

# HEARTLAND USA<sup>®</sup>

## 250 Conversion 1991-1999 Softail Models (Instruction)



### HARDWARE LIST

Must upgrade to 2000 -2005 1-1/8" 70 tooth Pulley and 1-1/8" 135 tooth Belt. **Not Supplied.**  
Conversion does come with 2000 plus Softail Chrome Brake Caliper

#### Parts List:

Swing Arm with  
Steel Rock Guard,  
Axle and Axle Covers

Slotted Struts

Solo Seat

Raw Steel Fender

Primary Offset

Swing Arm Accesories

Rear Brake Caliper

Left Side Trans Nuts & Washers

Pivot Axle Spacers

Hardware



Swing Arm with Steel Rock Guard,  
Axle and Axle Covers



Slotted Struts



Raw Steel Fender



Horn CUT Template



Solo Seat



Offset Kit



Rear Brake Caliper



Hardware



Pivot Axle Spacers



Left Side Trans Nuts  
& Washers

2466 E. Fender Ave. Suite B Fullerton CA. 92831 Ph: 310-822-2697 Fax: 310-634-1271

[www.heartlandbiker.com](http://www.heartlandbiker.com)

We recommend reading through the entire install process before beginning.

## STEP ONE

Remove Rear Wheel, Seat,  
Fender Struts, Fender.

Remove Outer and  
Inner Primary as per

**Service Manual.**

**Note: Clutch Nut is reverse thread  
Remove Stock Swingarm and shocks.**

3



3. You will also need to grind clearance for the swing arm on both sides of the frame. The rubber stopper will give so make the clearance about 3/16" plus / see photo.

1

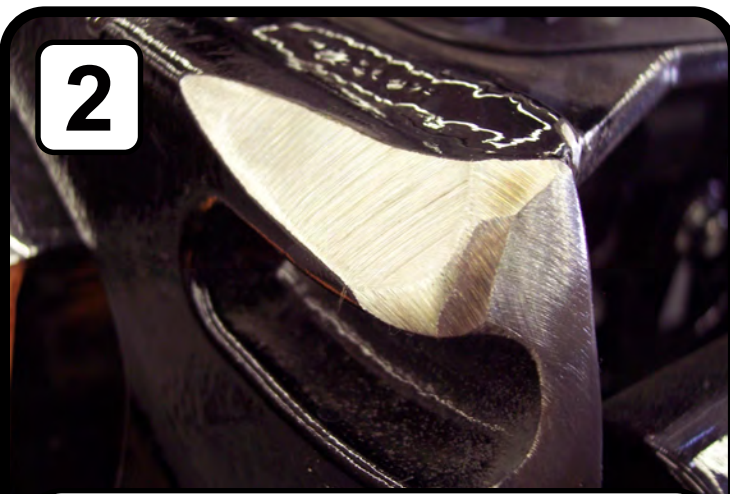


### Cutting off Horns from the Frame

You will need to cut the steel horns off the frame to allow the Bobber Seat and fender to work.

1. Cut at both straight edges using the "Horn Cut Template" provided. With the template in place, begin cutting with a sawzall. .

2



2. Grind for seat clearance on both sides of the seat frame.

4

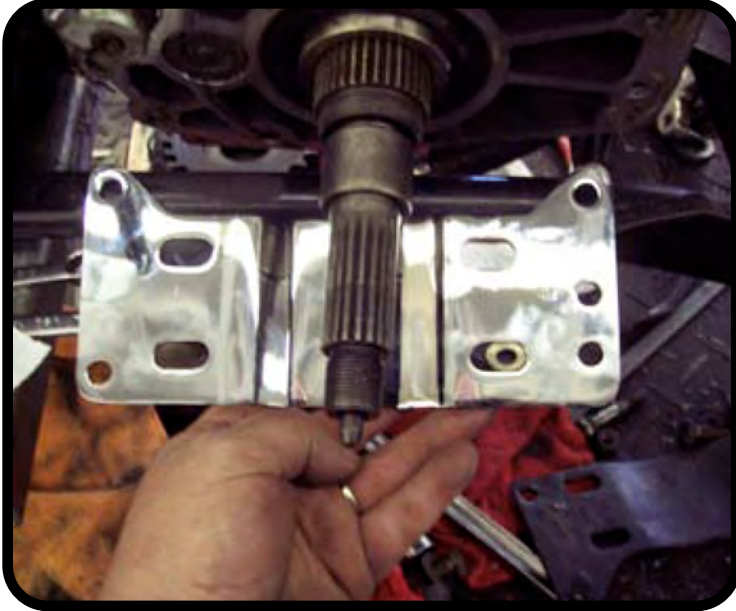


4. Always check clearance between the swing arm and frame. See Swing arm install. You can use stock hat sleeves to help hold the swing arm in place as you check clearance. Put Stock hat sleeves from out side in as it is temporary. It will hold the swing arm as you check clearance.

