

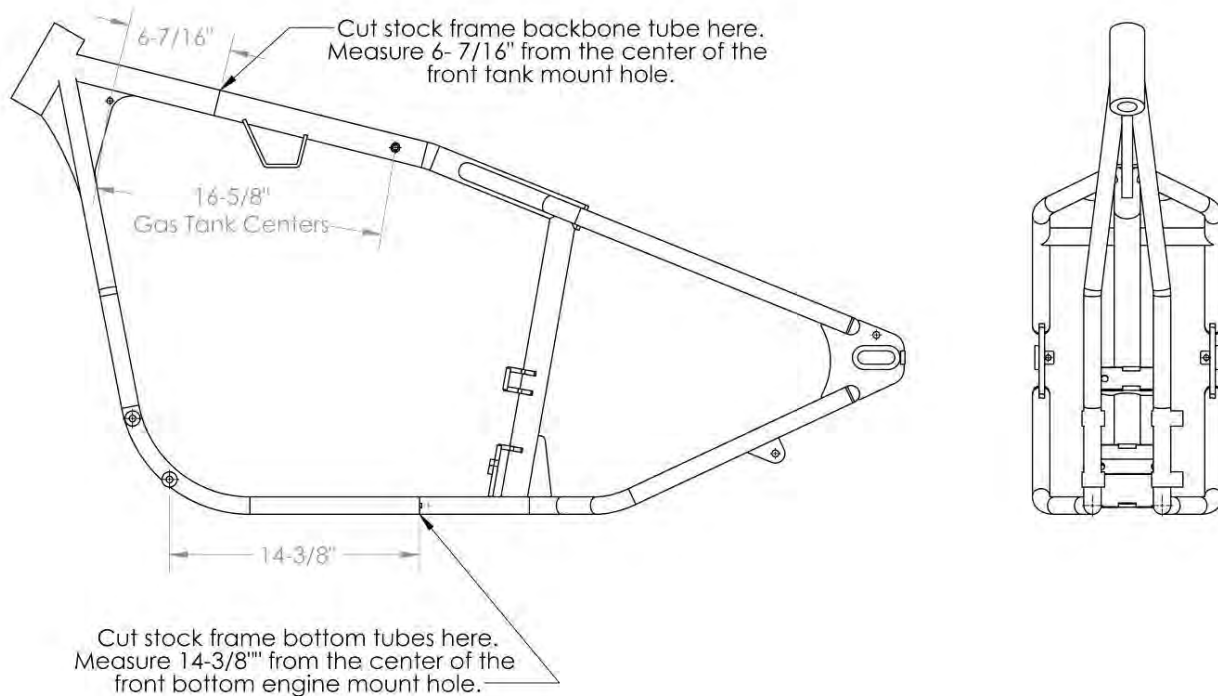
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Ironhead Sportster weld on hardtail part #A-1100

- Fitment is for early type rear engine mounts #16203-67. Late Ironhead engines will need the early mount installed on the rear of the engine.
- Fitment is for stock front engine mounting plates, bolts, washers and tube spacers.
- Features 9.5" rear distance between the axle plates, 3/4" axle.
- The top engine motor mount and disc brake tab are included with the kit, to be welded on for a custom fit.
- Designed for 1952-1981 Sportster frames.
- This Hardtail removes enough of the stock frame, so that even if an inferior hardtail has been installed. You will still be able to cut it off and install this one.

Frame cut dimensions:

