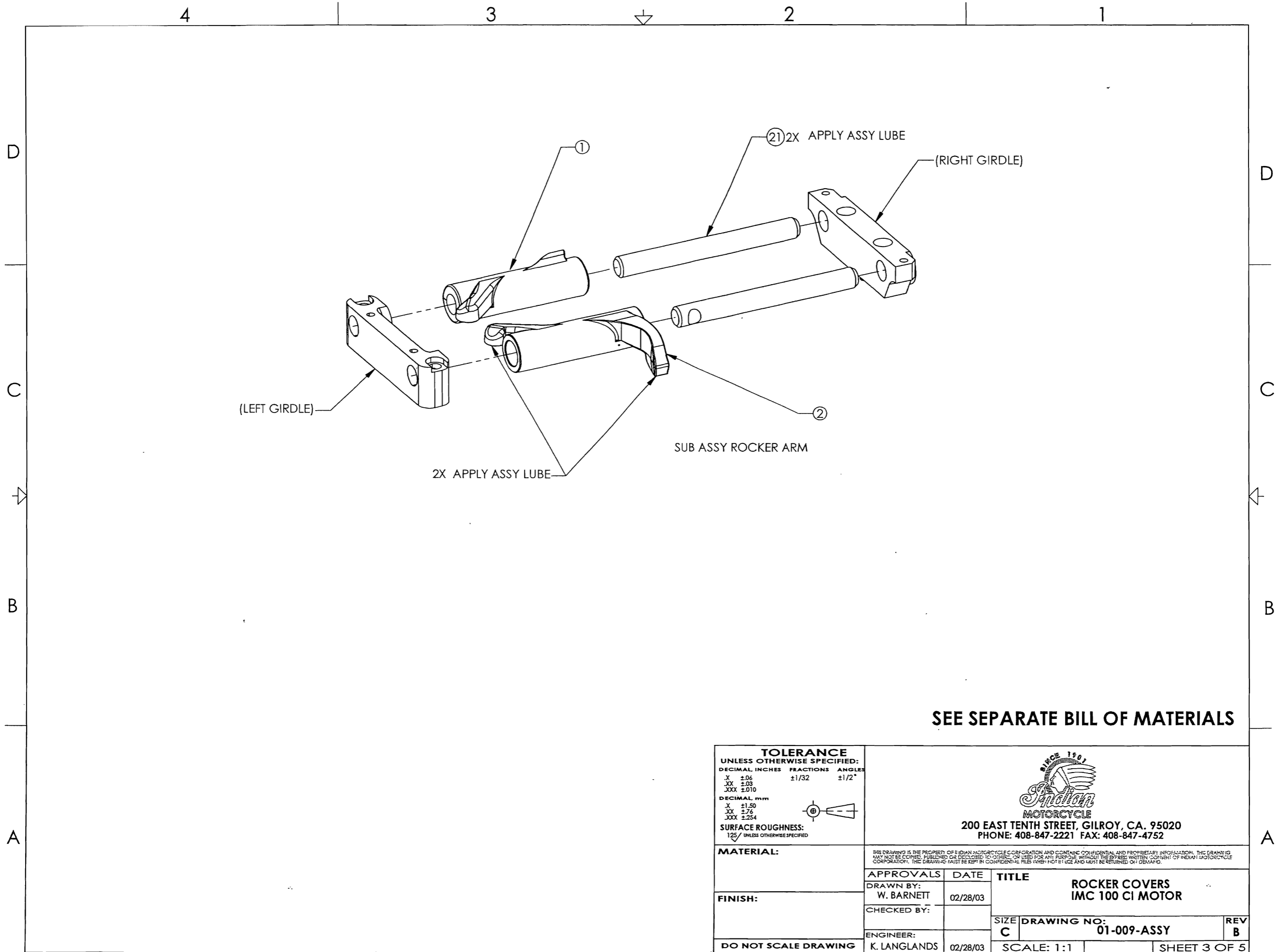
DRAWING NO: **01-009-ASSY**

SCALE: 1:1

REV **B**

SHEET 2 OF 5

REAR CYLINDER



**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED



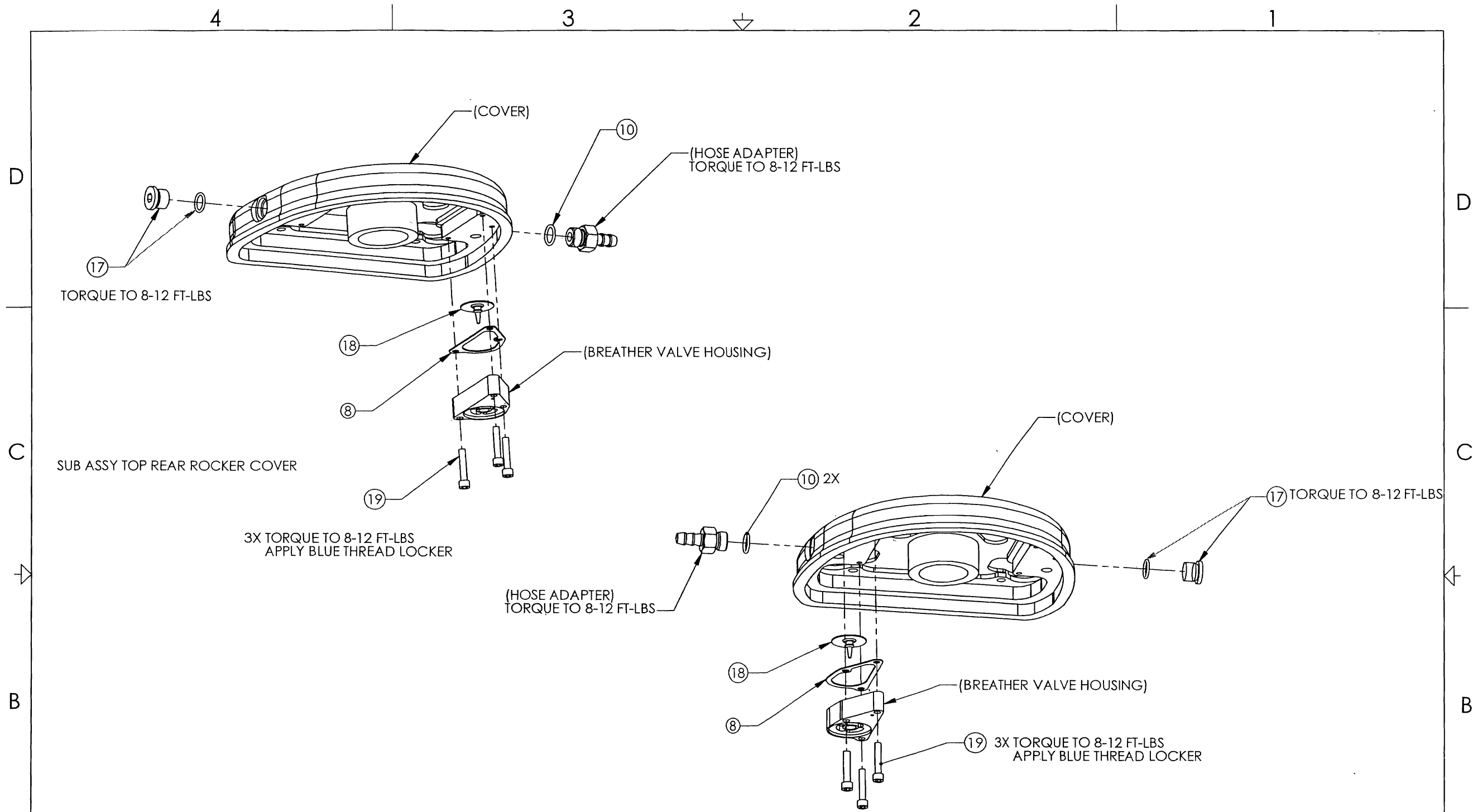
200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

**MATERIAL:**

**FINISH:**

**DO NOT SCALE DRAWING**

<b>APPROVALS</b>		<b>DATE</b>	<b>TITLE</b>	
DRAWN BY: W. BARNETT		02/28/03	<b>ROCKER COVERS IMC 100 CI MOTOR</b>	
CHECKED BY:				
ENGINEER: K. LANGLANDS		02/28/03	<b>SIZE</b> C	<b>DRAWING NO.:</b> 01-009-ASSY
			<b>SCALE:</b> 1:1	<b>REV</b> B
			<b>SHEET 3 OF 5</b>	



