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(12) **United States Patent**  
**Kerner et al.**

(10) **Patent No.:** **US 8,590,654 B2**  
(45) **Date of Patent:** **Nov. 26, 2013**

(54) **SNOWMOBILE**

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **13/027,116**

(22) Filed: **Feb. 14, 2011**

(65) **Prior Publication Data**

US 2011/0132679 A1 Jun. 9, 2011

**Related U.S. Application Data**

(63) Continuation of application No. 12/736,073, filed as application No. PCT/US2009/036315 on Mar. 6, 2009.

(60) Provisional application No. 61/104,436, filed on Oct. 10, 2009, provisional application No. 29/301,572, filed on Mar. 7, 2008.

(51) **Int. Cl.**  
**B62K 19/22** (2006.01)  
**B62M 27/02** (2006.01)

(52) **U.S. Cl.**  
USPC ..... **180/190**; 29/525.15; 403/268

(58) **Field of Classification Search**  
USPC ..... 180/182, 186, 190; 280/281.1, 288.3, 280/288.2, 781, 798; 403/109, 217, 272, 403/295, 312, 265, 268, 292; 156/156, 293; 29/458

See application file for complete search history.

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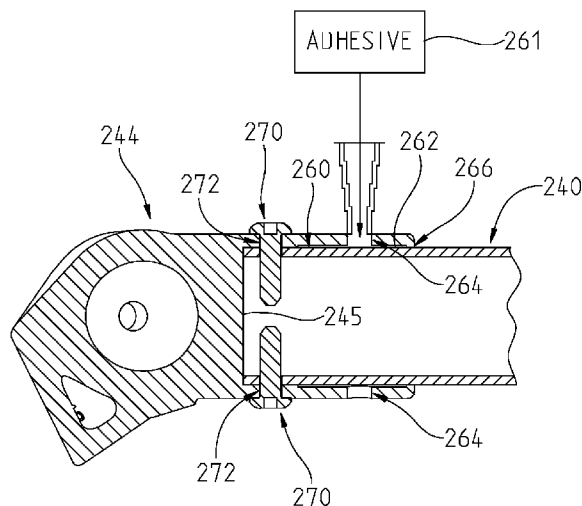
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*Primary Examiner* — Anne Marie M Boehler  
(74) *Attorney, Agent, or Firm* — Faegre Baker Daniels LLP

(57) **ABSTRACT**

A vehicle is shown such as a snowmobile, where a frame includes a tunnel and a front frame portion comprised of cast halves. A suspension system is comprised of upper and lower control arms connected to the front frame portion. Some of the frame components are adhesively fixed together. A powertrain is supported by the frame, and is comprised of an engine and a clutch. The clutch includes a clutch guard supporting an oil container. The engine has an exhaust system which extends through the front frame portion. The snowmobile also has a rear snow deflector.

**18 Claims, 58 Drawing Sheets**



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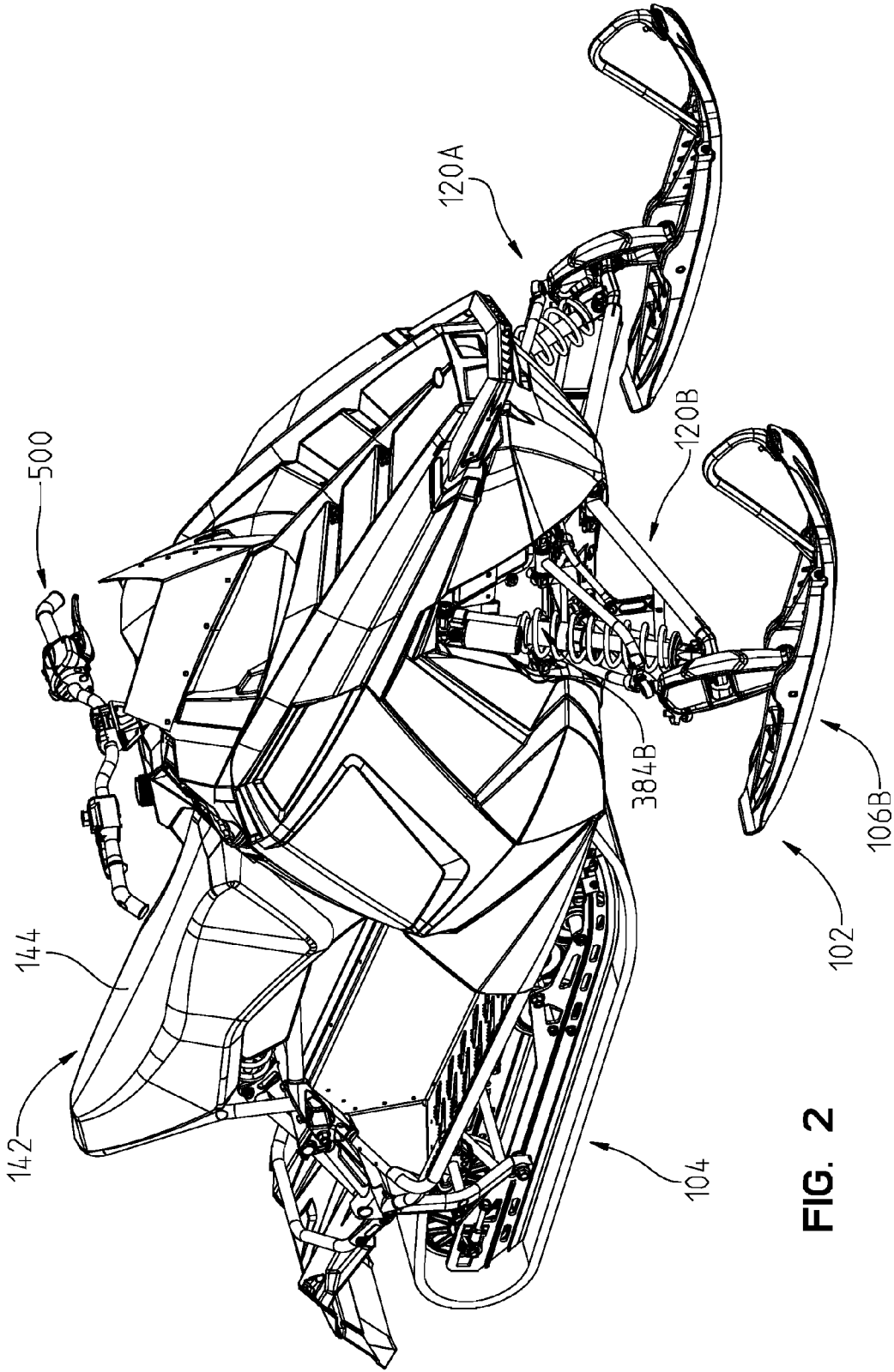


