

DRIVE BELT UPGRADE KIT KIT PN 2202216



Application

All 1999 Victory Motorcycle Models

Before you begin, read these instructions and check to be sure all parts and tools are accounted for. Please retain these installation instructions for future reference and parts ordering information.

Kit Components:

<u>Qty</u>	<u>Part No.</u>	<u>Part Description</u>	<u>Qty</u>	<u>Part No.</u>	<u>Part Description</u>
1	3211085	Belt-Drive, 135T, HTD	1	7547165	Nut-Hex, M36 x 2
1	1341334	Asm-Sprocket Driven 64T HTD	5	7518066	Screw-M10 x 40, Socket Head
1	5132748	Sprocket-Drive 30 T, HTD, HD	5	7556123	Washer-Flat, 10 x 2
1	5244114	Washer-Lock Plate M36	1	9917954	Instructions

You will need to supply:

Torque Wrench, 0-150 ft-lbs. (0-200 Nm)

IMPORTANT: Do not remove all fasteners at once. Remove only one fastener at a time and replace per the instructions prior to removing the next fastener.

INSTALLATION INSTRUCTIONS

1. Secure the bike in an upright position with the rear wheel elevated approximately 6 inches off the ground.
2. Remove the rear cylinder muffler.
3. Remove the engine sprocket cover.
4. Remove the sprocket lock plate.
5. Apply the rear brake to hold the sprocket. Remove the sprocket nut.
6. Remove the rear axle cotter key and loosen the rear axle nut.
7. Loosen the rear wheel adjustment bolt lock nuts.
8. Loosen the rear wheel adjustment bolts and slide the rear wheel completely forward.
9. Move the belt and front sprocket to the right of the machine and remove the front sprocket.
NOTE: Observe the location and orientation of the wheel spacers with the small diameter toward the wheel bearing.
10. Lift up slightly on the rear wheel and remove the rear axle.
11. Lower the rear wheel and remove the belt to the right of the sprocket.
12. Secure the brake caliper with a tie strap or other means.
CAUTION: Do not hang the rear brake caliper by its hose and do not twist the brake hose.
NOTE: Do not apply the rear brake pedal once the brake caliper has been removed.
NOTE: Refer to Service Manual for procedures on how to inspect the rear axle, rear wheel, and rear wheel bearings.
13. Tip the rear wheel slightly and remove the rear wheel assembly out the left side.
14. Remove the sprocket bolts and rear sprocket from the wheel.
15. Inspect the mating surfaces of the wheel for excessive wear. Replace the wheel if:
 - a. Fretting is present on 50% of the wheel mating surface.
 - b. Sprocket bolt clearance holes are elongated.
 - c. Sprocket bolt wheel hub threads are damaged.
16. Remove the thread-locking compound in the sprocket bolt threads of the wheel using clean and dry compressed air, contact cleaner and a thread chaser or slotted M10 bolt. Clean the threads thoroughly until an M10 bolt can be screwed freely by hand into the hole to a minimum depth of 25mm.
17. Remove any protruding nicks or burrs on the sprocket mounting surface of the wheel using fine grit emery paper.

18. Clean the mounting surfaces of the sprocket and wheel with isopropyl alcohol or warm soap and water. Allow to dry thoroughly before assembly.
19. Assemble the sprocket onto the wheel. The sprocket must freely drop over the lip on the wheel and sit square on the wheel mating surface. If a tight fit-up exists or if any rocking is noticed, remove the sprocket and rework as required.
20. Insert the five (5) new sprocket bolts and washers found in the kit into the sprocket and wheel assembly. Screw each sprocket bolt into the wheel and onto the sprocket. If more than 5 ft-lbs. of force is required to screw the bolt into the wheel, disassemble and repeat step 12.
21. Tighten the sprocket bolts in a star shaped pattern and torque to 20 ft-lbs. Immediately after all bolts are tightened, torque the bolts again to 55 ft-lbs.
22. Secure the motorcycle with the rear of the bike raised.
23. Apply a thin film of grease to the axle surface.
24. Insert the wheel assembly from the left side of the motorcycle.
25. Install the belt on the rear sprocket.
26. Center the wheel in the swing arm and place the belt over the tab of the belt guard.
27. Apply grease to the inner portion of the left side wheel spacer to hold it in place on the wheel bearing.
28. Engage the slot of the rear brake caliper bracket with the lug on the swing arm.
29. Lift the wheel assembly and guide the brake disc between the brake pads.
30. Align the wheel assembly with the swing arm.
31. Insert the axle into the swing arm and wheel assembly from the left side of the motorcycle. Push the axle in until 1/2 of the axle is exposed on the right side of the wheel assembly.
32. Install the right side axle spacers with the small diameter of the shouldered inner spacer against the wheel bearing.
33. Slide the wheel forward and place the belt onto the new front sprocket (PN 5132748), then assemble the new drive sprocket onto the splined shaft.
34. Install the axle nut. Tighten the nut until it seats, then back off 1/2 turn.
35. Clean the threads on the front sprocket shaft of all thread-locking compound and install the new sprocket nut.
36. Apply the rear brake and torque the front sprocket nut to 125 ft-lbs.
37. Adjust the belt tension at 8mm deflection with a 10-lb. load. Refer to the Victory Service Manual for the procedure.
38. Inspect the wheel alignment. Refer to the Victory Service Manual for the procedure.
39. Torque the rear axle nut to 65 ft-lbs.
40. Install the new rear axle nut cotter key.
41. Rotate the rear wheel by hand and inspect for proper assembly without binding.
42. Apply the rear brake pedal two or three times to position the brake pads and ensure proper function.
43. Install the muffler. Torque the muffler clamp and the muffler mounting bolt to 20 ft-lbs.