**SEE SEPARATE BILL OF MATERIALS**

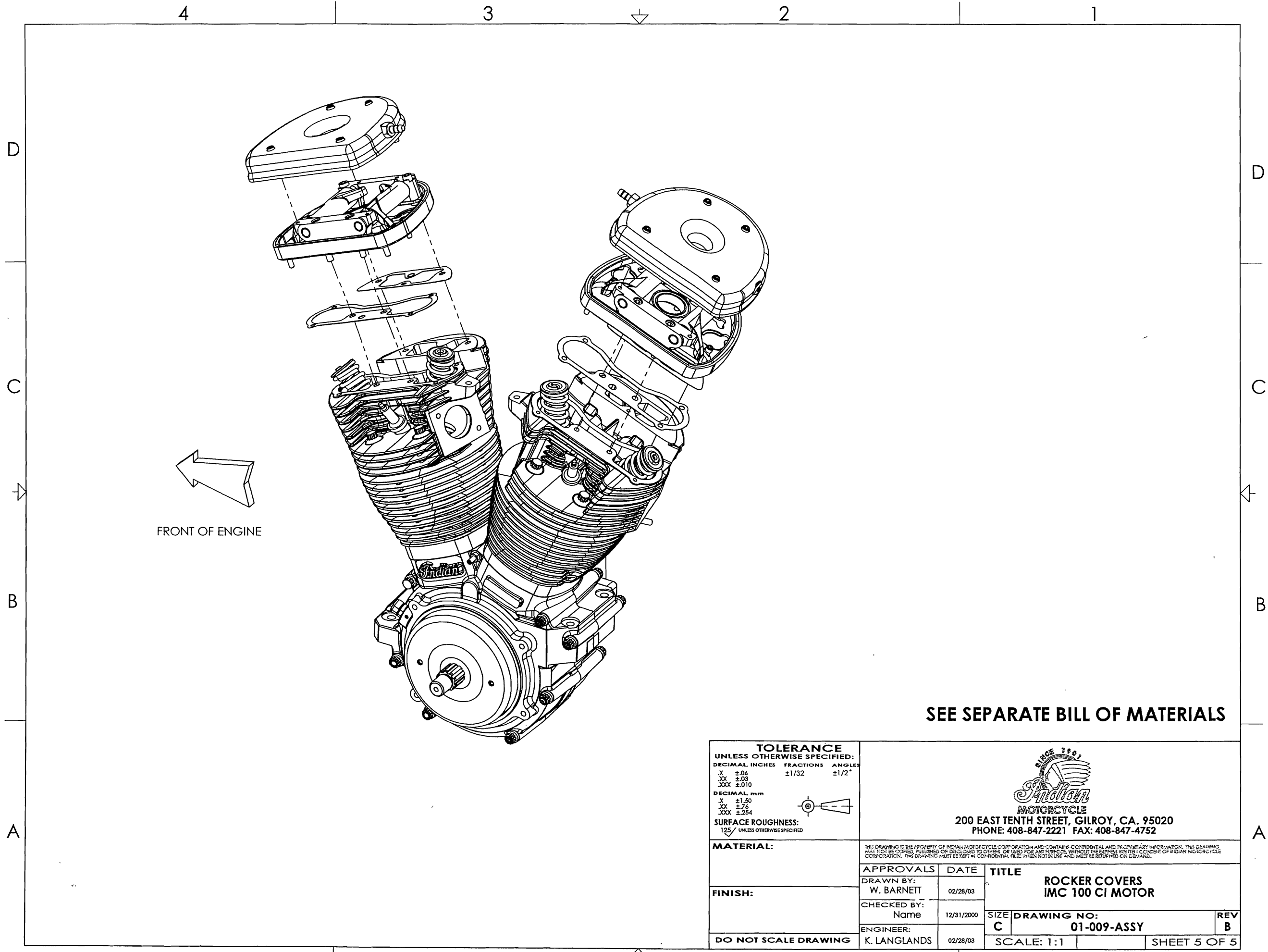
**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.04	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		
DECIMAL mm		
X ±1.50		
XX ±.76		
XXX ±.254		
SURFACE ROUGHNESS: 125/ UNLESS OTHERWISE SPECIFIED		



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

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	<b>APPROVALS</b>	<b>DATE</b>	<b>TITLE</b>
<b>FINISH:</b>	DRAWN BY: W. BARNETT	02/28/03	<b>ROCKER COVERS IMC 100 CI MOTOR</b>
	CHECKED BY:		
<b>DO NOT SCALE DRAWING</b>	ENGINEER: K. LANGLANDS	02/28/03	SIZE <b>C</b> DRAWING NO: <b>01-009-ASSY</b> REV <b>B</b>
			SCALE: 1:1 SHEET 4 OF 5



FRONT OF ENGINE

SEE SEPARATE BILL OF MATERIALS

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

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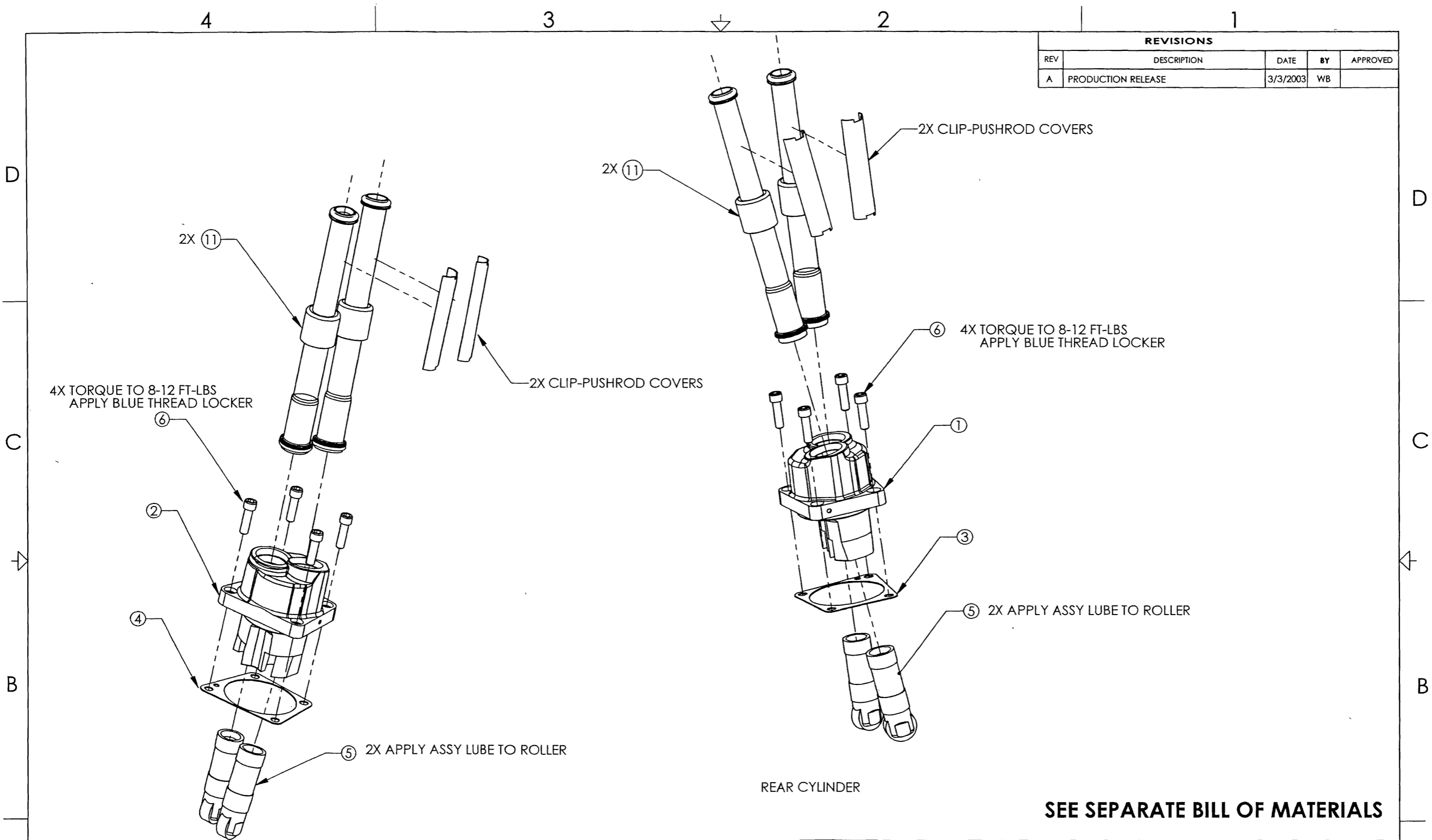
**FINISH:**

