GENERAL NOTES

1. VERIFY INSIDE AND OUTSIDE DIAMETERS OF ALL TUBING COMPONENTS PRIOR TO MACHINING.

FABRICATION NOTES

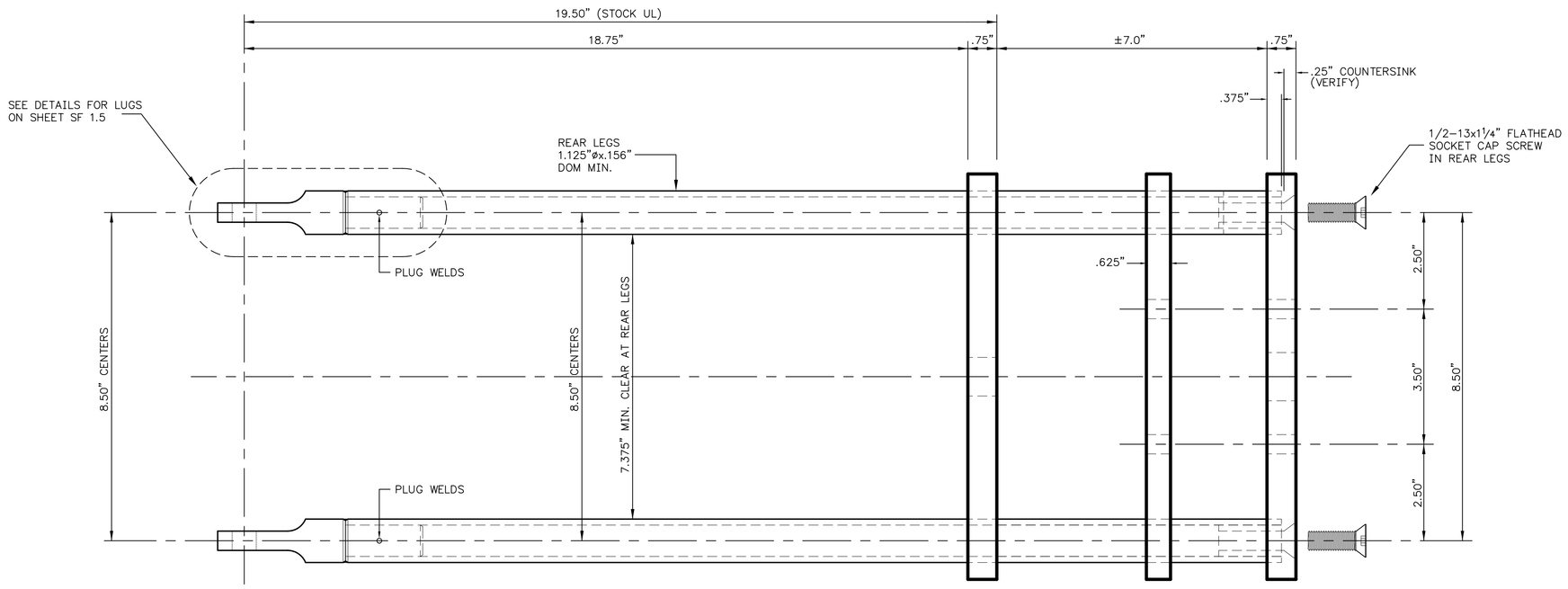
1. THE EXACT DIAMETER AND BEVEL ANGLE IN THE FLAT HEAD SOCKET CAP SCREWS CAN VARY SLIGHTLY FROM ONE MAKER TO THE NEXT SO IT'S A GOOD IDEA TO PROVIDE THESE SCREWS TO YOUR MACHINIST SO HE KNOWS TO WHAT LEVEL OF TOLERANCES HE NEEDS TO WORK WITH.

2. TRY TO HAVE THE BORES FOR THE LEGS IN THE TREES AND SPRING PLATE REAMED 0.005" OVER. IF YOU'RE HAVING THE UNIT CHROMED GET THE OVERBORE DATA FROM THE CHROME PLATE SHOP

3. THIS DIMENSION MUST BE VERIFIED AGAINST THE ACTUAL PARTS YOU'LL BE USING ON THE BIKE IN QUESTION AS IT CAN VARY SIGNIFICANTLY DEPENDING UPON THE 'REAL' LENGTH OF THE NECK YOU DECIDED TO USE, THE DEPTH OF THE BEARING CUPS, THE AMOUNT OF 'STICK-OUT' ON THE BEARING CONES, THE TYPE OF BEARING ADJUSTING NUT YOU USE AND WHETHER OR NOT IT ALSO USES A TAB-LOCKING WASHER AND JAM NUT. IN GENERAL THIS DIMENSION RANGES, ON TYPICAL BIKES, FROM 6.76" TO 7.375" BUT WE'VE SEEN IT AS LARGE AS 7.5 ON SOME 'CUSTOMS.