## STEP TWO

### Transmission Offset

Remove the transmission & trans plate. Replace the transplate with the supplied 1" offset plate. When installing you will not reuse the 5th bolt on the right side of the trans. Install the supplied 3/8" washers & nuts onto the left side of the trans studs using Red Loctite. You may need to cut/grind the threads to allow for shock clearance. On the right side trans studs, use the stock nuts. The primary needs to be in place before all nuts can be tightened.



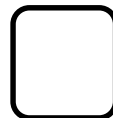
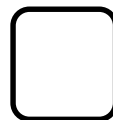
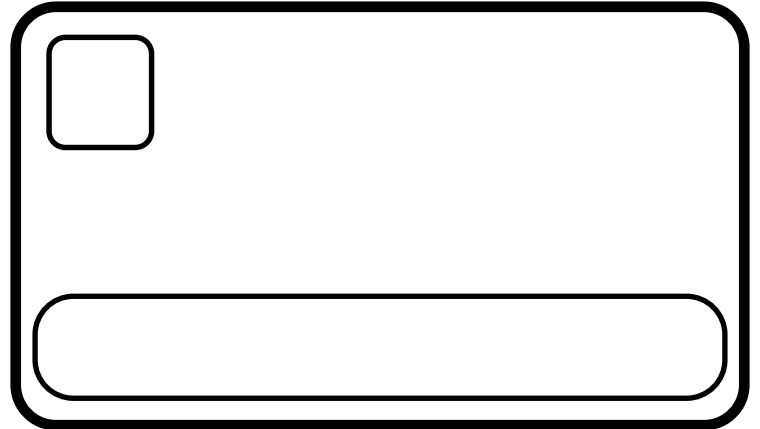
Now you can install the 25mm Primary Spacer and extended compensating sprocket & nut. Use Red Loctite on nut.



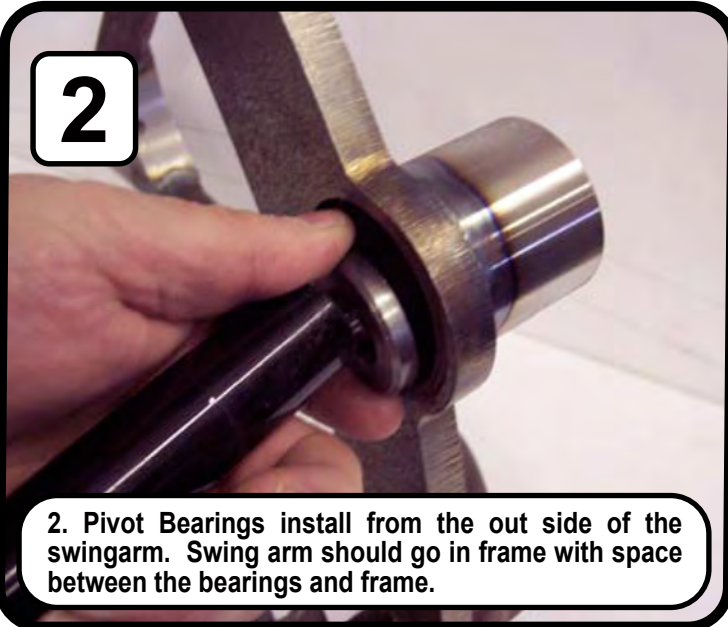
# EVO Softail® Swing Arm Install

**1**

1. Install Pivot bearings in new 250 Swing arm from out side as per HD Specs.



**2**



2. Pivot Bearings install from the out side of the swingarm. Swing arm should go in frame with space between the bearings and frame.

**3**



3. Both .250 Spacers need to go in. Both are supplied in kit. This is to center the Pivot Axle. Use stock Pivot Bolts at each side. Tighten as per manual.

8



8. Install the top & bottom Rockguard Brackets to the swingarm tabs with supplied Hex bolts.

9



9. Simply bolt the rockguard to the brackets with the supplied button head bolts.

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