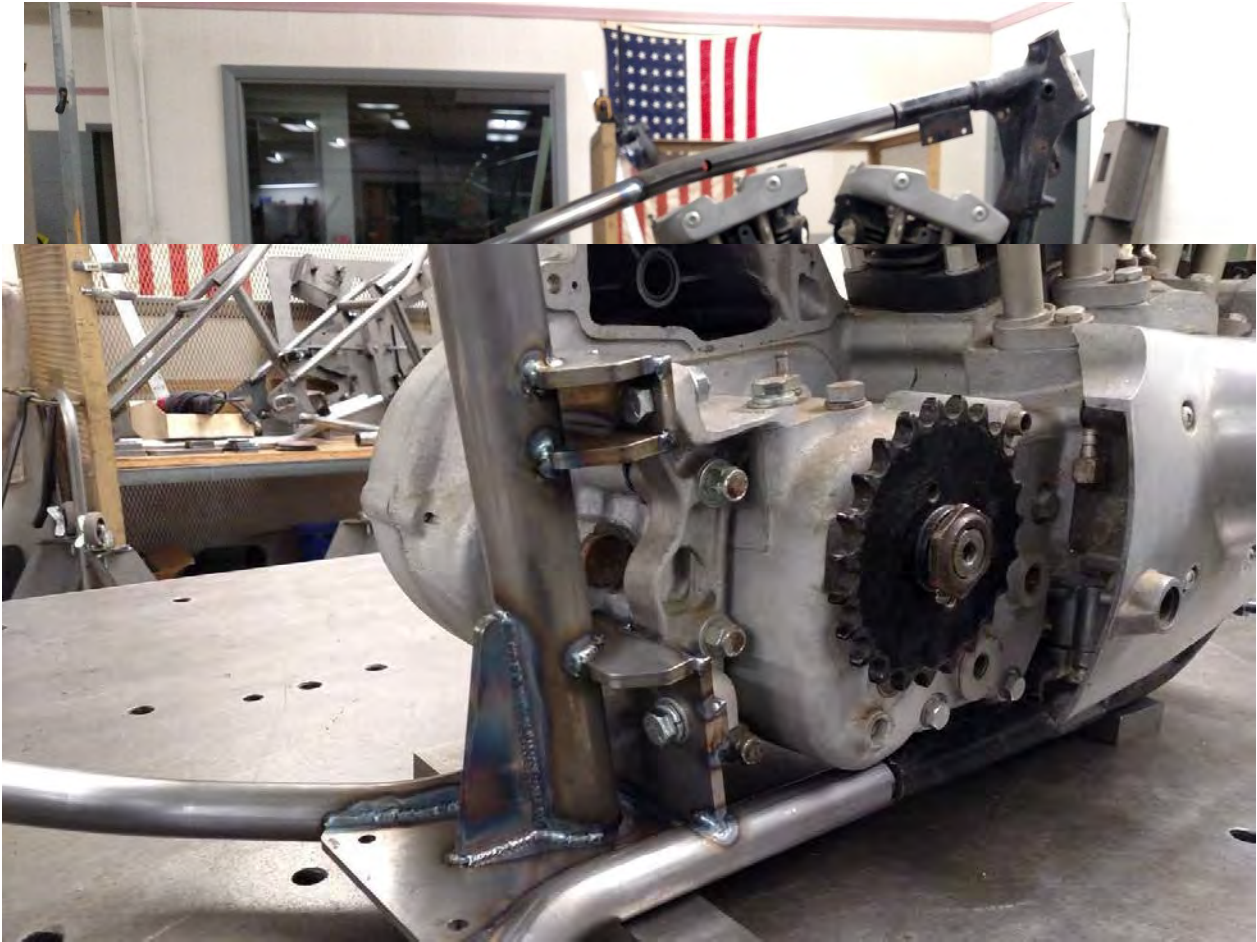
1. Measure your stock gas tank mounting hole centers. Typical centers are 16-5/8".
2. Cut the frame at the recommended measurements.



3. After cutting, deburr the inside of the tubes and weld prep the outside of the tubes by removing paint or rust as necessary.

Welding:

1. The engine is installed and bolted in place to function as the welding fixture for the front frame section and the hard tail.
2. One bung centers the backbone tube. Bungs center each of the lower tubes.