DO NOT SCALE DRAWING

APPROVALS	DATE
DRAWN BY: W. BARNETT	02/28/03
CHECKED BY: Name	12/31/2000
ENGINEER: K. LANGLANDS	02/28/03

<b>TITLE</b>		<b>REV</b>	
ROCKER COVERS		B	
IMC 100 CI MOTOR			
SIZE	DRAWING NO:		
C	01-009-ASSY		
SCALE: 1:1	SHEET 5 OF 5		

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	3/3/2003	WB	



**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED

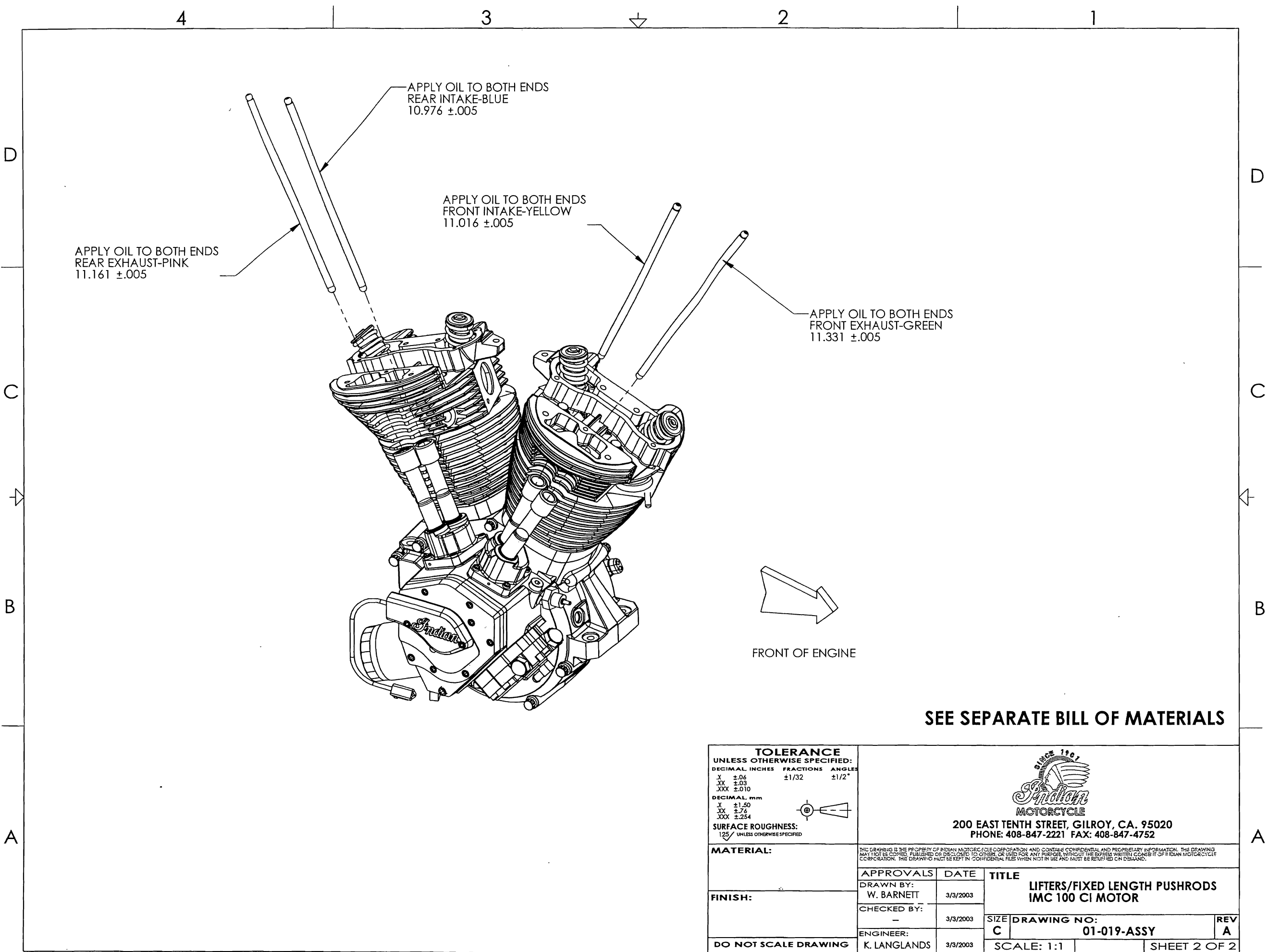
  
**200 EAST TENTH STREET, GILROY, CA. 95020**  
**PHONE: 408-847-2221 FAX: 408-847-4752**

**MATERIAL:**

**FINISH:**

**DO NOT SCALE DRAWING**

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<p><b>APPROVALS</b></p> <p>DRAWN BY: W. BARNEIT</p> <p>CHECKED BY: -</p> <p>ENGINEER: K. LANGLANDS</p>	<p><b>DATE</b></p> <p>3/3/2003</p> <p>3/3/2003</p> <p>3/3/2003</p>	<p><b>TITLE</b></p> <p>LIFTERS/ FIXED LENGTH PUSHRODS IMC 100 CI MOTOR</p> <p><b>SIZE</b> <b>DRAWING NO:</b> C 01-019-ASSY</p> <p><b>SCALE:</b> 1:1</p>	<p><b>REV</b></p> <p>A</p> <p><b>SHEET 1 OF 2</b></p>

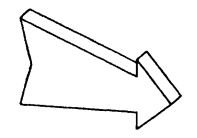


APPLY OIL TO BOTH ENDS  
REAR EXHAUST-PINK  
11.161 ±.005

APPLY OIL TO BOTH ENDS  
REAR INTAKE-BLUE  
10.976 ±.005

APPLY OIL TO BOTH ENDS  
FRONT INTAKE-YELLOW  
11.016 ±.005

APPLY OIL TO BOTH ENDS  
FRONT EXHAUST-GREEN  
11.331 ±.005



FRONT OF ENGINE

**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

DECIMAL mm

X ±1.50
XX ±.76
XXX ±.254

SURFACE ROUGHNESS:  
125/ UNLESS OTHERWISE SPECIFIED



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PHONE: 408-847-2221 FAX: 408-847-4752

