

# TRUE-TRACK, INC.

## TRUE-PIVOT REPAIR KIT

P/N #20-19E-RK (1980-2001) and 20-19L-RK (2002-2008)

**For use by experienced technicians only. Please read directions carefully and thoroughly before you begin.**

### Parts included in True-Pivot Repair Kit:

- 10 bushings
- 1 threaded rod
- 1 drill cutter
- 3 nuts
- 1 hone
- 2 washers

### Tools needed:

- 1/2" drill – use variable speed electric hand drill
- (2) 3/4" or 13/16" wrenches

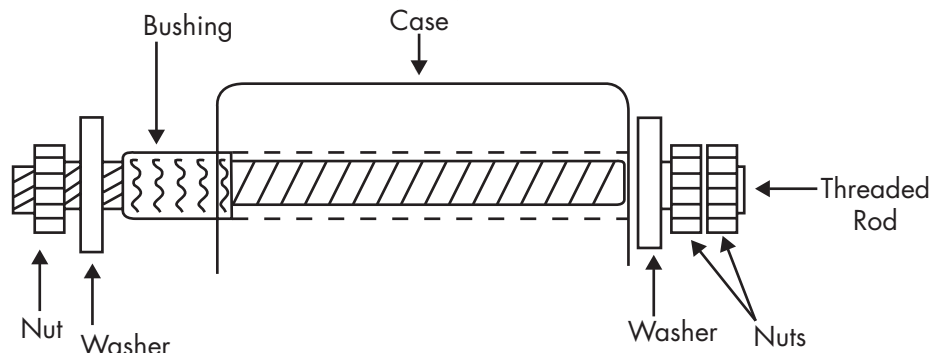
### Lubrication needed:

- WD40
- Blue Marine Grease

### Installation instructions:

Before you start, place bronze bushings in your freezer. This will make installation easier by shrinking them.

1. Remove swing arm assembly per Harley Davidson manual.
2. Clean trans case
3. Install drill cutter into 1/2" drill and set cutter into bore of trans case. It will center up. Using WD 40 for lubrication, start drilling out case. Drill from the passenger side (foot brake side) straight through to the other side. Go slow as you approach the other end!, IF YOU FORCE IT, IT WILL GRAB!! Go slow and be prepared! **DO NOT REAM HOLE AND DO NOT RUSH THIS PROCEDURE.** Remove the drill periodically as material builds up on cutter. Clean and continue drilling hole using WD 40 to lubricate until all the way through.
4. Chamfer both sides of hole going through the trans case.
5. Clean up all shavings in hole and surrounding area prior to installation of bushing.
6. Take threaded rod and slide into case with one bushing on rod as shown below:



Draw bushings into case one side at a time using WD 40 as lubricant. Tighten the single nut and hold the double nut side until bushing is flush. Repeat procedure for the other side.

7. Test axle fit at this time (use WD40), using hone to fit if it's too tight. Use Marine grease for final assembly.