FIG. 2

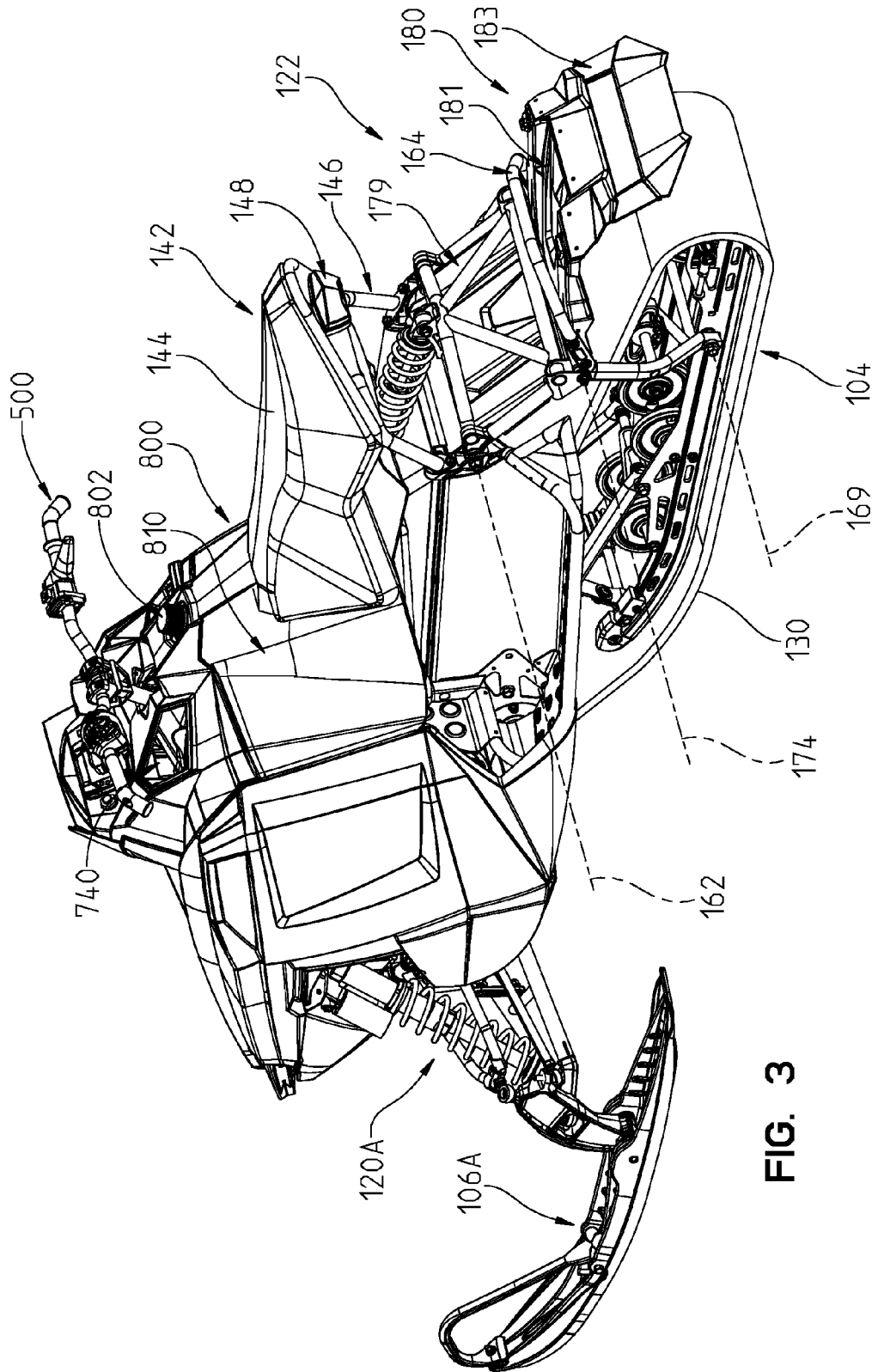


FIG. 3

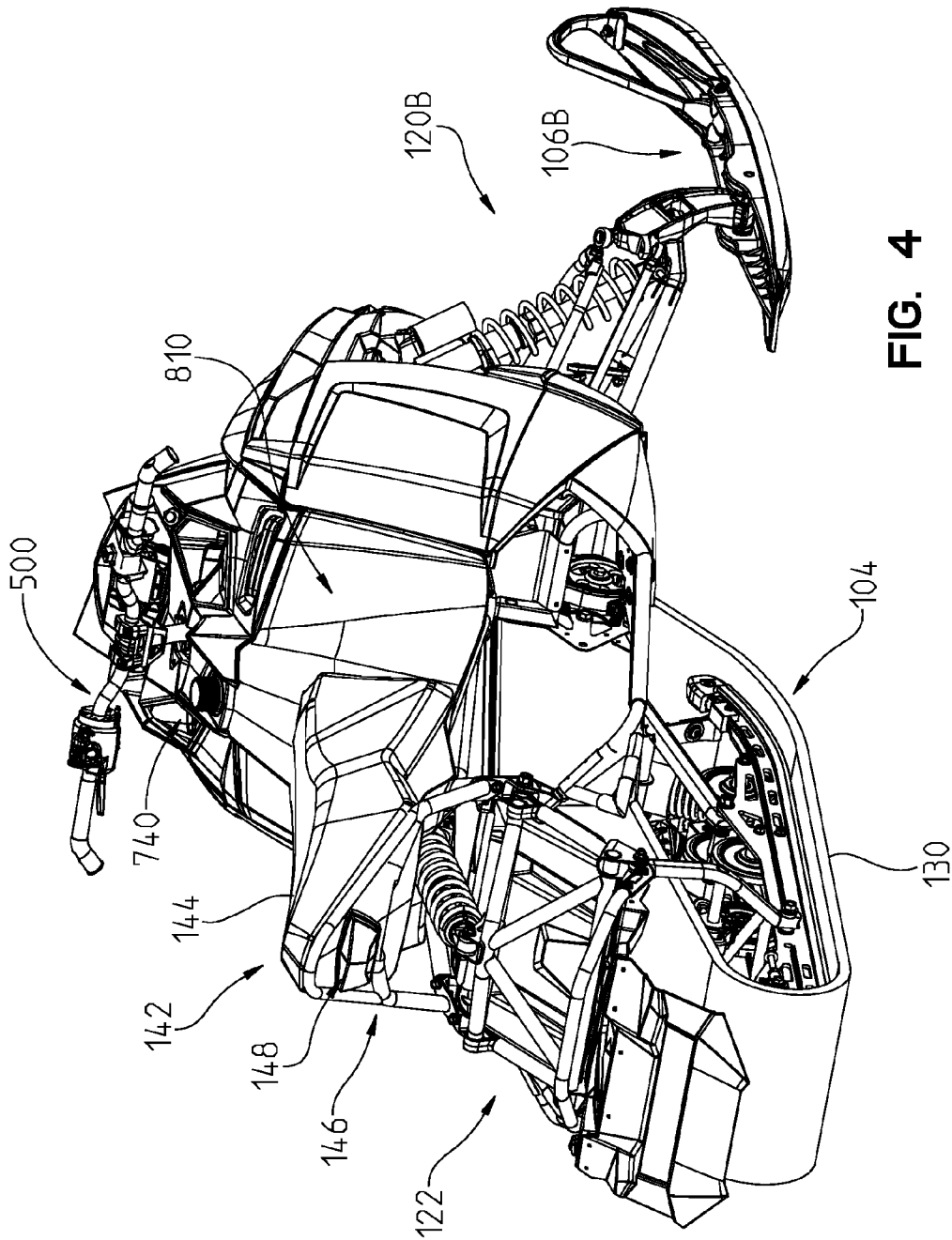


FIG. 4

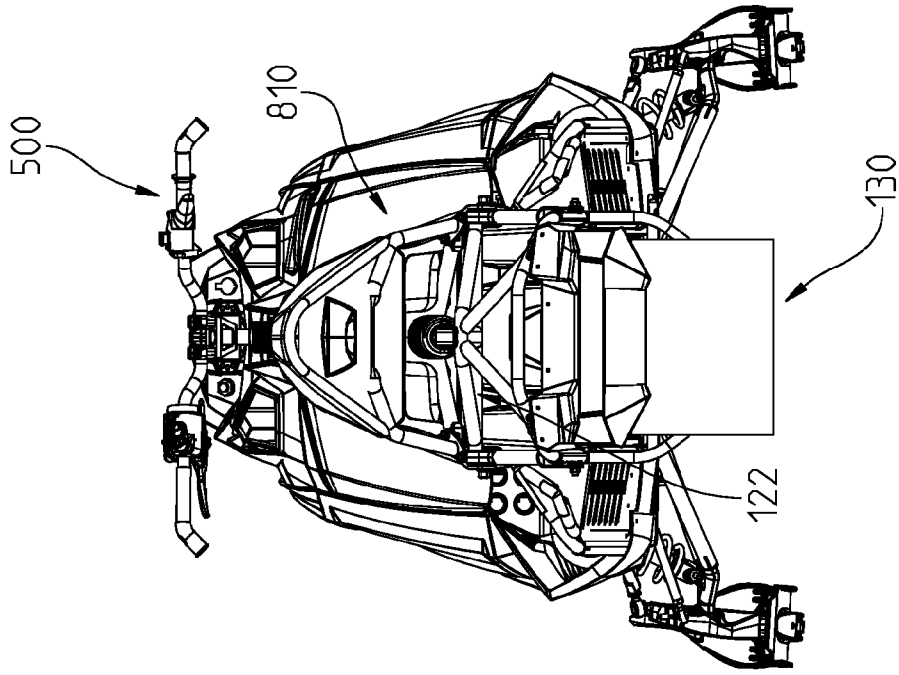


FIG. 8

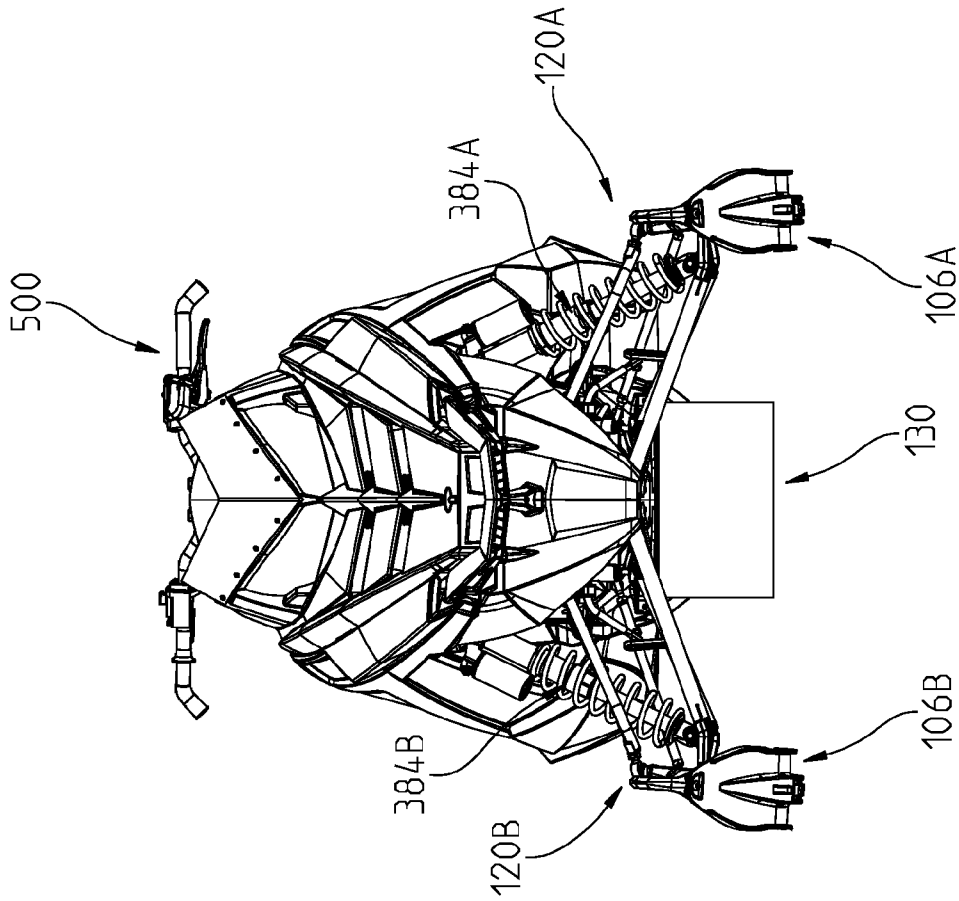


FIG. 5





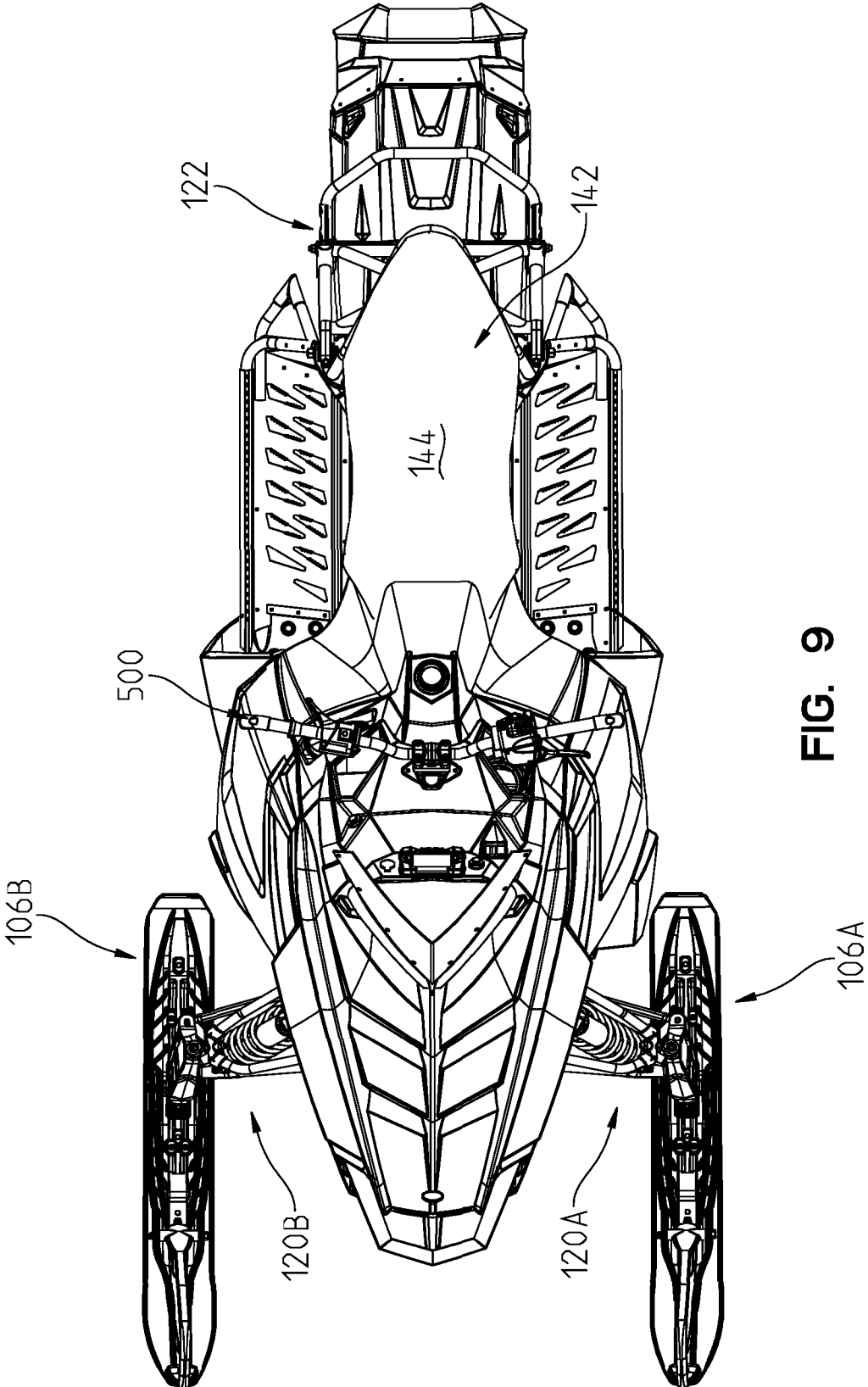


FIG. 9

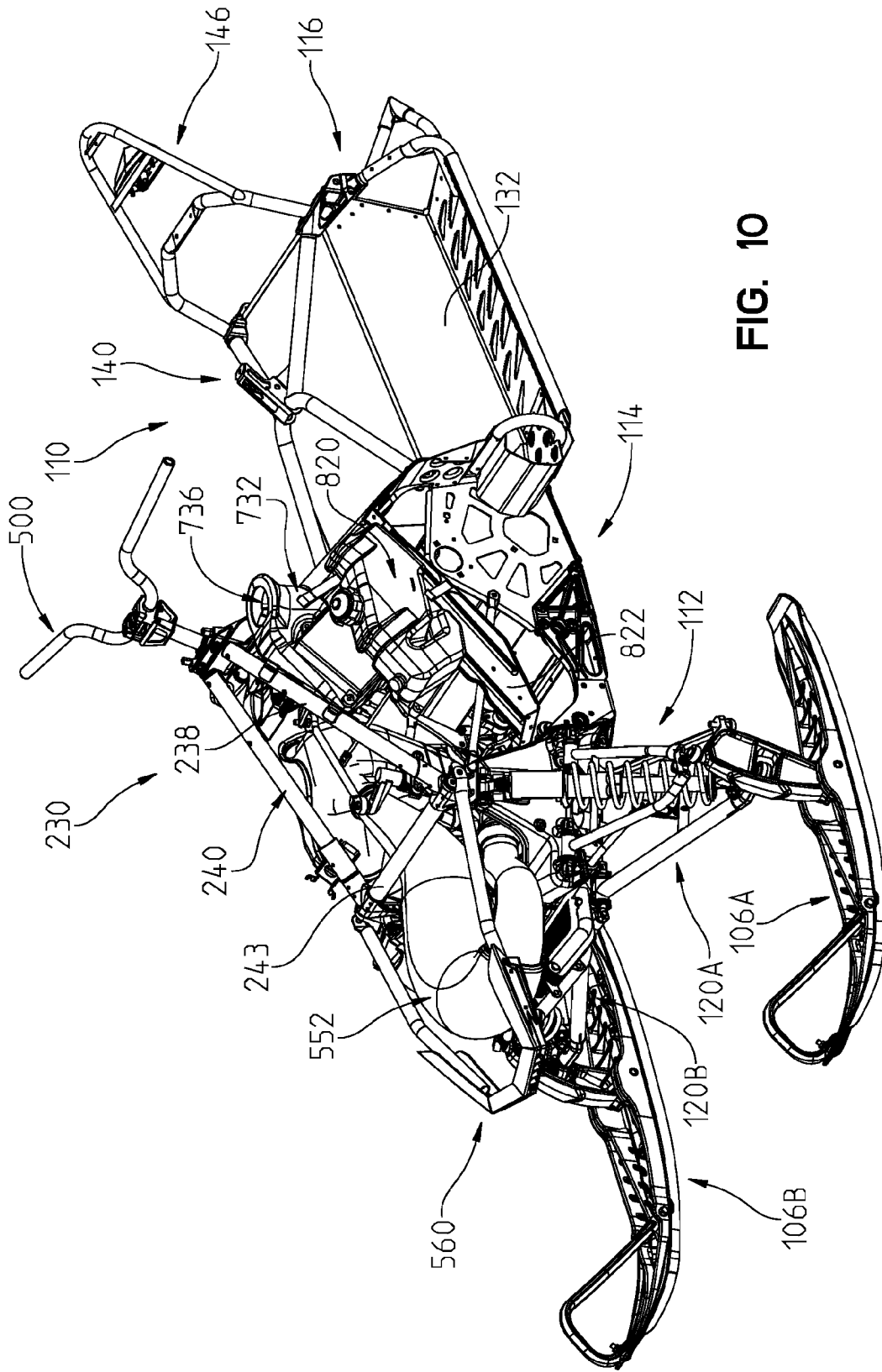


FIG. 10

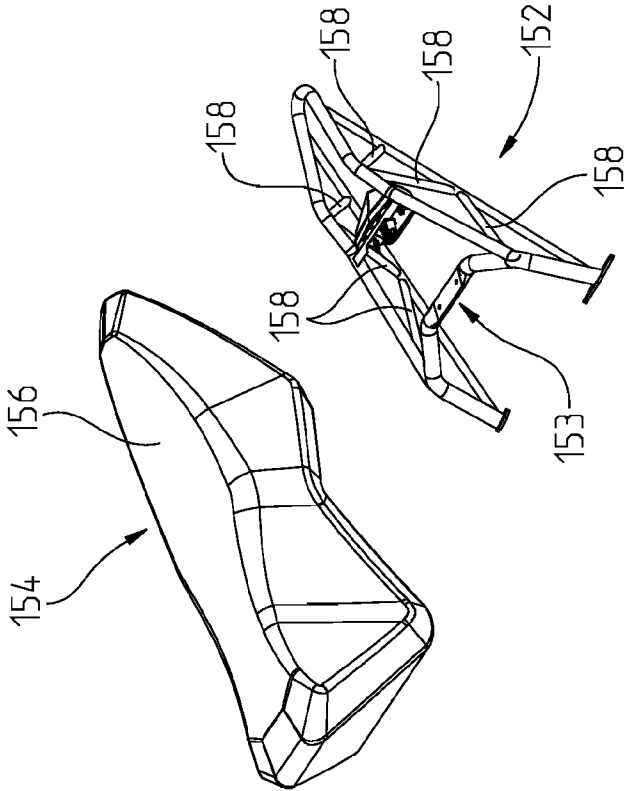


FIG. 11B

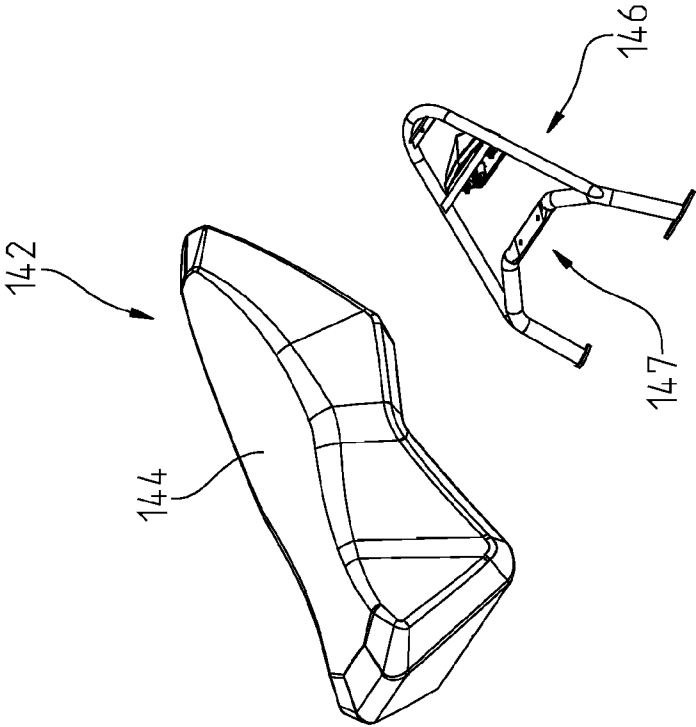


FIG. 11A

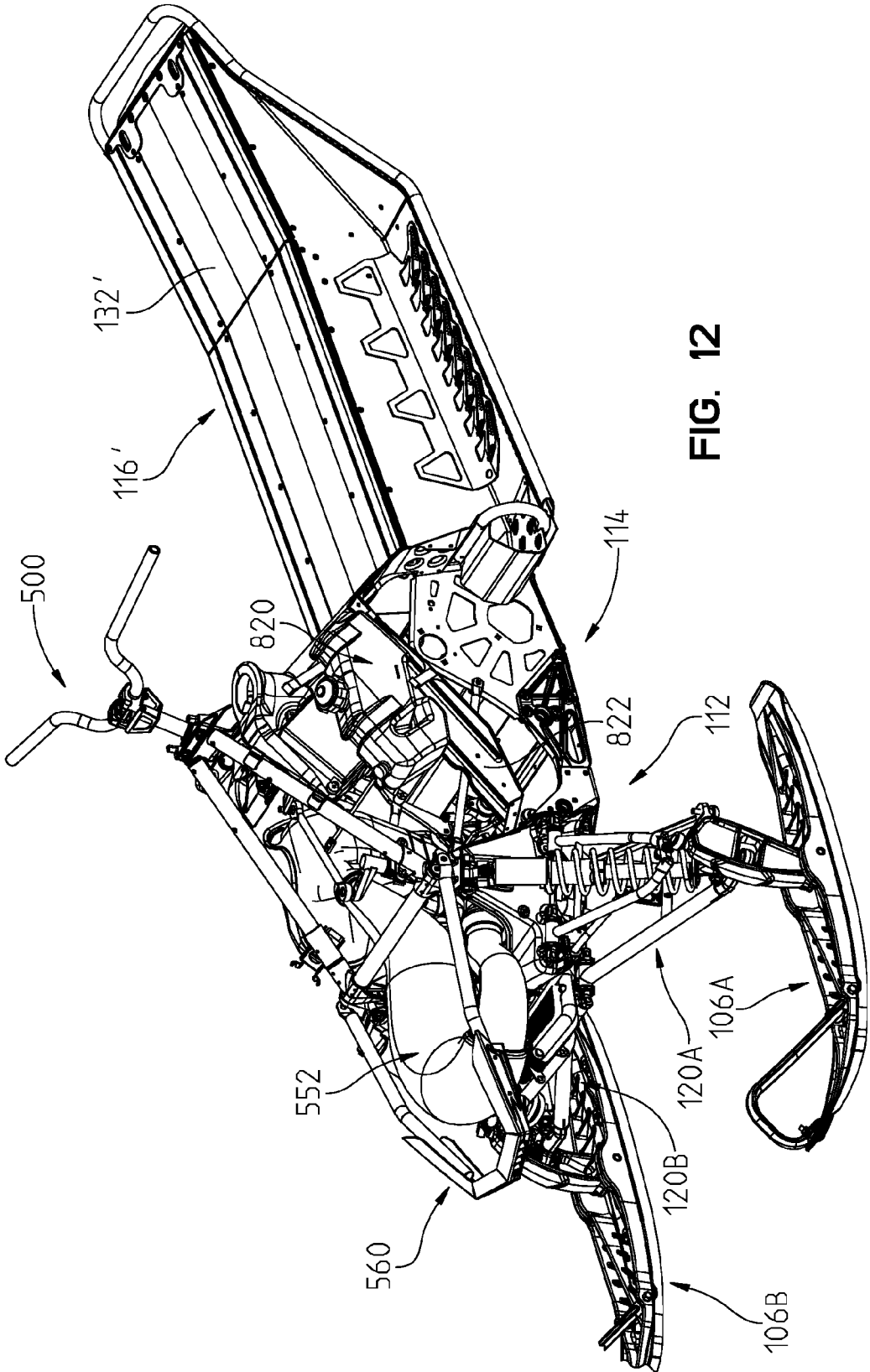


FIG. 12



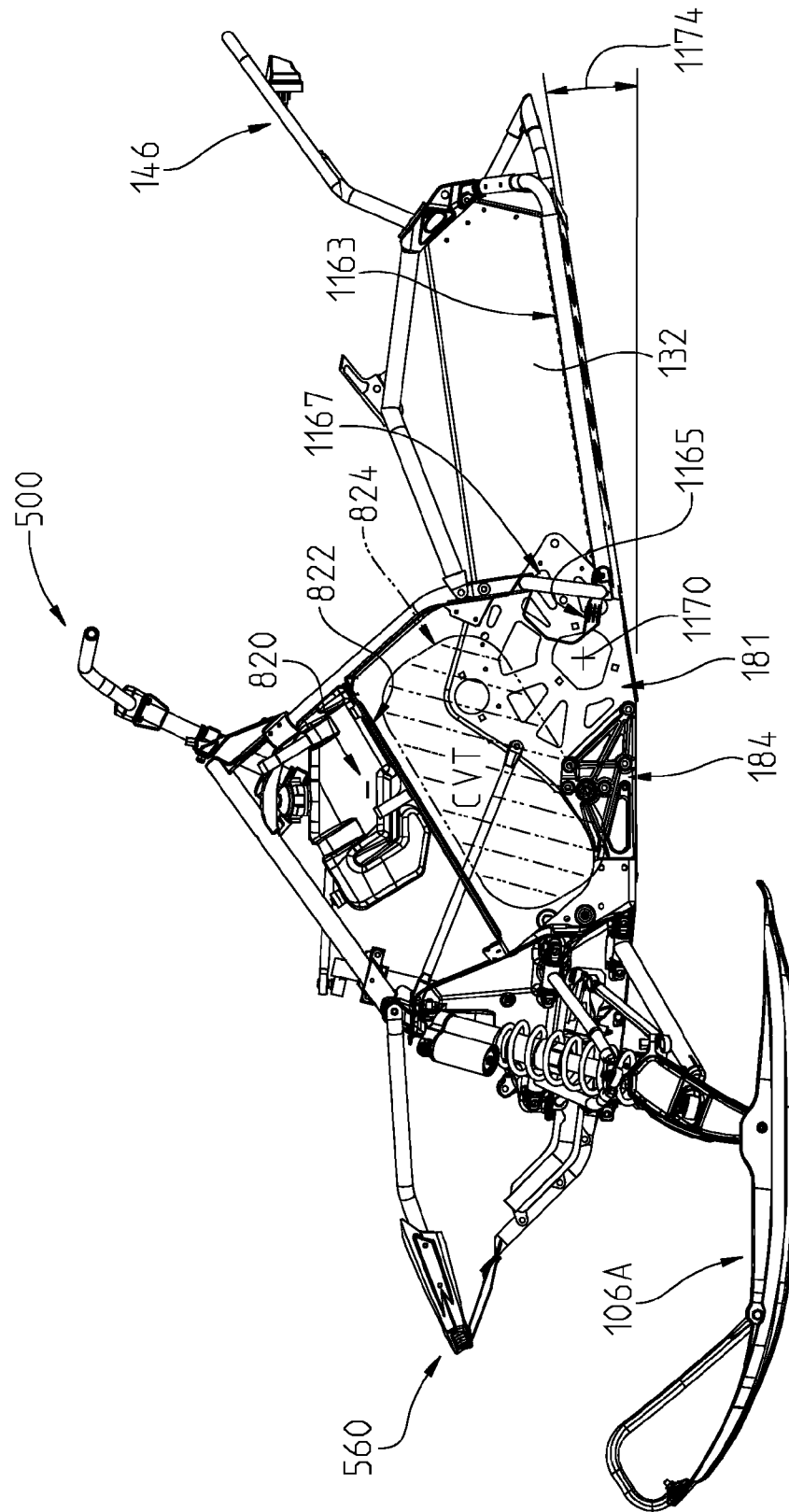
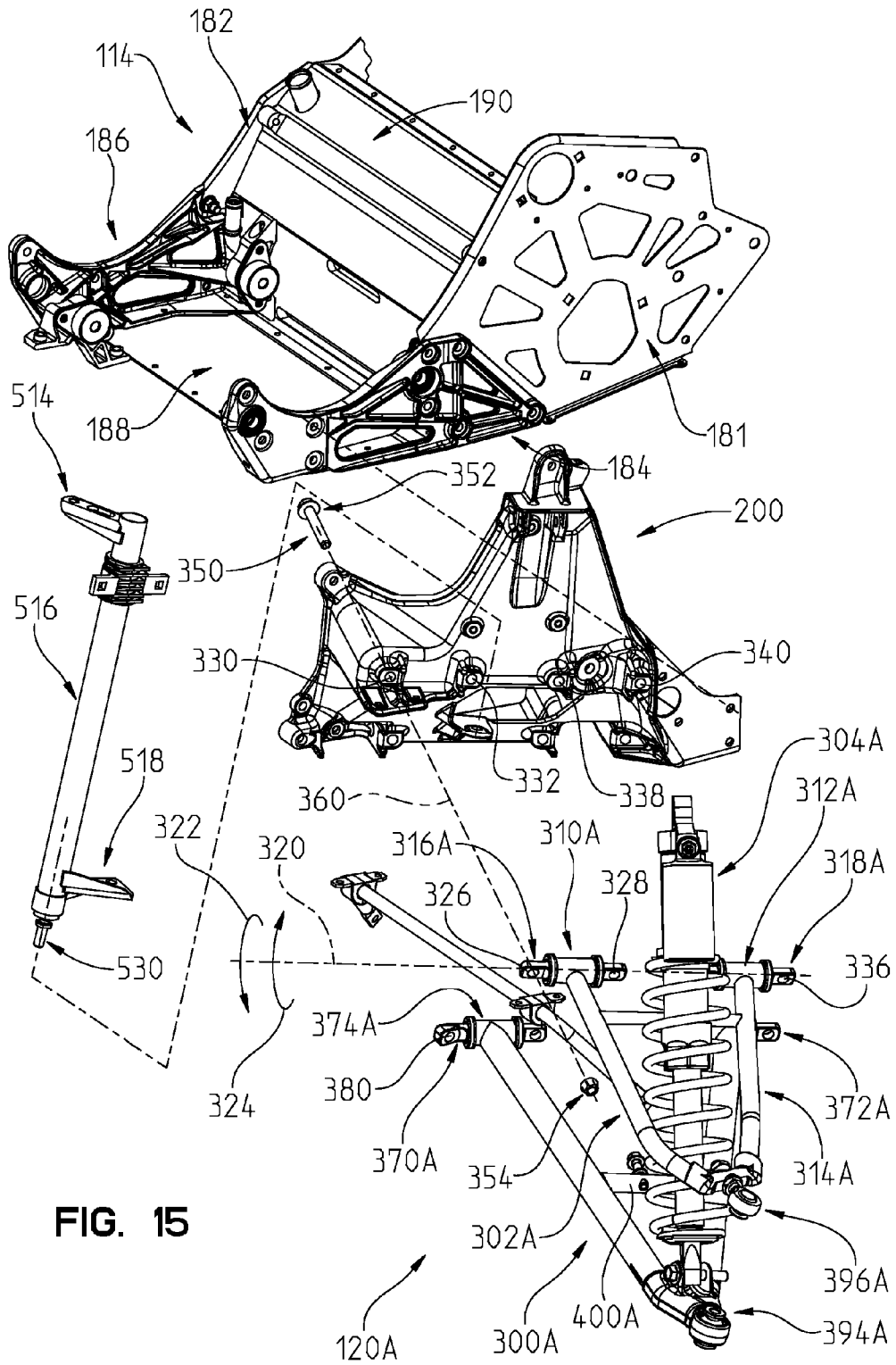


FIG. 14



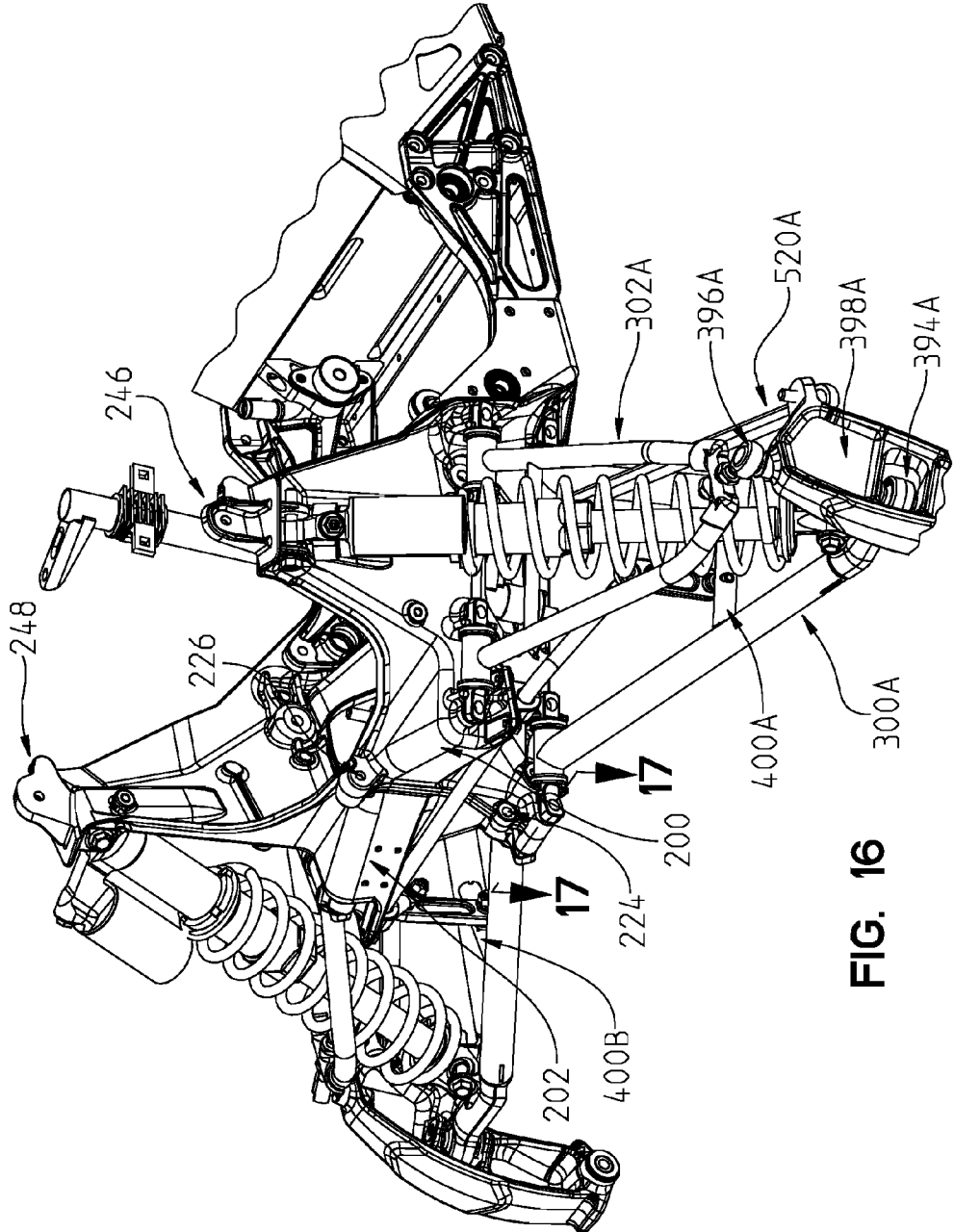


FIG. 16

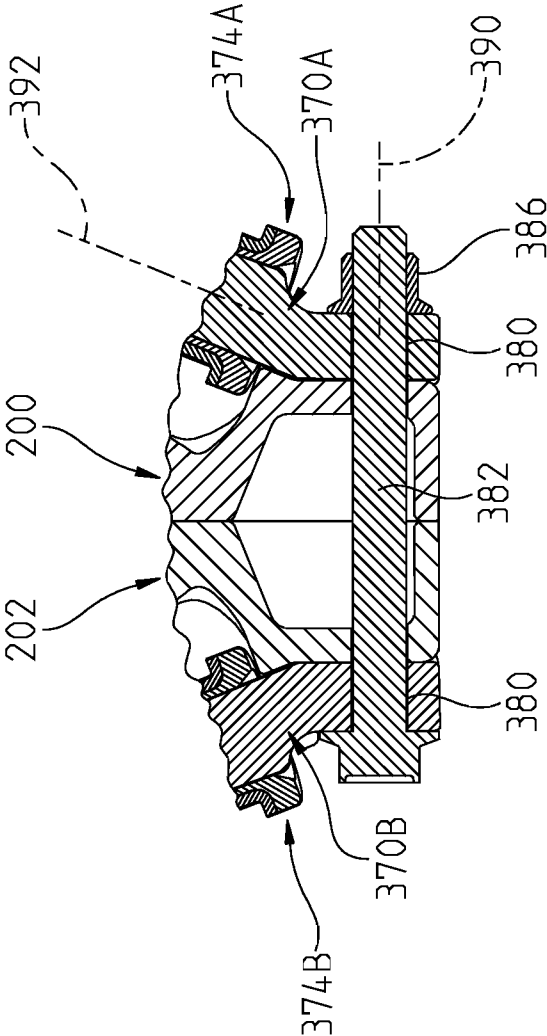


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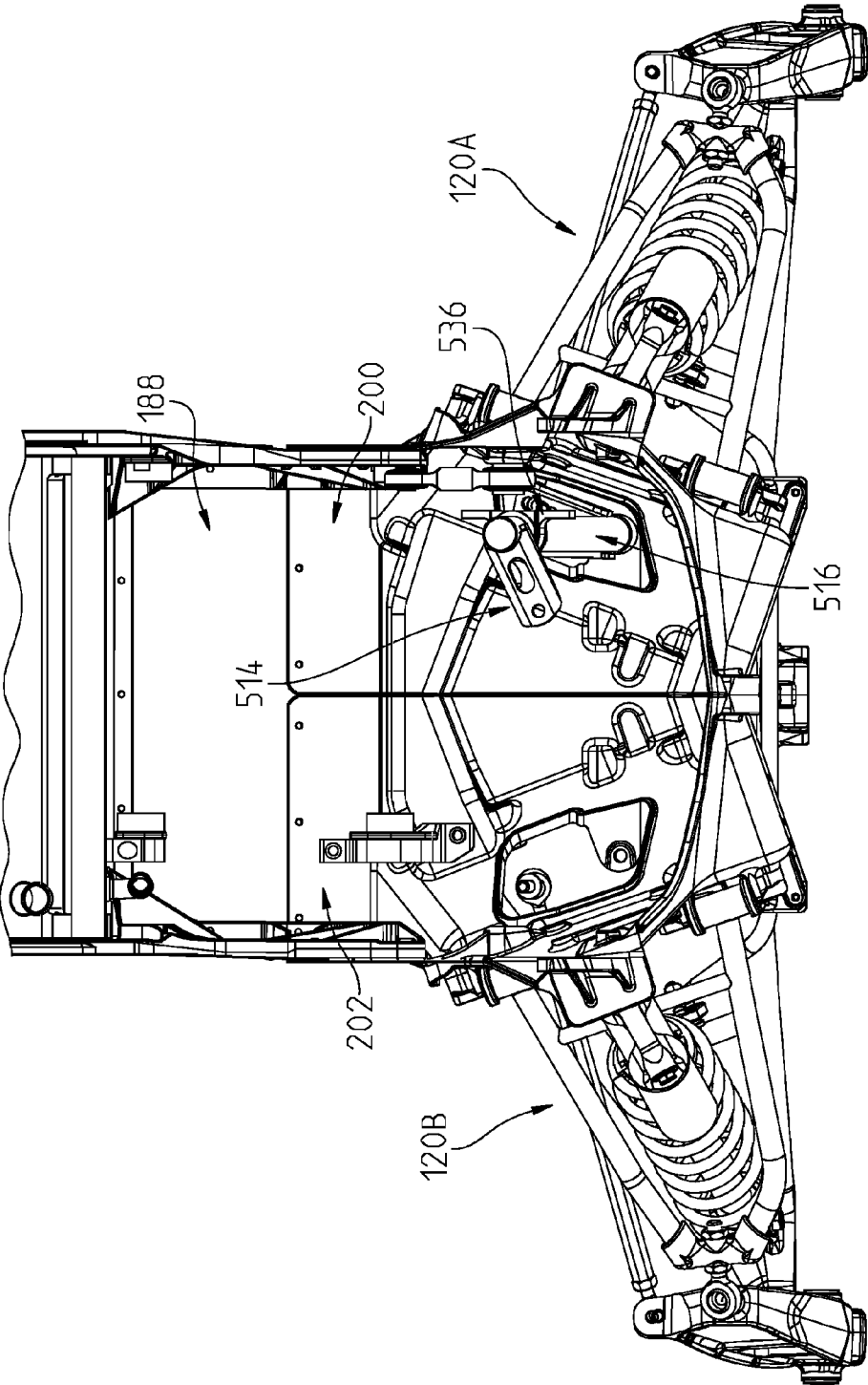


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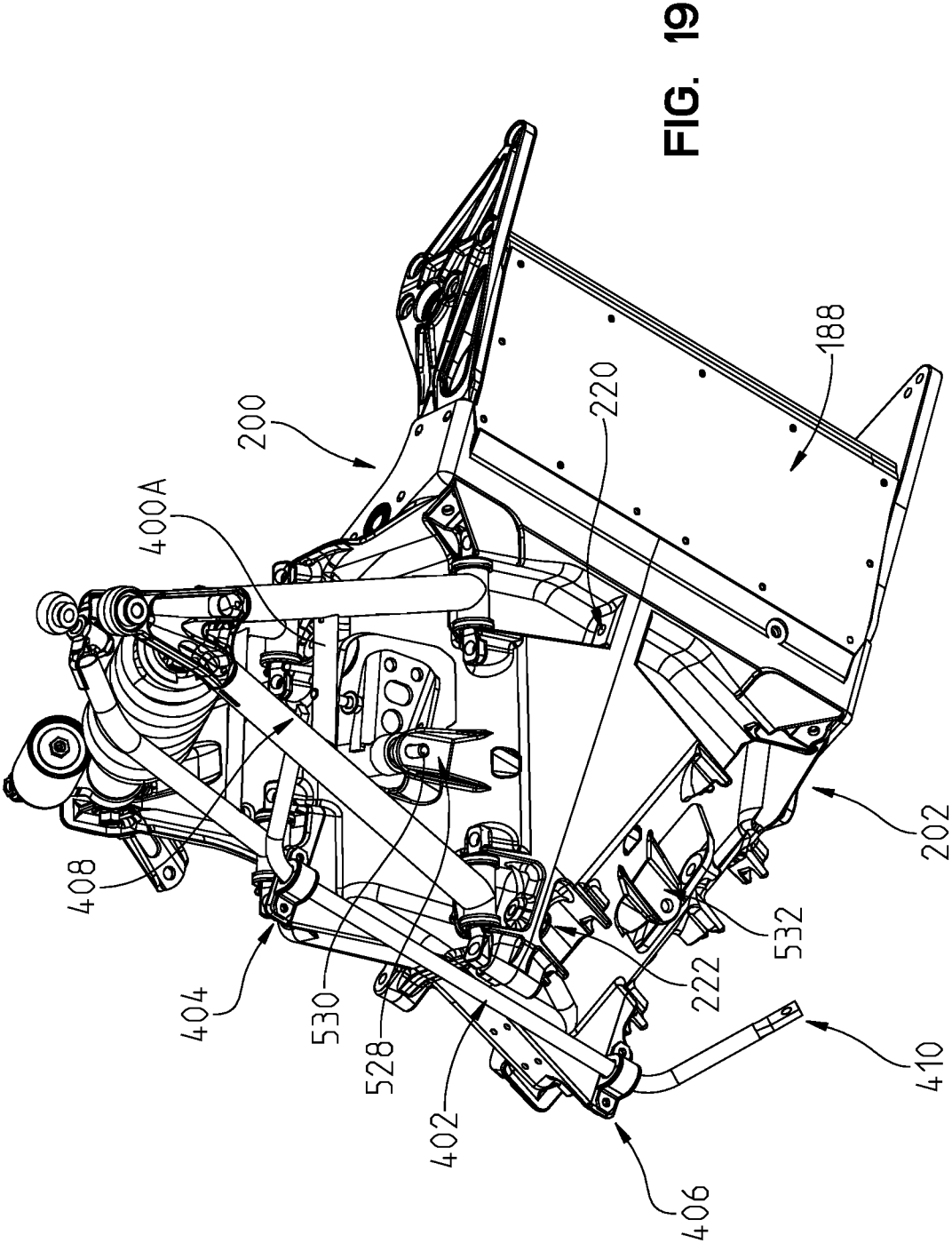


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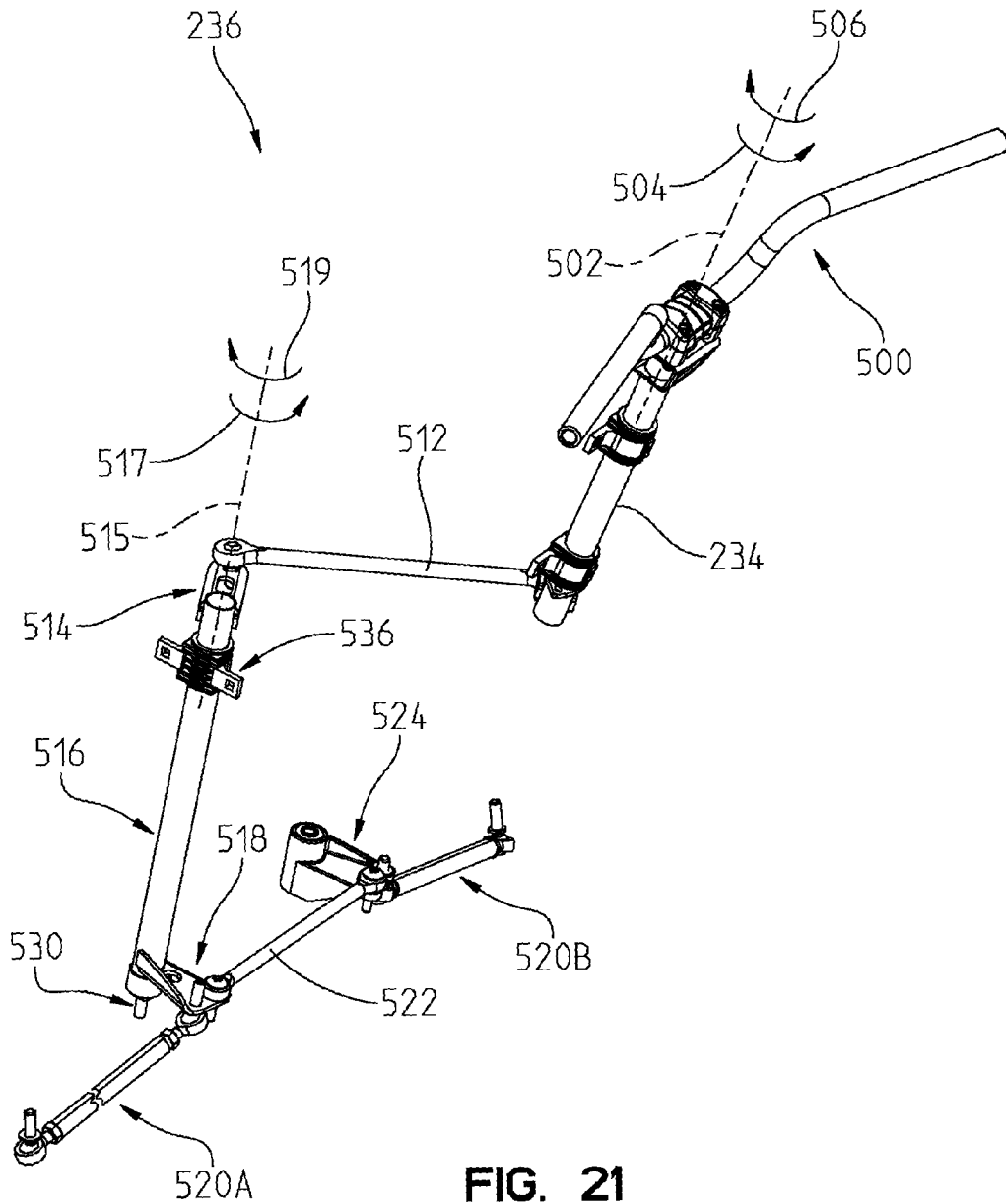


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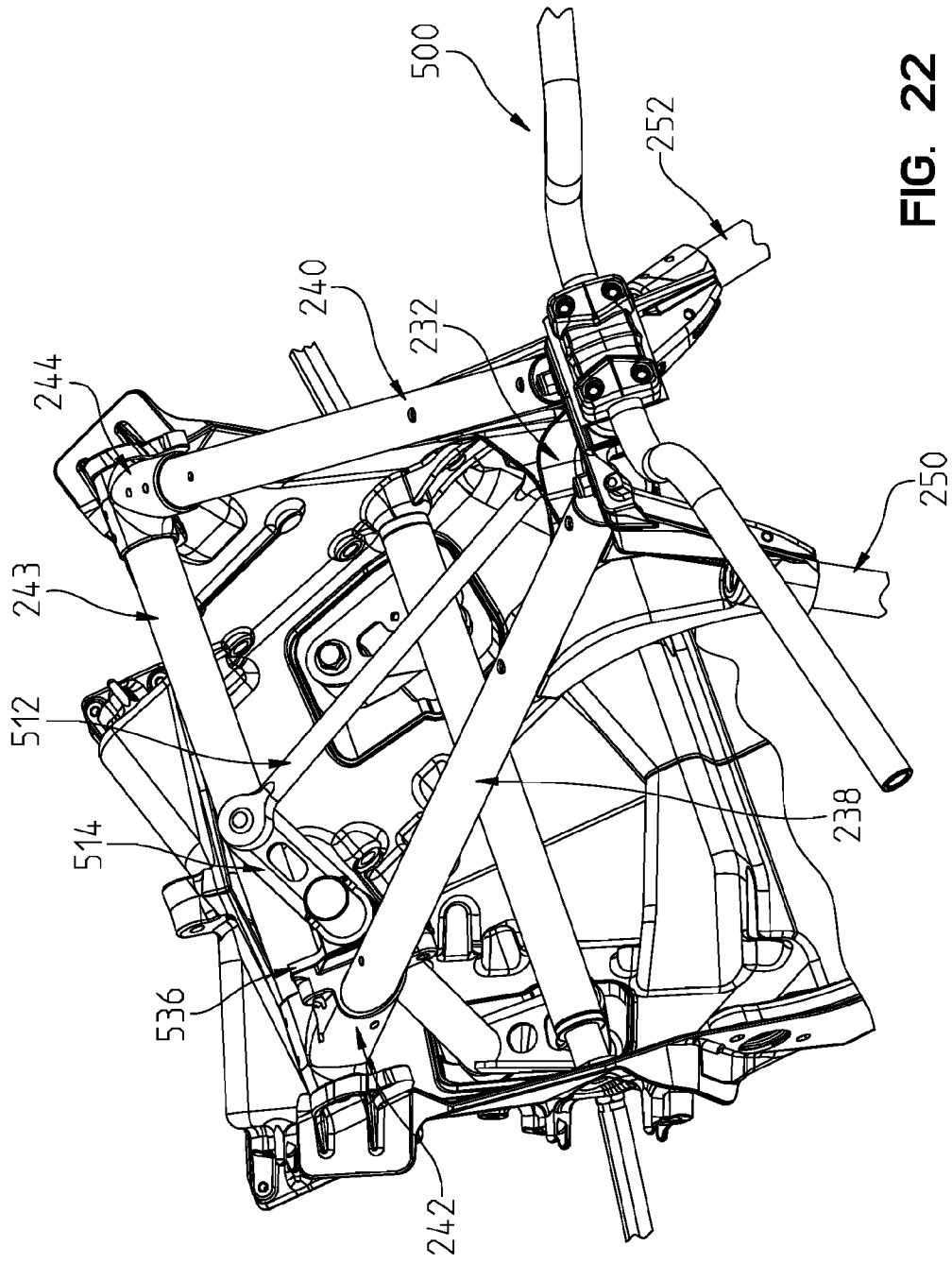