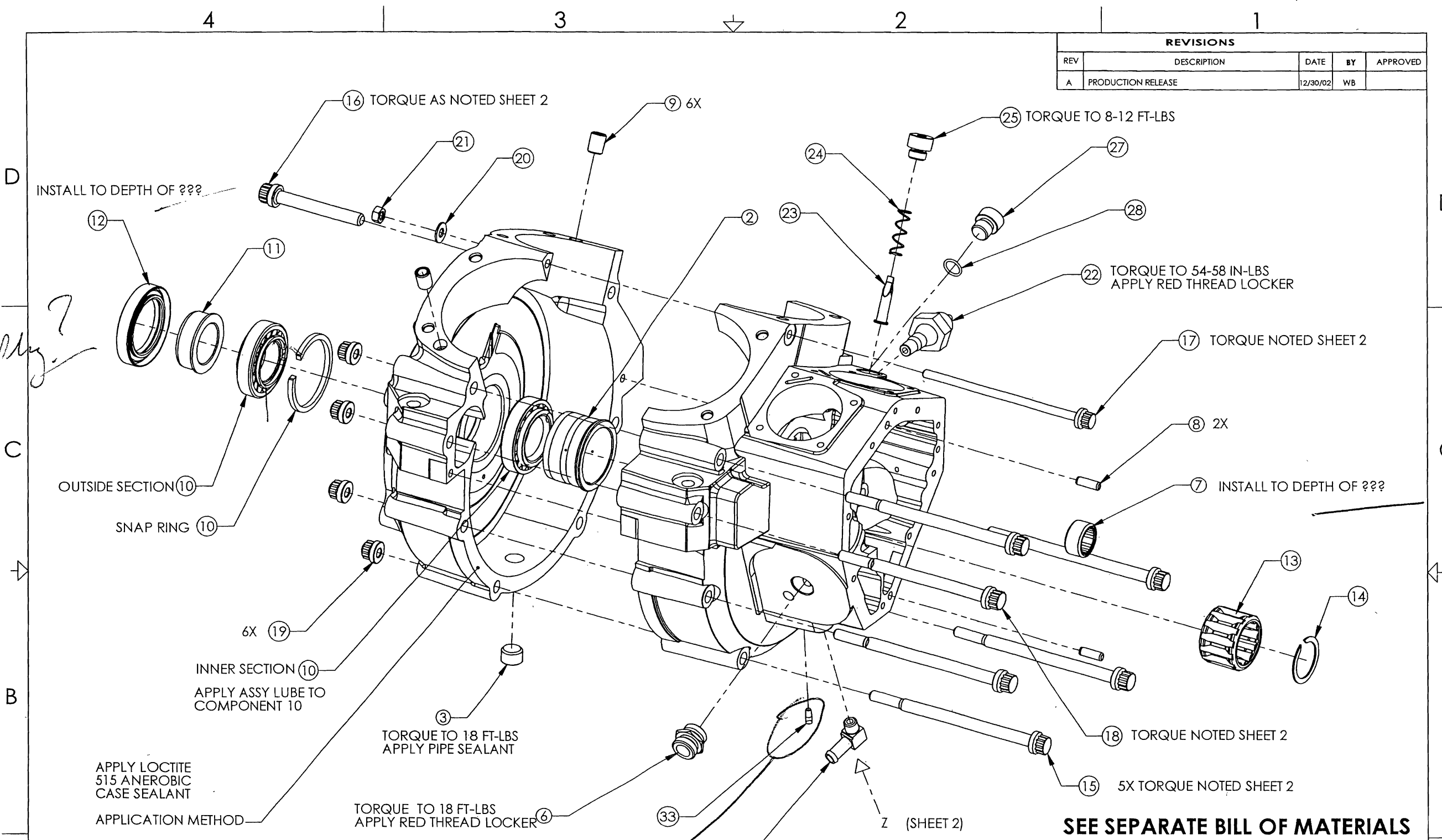
**MATERIAL:**

**FINISH:**

**DO NOT SCALE DRAWING**

APPROVALS		DATE	TITLE	
DRAWN BY: W. BARNETT		3/3/2003	LIFTERS/FIXED LENGTH PUSHRODS IMC 100 CI MOTOR	
CHECKED BY: -		3/3/2003	SIZE	DRAWING NO:
ENGINEER: K. LANGLANDS		3/3/2003	C	01-019-ASSY
SCALE: 1:1			REV A	
SHEET 2 OF 2				

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	12/30/02	WB	



*End Pkg?*

*Change per ESW (see Kyle)*

*Threads Not Shown Comment*

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
XX ±.03		
XXX ±.010		

**DECIMAL mm**

X ±1.50
XX ±.75
XXX ±.254

**SURFACE ROUGHNESS:**  
125/ UNLESS OTHERWISE SPECIFIED

  
**INDIAN MOTORCYCLE**  
 200 EAST TENTH STREET, GILROY, CA. 95020  
 PHONE: 408-847-2221 FAX: 408-847-4752

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<b>MATERIAL:</b>	<b>APPROVALS</b>	<b>DATE</b>	<b>TITLE</b>
	DRAWN BY: W BARNETT	12/30/2002	<b>ENGINE CASE COMPONENTS, 100 CI</b>
<b>FINISH:</b>	CHECKED BY:	12/30/2002	<b>SIZE</b> C
	ENGINEER: K LANGLANDS	12/30/2002	<b>DRAWING NO:</b> 01-220-ASSY
<b>DO NOT SCALE DRAWING</b>			<b>REV</b> A
		<b>SCALE: 1:1</b>	<b>SHEET 1 OF 3</b>

4

3

2

1

D

D

C

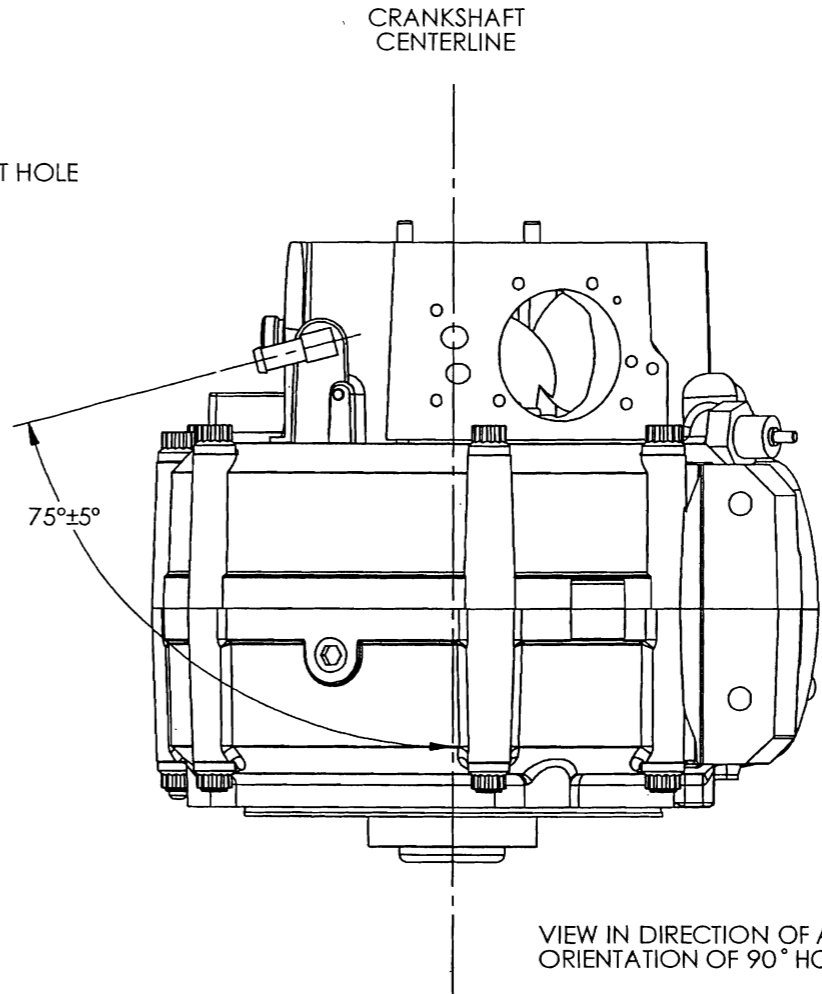
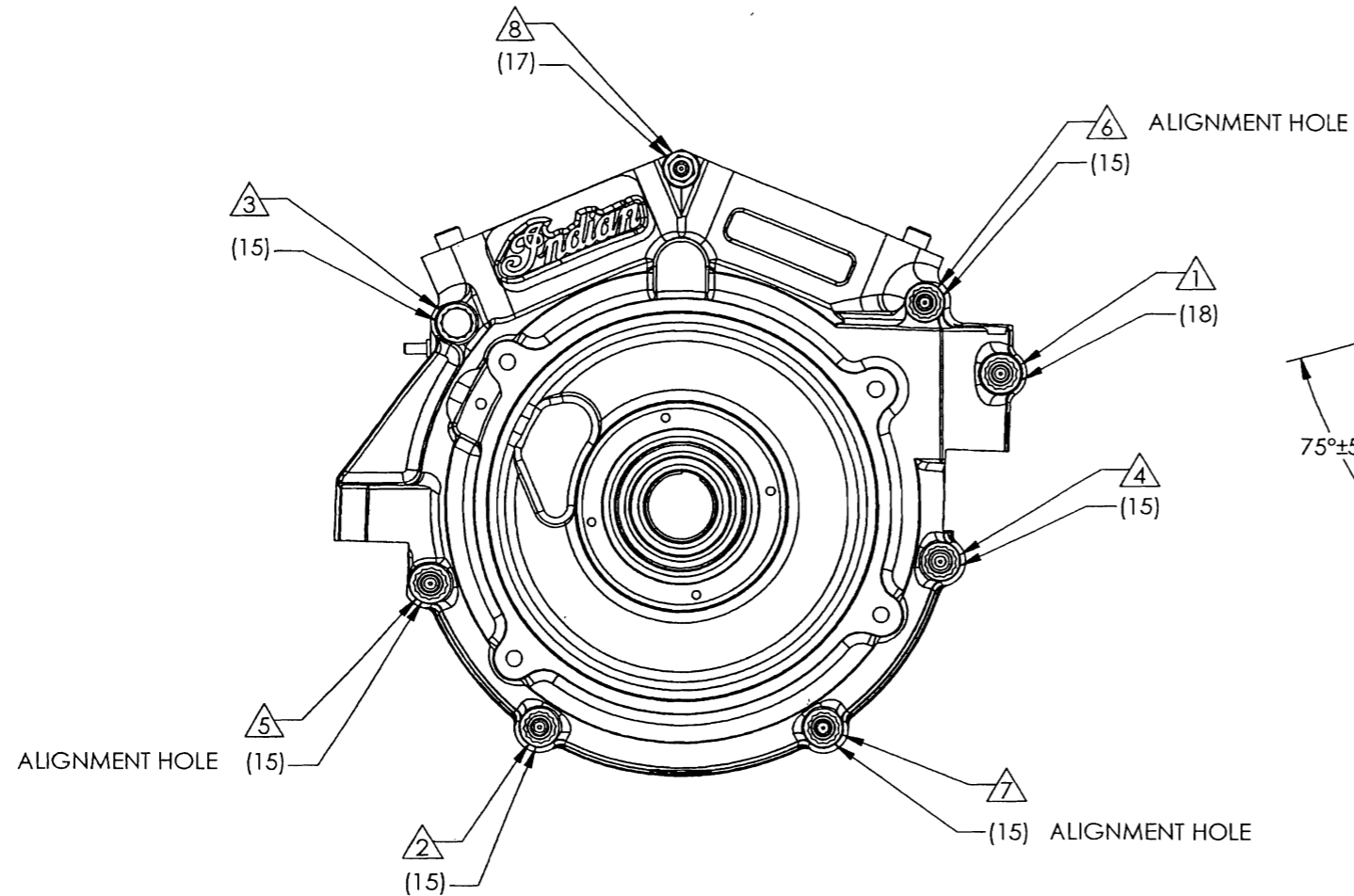
C