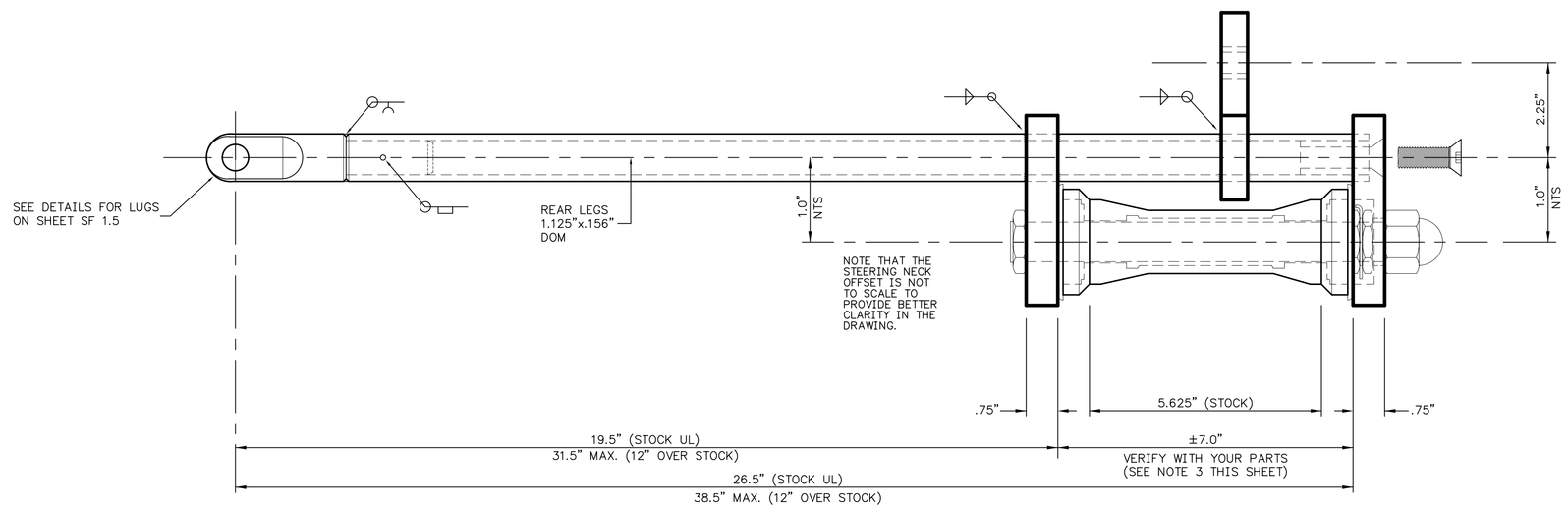
REAR LEG TUBING SCHEDULE	
EXTENSION	TUBING
0"	1.125"O.D.x.156"I.D.
2"	1.125"O.D.x.156"I.D.
4"	1.125"O.D.x.180"I.D.
6"	1.125"O.D.x.188"I.D.
8"	1.125"O.D.x.219"I.D.
10"	1.125"O.D.x.219"I.D.
12"	1.125"O.D.x.250"I.D.

NOTE THAT 1.25"ø TUBING MAY BE SUBSTITUTED IF DESIRED AS ENOUGH ROOM HAS ALREADY BEEN ALLOWED IN THE DIMENSIONS OF THE TREES FOR LARGER DIAMETER TUBING.
ALSO NOTE THAT SOLID 1.125"ø 1018 STEEL BAR STOCK MAY BE USED IN LIEU OF TUBING AS A FABRICATION ALTERNATIVE AT THE MAKERS OPTION.



FRONT VIEW - REAR (RIGID) LEGS

SCALE 1/2" = 1"



SIDE VIEW

SCALE 1/2" = 1"

GARY W. WEISHAUPT

PERFORMANCE ENGINEERING
CHASSIS FABRICATION
FLOWBENCH TESTING
MACHINE WORK
RESTORATIONS

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• AS-BUILT REVISIONS	12-20-03
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Key Plan

Project Title
CHOPPER BUILDERS HANDBOOK

SPRINGER FORKS

PLAN SPF-19-1

Drawn By	GWW
Date	11-14-05
Checked By	HC
Date	11-16-05
Scale	1/2" = 1"
Plot At:	.5" = 1"
Project No.	-

Sheet Description
REAR FORK LEG ASSEMBLY

Sheet No.
SF1.4

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