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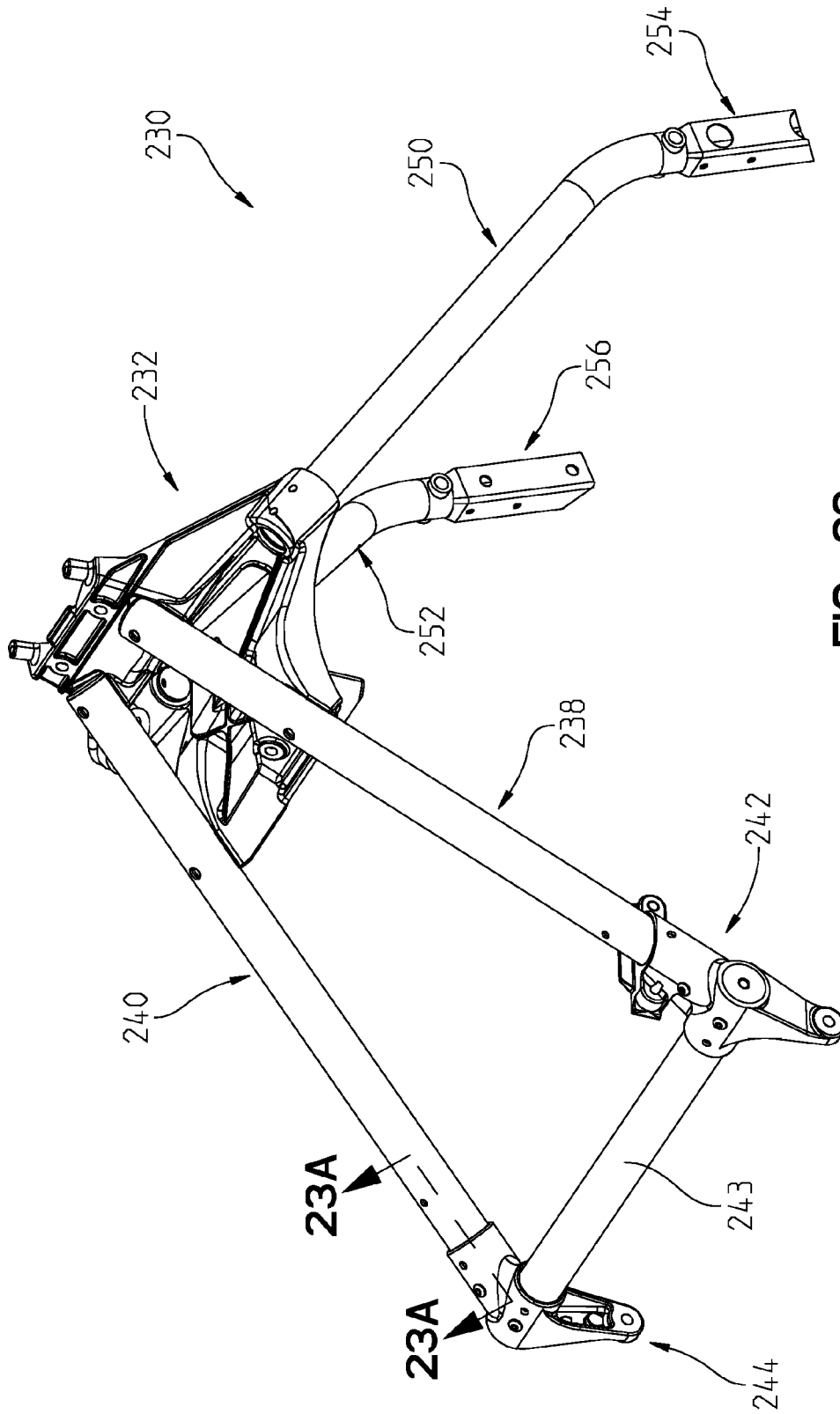


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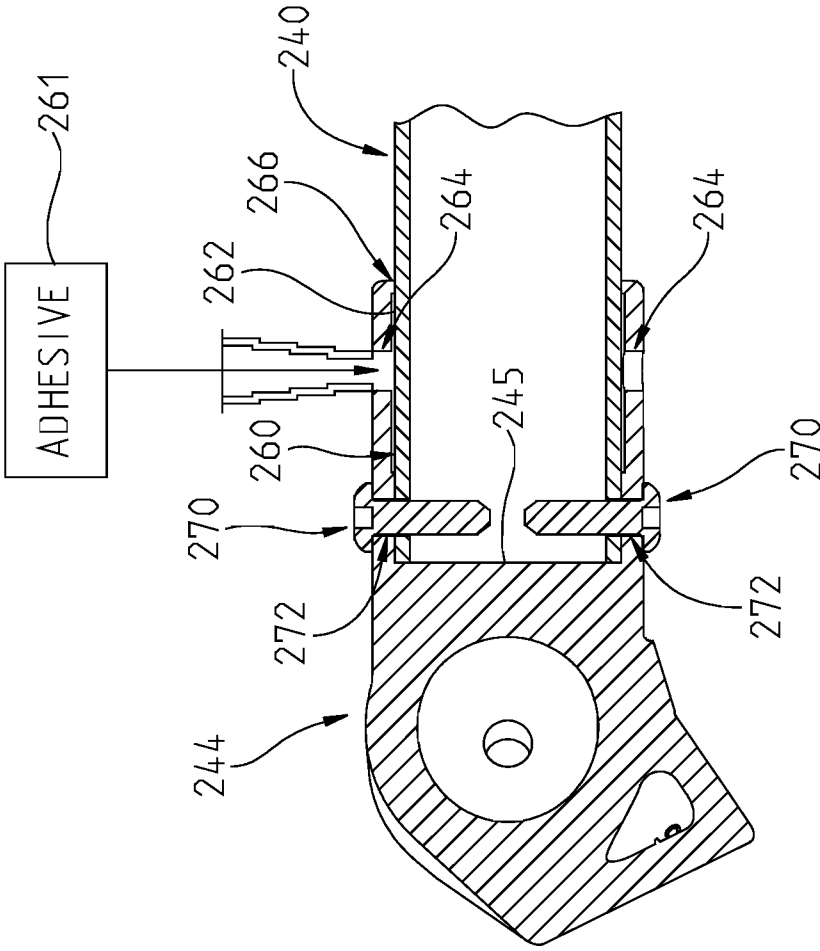


FIG. 23A



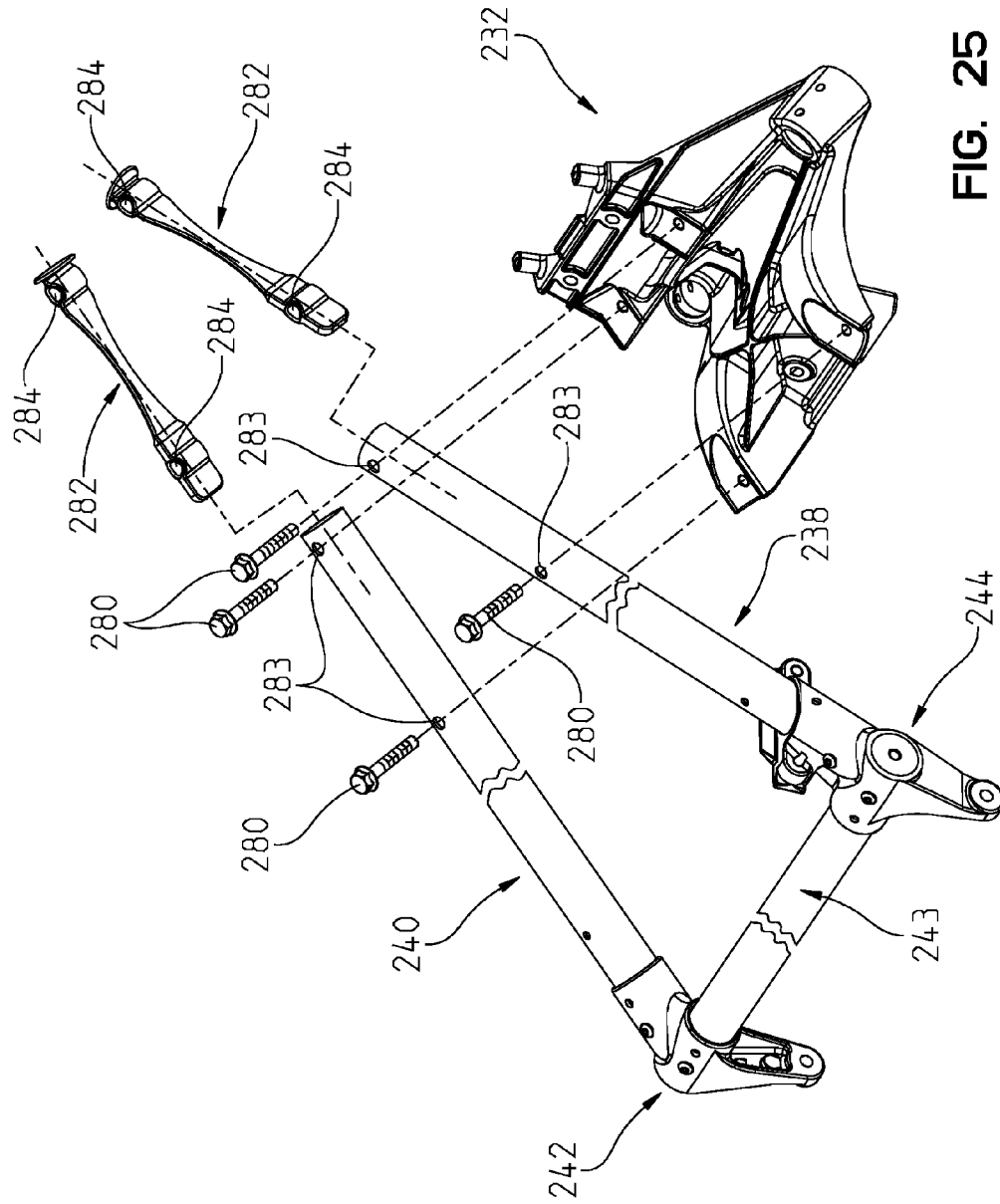


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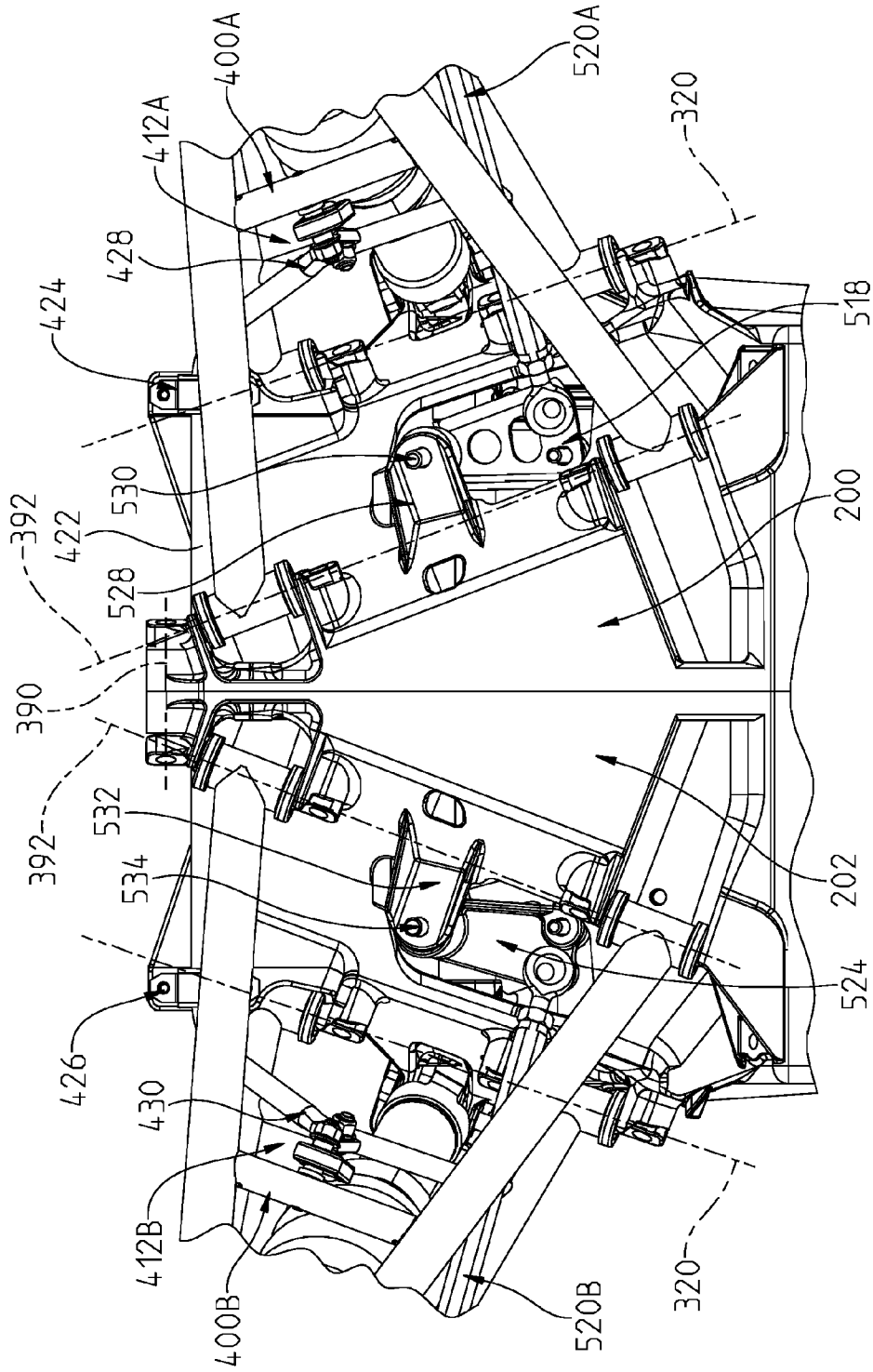


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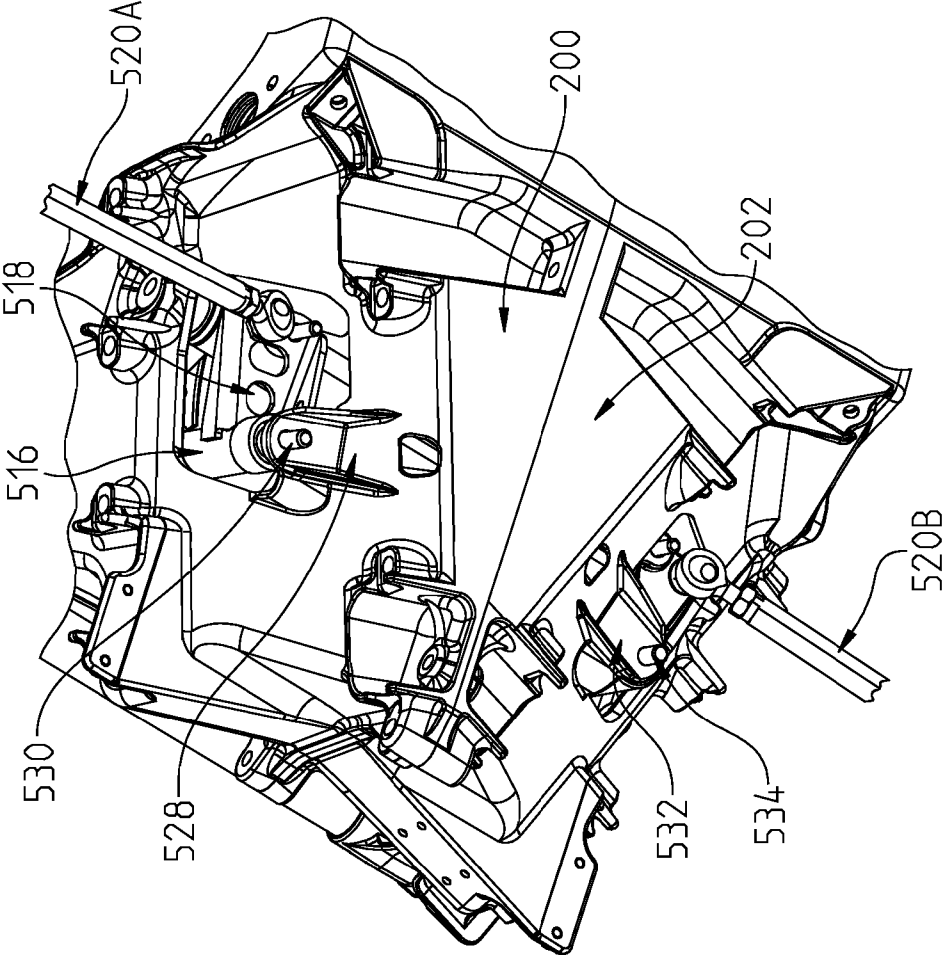


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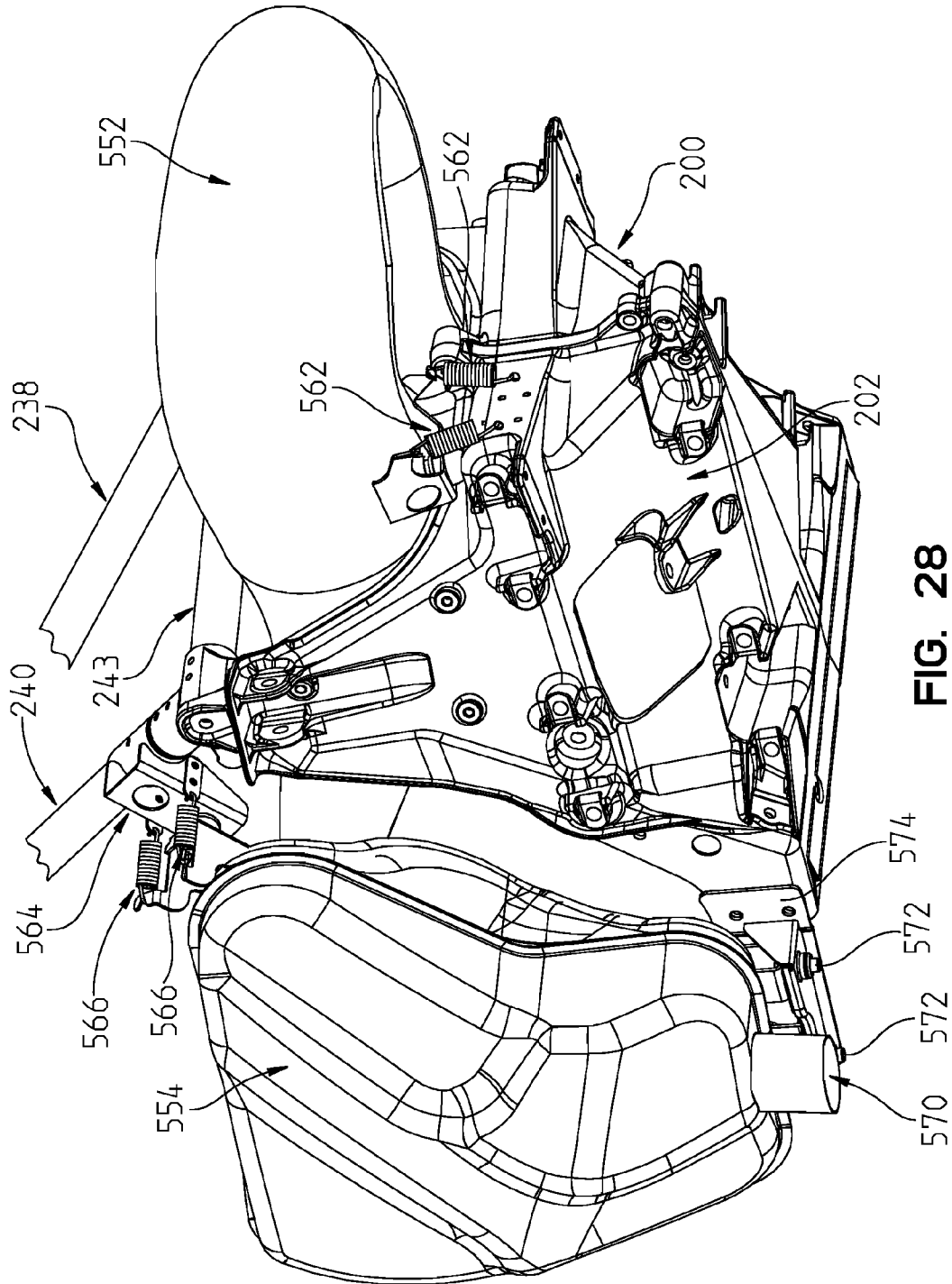


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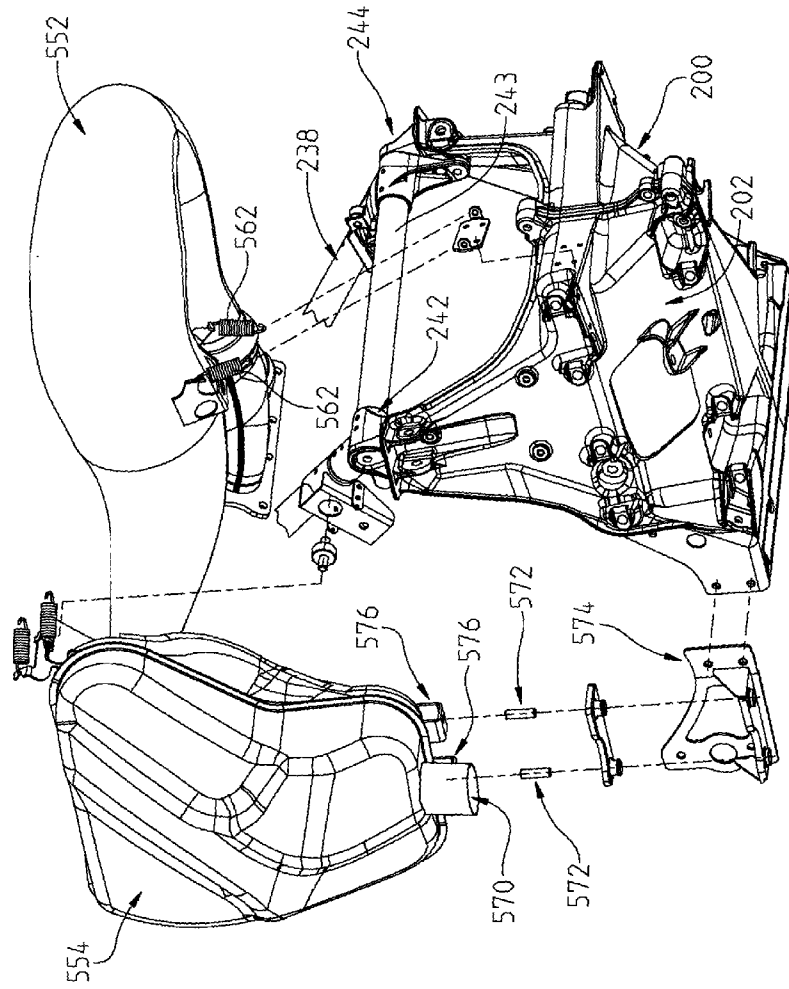


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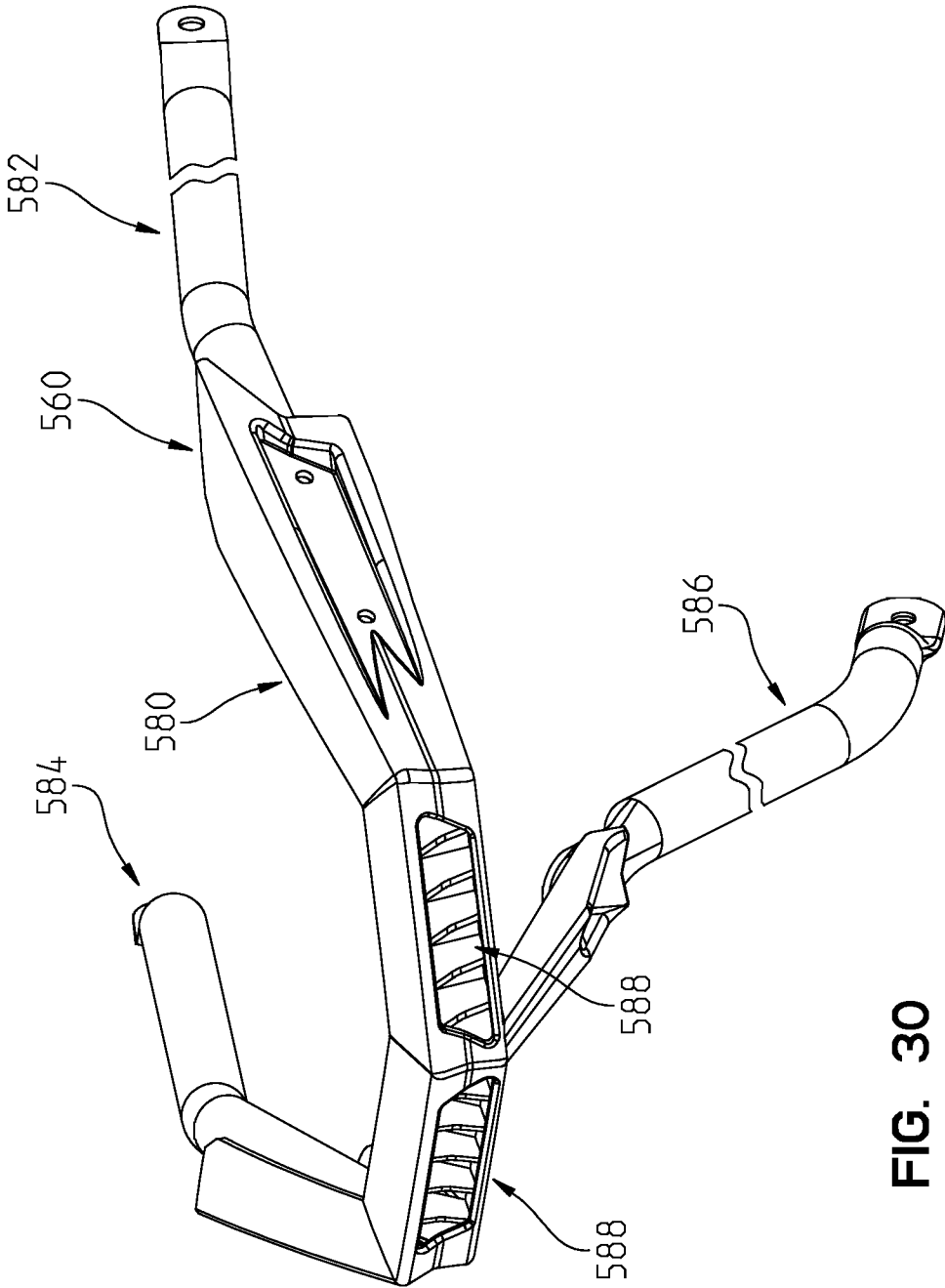


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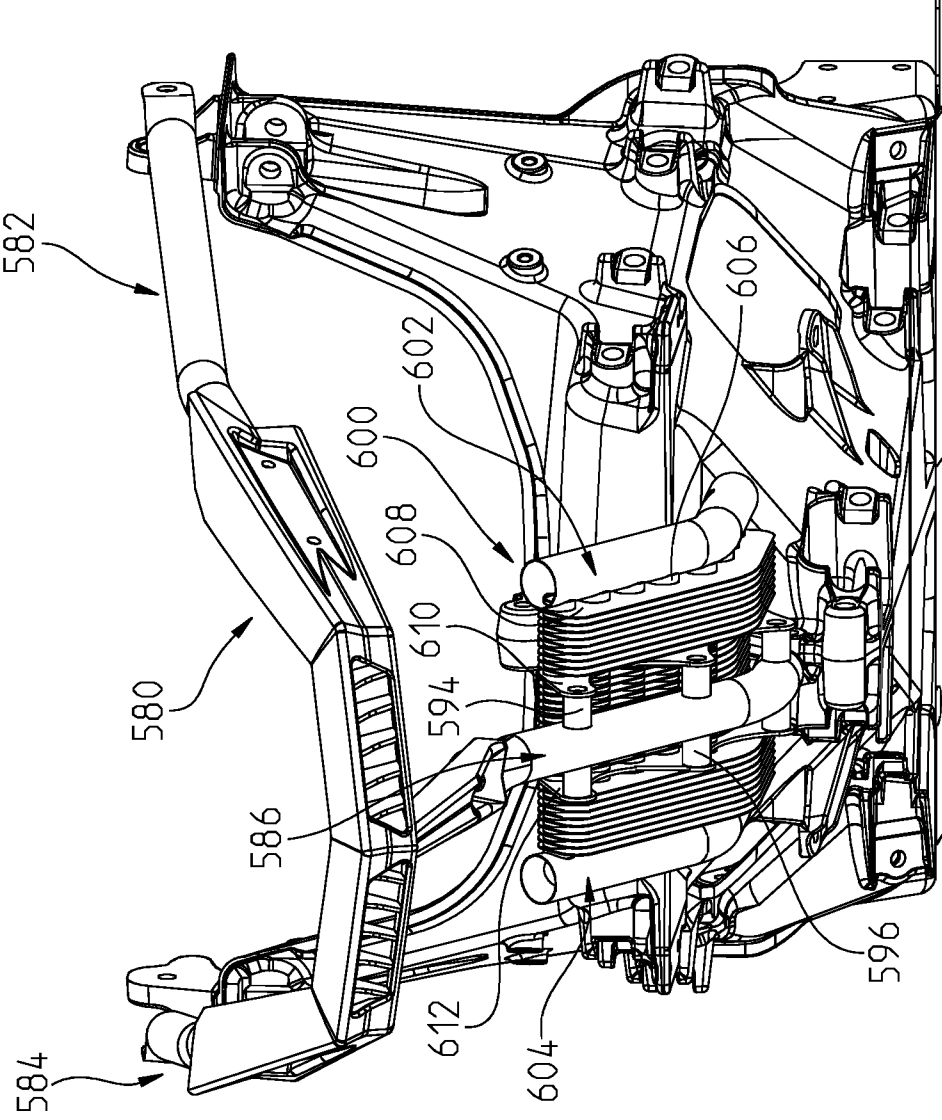


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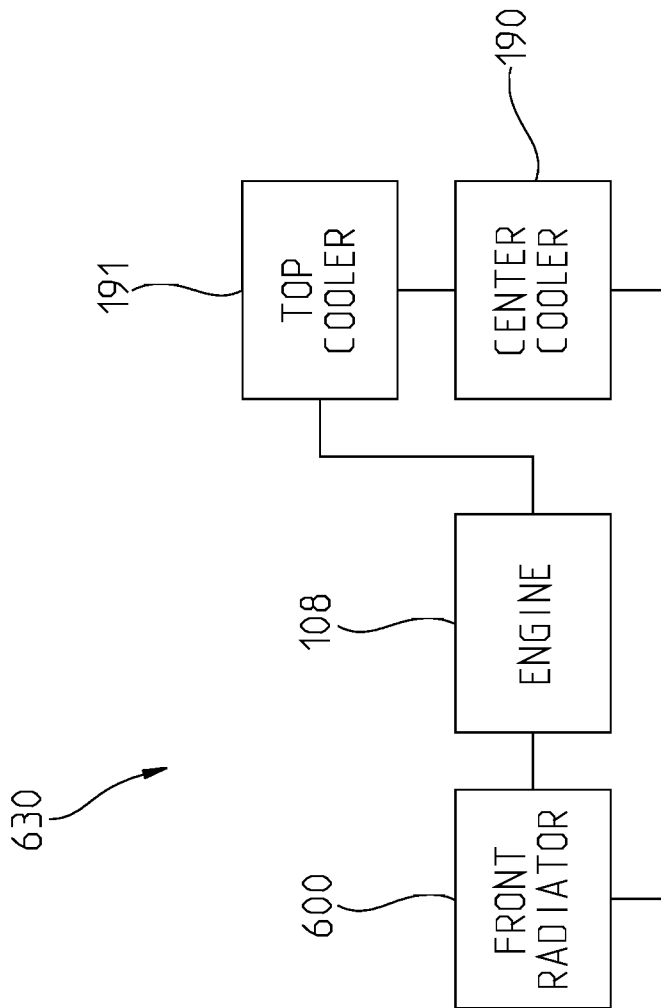