B

B

A

A



△ = RIGHT CASE TO LEFT CASE TORQUE SEQUENCE

1. APPLY BLUE THREAD LOCKER TO FASTENERS PRIOR TO ASSY.
2. PRE-TORQUE FASTENERS 1 THRU 8 TO 2 FT-LBS IN SEQUENCE
3. FINAL TORQUE FASTENERS 1 THRU 7 TO 18 FT-LBS IN SEQUENCE
4. FINAL TORQUE FASTENER 8 TO 10-12 FT-LBS

**SEE SEPARATE BILL OF MATERIALS**

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL mm

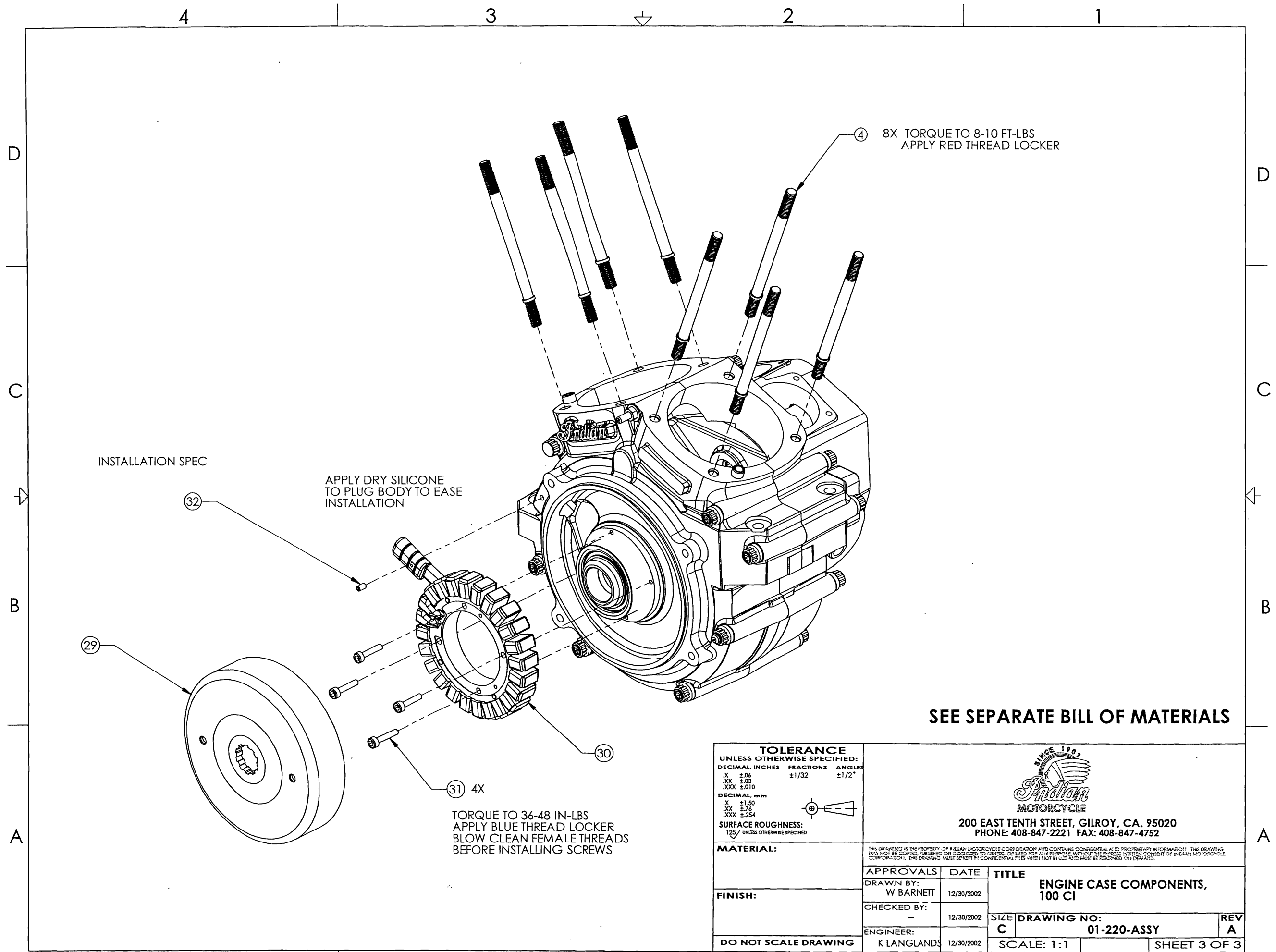
X ±1.50
XX ±.76
XXX ±.254

SURFACE ROUGHNESS:  
125 / UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

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<b>FINISH:</b>		<b>APPROVALS</b>	<b>DATE</b>
		DRAWN BY: W BARNETT	12/30/2002
		CHECKED BY: -	12/30/2002
		ENGINEER: K LANGLANDS	12/30/2002
<b>DO NOT SCALE DRAWING</b>		<b>TITLE</b>	<b>REV</b>
		ENGINE CASE COMPONENTS, 100-CI	A
		SIZE <b>C</b>	DRAWING NO: 01-220-ASSY
		SCALE: 1:1	SHEET 2 OF 3



