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**HONDA: XR 650L  
FUEL TANK:  
4.0 GALLON  
IMS TANK ID: XR-1A  
(All XR 650L Models)  
IMS Part #:  
112221 /212221**

**IMS PARTS LIST**

- (1) Fuel Tank
- (1) Gas Cap & Seal
- (1) Rubber Grommet  
"9305K33"
- (2) "L" Brackets  
"XR650L-125-350"
- (4) 6 x 12mm Sm. Flange Bolt
- (1) 6 x 20mm Hex Head Bolt
- (1) 6 x 30mm Hex Head Bolt
- (2) 6 x 12 Flat- Sockethead Bolt
- (1) Mount Plate "IMS-BH-1"
- (1) Petcock Coupling (Small:  
1/2")
- (1) Rubber O-Ring #D-206

**OEM ITEMS TO USE**

- Fuel Line
- Breather Hose
- Rear Tank Mount Washer

**WARNING!**

Prior To Installation Clean IMS Tank Interior Thoroughly.  
Install This Fuel Tank ONLY In a Well Ventilated Area, As Gasoline Fumes Are  
EXTREMELY Dangerous.

**DO NOT START OR OPERATE THE VEHICLE IF THERE ARE ANY FUEL LEAKS!**  
IMS Recommends Installation Be Performed By a Licensed Mechanic.  
Improper Installation May Result In Severe Bodily Injury Or Death.  
Prior To Installation Read All Instructions Thoroughly

**TANK REMOVAL**

Drain all fuel from OEM fuel tank into a government approved fuel container with a greater capacity than fuel tank on vehicle.

Remove OEM tank shrouds with allen wrench-3 screws each side (the IMS "L" brackets will mount to the shroud frame tabs on down tube.)

Passenger safety hold strap over seat. Remove one of the barrel socket head screws and flip to one side.

Removed the (2), 12mm bolts under the seat, in the rear tire well, then remove the seat.

Remove the rear tank mount bolt. The OEM indented washer will be used on the IMS tank, but the bolt & rubber pad will be replaced with IMS parts.

Use needle nose pliers to spread and move retaining clips on fuel cap vent tube and fuel line at petcock valve. Remove both lines.

Slide fuel tank back while lifting rear of tank to remove from frame.

Remove petcock valve from OEM tank.

**TANK INSTALLATION**

Assemble the petcock mounting fixture as Illustrated. Place threaded coupling through mounting plate. Make sure that the flat sides of coupling align with flat sides in opening of plate. Place the O-ring into groove of coupling & place complete assembly on IMS tank and fasten firmly with 2) 6x12 flat sockethead bolts. **NOTE:** The plate may not tighten completely flush to tank surface due to depth of recess in tank, take care O-ring & coupling are properly seated in recess.

Once the coupling assembly is installed On IMS tank, thread the OEM petcock onto the coupling & tighten firmly.

Loosely install the "L" brackets onto The IMS tank, attach the short leg of the bracket to the tank using (2) 6 x 12mm bolts.

Insert the rubber grommet into the IMS rear tank mount from the bottom of the tank.

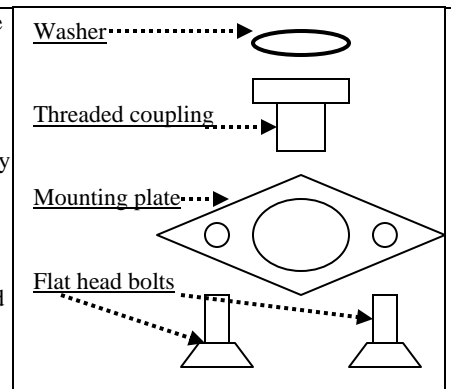
Place the IMS tank onto the frame backbone making sure the slots in the tank tunnel Properly engage the OEM cushions on the frame. Position tank so petcock does not contact cylinder.

Align the "L" brackets with the frame tabs, (**NOTE:** that the frame tabs are offset one forward of the other) insert (2) 6 x 12mm bolts & finger tighten all "L" bracket bolts.

Insert the rear IMS mounting bolt (6mm x 20mm or 6mm x 30mm) with the OEM indented washer & tighten completely.

Now completely tighten the "L" bracket bolts on the front mounts. **DO NOT OVER TIGHTEN** the bolts to the tank!

Reconnect the OEM vent tube & fuel line to the IMS tank. Fill up your new IMS fuel tank, check for leaks & enjoy the longer ride!



**"FOR COMPETITION USE ONLY"**

**"Legal in California ONLY for racing vehicles**

**Which may never be used upon a highway?"**

**DISCLAIMER:**

Due to uncontrolled variables in the manufacturing process of rotationally molded fuel tanks, the fuel tank may vary in size and shape by up to 7% of the manufacturer's original listed capacity