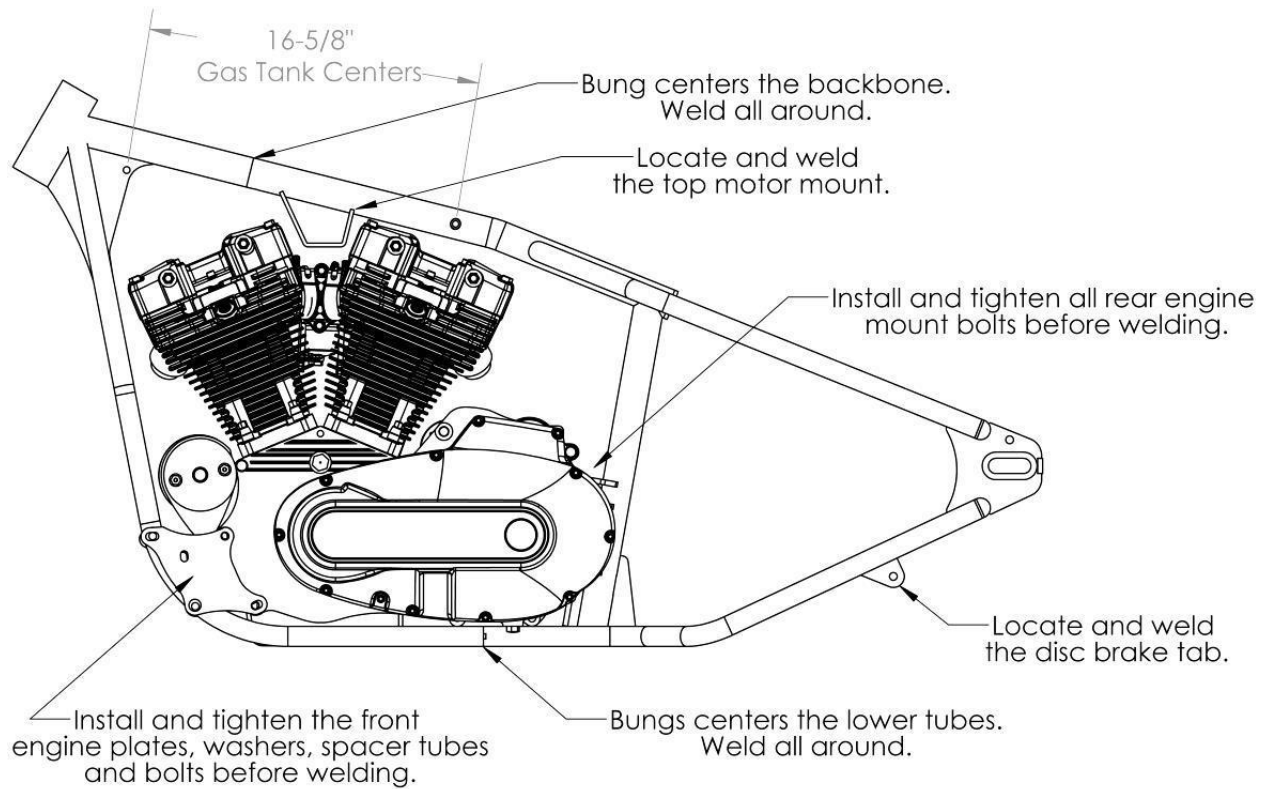


3. Bolt in the four rear engine mount bolts and tighten.
4. Assemble the front engine mounting plates, washers, bolts, nuts and spacer tubes. Loosen them if you need to adjust your tube alignment. The large holes in the engine plates allow for a range of adjustment to align the frame to the hard tail.



5. Check your tube alignment and adjust for the best fit. The gas tank hole centers should match your measurements of 16-5/8".

Note: Since not all frames are exactly the same, you may trim the frame cuts a little for best fit and tube alignment. A small gap between tubes allows welding the bungs to the tubes on each side for the strongest joint.



6. With all engine bolts tight and tubes in best alignment, weld all around the bungs and tube joints that can be reached.
7. Fit your top engine motor mount on the engine. Locate the top motor mount to the backbone, align the bolt holes and weld in place. Add washers or a spacer if the mounts don't meet together.



8. Locate and weld the disc brake tab for a custom fit.



9. Remove the engine and finish welding the backbone tube and lower frame tubes for a complete weld.