INSTALLATION SPEC

APPLY DRY SILICONE TO PLUG BODY TO EASE INSTALLATION

8X TORQUE TO 8-10 FT-LBS  
APPLY RED THREAD LOCKER

TORQUE TO 36-48 IN-LBS  
APPLY BLUE THREAD LOCKER  
BLOW CLEAN FEMALE THREADS  
BEFORE INSTALLING SCREWS

SEE SEPARATE BILL OF MATERIALS

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL mm

X ±1.50
.XX ±.75
.XXX ±.254

SURFACE ROUGHNESS:  
125 / UNLESS OTHERWISE SPECIFIED



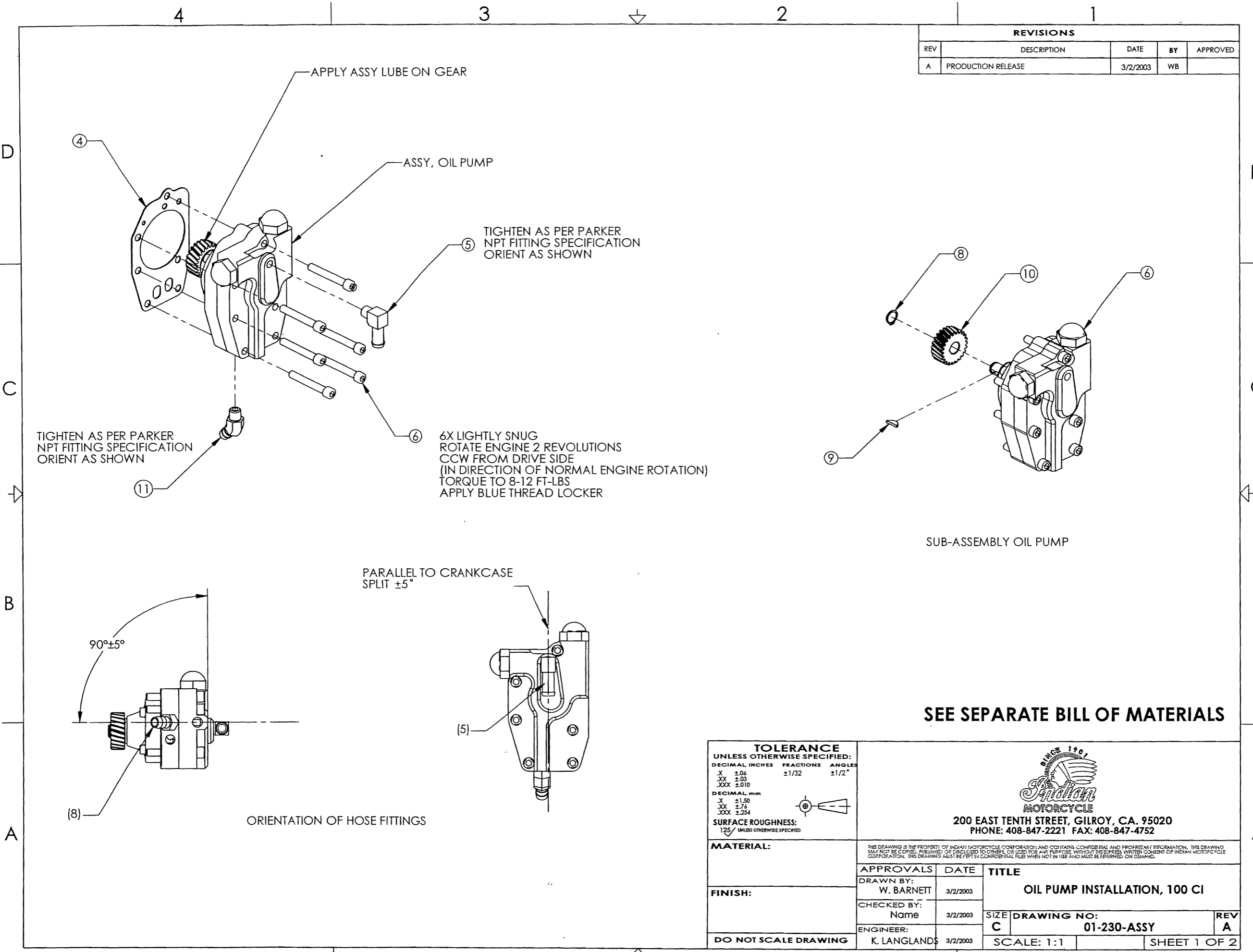
200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

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APPROVALS	DATE	TITLE
DRAWN BY: W BARNETT	12/30/2002	ENGINE CASE COMPONENTS, 100 CI
CHECKED BY: -	12/30/2002	
ENGINEER: K LANGLANDS	12/30/2002	SIZE C DRAWING NO: 01-220-ASSY
DO NOT SCALE DRAWING		SCALE: 1:1
		REV A
		SHEET 3 OF 3

REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	3/2/2003	WB	



SEE SEPARATE BILL OF MATERIALS

**TOLERANCE**  
UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL mm

.X ±1.50
.XX ±.76
.XXX ±.254

SURFACE ROUGHNESS:  
125 UNLESS OTHERWISE SPECIFIED

  
**Indian**  
 MOTORCYCLE  
 200 EAST TENTH STREET, GILROY, CA. 95020  
 PHONE: 408-847-2221 FAX: 408-847-4752

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	<b>APPROVALS</b> DRAWN BY: W. BARNETT CHECKED BY: Name ENGINEER: K. LANGLANDS	<b>DATE</b> 3/2/2003 3/2/2003 3/2/2003
	<b>TITLE</b> OIL PUMP INSTALLATION, 100 CI <b>SIZE</b> C <b>DRAWING NO:</b> 01-230-ASSY <b>SCALE:</b> 1:1 <b>REV</b> A SHEET 1 OF 2	

4

3

2

1

D

D

C

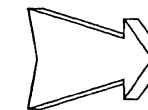
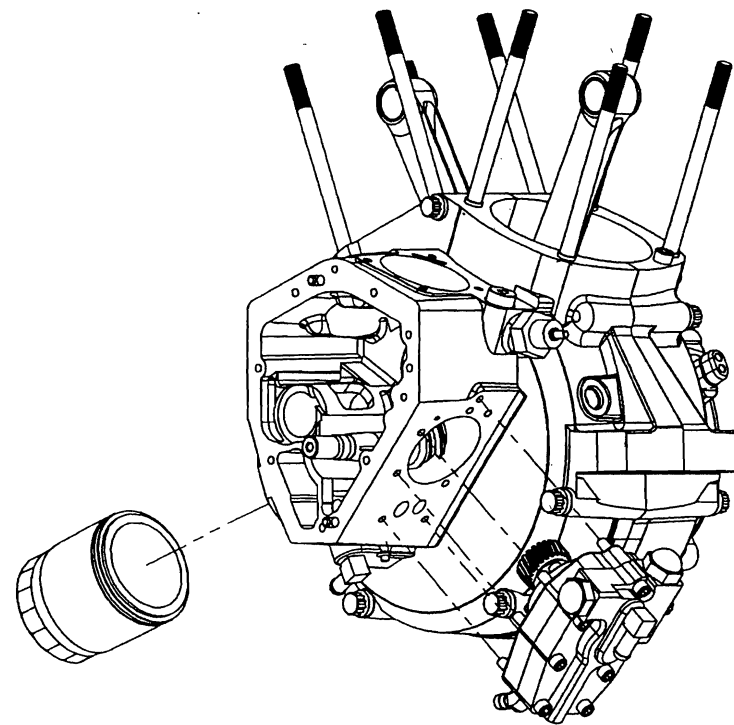
C

B

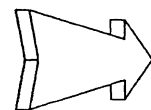
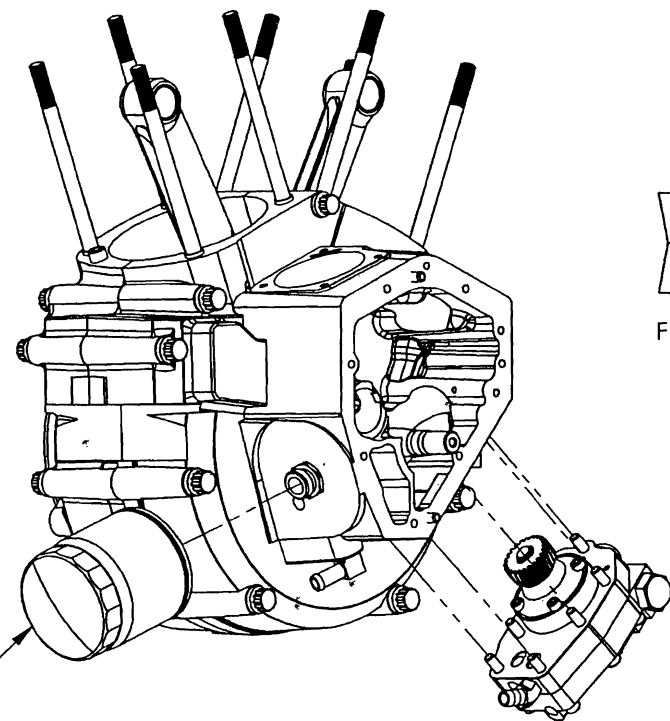
B

