

# Twin Cam/Evo/XL/Buell Case Boring Instructions

## Twin Cam/Evo/XL/Buell Case Boring Instructions:

This is a service that we offer if you feel that your local shop is unable to do the job correctly please contact us and we can bore the case's for you.

Boring your cases to accept your new big bore kit can be quite the challenge for the inexperienced and should only be attempted by trained personnel with the proper equipment. Various suppliers make jigs that vastly simplify the process the do-it-yourself home mechanic. If you must tackle it yourself please invest in one of these. Supplied below are the case bore dimensions for the respective models:

All cases must be bored with a center case through bolt!

Before your cases can be bored you must drill out the existing threaded hole in the right (cam side) case half with a 5/16" drill. Once this is accomplished, machine a flat area centered over the new hole in the outer case surface with a .875 flat end mill to achieve just enough surface for the flat washer to sit on. Put the case halves together and insert a 5/16" x 5" grade 5 socket head cap screw through the center hole and tighten. Be sure that you have flat washers on both ends of the bolt! You are now ready to mount and bore your cases in the manner that you so choose. You will find that the middle section of the bolt will be milled along with the cases as go. This is normal and reinforces the need to be sure that your flat washers are in place as you go.

## 1999-Present Twin Cam 88 A-B:

4.250" Big Bore Cylinders (114" 124" 131") – 4.410" x 1.500"

4.125" Big Bore Cylinders (107") – 4.310" x 1.500"

98" Bolt-On Big Bore Kit – No case boring necessary!

## XL/Buell Tube Frame /Buell XB(Including Blast and Ulysses)

3.875" Big Bore Cylinders (90" Kit) – 4.010" x 1.500"

3.8125" Big Bore Cylinders (87" Kit) – 4.010" x 1.500"

1250cc Big Bore Cylinders (76" Kit) – No case boring necessary!

## Evolution Big Twin

3.875" Big Bore Cylinders (100" Kit) – 4.010" x 1.500"

3.8125" Big Bore Cylinders (97" Kit) – 4.010" x 1.500"

3.563" Big Bore Cylinders (85" Kit) – No case boring necessary!