

# Parts & Accessories Bulletin

August 26, 1987



P&A #311

## **\*\*CORRECTION\*\***

PLEASE REPLACE BULLETIN #305 WITH THIS BULLETIN

### NO LEAD VALVE SEAT INSERTS

### 1200/1340 SHOVELHEAD ENGINES

We are pleased to announce the addition of the following new No-Lead Valve Seat inserts to our Replacement Parts product line:

<u>PART NUMBER</u>	<u>DESCRIPTION</u>	<u>DLR.</u> <u>NET</u>	<u>SUGGESTED</u> <u>LIST</u>
18017-66	Valve Seat Insert, Exhaust	3.80	7.60
18018-66	Valve Seat Insert, Intake	3.25	6.50

These new inserts, which fit 1200 and 1340 Shovelhead Engines, 1966 and up, have been engineered to eliminate or greatly reduce the "pitting" that occurs when using today's no-lead fuels.

When installing these new inserts, the following steps must be taken to ensure proper performance:

### VALVES

On engines manufactured prior to late 1981, the following valves must be used to ensure material compatibility with the new inserts:

18075-81 Intake

18086-81 Exhaust

On engines manufactured, late 1981 and up, the valves only need to be replaced if their condition warrants it. Please inspect thoroughly.



FILE IN ACCESSORY GUIDE FOR FUTURE REFERENCE

GUIDES

On engines manufactured prior to 1980, the following guides must be used in order to ensure material compatibility with the 18075-81 and 18086-81 valves:

<u>PART NUMBER</u>	<u>SIZE</u>
18138-79A	.001 O.S. Intake Or Exhaust
18139-79A	.008 O.S. Intake Or Exhaust
18140-79A	.006 O.S. Intake Or Exhaust
18141-79A	.004 O.S. Intake Or Exhaust
18143-79A	.002 O.S. Intake Or Exhaust

On overhead engines manufactured after 1979, valve guide replacement is not necessary unless their condition warrants it. Please inspect thoroughly.

VALVE STEM SEALS

On engines manufactured prior to late 1981, we also recommend that you install valve stem seals. This will require the following additional parts:

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>
4	18219-81	Valve Spring Collar, Upper
4	<del>18221-81</del> (18222-81)	Valve Spring Collar, Lower
4	18000-81	Valve Seal

When installing these seals, valve stem to guide clearance must be limited to the following tolerances in order to prolong seal life and enhance oil economy:

\*\*Intake - .001 to .0015  
 \*\*Exhaust - .002 to .0025

\*\* Mark the change in the Bulletin.

NOTE If a high performance or high lift camshaft is utilized, additional valve travel can be obtained by machining the top of the valve guides.

Thank you!

PARTS AND ACCESSORIES DIVISION

mm

Attachment



HARLEY-DAVIDSON MOTOR CO., INC.

P.O. BOX 594 MILWAUKEE, WIS., U.S.A. 53201

PARTS AND ACCESSORY ORDER

TYPE CODE	ORDER TYPE	VEHICLE IDENTIFICATION NUMBER
R	REGULAR	
P	POLICE	
D	DOWN VEHICLE	
W	WARRANTY	

DEALER ORDER
ORDER DATE
DEALER NO.
ORDER TYPE
WARRANTY CLAIM NO.

NAME \_\_\_\_\_  
ADDRESS \_\_\_\_\_  
CITY/STATE/ZIP \_\_\_\_\_

NAME \_\_\_\_\_  
ADDRESS \_\_\_\_\_  
CITY/STATE/ZIP \_\_\_\_\_

FOR OFFICE USE ONLY
ACCT
FBI ACCT

QUANTITY	PART NUMBER	NAME	
		NO-LEAD VALVE SEAT INSERTS	DLR. NET (EA.)
	18017-66	Exhaust	3.80
	18018-66	Intake	3.25
		VALVES	
	18075-81	Intake	6.375
	18086-81	Exhaust	16.984
		VALVE GUIDES (1966 to 1979)	
	18138-79A	.001 O.S. Intake Or Exhaust	5.085
	18139-79A	.008 O.S. Intake Or Exhaust	5.085
	18140-79A	.006 O.S. Intake Or Exhaust	5.085
	18141-79A	.004 O.S. Intake Or Exhaust	5.085
	18143-79A	.002 O.S. Intake Or Exhaust	5.085
		VALVE GUIDES (1980-Up)	
	18103-81A	.008 O.S. Intake Or Exhaust	3.065
	18104-81A	.006 O.S. Intake Or Exhaust	3.065
	18106-81A	.004 O.S. Intake Or Exhaust	3.065
	18107-81A	.003 O.S. Intake Or Exhaust	3.065
	18108-81A	.002 O.S. Intake Or Exhaust	3.065
	18109-81A	.001 O.S. Intake Or Exhaust	3.065
		MISCELLANEOUS	
	18219-81	Valve Spring Collar, Upper	2.145
	18222-81	Valve Spring Collar, Lower	1.245
	18000-81	Valve Stem Seal (Package Quantity of 10)	.61
	17029-66A	Gasket Set - Complete ('66 to '78)	10.10