A

A



FRONT OF ENGINE



FRONT OF ENGINE

SEE SEPARATE BILL OF MATERIALS

9  
 INSTALL FILTER UNTIL SEAL TOUCHES CASE  
 THEN TURN 1/4 ROTATION BY HAND???  
 APPLY OIL LIGHTLY TO SEAL

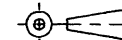
**TOLERANCE**  
 UNLESS OTHERWISE SPECIFIED:

DECIMAL INCHES	FRACTIONS	ANGLES
.X ±.06	±1/32	±1/2°
.XX ±.03		
.XXX ±.010		

DECIMAL MM

X ±1.50
XX ±.75
XXX ±.254

**SURFACE ROUGHNESS:**  
 125/ UNLESS OTHERWISE SPECIFIED



200 EAST TENTH STREET, GILROY, CA. 95020  
 PHONE: 408-847-2221 FAX: 408-847-4752

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**FINISH:**

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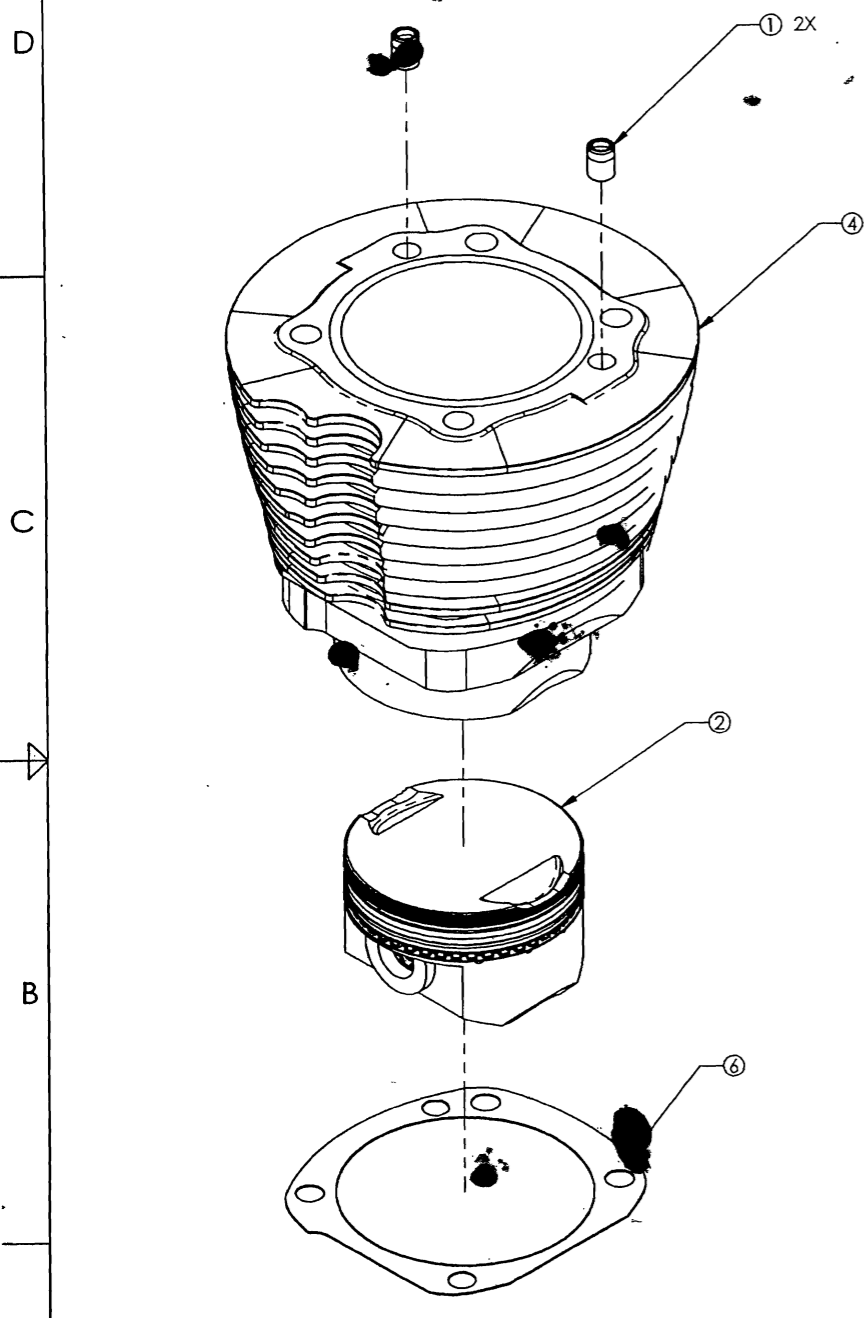
APPROVALS	DATE	TITLE
DRAWN BY: W. BARNETT	02/11/03	OIL PUMP INSTALLATION, 100 CI
CHECKED BY: Name	12/31/2000	
ENGINEER: K. LANGLANDS	02/11/03	

SIZE	DRAWING NO:	REV
C	01-230-ASSY	A

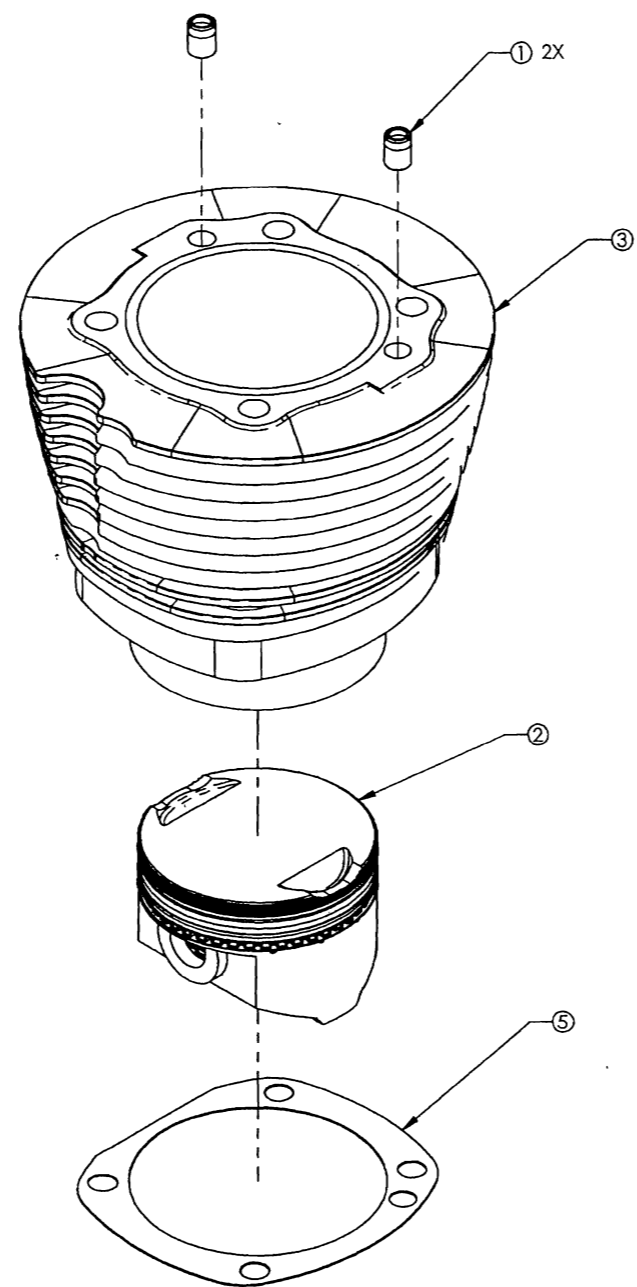
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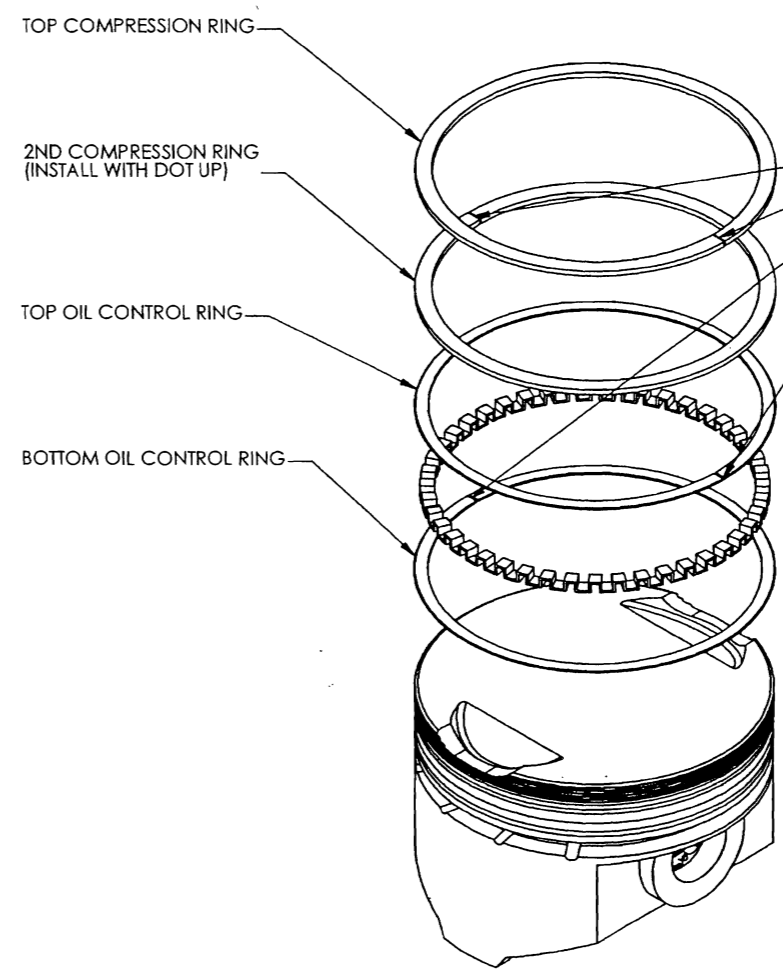
REVISIONS				
REV	DESCRIPTION	DATE	BY	APPROVED
A	PRODUCTION RELEASE	3/3/2003	WB	