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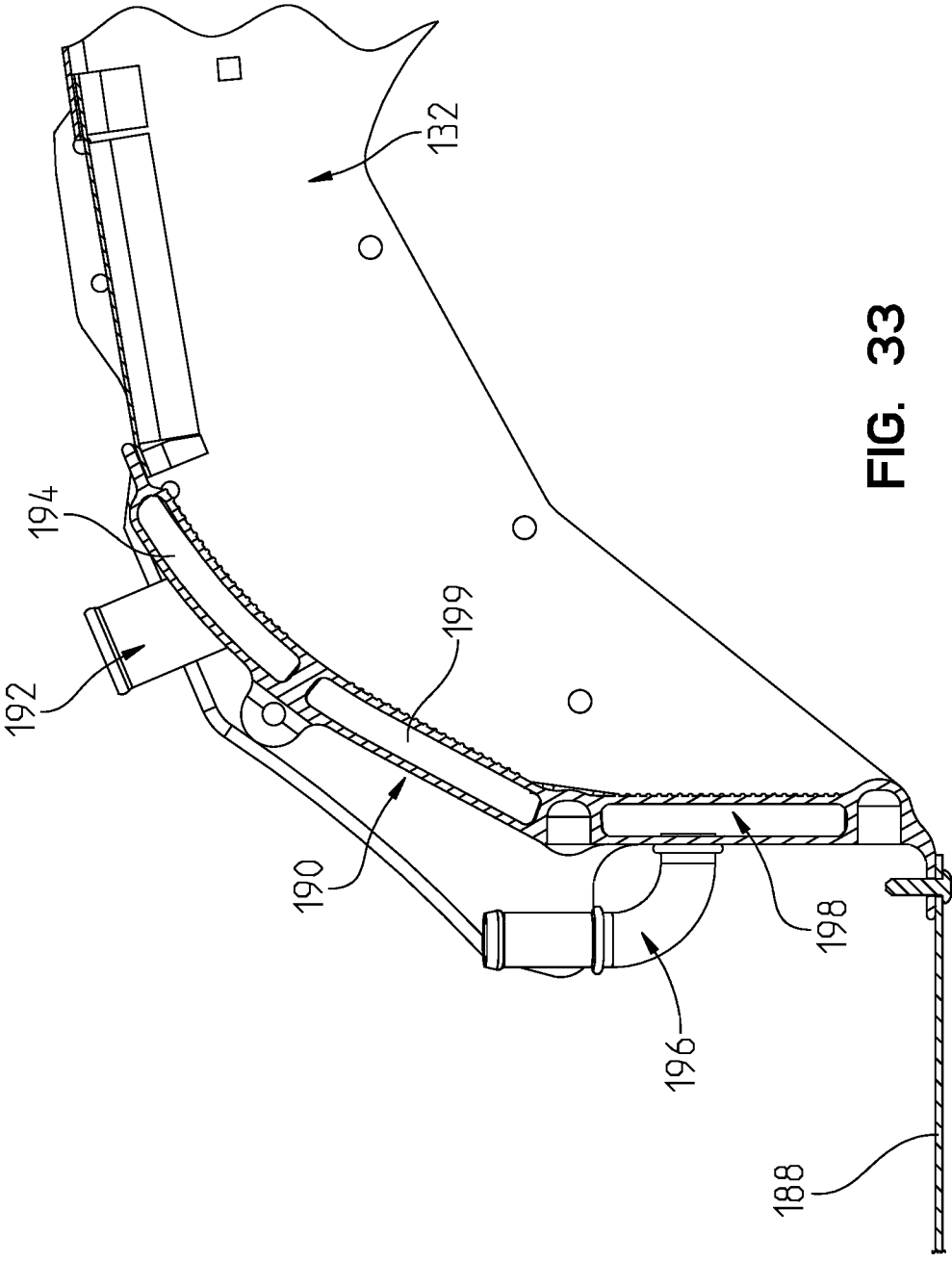


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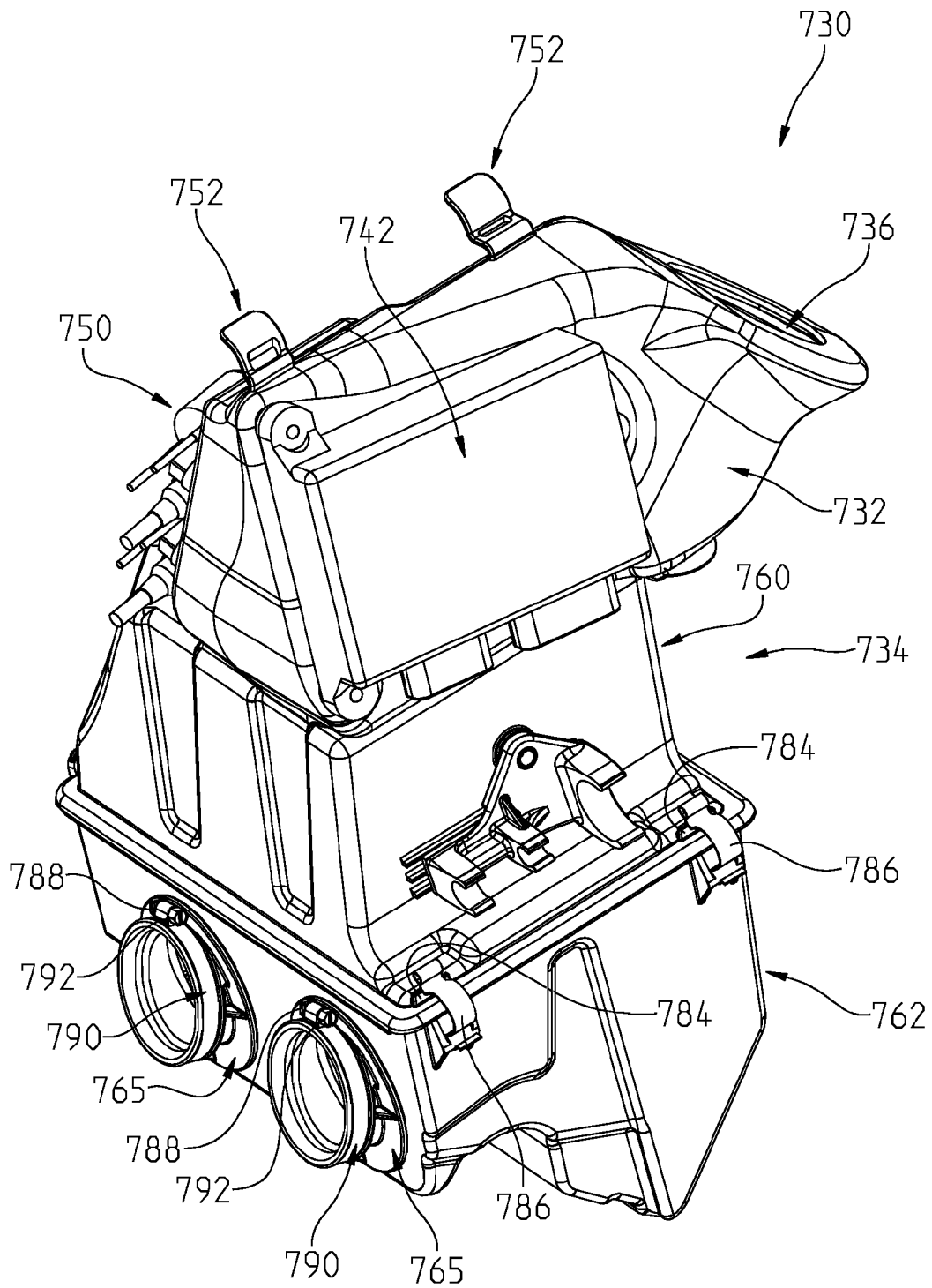


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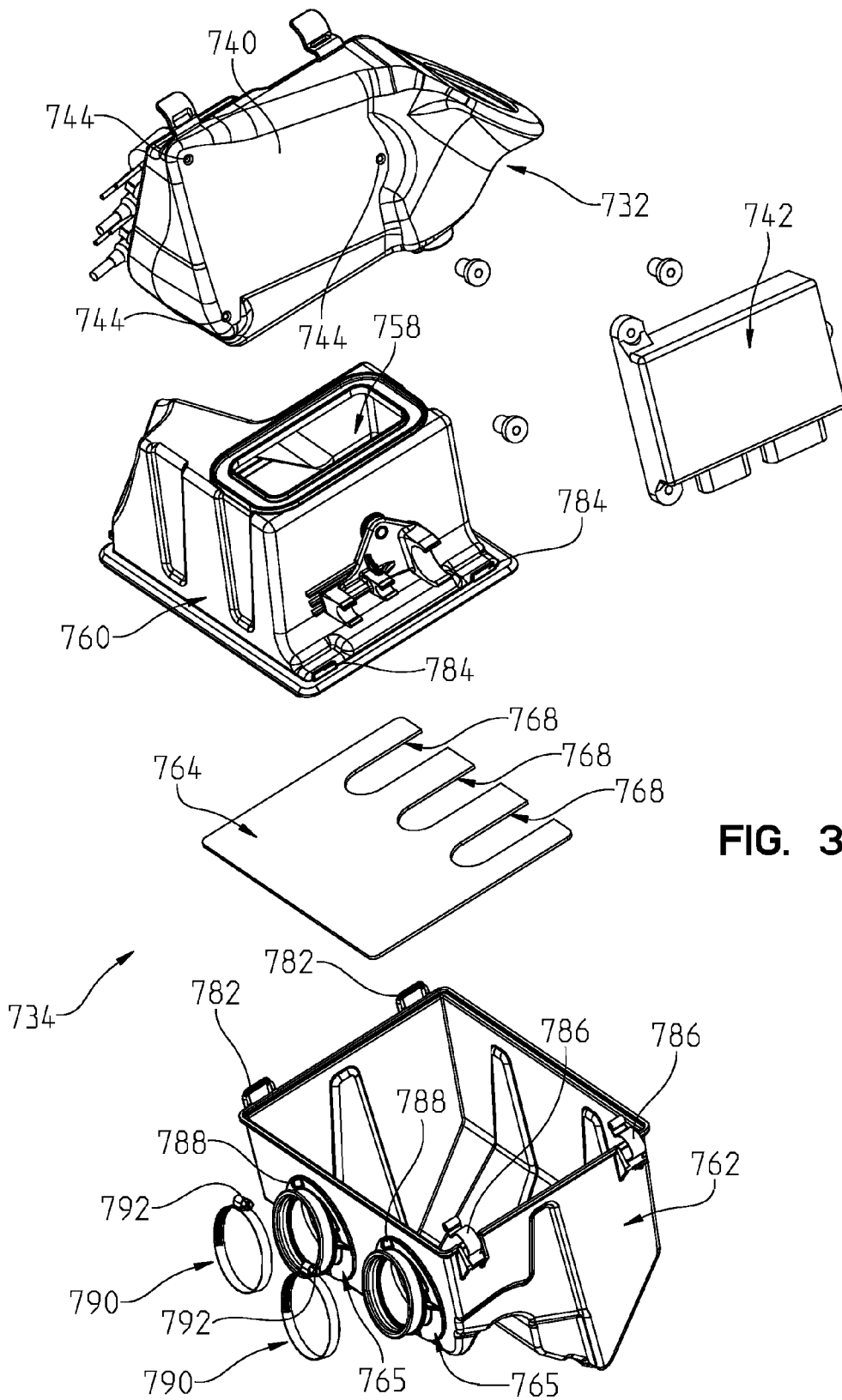


FIG. 35

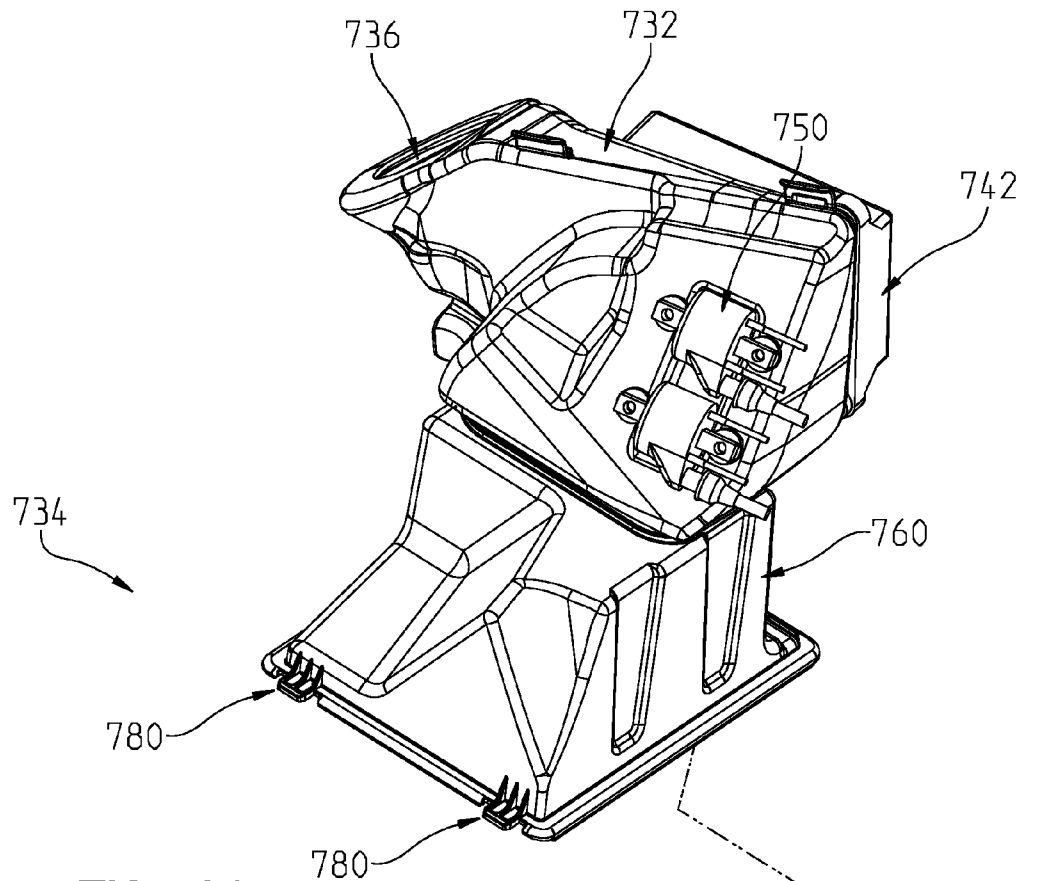
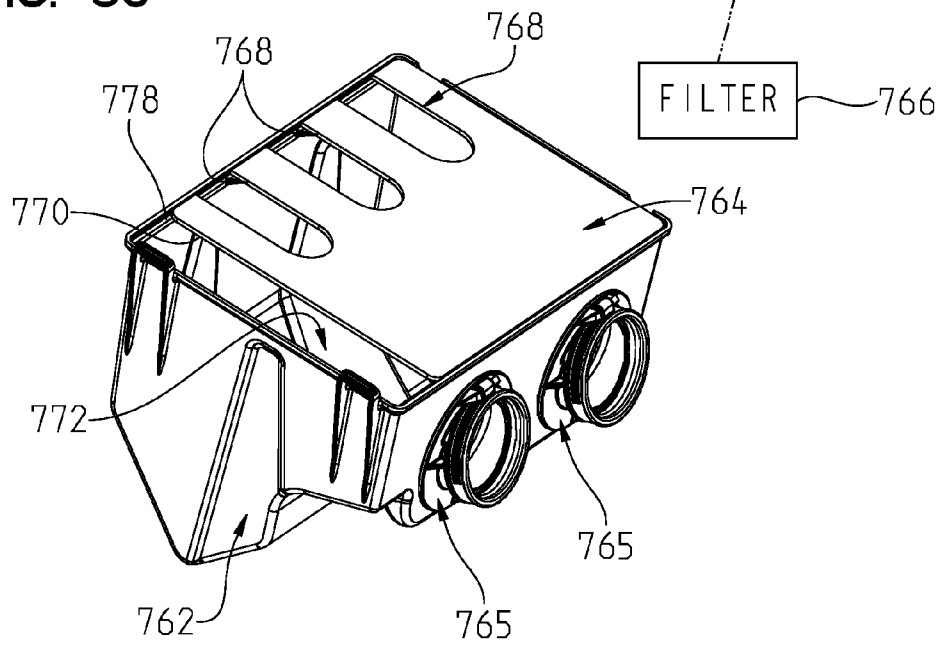


FIG. 36



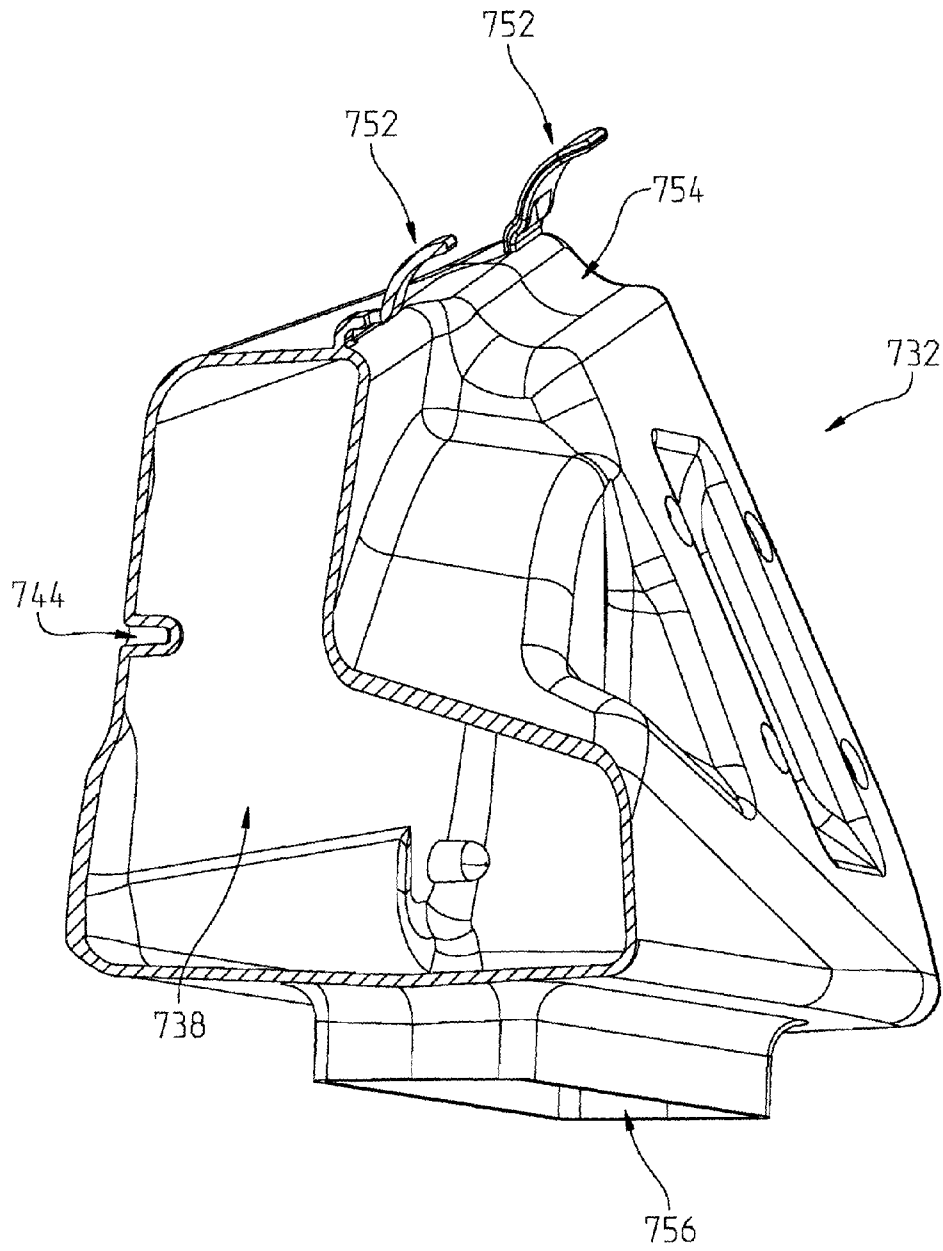


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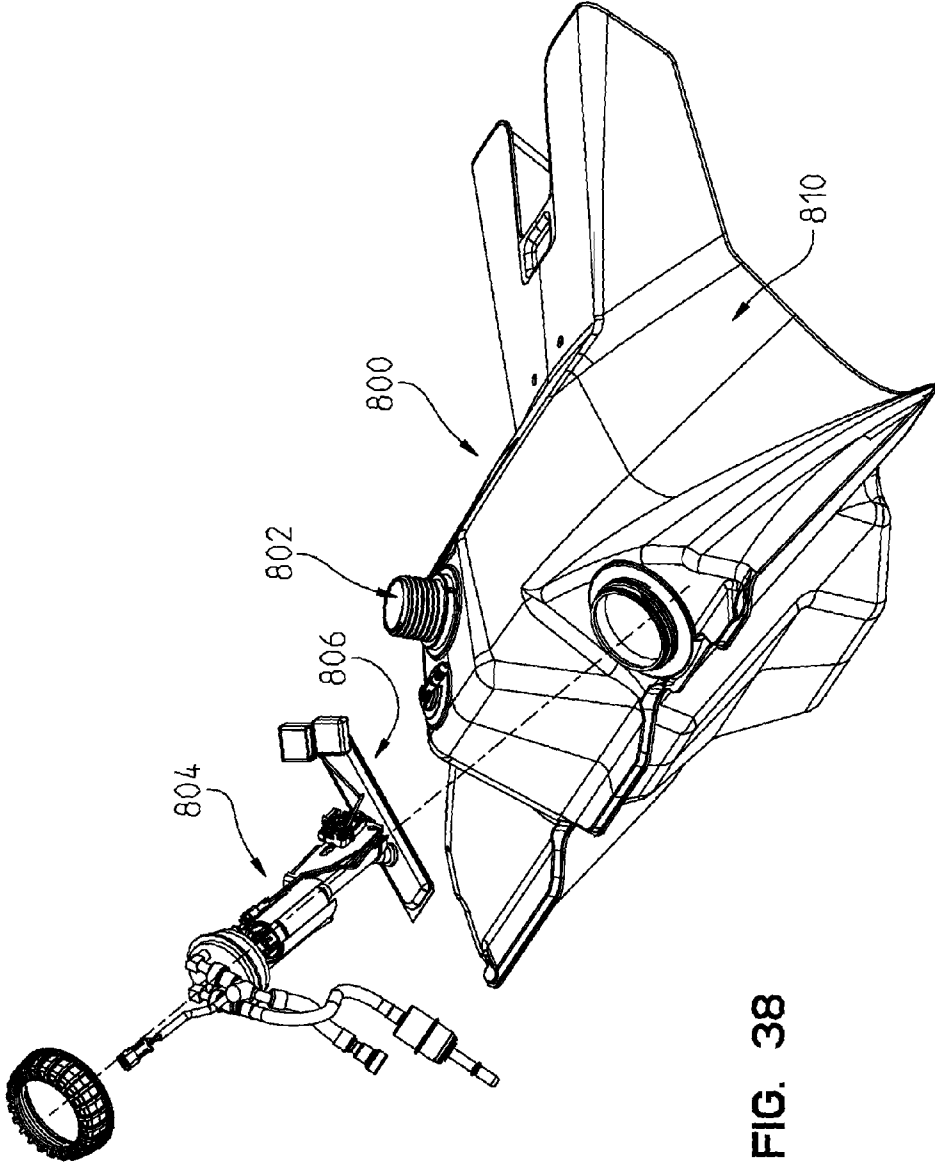


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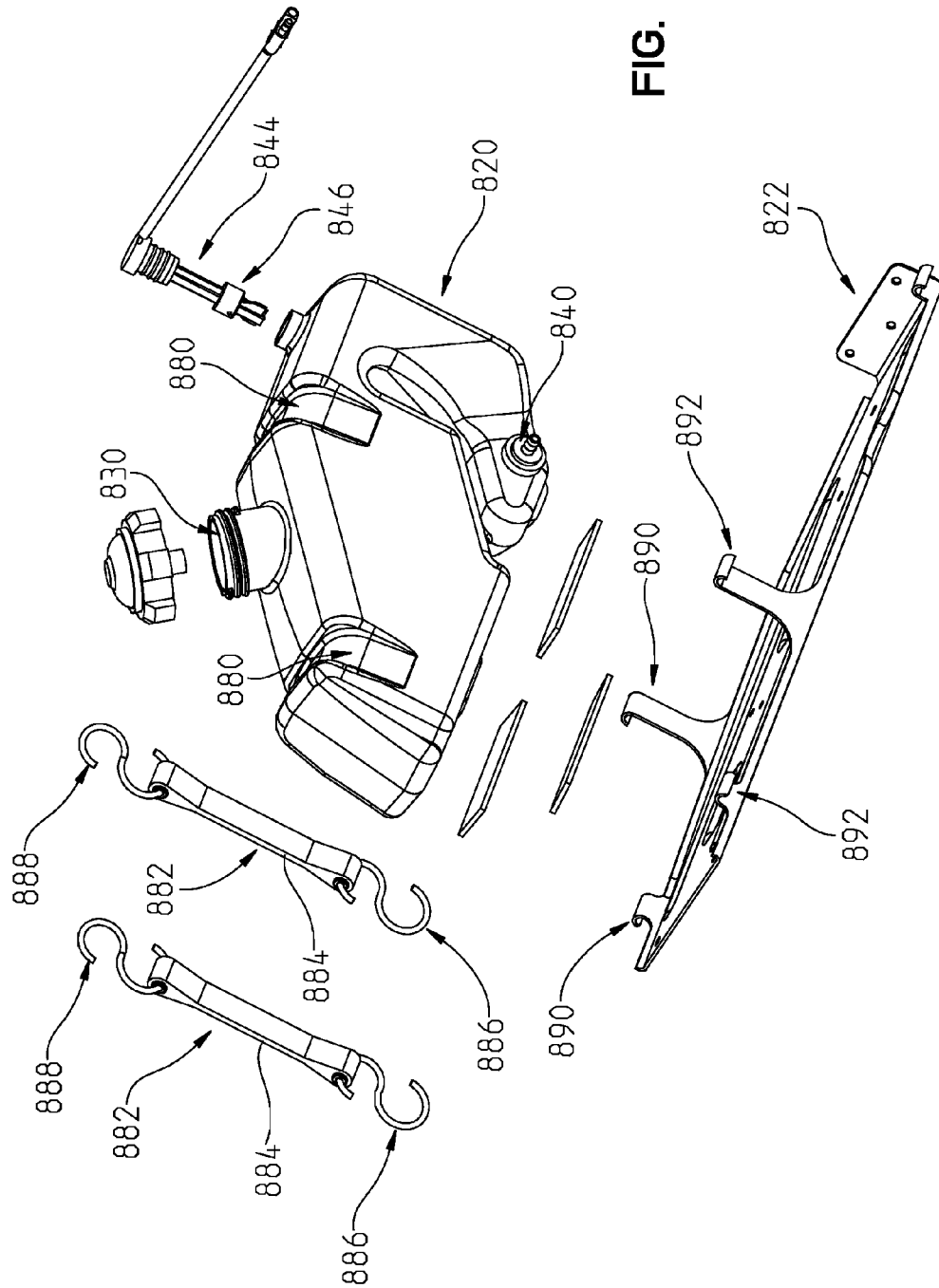


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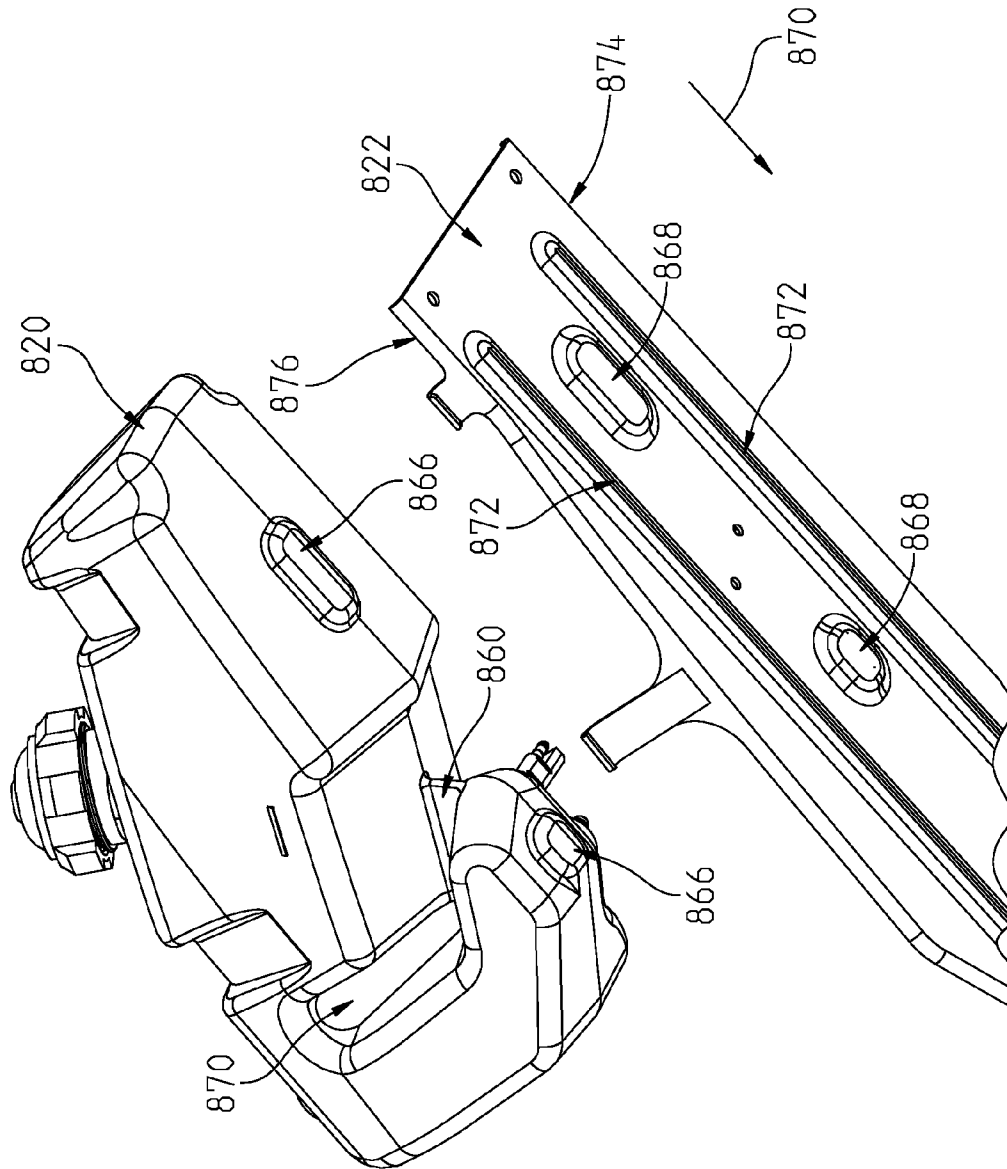


