

V-Twin Mfg.  
Fork Neck Cup Kit with Stops  
Fits 1957-1981 XL  
VT #24-0236

**Instructions:**

1. Install lower neck cup with tab into frame with stop tab to, either the front or back of neck.
2. Drill 4 holes, 1/8" diameter about .400 deep, using neck cup securing pinholes as a pilot.
3. Install pins.
4. Place stop plate on lower stem with slot forward or rear, depending on how cup was installed in frame and center on neck stem.
5. Center punch 4 holes. Use holes in plate as a pilot.
6. Drill 4 holes, 3/16" diameter about .400" deep.
7. Install the 4 pins.
8. Press race into lower cup.
9. Install bearing on lower tree.
10. Install top neck cup in frame.
11. Install top neck bearing in cup.
12. Install top dust cover.
13. Install neck into frame.

**NOTE:** Bearing should be properly lubricated before final assembly.