REAR CYLINDER



FRONT CYLINDER



PISTON KIT ASSEMBLY (01-110)

TOP AND 2ND COMPRESSION RING GAP (.018-.024)" INSTALLED  
 TOP AND 2ND COMPRESSION RING GAPS 180 XX APART  
 TOP AND BOTTOM OIL CONTROL RING GAPS 180 XX APART  
 ALL RING GAPS SHOULD ALIGN WITH WREST PIN AXIS

SEE SEPARATE BILL OF MATERIAL



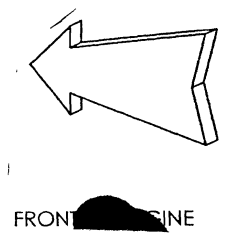
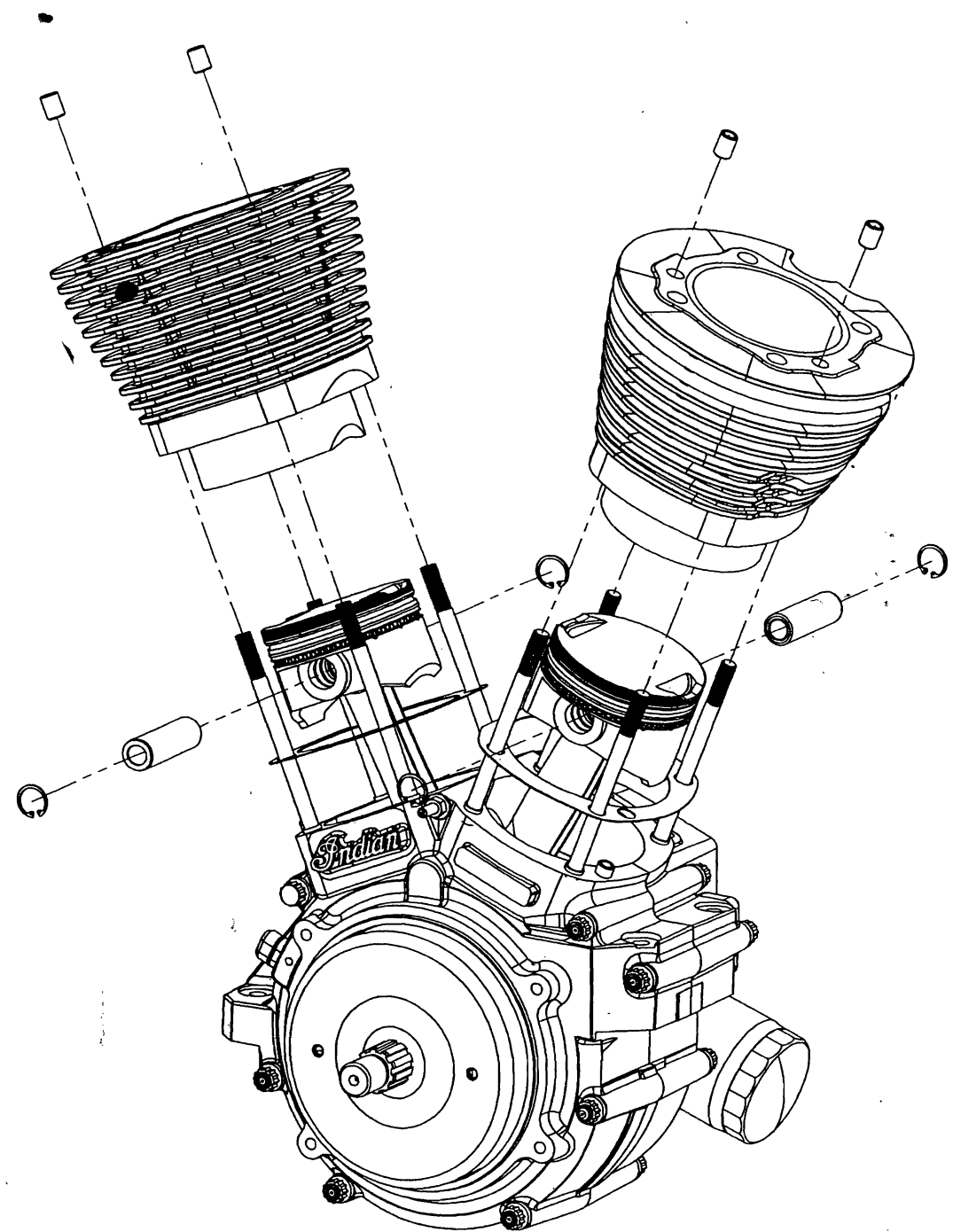
200 EAST TENTH STREET, GILROY, CA. 95020  
 PHONE: 408-847-2221 FAX: 408-847-4752

APPROVALS		DATE	TITLE:
DRAWN BY: WB		3/3/2003	CYLINDER ASSEMBLY COMPONENTS 100 CI
CHECKED BY:		3/3/2003	
ENGINEER: K. LANGLANDS		3/3/2003	SIZE: <b>D</b> DRAWING NO: <b>01-232-ASSY</b> REV <b>A</b> SCALE: 1:1 SHEET 1 OF 2

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D  
C  
B  
A



SEE SEPARATE BILL OF MATERIAL



200 EAST TENTH STREET, GILROY, CA. 95020  
PHONE: 408-847-2221 FAX: 408-847-4752

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APPROVALS	DATE	TITLE:	
DRAWN BY: W. BARNETT	3/3/2003	CYLINDER ASSEMBLY COMPONENTS, 100 CI	
CHECKED BY:	3/3/2003	SIZE	REV
ENGINEER: K. LANGLANDS	3/3/2003	D	A
		DRAWING NO:	SHEET 2 OF 2
		01-232-ASSY	
		DNS	

8 7 6 5 4 3 2 1