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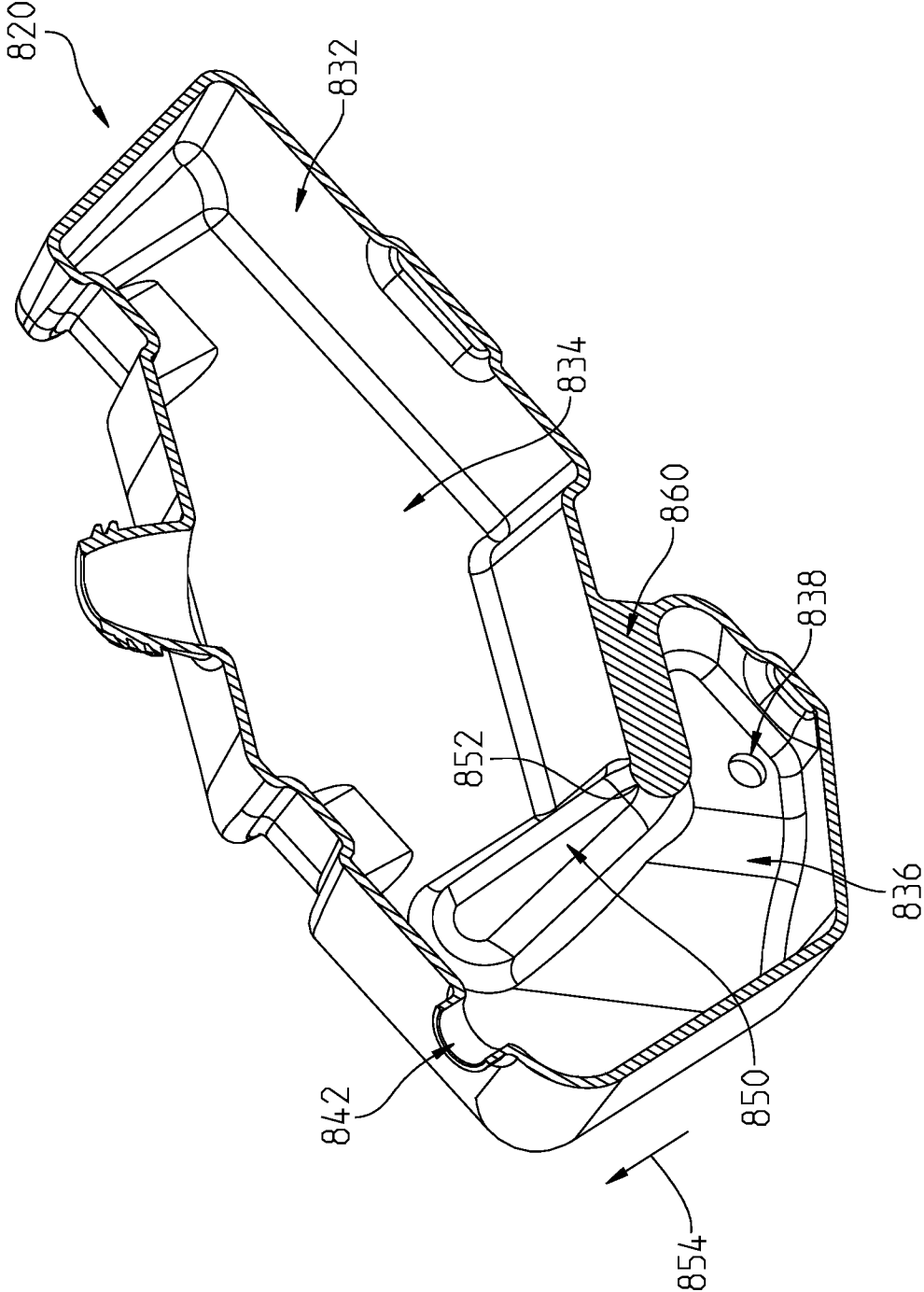


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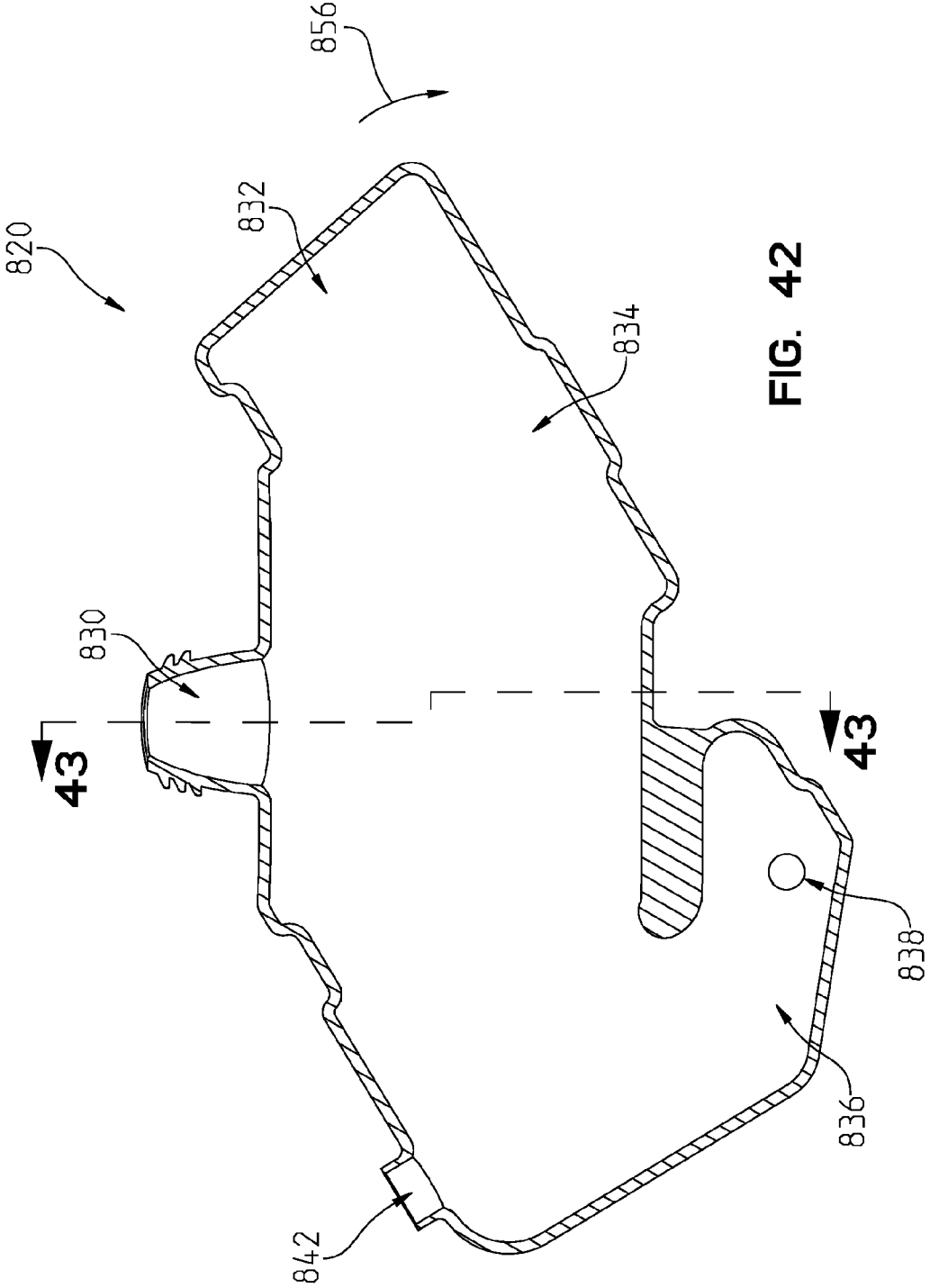


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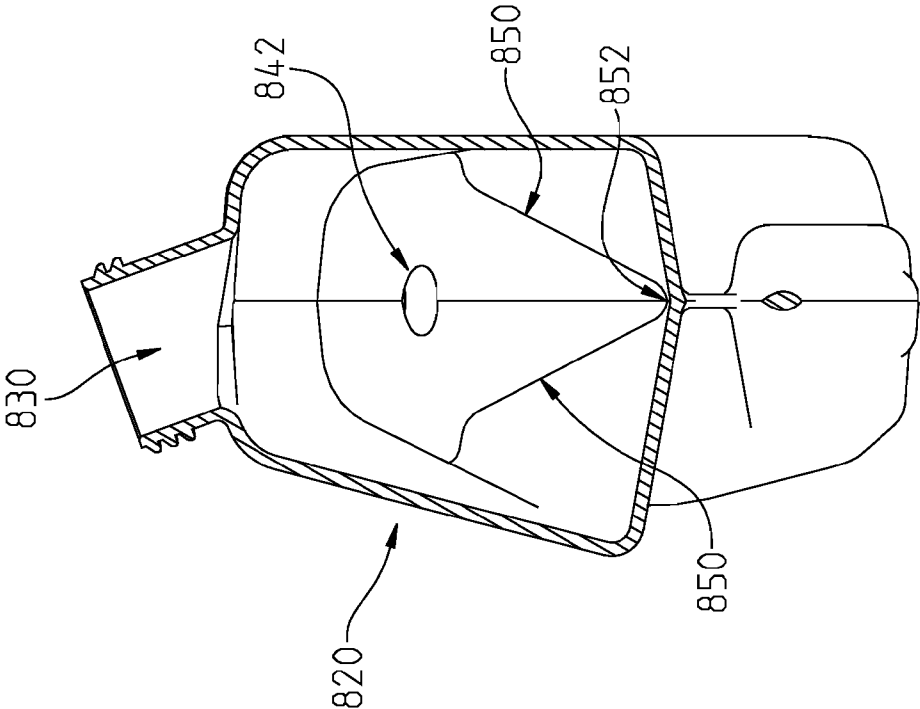


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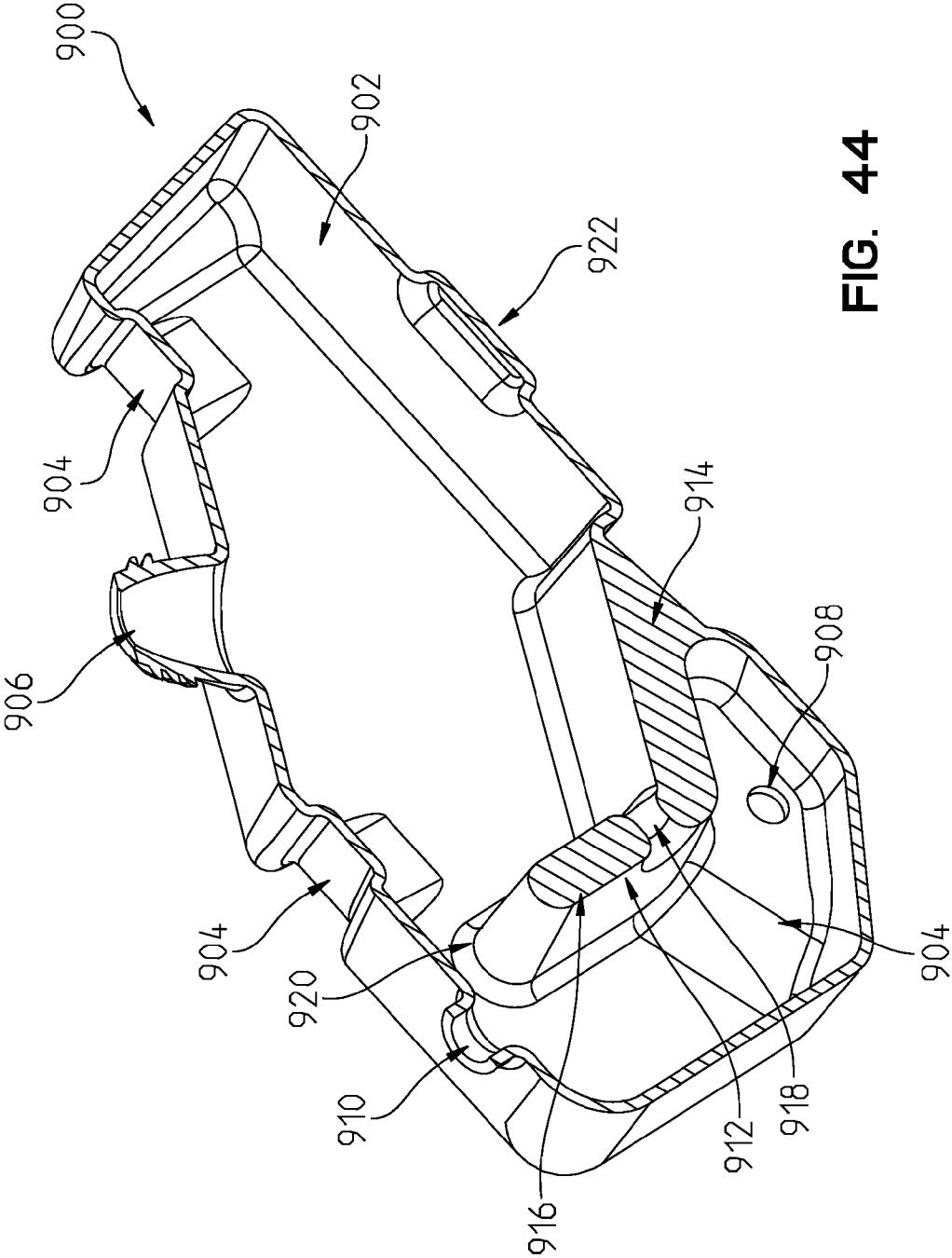


