



# INSTRUCTIONS

J03190

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## BUELL XB MODEL FRAME PUCK

### GENERAL

#### Kit Number

93001-03YA and 93004-05YA.

#### Models

**Kit Number 93001-03YA** fits all 2002 and later Buell XB model motorcycles (**except** 2006 and later XB12Ss and XB12X models).

**Kit Number 93004-05YA** fits all 2006 and later XB12Ss and XB12X model motorcycles.

#### Kit Contents

Table 1. Kit Contents

Description (Quantity)	Part Number
Frame puck, LH	Not Sold Separately
Frame puck, RH	Not Sold Separately
Primer/ applicator, 3M #94 (2)	98986-05Y

#### NOTE

A Service Manual for your motorcycle is available from a Harley-Davidson dealer.

### INSTALLATION

#### NOTE

If the motorcycle is not equipped with existing frame pucks, proceed to **Install Puck**.

If you are replacing a damaged puck, begin with **Remove Puck**.

#### Remove Puck

#### NOTE

Take care not to damage the finish on the frame/fuel tank.

1. To break the adhesive bond, apply isopropyl alcohol along the perimeter edge of the existing puck at the upper rear or the lower rear corner. Wipe off excess alcohol.



Figure 1. Pulling Puck Away from Frame

2. See Figure 1. Fit fingers under upper or lower corner edge and pry to loosen puck.

#### NOTE

If the puck fit prevents getting finger tips under puck, cover the blade of a putty knife or similar tool with duct tape, to prevent scraping the frame, and pry up one corner of the puck.

3. Slip fingers under loose corner of the puck and slowly pull the puck away from the frame. Apply isopropyl alcohol as needed to break any remaining adhesive bond.

4. Clean adhesive from painted finish with isopropyl alcohol. Wipe up excess alcohol with cloth.

#### Install Puck

#### NOTE

Ambient temperature during puck installation should be **at least** 50° F (10° C). A temperature of 70° F (21° C) or higher is best.

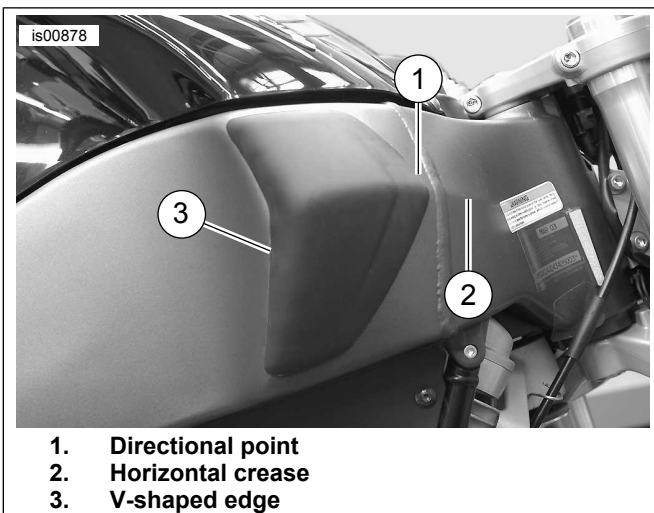
Puck installation at temperatures **below** 50° F (10° C) will likely cause failure of the adhesive bond.

1. Using isopropyl alcohol, clean the frame for the new puck. Wait a minimum of 5 minutes for the alcohol to evaporate.

#### NOTE

Do not sand or scuff the surface where the puck will be installed.





**Figure 2. Puck Orientation**

2. See Figure 2. Identify the left and right hand pucks by the forward facing directional point (1).
3. With the adhesive backing in place, locate the puck on the frame so that the puck makes contact all around its perimeter and fits the horizontal crease (2) and the "V"-shaped edge (3).
4. See Figure 3. With a pencil, trace the outline of the entire puck onto the frame.



**Figure 3. Outlining Puck Upper Rear Corner**

5. Obtain one primer/ applicator from the kit.

**⚠ WARNING**

Observe warnings on label of Surface Primer. Failure to follow warnings could result in death or serious injury. (00454b)

**⚠ WARNING**

Surface Primer contains ethyl benzene and toluene, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. (00453b)

6. Carefully follow the directions on the primer/ applicator stick. Make sure the puck installation area of the frame is clean and completely dry. Use the applicator brush to apply the primer to the entire puck installation area, all the way out to the pencilled outline. Allow the primer to cure for **at least 5 minutes** before proceeding to the next step.

**NOTE**

The puck can only be applied **once**. If the puck is peeled off, it will have reduced adhesive strength when it is re-applied to the frame.

7. Starting from the edge and working toward the center, carefully peel off the adhesive backing from the the puck.

**NOTE**

Peeling away the backing may loosen the adhesive in the center of the puck. This should not affect the final seal.

8. Align the corners of the puck with the pencil marks and tack the puck to the frame at the corners.
9. From the tacked corners, pivot the puck onto the frame keeping the directional point aligned with the horizontal crease.
10. See Figure 4. For 60 seconds, press evenly and firmly around the perimeter to firmly seal the puck to the frame.
11. Allow puck to cure for at least one hour before riding.
12. Remove the pencil marks.
13. Repeat the preceding steps for the opposite side of the vehicle.



**Figure 4. Pressing Puck to Frame**