



A Division of Thiessen Products, Inc.

INSTRUCTION SHEET FOR TOOL #604

TWIN CAM ROCKER BOX ALIGNMENT SCREWS

These screws are designed for perfect alignment of 1999 to present Twin Cam OEM Rocker Box Covers

RECOMMENDED TOOLS AND SUPPLIES

- 3/16" Allen wrench
- 7/16" socket wrench and ratchet
- Torque wrench reading in ft/lbs
- Two new rocker box lid gaskets H-D No. 17386-99A
- H-D Service manual for year and model of motorcycle you will be servicing
- Loctite threadlocker 243 (blue)

Note: Please read all instructions completely before performing any work. If you do not know what you are doing, do not do it! Always wear safety glasses or other face and eye protection such as a full face shield. JIMS is not responsible for damage, injury, or the quality and safety of your work.



PARTS AVAILABLE SEPARATELY

NO.	QTY	DESCRIPTION	PART NO.
1	1	SHORT ALIGNMENT SCREW	604-1
2	1	LONG ALIGNMENT SCREW	604-2
	1	INSTRUCTION SHEET	604-IS

1. Follow H-D® service manual to the point of rocker box lid installation. Clean sealing surfaces on lower and upper rocker boxes, apply a drop of blue threadlocker to the six screws, and install a new gasket H-D No. 17386-99A on front cylinder rocker box. Install the four outer screws finger tight to hold the assembly together.
2. Install one JIMS® tool No. **604-1** short rocker box alignment screw into the center rocker box screw hole on the left side of the engine. Snug screw down until the taper lightly seats into the screw hole of rocker box lid.
3. Install the other JIMS tool No. **604-2** long rocker box alignment screw into the center rocker box screw hole on the right side of engine. Snug tool down until the taper is lightly seated in the lid.
4. Torque the four outer rocker box cover screws to 15-18 ft/lbs. following the torque sequence in H-D service manual.
5. Remove the two JIMS Rocker Box Alignment Screws and install the remaining two rocker box fasteners with No. **242** Loctite and torque to 15-18 ft/lbs.
6. Repeat this process on rear rocker box.
7. Re-assemble motorcycle following the H-D service manual.

CAUTION: WEAR SAFETY GLASSES OVER YOUR EYES.
SEE JIMS® CATALOG FOR HUNDREDS OF TOP QUALITY PROFESSIONAL TOOLS.
THE LAST TOOLS YOU WILL EVER NEED TO BUY.

Performance Parts For Harley-Davidson Motorcycles

Rely on premium motorcycle tools made by JIMS if you're looking for quality and efficiency.