FIG. 44

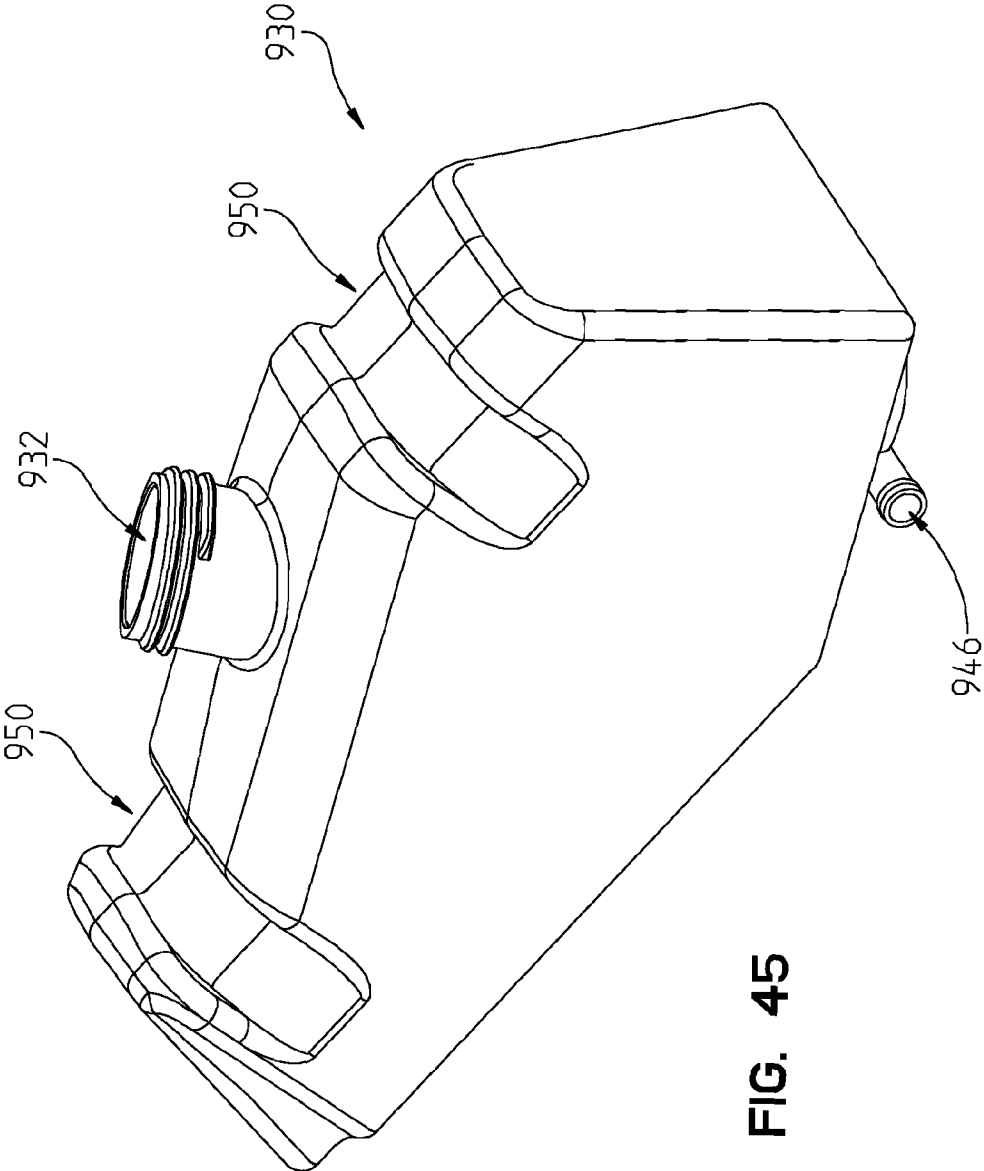


FIG. 45

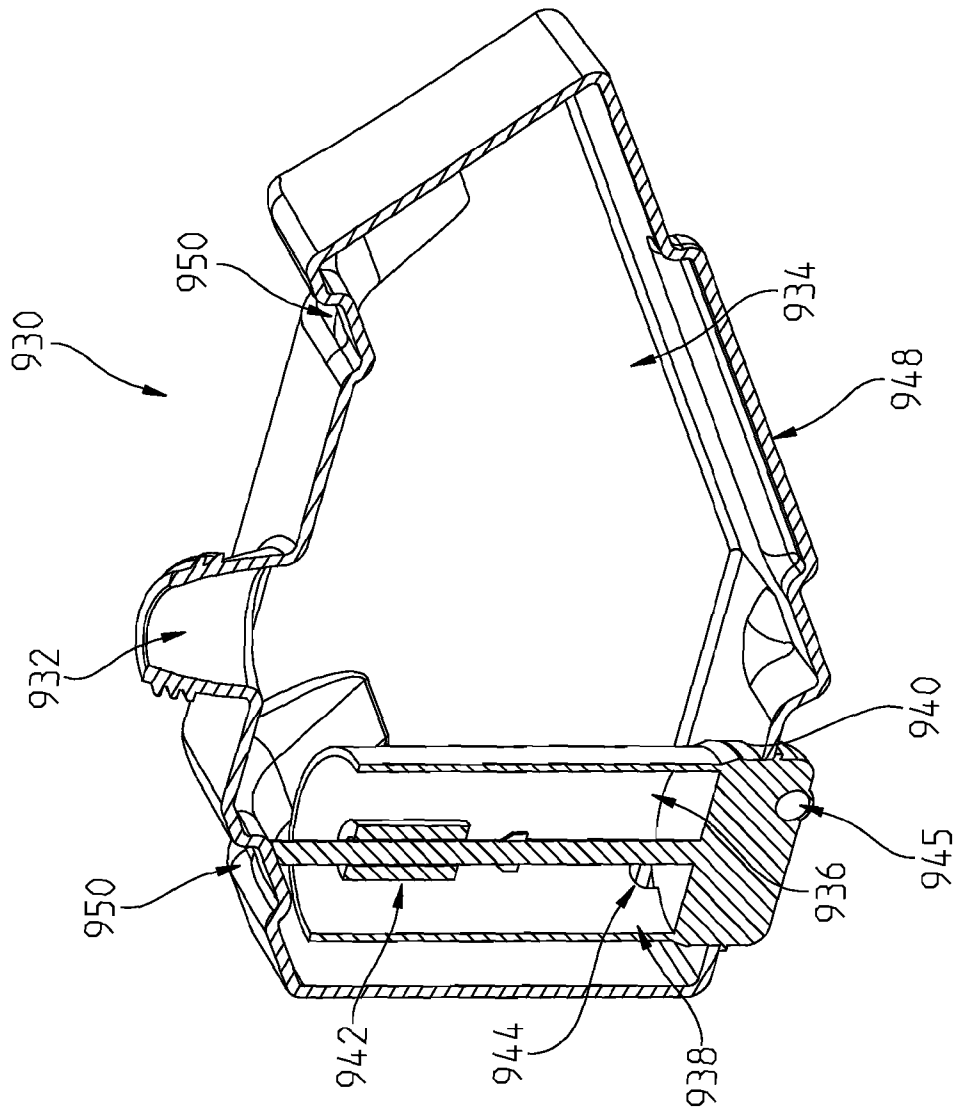


FIG. 46

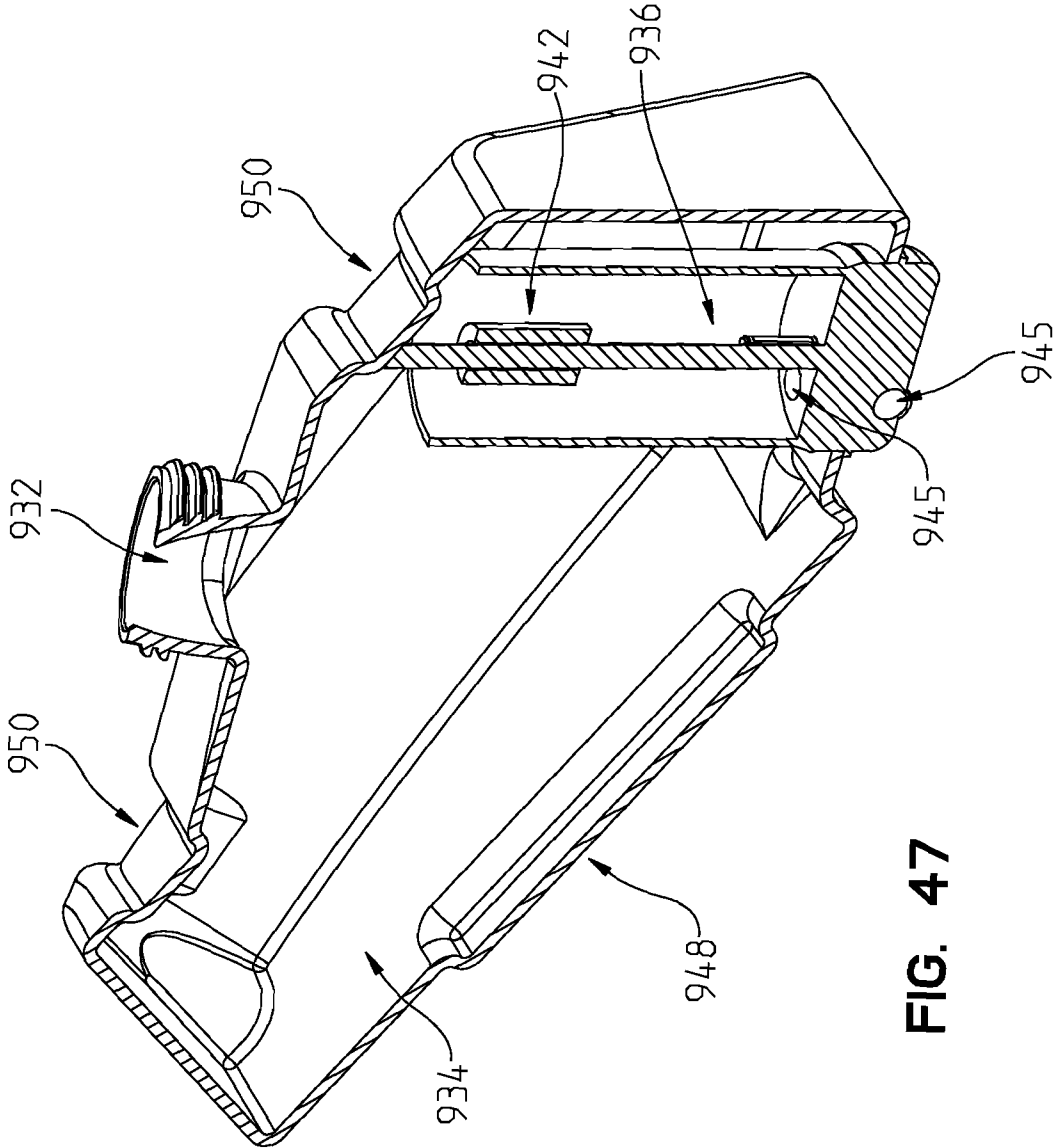


FIG. 47

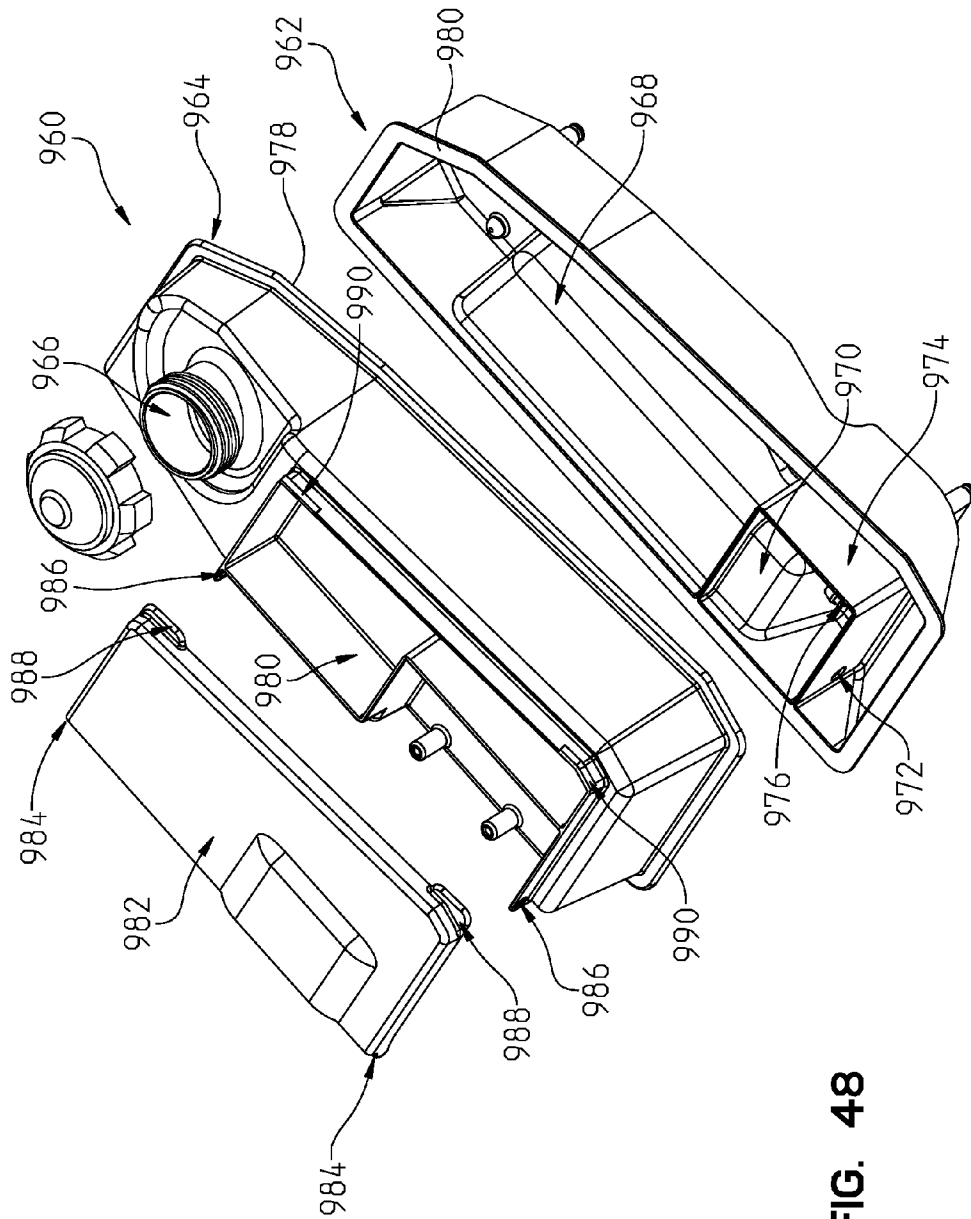


FIG. 48

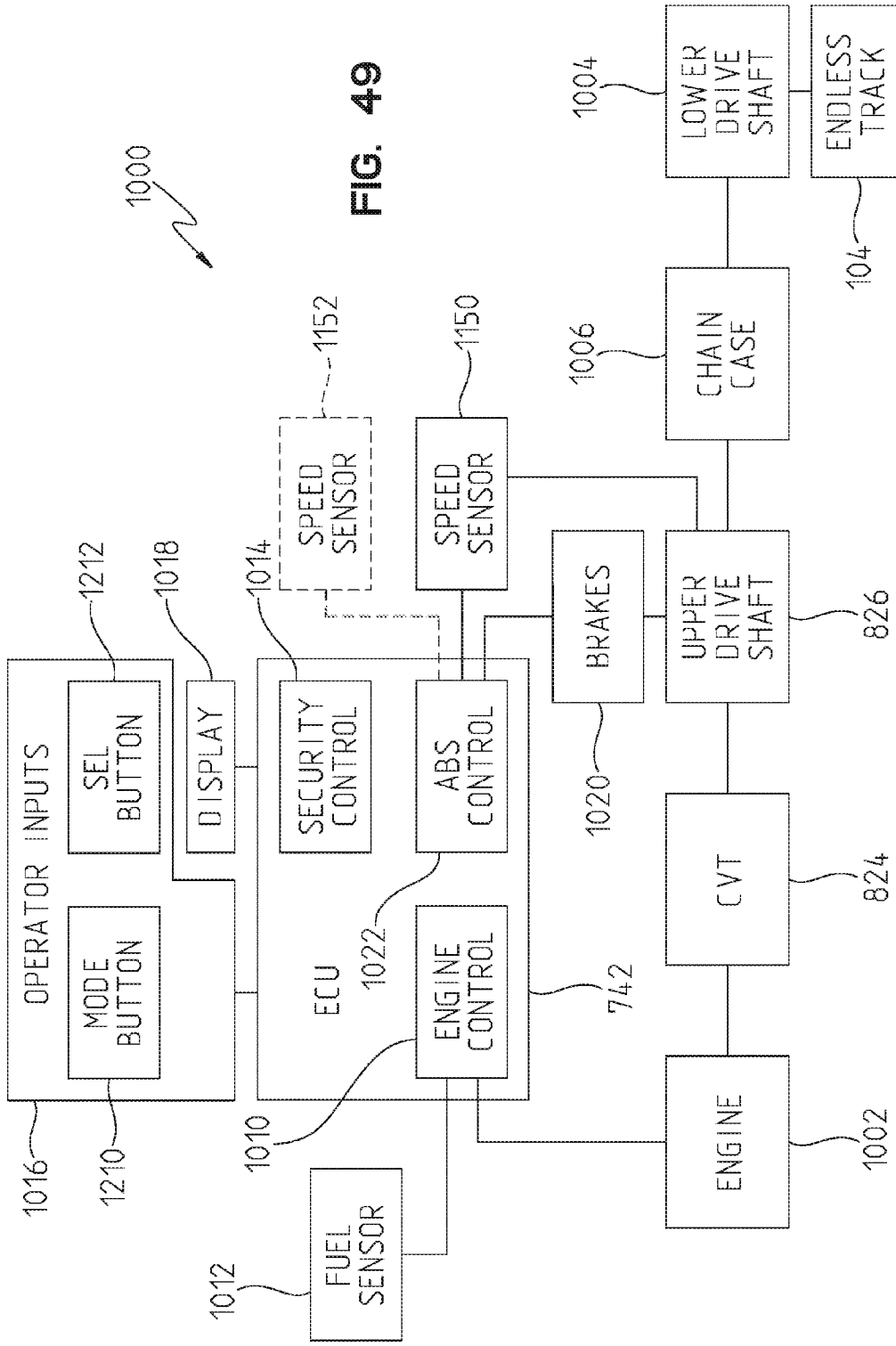


FIG. 49

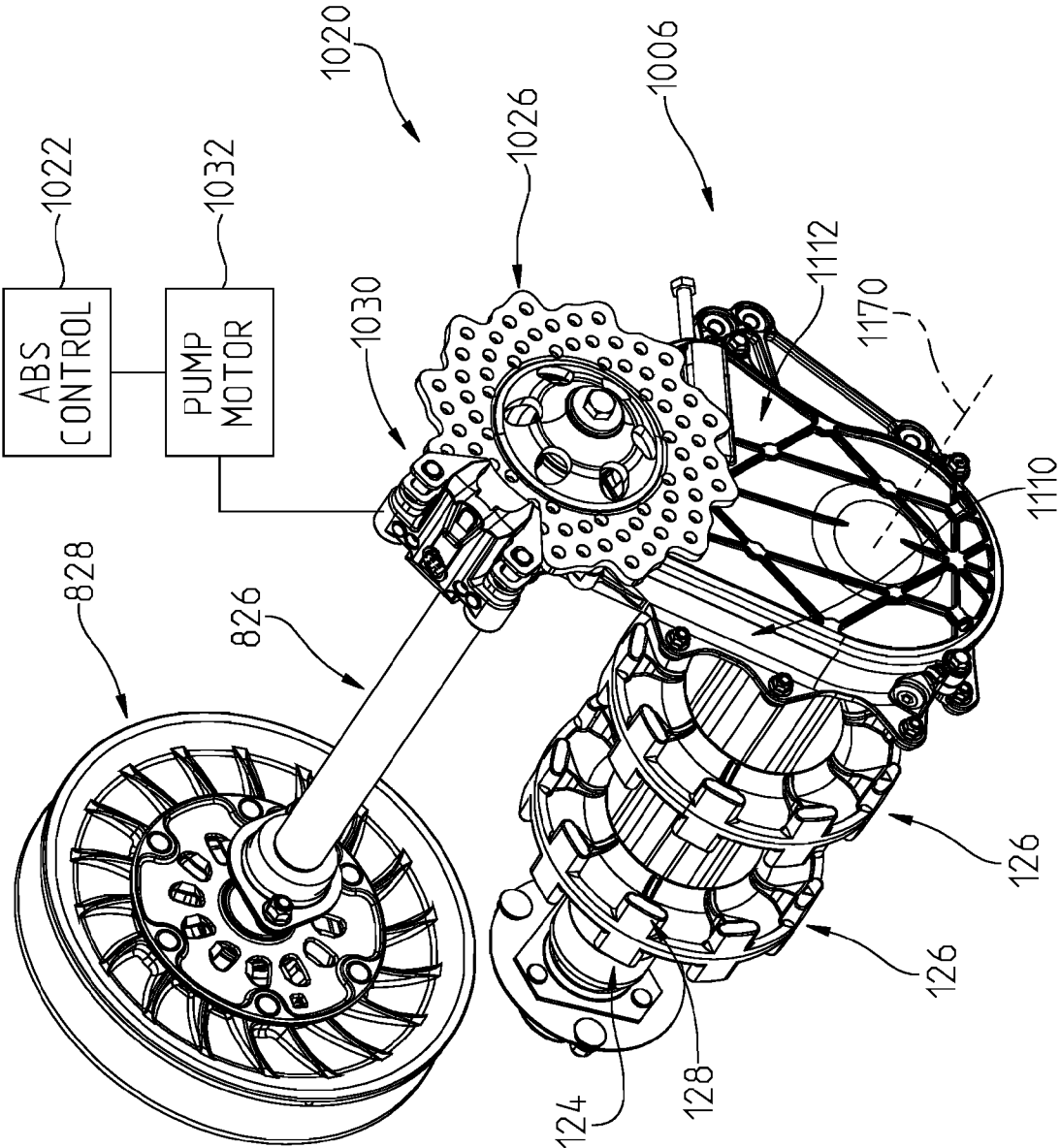


FIG. 50

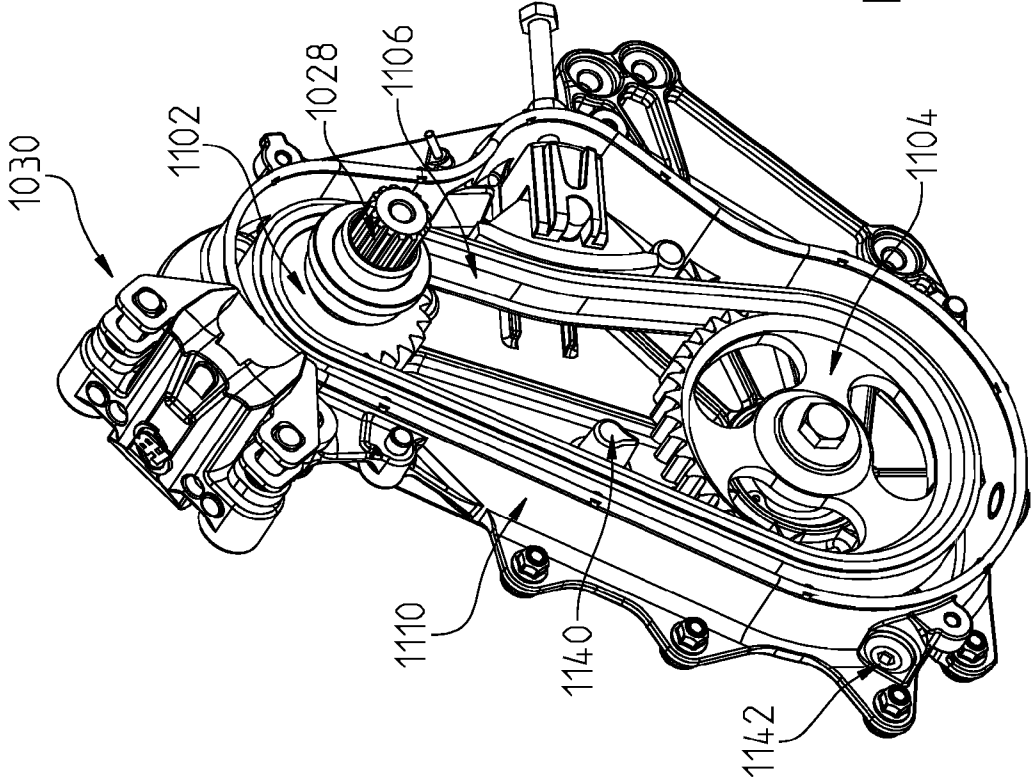


FIG. 51

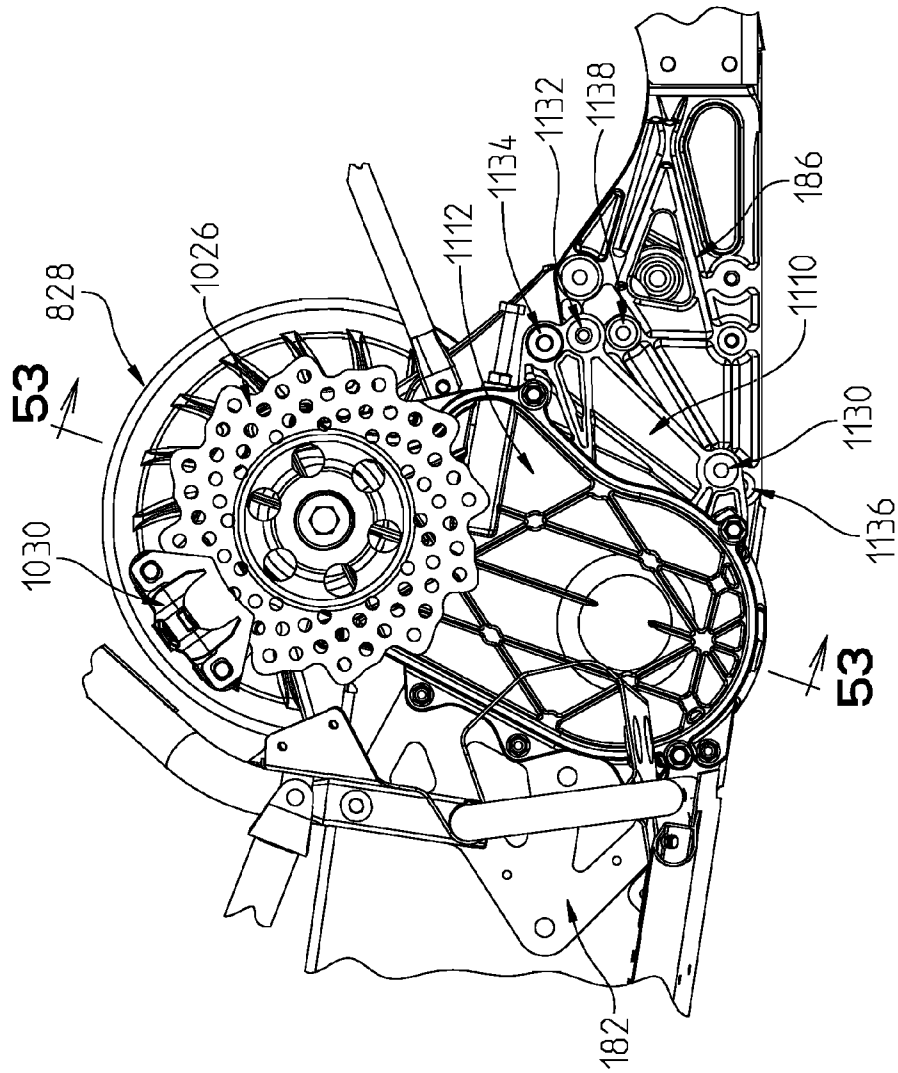


FIG. 52

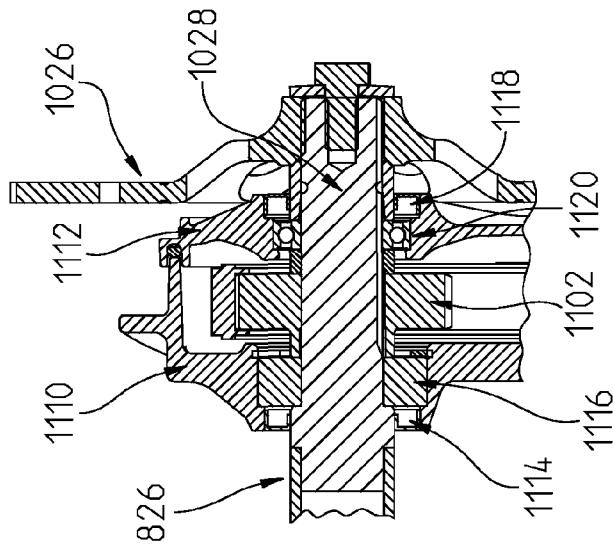


FIG. 53

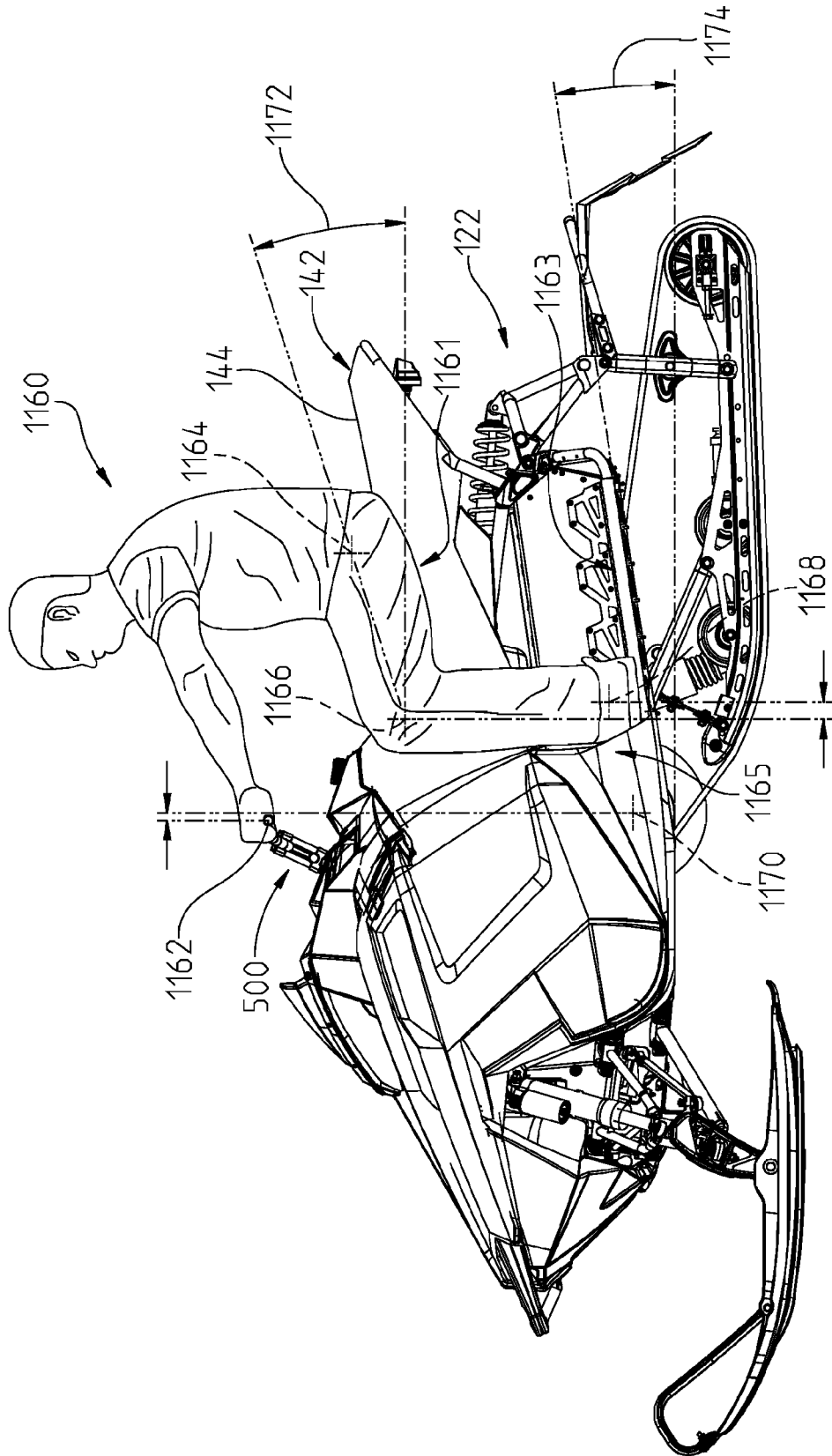


FIG. 54

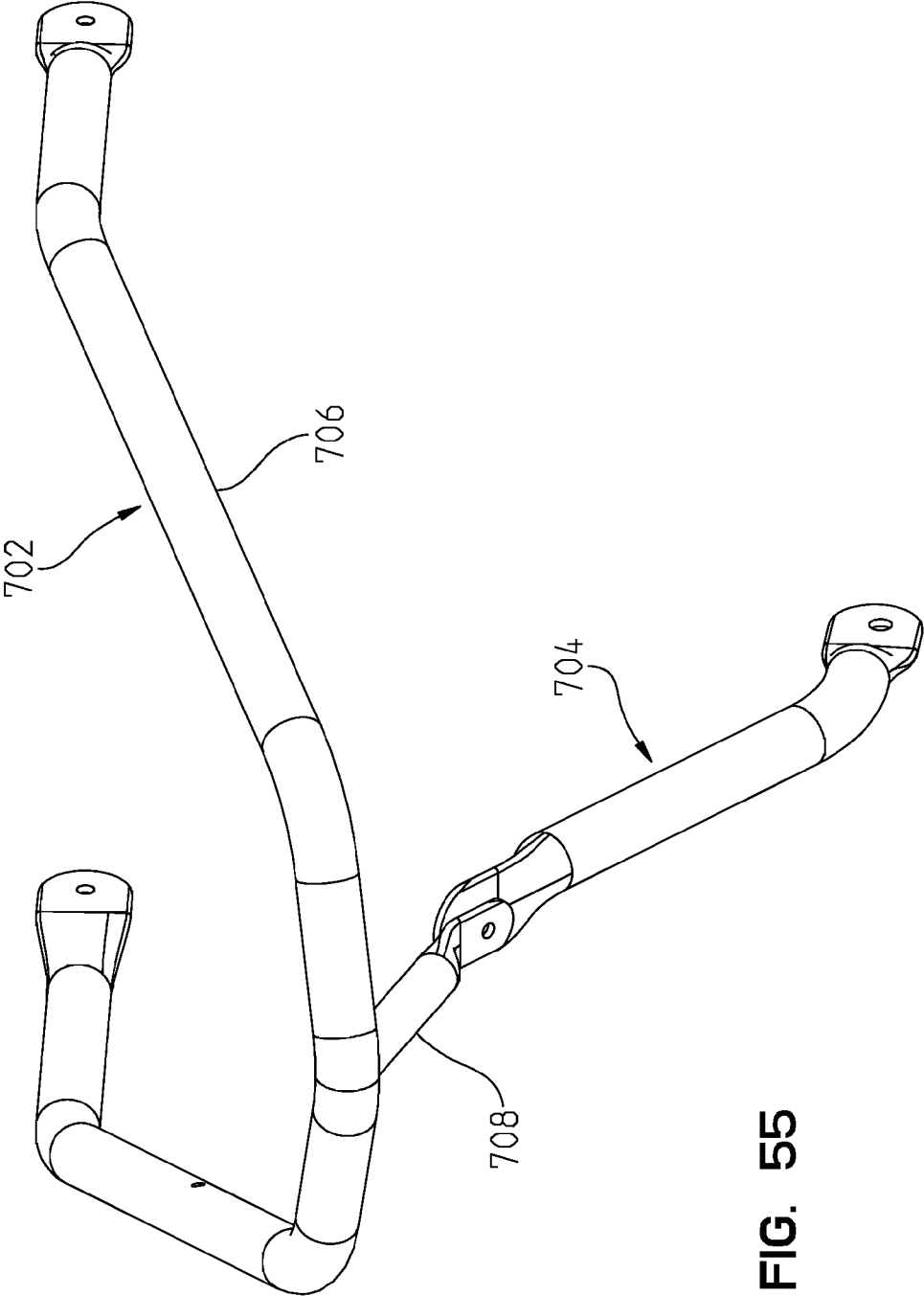


FIG. 55

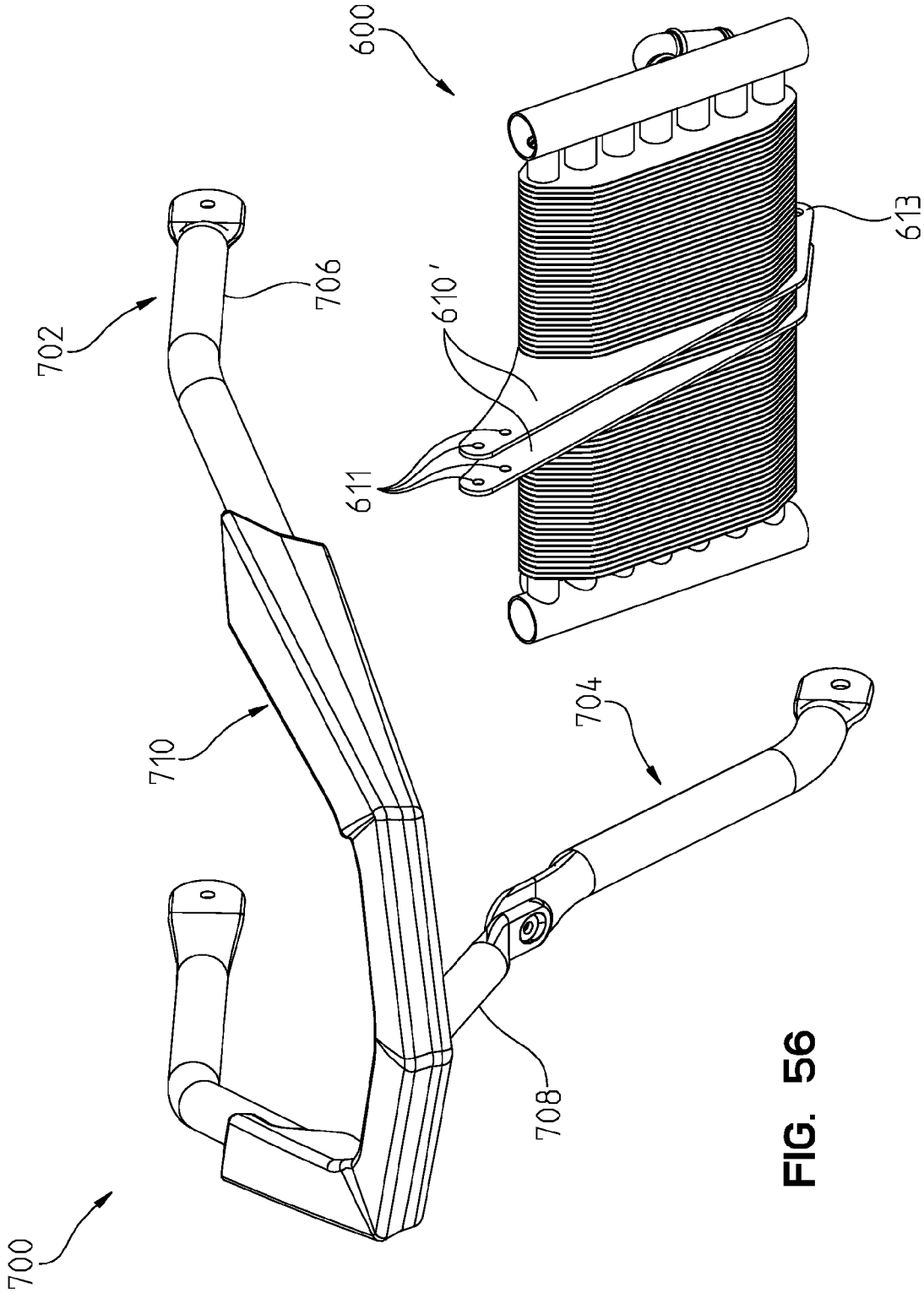
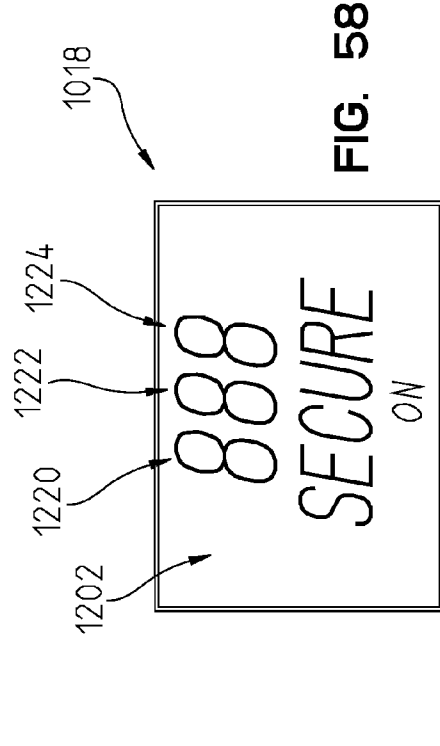
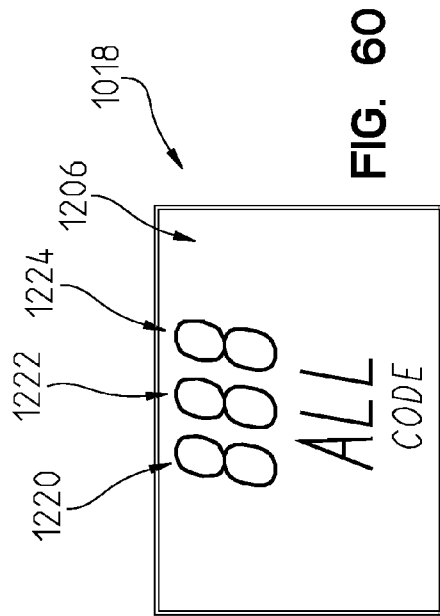
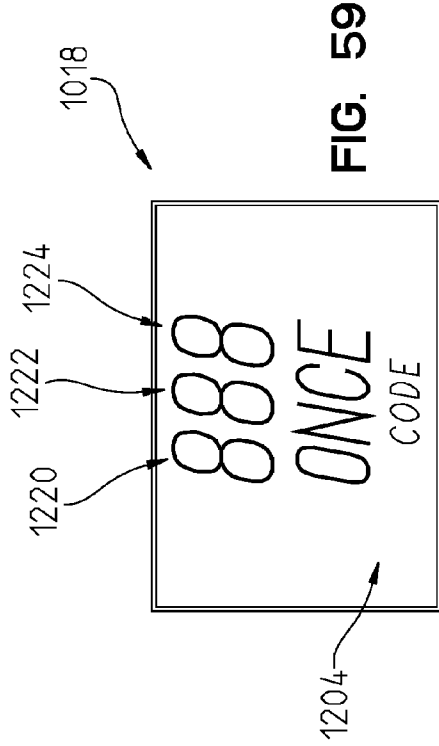
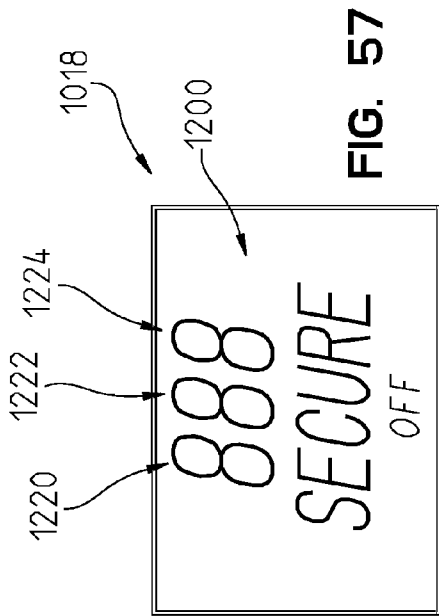


FIG. 56



INSTRUMENT CLUSTER SECURITY SYSTEM

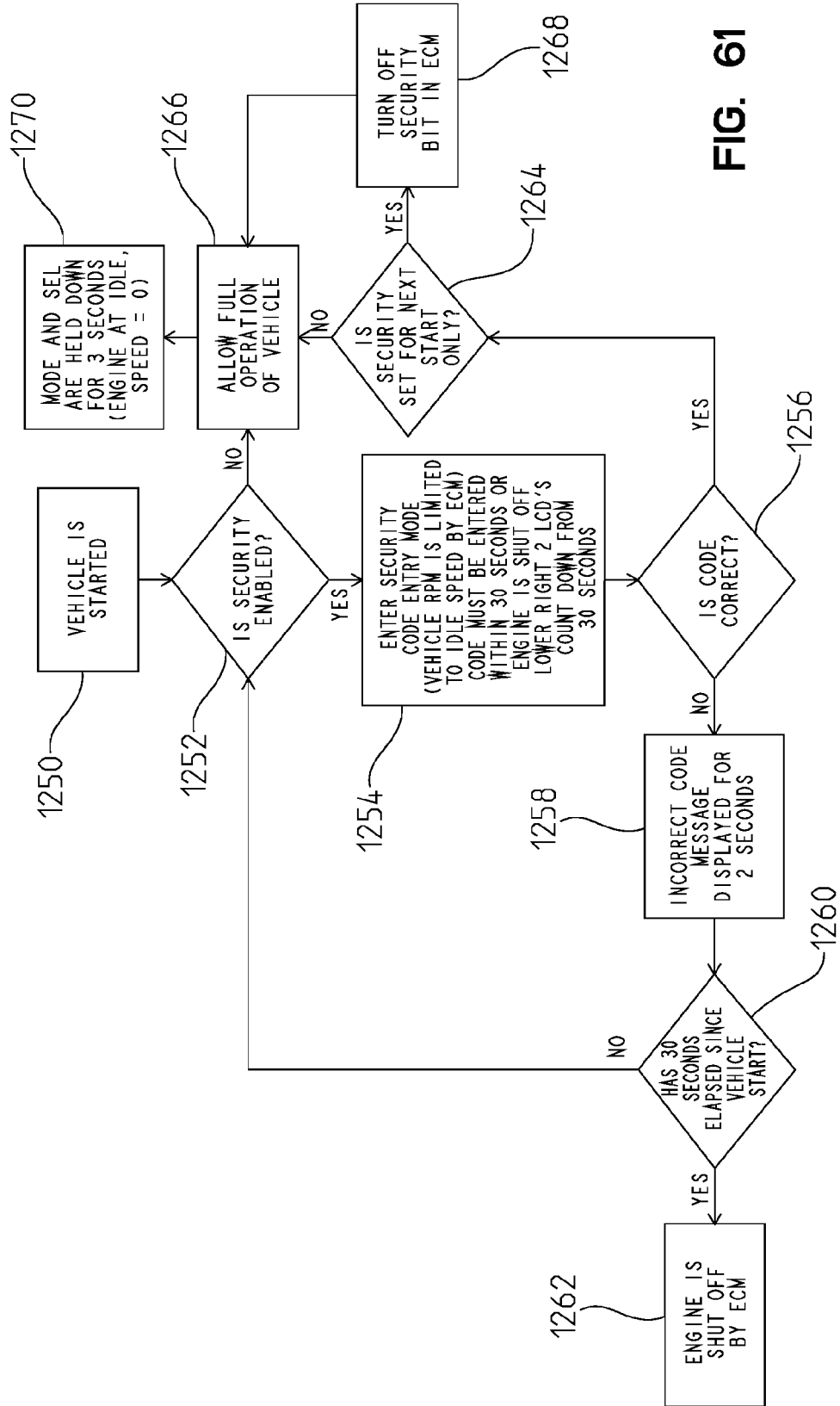


FIG. 61



# 1

## SNOWMOBILE

This application is a continuation of U.S. patent application Ser. No. 12/736,073 filed Sep. 7, 2010 now abandoned; which is an application claiming priority under 35 USC §371 of PCT application number PCT/US2009/036315 filed Mar. 6, 2009, which in turn claimed priority from U.S. Patent Application Ser. No. 61/104,436 filed Oct. 10, 2008 and Ser. No. 29/301,572 filed Mar. 7, 2008, the subject matter of which are all incorporated herein by reference.

### BACKGROUND

The present invention relates to various systems for snowmobiles.

Performance characteristics of snowmobiles, including the comfort of the ride, depend on a variety of systems and components, including the snowmobile suspension. Typically, a snowmobile suspension includes two systems, a front suspension system for a pair of skis and a rear suspension system for the track.

The rear suspension of a snowmobile supports an endless track driven by the snowmobile engine to propel the machine. The track is supported beneath a vehicle chassis by a suspension that is designed to provide a comfortable ride and to help absorb the shock of the snowmobile crossing uneven terrain. Most modern snowmobiles use a slide rail suspension which incorporates a pair of slide rails along with several idler wheels to support the track in its configuration. The slide rails are typically suspended beneath the chassis by a pair of suspension arms, with each arm being attached at its upper end to the chassis of the snowmobile, and at its lower end to the slide rails. The mechanical linkage of the slide rails to the suspension arms and to the snowmobile chassis typically is provided by springs and at least one element acting along a linear path, such as a shock absorber, damper, air shock, shock and spring combination.

The front suspension is typically provided by upper and control arms which pivot relative to the front portion of the frame at an inner end, and connect to the skis at an outer end.

### SUMMARY

In one embodiment, a vehicle comprises a frame, a plurality of ground engaging members including one or more front ground engaging members supporting a front portion of the frame and one or more rear ground engaging members supporting a rear portion of the frame. A power train system is supported by the frame and operatively coupled to at least one of the plurality of ground engaging members. A straddle seat is supported by the frame, and a steering assembly is operatively coupled to at least the one or more front ground engaging members to orient the one or more front ground engaging members. The frame includes first and second metallic frame members, the first frame metallic member being coupled to the second frame member through a structural adhesive.

In another illustrative embodiment, a method of assembling a snowmobile frame comprises the steps of receiving a first frame member of the snowmobile and a second frame member of the snowmobile; positioning the first frame member of the snowmobile relative to the second frame member of the snowmobile; joining the first frame member of the snowmobile to the second frame member of the snowmobile with a mechanical coupler which passes through an opening in at least one of the first frame member of the snowmobile and the second frame member of the snowmobile; and securing the

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first frame member of the snowmobile to the second frame member of the snowmobile with a structural adhesive.

### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 illustrates a front, left, perspective view of an exemplary snowmobile;

FIG. 2 illustrates a front, right, perspective view of the exemplary utility vehicle of FIG. 1;

FIG. 3 illustrates a rear, left, perspective view of the exemplary snowmobile of FIG. 1;

FIG. 4 illustrates a rear, right, perspective view of the exemplary snowmobile of FIG. 1;

FIG. 5 illustrates a front view of the exemplary snowmobile of FIG. 1;

FIG. 6 illustrates a left side view of the exemplary snowmobile of FIG. 1;

FIG. 7 illustrates a right side view of the exemplary snowmobile of FIG. 1.

FIG. 8 illustrates a rear view of the exemplary snowmobile of FIG. 1;

FIG. 9 illustrates a top view of the exemplary snowmobile of FIG. 1;

FIG. 10 illustrates a perspective view of a frame of the exemplary snowmobile of FIG. 1 along with several components supported by the frame;

FIG. 11A illustrates an exemplary seat frame bracket and an exemplary seat cushion;

FIG. 11B illustrates another exemplary seat frame bracket and another exemplary seat cushion;

FIG. 12 illustrates a perspective view of another frame of the exemplary snowmobile of FIG. 1 along with several components supported by the frame;

FIG. 13 illustrates a top view of the assembly of FIG. 10;

FIG. 14 illustrates a side view of a portion of the assembly of FIG. 10;

FIG. 15 illustrates a portion of the frame of FIG. 10 including a left front clip casting, a left side casting, a right side casting, a floor portion extending therebetween, a left side bulkhead, and a right side bulkhead, and a tunnel front member which also provides a cooler unit for the cooling system of the exemplary snowmobile of FIG. 1;

FIG. 16 illustrates an independent front suspension assembled to a portion of the frame of FIG. 10 including a left front clip casting, a right front clip casting;

FIG. 17 illustrates a connection of a left lower control arm of the front suspension and a right lower control arm of the front suspension to the frame; along lines 17-17 in FIG. 16;

FIG. 18 illustrates a top view of the assembly of FIG. 16;

FIG. 19 illustrates a lower, left, perspective view of the assembly of FIG. 16;

FIG. 20 illustrates a cross-section of an exemplary shock of the front suspension of FIG. 16;

FIG. 21 illustrates a perspective view of a steering assembly of the exemplary snowmobile of FIG. 1;

FIG. 22 illustrates a top perspective view of the steering assembly of FIG. 21 assembled to the frame of the exemplary snowmobile of FIG. 1;

FIG. 23 illustrates a front, perspective view of an over structure of the frame;

FIG. 23A illustrates an adhesive joint provided between two components of the over structure of FIG. 23;

FIG. 24 illustrates a rear, perspective view of the over structure of FIG. 23;

FIG. 25 illustrates the assembly of stiffener members into the over structure of FIG. 23;

FIG. 26 illustrates the positioning of a lower portion of the steering assembly and the front suspension relative to the front clip of the exemplary snowmobile of FIG. 1;

FIG. 27 illustrates a perspective view of the positioning of the steering assembly relative to the front clip of the exemplary snowmobile of FIG. 1;

FIG. 28 illustrates a perspective view of the positioning of a portion of an exhaust system relative to the front clip of the exemplary snowmobile of FIG. 1;

FIG. 29 illustrates an exploded view of a portion of the assembly of FIG. 28;

FIG. 30 illustrates a front bumper of the exemplary snowmobile of FIG. 1;

FIG. 31 illustrates the front bumper of FIG. 30 coupled to the front clip of the exemplary snowmobile of FIG. 1;

FIG. 32 illustrates a representation of a cooling system for the power source of the exemplary snowmobile of FIG. 1;

FIG. 33 illustrates a sectional view of a center cooler of the cooling system of FIG. 32;

FIG. 34 illustrates an air intake system and a control unit of the exemplary snowmobile of FIG. 1;

FIG. 35 illustrates the assembly of FIG. 34 exploded;

FIG. 36 illustrates the placement of a divider between an upper air box housing and a lower air box housing of the air intake system of FIG. 34;

FIG. 37 illustrates a partial view of the air box tower of the air intake system of FIG. 34;

FIG. 38 illustrates a fuel intake assembly of the exemplary snowmobile of FIG. 1;

FIG. 39 illustrates an exemplary oil container and clutch guard of the exemplary snowmobile of FIG. 1;

FIG. 40 illustrates exemplary locators of the oil container and the clutch guard of FIG. 39;

FIG. 41 illustrates a partial view of the oil container of FIG. 39 through a center plane of the oil container;

FIG. 42 illustrates a side view of the view of FIG. 41;

FIG. 43 illustrates a section view of the oil container of FIG. 39 along line 43-43 in FIG. 42;

FIG. 44 illustrates a partial view of another exemplary oil container through a center plane of the oil container;

FIG. 45 illustrates a perspective view of a further exemplary oil container;

FIG. 46 illustrates a right, partial, perspective view of the oil container of FIG. 45 through a center plane of the oil container;

FIG. 47 illustrates a left, partial, perspective view of the oil container of FIG. 45 through a center plane of the oil container;

FIG. 48 illustrates an exploded, assembly view of still another exemplary oil container;

FIG. 49 illustrates a representation of the power train of the exemplary snowmobile of FIG. 1;

FIG. 50 illustrates a perspective view of a portion of the power train of FIG. 49;

FIG. 51 illustrates a chain case of the assembly of FIG. 50 having a cover removed;

FIG. 52 illustrates a side view of the assembly of FIG. 50 positioned relative to the frame of the exemplary snowmobile of FIG. 1;

FIG. 53 illustrates a sectional view of an upper drive shaft along lines 53-53 in FIG. 52;

FIG. 54 illustrates an operator positioned on the vehicle of FIG. 1;

FIG. 55 illustrates an exemplary metal front bumper;

FIG. 56 illustrates the metal front bumper of FIG. 55 having an overmolded component coupled thereto;

FIG. 57 illustrates a first exemplary display screen of a vehicle display;

FIG. 58 illustrates a second exemplary display screen of a vehicle display;

FIG. 59 illustrates a third exemplary display screen of a vehicle display;

FIG. 60 illustrates a fourth exemplary display screen of a vehicle display; and

FIGS. 61 and 62 illustrate an exemplary flow chart for a vehicle security system of the vehicle of FIG. 1.

Corresponding reference characters indicate corresponding parts throughout the several views. Unless stated otherwise the drawings are proportional with the exception of the flowcharts and block representations.

#### DETAILED DESCRIPTION

The embodiments disclosed below are not intended to be exhaustive or to limit the invention to the precise forms disclosed in the following detailed description. Rather, the embodiments are chosen and described so that others skilled in the art may utilize their teachings. While the present disclosure is primarily directed to a snowmobile, it should be understood that the features disclosed herein may have application to other types of vehicles such as all-terrain vehicles, motorcycles, watercraft, utility vehicles, and golf carts.

Referring to FIG. 1, an illustrated embodiment of vehicle 100 is shown. The illustrated vehicle 100 is a snowmobile. However, the following disclosure is applicable to other types of vehicles such as all terrain vehicles, motorcycles, watercraft, utility vehicles, and golf carts. Vehicle 100 as illustrated includes a plurality of ground engaging members 102. Illustratively, ground engaging members 102 include an endless track assembly 104 and a pair of front skis 106a and 106b. Endless track assembly 104 supports a rear portion of vehicle 100 while skis 106 support a front portion of vehicle 100. Further, endless track assembly 104 is operatively coupled to an engine 108 (see FIG. 49).

Referring to FIG. 10, vehicle 100 includes a frame 110. Frame 110 includes a front frame portion 112 which is generally supported by skis 106. Frame 110 further includes a middle frame portion 114 which generally supports engine 108. Frame 110 further includes a rear portion 116 which is generally supported by endless track assembly 104. Front frame portion 112 is coupled to skis 106a and 106b through respective front suspensions 120a and 120b. Front suspensions 120a and 120b permits the relative movement of frame 110 relative to skis 106. In general, front suspension 120b is a mirror image of front suspension 120a.

Referring to FIG. 3, frame 110 is supported by endless track assembly 104 through a rear suspension 122 and a drive shaft 124 (see FIG. 50). Drive shaft 124 includes a pair of drive sprockets 126 which have a plurality of teeth 128 to engage and move endless track belt 130 of endless track assembly 104. Additional details regarding the structure and operation of rear suspension 122 and the connection between rear suspension 122 and frame 110 are provided in U.S. patent application Ser. No. 11/623,873, published under Publication No. 2007-0199753, filed Jan. 17, 2007, titled SNOWMOBILE FRAME ASSEMBLY; U.S. patent application Ser. No. 11/623,879, published under Publication No. 2007-0221424, filed Jan. 17, 2007, titled SNOWMOBILE REAR SUSPENSION; and U.S. patent application Ser. No. 11/710,177, published under Publication No. 2007-0246283, filed Feb. 23, 2007, titled SNOWMOBILE DRIVE ASSEMBLY, the disclosures of which are expressly incorporated by reference herein.

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As shown generally in FIGS. 3, 6, and 7, rear frame portion 116 includes a generally U-shaped tunnel 132 which covers a front portion 133 of endless track assembly 104. A rear portion 134 of endless track assembly 104 extends beyond the rear of tunnel 132. The rear of tunnel 132 is indicated in FIG. 6 by line 136.

Referring to FIG. 12, an alternative rear portion 116' of frame 110 is shown. Rear portion 116' includes an elongated tunnel 132' which generally covers an entire endless track assembly. Rear frame portion 116' is intended for use with a traditional rear snow mobile suspension, such as the Polaris Fusion rear suspension illustrated in FIG. 1 of U.S. patent application Ser. No. 11/623,879, published under Publication No. 2007-0221424, filed Jan. 17, 2007, titled SNOWMOBILE REAR SUSPENSION, the disclosure of which is incorporated by reference herein.

Returning to FIG. 10, rear portion 116 of frame 110 supports a seat bracket 140 which supports and couples a seat 142 shown in FIG. 1. In one embodiment, seat 142 is coupled to portion 147 of seat bracket 140 through couplers, such as screws, bolts, or other fasteners. Seat 142 includes a seating surface 144 upon which the operator of vehicle 100 is supported. A rear portion of seat 142 is supported by a rear seat support bracket 146. Referring to FIG. 6, rear seat support bracket 146 is coupled to rear frame portion 116 through a mounting bracket 150.

Mounting bracket 150 also couples seat bracket 140 to rear frame portion 116 as well as a portion of rear suspension 122 to rear frame portion 116. As shown in FIG. 6, rear seat support bracket 146 is coupled to mounting bracket 150 forward of the end of tunnel 132 as indicated by line 136. Further, rear seat support bracket 146 supports seat 142 beyond the end of tunnel 132 as indicated by line 136. In addition, rear seat support bracket 146 also provides a mounting location for tail light 148.

Referring to FIG. 11B, another rear seat support bracket 152 is shown which may be coupled to mounting bracket 150. Rear seat support bracket 152 is elongated relative to rear seat support bracket 146 which is shown FIG. 11a. The additional length of rear seat support bracket 152 accommodates an elongated seat 154 having a seating surface 156. Seat 154 is coupled to seat bracket 140 and portion 153 of rear seat support bracket 152. Rear seat support bracket 152 also includes a plurality of attachment bars 158 which permit the attachment of bungees or other cargo securing means to rear seat support bracket 152. In one embodiment, either rear seat support bracket 146 or rear seat support bracket 152 includes openings sized to cooperate with expansion retainers to couple cargo or cargo carrying devices to their respective rear seat support bracket 146 or rear seat support bracket 152. Additional details regarding expansion retainers and the openings to which they couple are provided in U.S. Pat. No. 7,055,454, to Whiting et al., filed Jul. 13, 2004, titled "Vehicle Expansion Retainers," the disclosure of which is expressly incorporated by reference herein.

Returning to FIG. 6, a rear bumper 164 is coupled to rear suspension 122. As shown in FIG. 6, rear suspension 122 includes an upper portion 160 which is rotatably coupled to mounting bracket 150 at a location 162. Location 162 corresponds to an axis of rotation extending out of the page of FIG. 6. Upper portion 160 is also rotatably coupled to a linear force element 170 at a location 172. Location 172 corresponds to an axis of rotation extending out of the page of FIG. 6. Rear suspension 122 further includes a lower portion 166 coupled to slide rails 168 at the location 169. Location 169 corresponds to an axis of rotation extending out of the page of FIG. 6. As known in the art slide rails 168 and idler wheels 170 are

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provided inside endless belt 130 and generally maintain endless belt 130 in its proper configuration and tension relative to driveshaft 126. Upper portion 160 of rear suspension 122 is rotatably coupled to lower portion 166 of rear suspension 122 at a location 174. Location 174 corresponds to an axis of rotation extending out of the page of FIG. 6.

As stated herein, rear bumper 164 is coupled to rear suspension 122 and extends rearward from rear suspension 122. In the illustrated embodiment rear bumper 164 is coupled to lower portion 166 of rear suspension 122 at a location 176 which is generally between the rotatable axis 162 and the rotation axis 169. As best shown in FIG. 3, rear bumper 164 moves with lower portion 166 of rear suspension 122.

A flexible snow deflector 180 is shown in FIG. 6. Snow deflector 180 has a first portion 179 which extends from location 162 to location 174, a second portion 181 which extends from location 174 generally out past the end of rear bumper 164, and a third portion 183 which is angled down relative to second portion 181. In one embodiment, first portion 179, second portion 181, and third portion 183 are a single component. In one embodiment, one or more of first portion 179, second portion 181, and third portion 183 are separate from the remainder of first portion 179, second portion 181, and third portion 183.

Snow deflector 180 may be coupled to locations 162 and 174 in any suitable manner. In one example, ties may be provided to couple snow deflector 180 to cross members extending over endless track belt 130. In another example, snow guard 180 includes clips or passageways which receive a portion of the cross members extending over endless track belt 130. Second portion 181 of snow deflector 180 may be coupled to rear bumper 164 through ties to keep snow deflector 180 spaced apart from endless belt 130.

Flexible snow deflector 180 is generally coupled to frame 110 at the rear of tunnel 132 and is coupled to upper portion 165 of rear bumper 164. In one embodiment, snow deflector 180 is a flexible snow flap. Snow deflector 180 moves with rear bumper 164 as rear suspension 122 is compressed or extended during the operation of vehicle 100.

Referring to FIG. 14, mid-frame portion 114 of frame 110 includes a bulkhead member 181 and a bulkhead head member 182 (See FIG. 52) which are coupled to tunnel 132 on the left side and the right side of vehicle 100, respectively. Middle frame portion 114 further includes a left side bulkhead member 184 and right side bulkhead member 186 (See FIG. 15). Bulkhead members 184 and 186 are coupled to respective bulkhead members 181 and 182. In one embodiment, bulkhead members 184 and 186 are cast components. As explained herein, these cast components include mounting locations for other frame members and components of vehicle 100. Referring to FIG. 15, mid-frame portion 114 of frame 110 further includes a floor member 188 which is coupled to and extends between cast members 184 and 186. Floor member 188 is coupled along its rearward edge to a front cooler unit 190 as shown in FIG. 33.

Front cooler unit 190 serves as a structural component of frame 110. Referring to FIG. 33 front cooler 190 provides a front portion of tunnel 132. Front cooler 190 includes a first fluid conduit 192 which is in fluid communication with a fluid conduit 194 internal to front cooler 190. Front cooler 190 further includes a second fluid conduit 196 which is in fluid communication with a second internal fluid conduit 198 of front cooler 190. Front cooler 190 further includes a third internal fluid conduit 199. Fluid flows through front cooler 190 from one of first fluid conduit 192 and second fluid conduit 196 to the other of first fluid conduit 192 and second fluid conduit 196 by way of fluid conduits 194, 198, and 199.

In one embodiment, front cooler 190 is a part of a cooling system 630 of vehicle 100, represented in FIG. 32. Referring to FIG. 32, cooling system 630 includes a front radiator 600, front tunnel cooler 190, and a top tunnel cooler 191. Warmed cooling fluid from engine 108 is circulated through front radiator 600, front tunnel cooler 190, and a top tunnel cooler 191 to be cooled and then is provided back to engine 108. Front tunnel cooler 190 and top tunnel cooler 191 mainly cool the fluid due to snow present in tunnel 132 during operation. However, sometimes the amount of snow brought into contact with front cooler 190 and top cooler 191 is not sufficient to cool the fluid. Front radiator 600 cools the fluid due to air passing therethrough. As such, front radiator 600 and the coolers 190 and 191 combine to cool the fluid in most riding environments. Exemplary front radiators are discussed herein.

Returning to the frame 110 and FIG. 18, floor member 188 is further coupled along its front portion to a left side cast clip member 200 of front frame portion 112 and a right side clip member 202 of front frame portion 112. Referring to FIG. 15, left side cast clip member 200 is further coupled to left bulkhead member 184 through a plurality of couplers (not shown), such as bolts. In a similar manner, right side cast clip member 202 is coupled to right bulkhead member 186.

Referring to FIG. 19, left side cast clip member 200 is coupled to right side cast clip member 202 at first lower location 220 and a second lower location 222 by respective couplers (not shown), such as bolts. Referring to FIG. 16, left side cast clip member 200 and right side cast clip member 202 are further coupled together at locations 224 and 226 through respective couplers (not shown), such as bolts. As discussed herein in relation to FIG. 17, left side cast clip member 200 and right side cast clip member 202 are further coupled together through a connection that also couples a portion of left side front suspension 120A and right side front suspension 120B to the respective left side cast clip member 200 and right side cast clip member 202.

Referring to FIG. 23 an overstructure 230 is shown which is coupled to frame 110 as shown in FIG. 10. Overstructure 230 includes an upper mount member 232 which as shown in FIG. 24 provides mounting for an upper steering post 234 of a steering assembly 236 (see FIG. 21) of vehicle 100. Coupled to a front side of upper mounting member 232 are two tubular components 238 and 240. Tubular components 238 and 240 are mounted to mounting lugs 242 and 244, respectively. Mounting lugs 242 and 244 are further coupled to left side cast clip member 200 at location 246 (see FIG. 16) and right side cast clip member 202 at location 248 (see FIG. 16), respectively. Two tubular members 250 and 252 are coupled to upper mounting member 232 on the rear side of mounting member 232 as shown in FIG. 24. Tubular components 250 and 252 are further coupled to mounting components 254 and 256 which are coupled to rear frame portion 116 of frame 110 as shown in FIG. 14.

The various connections between frame members may be made by traditional mechanical couplings such as bolts, welds and screws and other types of fasteners. In one embodiment, at least a portion of the connections between the various frame members are made at least in part with a structural adhesive. In the illustrated embodiment the connection between mounting lug 244 and tubular component 240 is made at least in part with a structural adhesive.

Referring to FIG. 23A, the joint between mounting lug 244 and tubular component 240 is shown. Mounting lug 244 includes a recess 260. In one embodiment, recess 260 is a part of component 240 as opposed to mounting lug 244. Regardless component 240 and mounting lug 244 cooperate to define

an adhesive cavity 262 into which an adhesive 261 may be introduced through a port 264 in mounting lug 244. The adhesive cavity 262 is bounded on the one end by a lip 266 which shuts off the axial end of adhesive cavity 262. Component 240 and mounting lug 244 are secured together through the use of mechanical fasteners 270 which are received in openings 272 in mounting lug 244. In one embodiment, fasteners 270 are self piercing rivets which pierce through component 240 and secure the location of component 240 relative to mounting lug 244. In the illustrated embodiment, adhesive cavity 262 circumscribes component 240. As illustrated, adhesive cavity 262 includes two ports 264 into which the adhesive may be introduced. The use of two ports provides for more uniform filling of adhesive cavity 262 with the adhesive 261. In one embodiment, a single adhesive port 264 is provided. In another embodiment three or more adhesive ports 264 are provided.

By having adhesive cavity 262 circumscribe component 240 a width of the joint formed by adhesive component 262 is maximized. In general, increasing a width of the joint formed by an adhesive 261 provides a greater increase in joint strength than increasing a length of the joint provided by adhesive 261. In one embodiment, tubular component 240 is an extruded tube. In one embodiment, tubular component 240 is a drawn tube. In general, the joint strength when component 240 is a drawn tube has been found to be about 10 percent stronger than the joint strength when component 240 is an extruded tube. In addition the thickness of adhesive cavity 262 relates to the strength of the joint formed by adhesive 261. If the thickness is too thin the resulting joint may be too weak. If the thickness is too great the resulting joint may not properly transfer the load from component 240 and mounting lug 244 to the other of component 240 and mounting lug 244. In one embodiment, the thickness of adhesive cavity 262 is in the range of about 0.25 millimeters (mm) up to about 0.76 mm. In one embodiment, the surface of tubular component 240 should be prepped prior to assembly to mounting lug 244. Exemplary surface preparations include a dry rag wipe, a solvent degrease, a vapor degrease, a mechanical abrasion of the surface, plasma treatment, chemical etching, and anodizing.

Through the use of adhesive 261 component 240 and mounting lug 244 may be joined regardless of whether component 240 and mounting lug 244 are made of similar materials or dissimilar materials.

The ability to combine different materials or dissimilar materials together allows the use of materials which are best suited for the operation of each of mounting lug 240 and 244. Further, the use of an adhesive distributes the load of a joint over an area rather than concentrating it at a point or a line as is the case with rivets and welds. Stress spikes from drilled holes are reduced and the structural changes to the materials caused by welding which affect material fatigue strength are eliminated and the components are not distorted dimensionally from the welding process. In one embodiment, the adhesive also forms a seal as well as a bond resulting in eliminating the need for the sealing of the joint between mounting lug 240 and 244. Further, the amount of transferred noise and vibration is reduced due to the elimination or reduction in metal on metal contact.

In one embodiment, the adhesive 261 is an acrylic adhesive. An exemplary acrylic adhesive is Lord 406 adhesive available from Lord corporation having offices located at 5101 E. 65<sup>th</sup> Street, Indianapolis, Ind. 46220. In one embodiment, the Lord 405 acrylic adhesive is combined with an accelerator to promote the curing of the 406 adhesive. An exemplary accelerator is Lord 19 also available from Lord

Corporation. For joints not having a defined adhesive cavity such as adhesive 261, Lord 19 GB accelerator may be used in combination with the acrylic adhesive. The Lord 19 GB accelerator includes glass beads to promote uniform bond line thickness between substrates. In one embodiment, the glass beads are 0.01 inches (in.) in diameter. In one embodiment, the cure time of the adhesive joint formed by adhesive 261 is approximately 24 hours at room temperature.

The use of adhesive 261 may be used to join other components of frame 110 together. In one embodiment, floor component 188 is joined to left side cast clip 200 and right side cast clip member 202 through use of an acrylic adhesive and an accelerator having the spacer components to provide a generally uniform bond line. In one embodiment, the spacer components are the glass beads such as provided by Lord A19GB accelerator. In other embodiments, one or both of floor member 188 and clip members 200 and 202 may include standoffs which define the thickness of the adhesive joint.

In addition, structural adhesives may be used to join together front cooler 190 and floor member 188, front cooler 190 and tunnel 132, bulkhead 181 and tunnel 132, bulkhead 182 and tunnel 132, bulkhead 184 and bulkhead 181, bulkhead 182 and bulkhead 186, mounting lugs 244 and tubular component 243, mounting lug 244 and tubular component 243, mounting component 242 and tubular component 238. Further, to the extent tunnel 132 or tunnel 132' includes side tunnel coolers, these side tunnel coolers may be secured to the tunnel through the use of structural adhesives. In any of these frame joints, mechanical fasteners, such as rivots, may be used to locate components while the adhesive forms the majority of the strength of the joint.

In one embodiment, tubular component 240 is joined to mounting lug 244 by inserting the end of tubular component 240 into the opening in mounting lug 244 as shown in FIG. 23A. Once tubular component 240 contacts an end wall 245 of mounting lug 244 mechanical fasteners 270 are passed through openings 272 in mounting lug 244 and are affixed to component 240. Mechanical fasteners 270 serve to locate component 240 relative to mounting lug 244. At this point, adhesive 261 is provided to adhesive cavity 262 through the one or more ports 264 provided in mounting lug 244. In one embodiment, the volume of adhesive cavity 262 is predetermined in such that a predetermined amount of adhesive 261 is injected into adhesive cavity 262. The predetermined amount of adhesive 261 generally corresponds to the volume of adhesive cavity 262. Once adhesive 261 has cured the strength of the joint between components 240 and 244 is largely governed by the strength of the adhesive joint between component 240 and mounting lug 244. In one embodiment, the curing of adhesive 261 may be accelerated by applying heat during the curing process.

In one embodiment, floor component 188 is coupled to cast components 200 and 202 by first applying the adhesive 261 to one or both of floor component 188 and cast components 200 and 202 and then positioning floor component 188 relative to cast components 200 and 202. The joint between floor member 188 and cast components 200 and 202 may be further reinforced through the use of mechanical fasteners.

In one embodiment, at least two frame members are assembled by attaching the members together with mechanical fasteners, such as rivets, for location of the members relative to each other and then use of a structural adhesive to complete joint between the members. The use of the mechanical fasteners replaces the need to clamp the members together until the adhesive sets.

Referring to FIG. 25 each of tubular members 238 and 240 are coupled to upper mounting member 232 through a plural-

ity of mechanical fasteners, illustratively bolts 280. Bolts 280 are received through openings in tubular components 238 and 240 and thread into upper mounting member 232. In the illustrated embodiment, stiffening members 282 are provided which are received inside tubular components 238 and 240, respectively. Stiffening members 282 include openings 284 which align generally with openings 283 in tubular components 238 and 240. Further, the regions of stiffening member 282 surrounding openings 284 are generally equal to and follow the contour of the internal diameter of tubular components 238 and 240. As such, stiffening members 282 provide a generally solid structure for tubular components 238 and 240 in the regions corresponding to couplers 280.

Referring to FIG. 15, the connections between front suspension 120a and left side cast clip member 200 are illustrated. The mounting of right front suspension 120b generally mirrors the mounting of left front suspension 120a. Left front suspension 120a includes a lower control arm 300A, an upper control arm 302A, and a shock member 304A. Upper control arm 302A includes a first collar portion 310A and a second collar portion 312A which are each coupled to a generally U-shaped control arm member 314A. Each of collars 310A and 312A are rotatably coupled to mounting members 316A and 318A respectively. Mounting members 316A and 318A are rotatable relative to respective collar members 310a and 312a about axis 320 in directions 322 and 324. Mounting member 316A includes openings 326 and 328 which may be aligned with openings 330 and 332 in left side cast clip member 200. Similarly mounting bracket 318A includes openings (not shown) and 336 which align generally with openings 338 and 340 in left side cast clip member 200. Each of the openings of mounting brackets 316A and 318A are coupled to left side cast clip member 200 through a mechanical coupler. As illustrated for opening 326, a bolt 350 is introduced from an inside portion of left side cast clip member 200 through opening 330 such that a head 352 of bolt 350 rests against the inside of left side cast clip member 200. Bolt 350 is also passed through opening 326 in mounting member 316A. Finally, a nut 354 is threaded onto bolt 350 to secure mounting bracket 316A to left side cast clip member 200. In a similar manner, opening 328 in mounting bracket 316A and the openings of mounting bracket 318A receive bolts 350 to couple the respective mounting brackets to the left cast clip member 200. In one embodiment, the axis of bolt 350 generally illustrated as assembly line 360 is generally perpendicular to axis 320. Of course, an end portion of mounting bracket 316A or 318A may be angled relative to axis 320 such that axis 360 is not perpendicular to axis 320.

Lower control arm 300A is generally mounted to left side cast clip member 200 in the same manner as upper control arm 302A. In particular, lower control arm 300A includes mounting brackets 370A and 372A which are received in collars 374A and 376A, respectively. Each of the openings of mounting brackets 370A and 372A are secured to left side cast clip member 200 as described above for control arm 302A with the exception of opening 380.

Referring to FIG. 17 a portion of left side cast clip member 200 and right side cast clip member 202 are shown along with mounting members 370A of left front suspension 120A and 370B of right front suspension 120B. Each of mounting members 370A and 370B include an opening 380. A mechanical coupler illustratively a bolt 382, passes through opening 380 in right mounting component 370B, through right side cast clip member 202, through left side cast clip member 200, and extends beyond left mounting member 370A. Bolt 382 is held in place through a nut 386 which is threadably secured to bolt 382. The connection illustrated in FIG. 17, in addition to

mounting lower control arm **300A** and **300B** to frame **110**, also provides another connection point between left side cast clip member **200** and right side cast clip member **202**. Further, the same coupler **382** is used to secure both a portion of control arm **300A** and **300B** to frame **110**.

As shown in FIG. **17**, the direction of mounting **390** is not perpendicular to an axis of rotation **392** of lower control arm **300**. In one embodiment, the mounting direction **390** and axis of rotation **392** form an angle of about 67 degrees. In one embodiment, the mounting direction of a control arm is relative to an axis of rotation of the control arm from about plus or minus about 68 degrees up to 90 degrees.

The mounting of the control arms in a direction angled relative to the direction of rotation, reduces the likelihood that cast clips **200** and **202** would be damaged in an accident. Rather, the control arms would break from the respective cast clip **200** and **202** prior to the respective cast clip **200** and **202** being damaged.

Returning to FIG. **15**, each of control arms **300A** and **302A** include a ball joint component **394A** and **396A**, respectively. As shown in FIG. **16** ball joint components **394A** and **396A** are coupled to a spindle **398A** which is further coupled to ski **106A**. Spindle **398A** is permitted to rotate relative to control arms **300A** and **302A** as well as to rotate relative to ski **106A**. In one embodiment, the axis of rotation **320** of upper control arm **302A** and the axis of rotation **392** (which includes both collar **37A** and collar **376A**) of lower control arm **300A** are generally parallel. In another embodiment the axis of rotation **320** of upper control arm **302A** is angled relative to the axis of rotation **392** of lower control arm **300A**. In one embodiment, lower control arm **300A** and upper control arm **302A** are angled as suggested in U.S. Pat. No. 6,942,050, the disclosure of which is expressly incorporated herein by reference. In one embodiment, the lower control arm **300A** and upper control arm **302A** are angled as suggested in U.S. patent application Ser. No. 12/135,107, filed Jun. 6, 2008, titled VEHICLE, the disclosure of which is expressly incorporated by reference herein.

Each of lower control arm **300A** and **300B** include a cross member **400A** and **400B**, respectively. Referring to FIG. **19**, a sway bar **402** is rotatably coupled to left side cast clip member **200** at location **404** and to right cast clip member **202** at location **406**. Sway bar **402** is rearward facing and includes ends **408** and **410** which are coupled to brackets **412A** and **412B** which are in turn coupled to cross members **400A** and **400B** of lower control arms **300A** and **300B**, as shown in FIG. **26**.

Control arms **300A** and **302A** are biased in a downward direction by a shock member **384A**. Any type of suitable shock may be used. In one embodiment, shock member **384A** is a Model No. 7043206 shock available from Walker Evans Racing located at 2304 Fleetwood Drive Riverside Calif. 92509.

Referring to FIG. **20** another exemplary shock **430** is shown. Shock **430** includes a first body member **432** having a mounting location **434** for rotatably coupling to one of left side cast clip member **200** and right side clip member **202**. First body member **432** further includes a first fluid chamber **436** and a second fluid chamber **438**. First fluid chamber **436** and second fluid chamber **438** are in fluid communication through a third fluid chamber **440**.

Coupled to first body member **432** proximate to second fluid chamber **438** is a cylindrical body member **442** having a floating piston **444** disposed therein. Floating piston **444** divides an interior of cylindrical body member **442** into a first fluid chamber **446** and a second fluid chamber **448**. First fluid

chamber **446** is in fluid communication with second fluid chamber **438**. An end cap **450** seals second fluid chamber **448**.

Coupled to first body member **432** proximate to first fluid chamber **436** is a cylindrical body member **452**. An interior of cylindrical body member **452** includes a fluid chamber **454**. Fluid chamber **454** is in fluid communication with first fluid chamber **436**. A piston **456** is disposed in the interior of cylindrical body member **452** and forms the end of fluid chamber **454**. Piston **456** is coupled to a support assembly **458** through a coupler **460**. Support assembly **458** includes a mounting location **462** for rotatably coupling to one of control arms **300**.

In operation, as control arm **300** wants to move upward, support assembly **458** pushes piston **456** in direction **464**. It should be noted that fluid chamber **454**, first fluid chamber **436**, second fluid chamber **438**, third fluid chamber **440**, and first fluid chamber **446** act as a single fluid chamber **466**. This movement of support assembly **458** in direction **464** is resisted by fluid chamber **466** because the fluid within fluid chamber **466** generally cannot escape from fluid chamber **466**. As such, the fluid pressure in fluid chamber **466** increases as piston **456** is moved in direction **464** absent a change in the volume of fluid chamber **466**. The volume of fluid chamber **466** may be increased by floating piston **444** moving in direction **468**, thereby increasing the volume of first fluid chamber **446** and decreasing the volume of second fluid chamber **448**.

The amount of resistance to the movement of piston **456** in direction **464** is dependent on many factors including the pressure in fluid chamber **466**, the pressure in second fluid chamber **448**, and the volume of second fluid chamber **448**. The pressure in fluid chamber **466** may be adjusted by adding air to fluid chamber **466** through nipple **474** or removing air from fluid chamber **466** through nipple **474**. In a similar fashion, the pressure in second fluid chamber **448** may be adjusted by adding air to second fluid chamber **448** through nipple **476** or removing air from second fluid chamber **448** through nipple **476**. In one embodiment, fluid chamber **466** includes an oil and gas mixture which is emulsified due to the movement of piston **456** in fluid chamber **466** and second fluid chamber **448** includes a gas. In one example, the gas in fluid chamber **466** and second fluid chamber **448** is nitrogen gas. The volume of second fluid chamber **448** may be adjusted by introducing oil into second fluid chamber **448**. The movement of floating piston **444** does not result in the emulsification of the oil and gas in second fluid chamber **448** and hence the volume of second fluid chamber **448** is effectively reduced through the addition of oil to second fluid chamber **448**.

A steering assembly **236** controls the orientation of skis **106** to control the direction of travel of vehicle **100**. Referring to FIG. **21**, steering assembly **236** includes an upper steering post **234** which is coupled to handle bars **500**. As is known, an operator through rotating handle bars **500** rotates upper steering post **234** about axis **502** and directions **504** and **506**. A lower portion of upper steering post **234** is coupled to a bracket **510** (See FIG. **24**) which turns with upper steering post **234** about axis **502**. Bracket **510** is rotatably coupled to a link **512** which is in turn rotatably coupled to a bracket **514**. Bracket **514** is coupled to a lower steering post **516** which rotates along with bracket **514**. Lower steering post **516** is rotatable about axis **515** in directions **517** and **519**. In one embodiment, axis **515** is parallel to axis **502**. In one embodiment, axis **515** is non-parallel to axis **502**. At its lower end, lower steering post **516** is coupled to a bracket **518** which rotates with lower steering post **516**. Bracket **518** is coupled to a steering arm **520A** which is coupled to a ski spindle **398A** as shown in FIG. **16**. Bracket **518** is further rotatably coupled to a connecting link **522** which is further rotatably coupled to a

bracket 524. Bracket 524 communicates movement of connecting link 522 to a right side steering arm 520B. Steering arm 520B is coupled to ski spindle 398B in a similar fashion as steering arm 520A is coupled to ski spindle 398A.

Referring to FIG. 26, left side cast clip member 200 includes a mounting portion 528 having an aperture to receive a post 530 extending from the lower end of lower steering post 516. In a similar fashion, right side cast clip member 202 includes a mounting portion 532 having an aperture to receive a post 534 on the bottom of bracket 524. As such, a lower end of steering post 516 is rotatably coupled to the left side cast clip member 200. An upper portion of lower steering post 516 is coupled through a bracket 536 coupled to mounting lug 242 of over structure 230, as shown in FIG. 22.

Referring to FIG. 13, an exhaust system of vehicle 100 is shown. The exhaust system includes an exhaust intake 550 which is coupled to the engine (not shown) to receive exhaust gases from the engine. The exhaust intake 550 is coupled to exhaust conduit 552 which extends forward from the engine and wraps around and is in fluid communication with a resonator unit 554. As shown in FIG. 28, exhaust conduit 552 is positioned below tubular member 243 and between left side cast clip member 200 and right side cast clip member 202. Further, exhaust conduit 552 extends beyond the front edge of left side cast clip member 200 and right side cast clip member 202 into a region bounded by front bumper 560 as shown in FIG. 13.

Returning to FIG. 28, exhaust conduit 552 is coupled to right side cast clip member 202 through compliant members 562. In one embodiment, compliant members 562 are springs. In a similar fashion, an upper portion of resonator unit 554 is coupled to a bracket 564 through compliant members 566. Compliant members 566, in one embodiment, are springs. Bracket 564 is coupled to tubular portion 240 of the over-structure 230. The exhaust gases communicated to resonator unit 554 exit resonator unit through fluid port 570.

Referring to FIG. 29, a lower portion of resonator unit 554 is located with a set of pins 572 which are coupled to a bracket 574 which is mounted to right side cast clip member 202. A bracket 576 in the lower portion of resonator unit 554 includes openings to receive pins 572. As such, resonator unit 554 is able to float up and down but is restricted forward and aft and side to side due to pins 572.

Referring to FIG. 30, an exemplary front bumper 560 which encloses fluid conduit 552 is shown. Front bumper 560 includes a front component 580, a pair of side components 582 and 584, and a lower component 586. Each of side components 582 and 584 and lower components 586 are coupled to one of left cast clip member 200 and right side cast clip member 202 and are coupled to front component 580. Front component 580 includes openings 588 which permit air to enter a portion of the interior of vehicle 100. Referring to FIG. 1 air passes through openings 588 in front bumper 560 and on through to openings 590 in body panel 592 and into the interior of vehicle 100.

Referring to FIG. 31 lower member 586 of front bumper 560 includes two attachment members 594 and 596. A radiator 600 is attached to lower portion 586 through attachment members 594 and 596.

Radiator 600 includes a fluid inlet tube 602 and a fluid outlet tube 604 which are in communication through a plurality of cross-tubes 606. One end of each of fluid inlet tube 602 and fluid outlet tube 604 is capped and the other end is in fluid communication with a fluid conduit connecting the respective fluid inlet tube 602 and the fluid outlet tube 604 to various components of cooling system 630.

Pressed onto the plurality of cross tubes 606 are a plurality of fin members 608 which are spaced apart to allow air flow there between. The fin members 608 act to cool the fluid passing through cross members 606 as it travels from fluid conduit 602 to fluid conduit 604. Two of the thin members illustratively 610 and 612 include extensions having openings therein. These extensions are coupled to attachment members 594 and 596 through mechanical couplers, such as bolts. Referring to FIG. 13 the location of radiator 600 is forward of front suspension 120a and 120b. Further, radiator 600 is forward of cast clip members 200 and 202.

Referring to FIGS. 55 and 56, an alternate front bumper 700 is shown. Referring to FIG. 55 front bumper 700 includes an upper structural piece 702 and a lower structural piece 704. Upper structural piece 702 and lower structural piece 704 are joined together through a coupler. In one embodiment, the coupler is a bolt and nut. Other couplers includes welds and other means of fastening upper structural component 702 to lower structural component 704. In one embodiment, upper structural component 702 is formed of a first tubular metal portion 706 and a second tubular metal portion 708 which is coupled to the first tubular metal portion 706.

Referring to FIG. 56, upper structural component 702 is overmolded an overmold component 710. In one embodiment, the overmolded component 710 is made of a soft rubber material. The use of a soft rubber material overmolded on a metal substrate provides an improved durability over a plastic bumper. In addition, it provides the ability to give a stylized appearance to the bumper 700 while maintaining the structural rigidity of the underlying metal support.

Also, shown in FIG. 56 is an alternative configuration of front radiator 600. The embodiment shown in FIG. 56 is the same as the radiator shown in FIG. 30 with the exception of fins 610' include upper mounting locations 611 which cooperates with mounting members similar to mounting members 594 shown in FIG. 31. Fins 610' further include lower mounting locations 613 which also cooperates with mounting members similar to mounting members 594 to secure radiator 600 to lower structural member 704.

Referring to FIGS. 34-37, an air intake system 730 is shown. Referring to FIG. 34, air intake system 730 includes an intake member 732 and an air box 734. Intake member 732 includes an opening 736 through which air is received into an interior 738 (See FIG. 37) from an opening 740 (See FIG. 3) in the body panels of vehicle 100.

Referring to FIG. 35, intake member 732 includes a generally flat surface 740 onto which an engine control unit 742 is mounted. As is known in the art, engine control unit includes a computing device and software for controlling the operation of engine 108 and other functions of vehicle 100. By placing the engine control unit 742 on intake member 732 the air passing through intake member 732 acts to cool the engine control unit 742. Intake member 732 includes recesses 744 which receive couplers for securing engine control unit 742 to intake member 732. Referring to FIG. 37, in one embodiment, recesses 744 are blow molded features which are sized to receive self tapping screws. Similar pockets are used for mounting coils 750 to intake member 732.

Referring to FIG. 37, air intake member 732 includes extension members 752 which rest against tubular member 238 of overstructure 230 as shown in FIG. 10. Tubular member 238 is located in recess 754 of intake member 732 shown in FIG. 37. Air exits intake member 732 through opening 756 (see FIG. 37) and enters into air box 734 through opening 758 (see FIG. 35). Referring to FIG. 35 air box 734 includes an upper air box housing 760, a lower air box housing 762 and

divider **764**. As indicated in FIG. **36**, an air filter **766** is positioned within an interior of upper air box member **760**.

Referring to FIG. **36**, air passes through filter **766** positioned in upper air box member **760** through one or more openings **768** and **770** of divider plate **764** and into an interior **772** of lower air box member **762**. The air exits lower air box member **762** through openings provided in a pair of boots **765**. The air then travels through conduits (not shown) which provide the air ultimately to engine **108**.

Divider plate **764** cooperates with upper air box member **762** and hold filter **766** in place. Openings **768** in divider plate **764** are generally u-shaped. Opening **770** is defined by a side of divider plate **764** and a perimeter of lower air box housing **762**. Divider plate **764** rests in the groove **778** of lower air box housing **762**. Divider plate **764** maybe removed as needed.

To assemble air box unit **734** tabs **780** on upper air box housing **760** are inserted into holders **782** (see FIG. **35**) on lower air box housing **762**. Referring to FIG. **35**, upper air box housing includes holders **784** which receive an end of clips **786** which are assembled to lower air box housing **762**. In the illustrated embodiment, clips **786** are spring clips.

Referring to FIG. **35**, boots **765** include a stop member **788**. Stop member **788** prevents the rotation of band clamps **790** and as the band clamps are being tightened. In one embodiment, stop member **788** include a recess to receive a portion of screw **792** of the respective band clamp **790**. In this manner, band clamp **790** is coupled to stop member **788**. As is known in the art, boots **765** are used to couple to air hoses which provide air from air box **734** to the engine **108**.

Referring to FIG. **38** a fuel tank **800** is shown. Fuel tank **800** includes a fill port **802** through which fuel is provided to an interior fuel tank **800**. Disposed within the interior of fuel tank **800** is a fuel pump **804** which pumps fuels from fuel tank **800** and provides it to the engine **108**. Fuel pump **804** is coupled to a single sock **806** which is in fluid communication with the fuel in fuel tank **800**. Sock **806** provides the fuel to fuel pump **804**. Exterior surface **810** of fuel tank **800** provides a portion of the exterior surface for vehicle **100** as shown in FIG. **3**.

In one embodiment, the engine **108** is a two cycle engine and requires a supply of oil to be mixed with the fuel for combustion. In one embodiment, the supply of oil is provided in an oil container separate from fuel tank **800**. A first exemplary oil container **820** is shown.

Referring to FIGS. **10** and **14**, oil bottle **820** is supported by a clutch guard **822**. Clutch guard **822** is positioned generally above a continuously variable transmission (“CVT”) **824**. CVT **824** couples the engine **108** to a drive shaft **826** (see FIG. **50**). As is known, a CVT includes a drive clutch which is operatively coupled to the engine **108** and a driven clutch **828** (see FIG. **50**) which is coupled to drive shaft **826**. Driven clutch **828** is coupled to the drive clutch through a drive belt. Clutch guard **822** is positioned to protect CVT unit **824**. Referring to FIG. **13**, oil bottle **820** is positioned on the opposite side of vehicle **100** from where exhaust conduit **552** enters resonator unit **554**.

Returning to FIG. **39**, oil bottle **820** includes a fill port **830** through which oil is provided to an interior **832** (see FIG. **41**) of oil bottle **820**. Referring to FIG. **41**, the interior of **832** of oil bottle **820** includes a main reservoir portion **834** and a sump portion **836**. Within sump portion **836** is an outlet **838** through which oil is communicated to a fluid conduit connected to the engine **108** or a component for mixing the oil with the fuel. As shown in FIG. **39**, a fitting **840** is provided in opening **838**. The oil line is connected to fitting **840**. A second opening **842** is provided in oil container **820**. Opening **842** is sized to receive an oil sender **844** which includes a float **846**. Float **846**

is positioned in sump area **836** of oil container **820**. The relative position of float **846** provides an indication of the oil level in oil container **820**. Based on the location of float **846**, the engine control unit **742** provides to a display, such as the display shown in FIG. **57**, a low oil indicator light to an operator of vehicle **100**. In one embodiment, the ECU **742** provides a low oil indicator light to the operator when the oil level in oil container **820** falls below 1.2 quarts.

Referring to FIG. **42** sump region **836** of interior **382** is positioned generally below main reservoir region **834** of interior **832** when oil container **820** is positioned on clutch guard **822** as shown in FIG. **14**. In one embodiment, the sump region **836** is sized to hold about 6.2 ounces of oil.

Referring to FIG. **41** the sump region **836** is separated from the main reservoir region **834** through a divider **850**. Divider **850** provides a generally v-shaped opening starting at point **852** and increasing in width and direction **854**. The variable width opening of divider **850** limits the rate at which fluid leaves sump region **836** to flow into main reservoir region **834** when the orientation of oil bottle **820** is changed (see FIG. **43**).

Changes in the orientation of oil container **820** occur when vehicle **100** is climbing hills and/or carving in left to right turns through deep snow. In one embodiment, the flow rate of oil from sump region **836** back into main reservoir region **834** is controlled such that at least 4.8 ounces of oil remain in sump region **836** as oil container **820** is tilted in direction **856** about 50 degrees for approximately four minutes. This allows an operator of vehicle **100** to climb a 50 degree hill for approximately 4 minutes time without running out of oil in sump region **836**. In one embodiment, the flow rate of oil from sump region **836** to main reservoir region **834** is controlled to permit up to two minutes of hill climb on a 50 degree hill. In this example, approximately 2.4 ounces of oil are needed in sump region **836**. In one embodiment, 6.7 ounces of oil are required in sump region **836** for a 60 degree right-hand carve. In one embodiment, about 8.7 ounces of oil are needed in sump region **836** for a 60 degree left-hand carve.

In one embodiment, oil container **820** is molded as a single molded component. In one example oil bottle **820** is blow molded. In one example, the wall thickness of oil bottle **820** is 0.15 inches and the interior **832** of oil bottle **820** is about 3.8 quarts. In another embodiment, the wall thickness of oil container **820** is about 0.15 inches and the volume of interior **832** of oil bottle **820** is about 4 quarts.

In one embodiment, sump region **836** has a volume of at least about 2.4 fluid ounces (fl oz) to about 6.2 fl oz and the volume of main reservoir region **834** and the sump region **836** combined is from about 3.5 quarts (about 112 fl oz) to about 4 quarts (about 128 ozs).

Referring to FIG. **41**, the blow molded oil container **820** includes a pinch off region **860**. Pinch off region **860** separates a portion of sump region **836** from main reservoir region **834**. Further, pinch off region **860** provides the starting location **852** of divider **850**. In one embodiment, one or more apertures may be provided in pinch off **860** to accommodate couplers to couple oil container **820** to clutch guard **824**.

Referring to FIG. **40**, oil bottle **820** includes locators **866** which cooperate with locators **868** of clutch guard **824**. Locators **866** and **868** position oil bottle **820** relative to clutch guard **824** and reduce the likelihood that oil container **820** will slide in direction **870** relative to clutch guard **824**. In the illustrated embodiment, locators **866** are bumps on the lower side of oil bottle **820** and locators **868** are recesses in clutch guard **824**. In one embodiment, oil container **820** includes recesses and clutch guard **824** includes bumps to locate oil

bottle **820** relative to clutch guard **824**. Alternative locators may be used to position oil bottle **820** relative to clutch guard **824**.

As shown in FIG. **40** clutch guard **824** includes recesses **872**. Recesses **872** extend along a first side **874** and a second side **876** respectively of clutch guard **824**. Recesses **872** serve to channel in the oil which is spilled during the filling of the oil container **820** away from CVT **824**. Instead the spilled oil flows down in direction **870** in recesses **872**.

Referring to FIG. **39**, oil container **820** includes a pair of recesses **880** which extend from a first side of oil container **820** across a top of oil container **820** and down a second side of oil container **820**. Recesses **880** are provided to retain a coupler **822**. In the illustrated embodiment, coupler **882** is a compliant strap **884** having a first clip member **886** and a second clip member **888**. Clip members **886** and **888** are received by corresponding clips **890** and **892**, respectively on clutch guard **822**. Clip members **890** and **892** on clutch guard **822** are positioned to take into account differences in the height of oil container **820** at the two recesses **880**. This permits identical couplers **882** to be used with both the first recess **880** and the second recess **880** of the oil bottle **820**.

Referring to FIG. **44**, another exemplary oil container **900** is shown. Oil container **900**, like oil container **820**, is made from a blow-molded plastic material. Oil container **900** includes a main reservoir region **902** and a sump region **904**. Oil enters oil container **900** through fill port **906**. Sump region **904** includes a fluid outlet **908** which receives a fitting, such as fitting **840** shown in FIG. **39**. Further, oil container **900** includes an opening **910** for receiving an oil sender. The volumes of main reservoir **902** and sump reservoir **904** generally correspond to the volumes of main reservoir **834** and sump reservoir **836**.

Oil container **900** includes a divider **912**. Divider **912** includes a first shut off region corresponding to a pinch off **914** and a second shut off region corresponding to a pinch off **916**. Pinch off regions **914** and **916** are separated by fluid conduit **918** which is in fluid communication with both main reservoir region **902** and sub-region **904**. Oil in main reservoir region **902** passes into sump region **904** either through fluid conduit **918** or in the region **920** above divider **912**.

Oil container **900** includes a locator **922** which cooperates with locator **868** on clutch guard **822** to position oil container **900** relative to clutch guard **822**. Oil container **900** also includes recesses **904** which are used to retain couplers **882** described above in connection with oil container **820**. Another exemplary oil container **930** is shown in FIGS. **45-47**. Oil container **930** as shown is formed from a blow molded piece of material. Referring to FIG. **46**, oil container **930** includes a fill port **932** through which oil is introduced into a main reservoir **934**. A sump reservoir **936** is provided within a housing **938**. Housing **938** is received in an opening **940** in the bottom of oil container **930**. Housing **938** includes an integrated oil sender **942**, a fluid inlet port **944**, and a fluid outlet port **946** (see FIG. **45**). Fluid inlet port **944** and fluid outlet port **946** are connected by fluid conduit **945**. Oil from main reservoir **934** enters sump reservoir **936** through fluid port **944** and is communicated to the engine **108** through fluid outlet port **946**.

Oil container **930** also includes a locator **948** which cooperates with a similarly-sized locator provided on clutch guard **822**. Further oil container **930** includes recesses **950** which retain couplers **882** to oil container **930** relative to clutch guard **822**.

Referring to FIG. **48** a further exemplary oil bottle **960** is shown. Oil bottle **960** is made from a lower housing **962** and an upper housing **964**. Upper housing **964** includes a oil fill

port **966** which communicates oil to a main reservoir portion **968**. A sump reservoir portion **970** is provided in oil container **960**. Sump region **970** is in fluid communication with main reservoir region **968** through a fluid inlet port **972** provided in a divider **974**. Oil leaves sump region **970** through a fluid outlet port **976** which is coupled to an oil line connected to an engine **108**. A lower flange **978** of upper housing **964** is positioned adjacent an upper flange **980** of lower housing **962** to form main reservoir **968** and sump reservoir **970**. In one embodiment, a seal is provided between lower housing **962** and upper housing **964** to prevent oil from leaking from oil container **960**. Upper housing **964** includes a storage compartment **980**. A tool kit or other items may be stored in storage compartment **980**. A cover **982** is provided which may be coupled to upper housing member **964**. In one embodiment, pins **984** on cover **982** are received in opening **986** of upper housing member **964** to rotatably couple cover **982** to upper housing **964**. Cover **982** includes handles **988** which are used to open cover **982**. Upper housing portion **964** includes detente members **990** which cooperate with corresponding members on cover **982** to secure cover **982** in a closed position.

Referring to FIG. **49** a representation of the power train system **1000** of vehicle **100** is shown. Power train system **1000** includes engine **108** which is operatively coupled to CVT **824**. CVT **824** is operatively coupled to an upper driveshaft **826**. Upper driveshaft **826** is operatively coupled to a lower driveshaft **1004** through a chain case **1006**. As stated herein lower driveshaft **1004** is operatively coupled to endless track assembly **104** through drive members **126**.

Engine **108** is operatively coupled to ECU **742**. ECU **742** includes an engine control portion **1010** which controls the operation of engine **108**. In one embodiment, a fuel sensor **1012** is provided to determine a type of fuel which is being used by engine **108** including various blends of ethanol and gasoline. Fuel sensor **1012** provides an indication of the fuel type to engine control unit **1010** which in turn controls the operation of engine **108**. Exemplary fuel sensors are described in U.S. patent application Ser. No. 11/445,731, filed Jun. 2, 2006, the disclosure of which is expressly incorporated by reference herein.

Further, the operation of engine **108** may be adjusted and based on the output of a security control module **1014** contained within the ECU **742**. As explained herein, in one embodiment security control module **1014** alters the operation of vehicle **100** based upon whether or not the correct security code or indicator has been provided to vehicle **100**. In one embodiment, as explained herein security modes and inputs are provided to ECU **742** through operator inputs **1016** and indications are provided back to the operator through a display **1018**.

Further, as explained herein a braking unit **1020** is operatively coupled to upper drive shaft **826**. In one embodiment, ECU **742** includes ABS control **1022** which controls the operation of braking unit **1020** as explained herein. In one embodiment, one or more of security control **1014** and ABS control **1022** are separate modules not included in ECU **742**.

Referring to FIG. **50**, an exemplary braking unit **1020** is shown. Braking unit **1020** includes a brake disc **1026** coupled to a spline section **1028** of upper drive shaft **826** and a brake caliper **1030** which is coupled to frame **110** through a housing **1110** of chain case **1006**. Brake caliper **1030** interacts with brake disc **1026** to slow or stop the rotation of drive shaft **826**.

In one embodiment, the pressure applied by brake caliper **1030** on brake disc **1026** is controlled by ABS control **1022**. ABS control **1022** controls a pump motor **1032** which varies

the hydraulic pressure applied to brake caliper **1030** which in turn varies the amount of force applied by brake caliper **1030** on brake disc **1026**.

During a braking event on a conventional brake equipped snowmobile when the operator quickly and firmly applies and holds the brake lever on the handlebar the endless track **130** will typically lock. The snowmobile will transfer weight to the front skis and the endless track will slide causing the snowmobile to over-steer and skid which will hinder the operator's ability to control the snowmobile. On an embodiment of vehicle **100** including ABS when the operator quickly and firmly applies and holds the brake lever, ABS control **1022** will intervene and cause brake caliper **1030** to release brake disc **1026** before endless track assembly **104** lockup occurs minimizing the possibility of an over-steer condition.

ABS control **1022** looks at the percent slip between the endless track velocity and the snowmobile velocity. Percent slip as

$$\text{Percent Slip} = 100 * \left( 1 - \frac{\text{Endless Track Velocity}}{\text{Snowmobile Velocity}} \right)$$

wherein Endless Track Velocity is the measured speed of the track through a speed sensor **1150** and Snowmobile Velocity is one of an estimated speed of the snowmobile or a measured speed through a speed sensor **1152**. In one embodiment, speed sensor **1150** measures the rotational speed of drive shaft **826**. Exemplary speed sensors to measure the rotational speed of drive shaft **826** include hall effect sensors.

In one embodiment, Snowmobile Velocity is measured with speed sensor **1152**. Exemplary speed sensors include GPS sensors, Doppler sensors, and accelerometers. In one embodiment, Snowmobile Velocity is estimated based on the Endless Track Velocity. It is assumed that prior to applying the brakes the Snowmobile Velocity is generally equal to the Endless Track Velocity. Then the Snowmobile Velocity is allowed to decay based on a deceleration curve to arrive at an estimated Snowmobile Velocity. Once the brake lever is released, or in the case of ABS the brake caliper is released to prevent lock, the Endless Track Velocity may again be sampled with speed sensor **1150** and the Snowmobile Velocity set equal to the sensed speed.

In one embodiment, when the operator applies the brake lever normal braking is permitted until the percent slip is at least about 33 percent, then the ABS module **1022** starts to cycle the brakes (applying pressure with caliper and then releasing in a repeated fashion) until the percent slip rises to about 70 percent, at which point ABS module **1022** releases the brake to prevent lockup. Of course, when the brake is released the estimated Snowmobile Velocity again returns to the sensed Endless Track Velocity and the progression begins again. In one example, the brake caliper is cycled at about 30 Hertz when the percent slip is between about 33 percent and about 70 percent. In one embodiment, the range corresponding to the cycling of the brake caliper is from about 50 percent to about 60 percent.

By using an estimate for the Snowmobile Velocity, ABS module is able to permit an operator to tap the brakes during a jump to assist in flattening out the vehicle while it is in the air. Further, in one embodiment, ABS module **1022** includes logic to take into account vehicle **100** moving on an icy surface. In this scenario, the Endless Track Velocity may be 80 miles per hour (mph), but the true Snowmobile Velocity is only 20 mph. when the brakes are first applied and the slip reaches the ABS threshold for cycling (such as about 50

percent slip) then ABS module **1022** initially assumes the Snowmobile Velocity is also 80 mph. Then when the module releases at the lock threshold (such as about 60 percent slip) due to the deceleration curve for 80 mph, the next Endless Track Velocity is about 20 mph. ABS control assumes that vehicle **100** is on an icy surface and sets the next estimated Snowmobile Velocity to about 20 mph.

Referring to FIG. **50**, drive shaft **826** is shown. Drive shaft **826** is coupled to driven clutch **828** of CVT **824** on a first end and a chain case **1006** on a second end. Driven clutch **828** causes a rotation of drive shaft **826**, which in turn, causes a rotation of a first gear **1102** (see FIG. **51**) positioned within chain case **1006**. Referring to FIG. **51**, first gear **1102** is coupled to a second gear **1104** through a chain **1106**, both being positioned within chain case **1006**. The second gear **1104** is coupled to drive shaft **124** which in turn is coupled to endless track assembly **104** through pair of drive sprockets **126**.

Referring to FIG. **53**, drive shaft **826** includes spline section **1028**. Spline section **1028** extends through an opening in a chain case housing **1110** and an opening in a chain case cover **1112**. A first seal **1114** is positioned between spline section **1028** and chain case housing **1110** along with a first bearing **1116**. An exemplary bearing is a roller bearing. A second seal **1118** is positioned between spline section **1028** and chain case cover **1112** along with a second bearing **1120**. An exemplary bearing is a roller bearing. First gear **1102** is mounted to spline section **1028** between first bearing **1116** and second bearing **1120**. Brake disc **1026** is mounted to spline section **1028** outward of chain case cover **1112**. By having bearings positioned on both sides of first gear **1102**, the amount of knock-back experienced while riding vehicle **100** is reduced.

Chain case **1006** includes various mounting locations which permit vehicle **100** to be setup for various configurations. Referring to FIG. **52**, chain case housing **1110** includes a first mounting location **1130**, a second mounting location **1132**, and a third mounting location **1134**. As illustrated, first mounting location **1130** and second mounting location **1132** are aligned with mounting locations (not shown) on right side bulkhead member **186**. Right side bulkhead member **186** also includes additional mounting locations **1136** and **1138**. During assembly of vehicle **100**, first mounting location **1130** is aligned with either the mounting location it is currently obscuring in FIG. **52** or additional mounting location **1136** and is coupled thereto with a coupler, such as a bolt. Then, one of second mounting location **1132** and third mounting location **1134** is aligned with either the mounting location obscured by second mounting location **1132** in FIG. **52** or additional mounting location **1138**. In this manner, the position of drive shaft **826** may be altered during assembly by the placement of chain case housing **1100**.

Referring to FIG. **51**, the inside of chain case housing **1110** includes features **1140** which direct the flow of oil in chain case **1006** onto second gear **1104**. Feature **1140** is generally teardrop shaped to direct drops of oil onto second gear **1104**. Oil is added to chain case **1006** through the opening left by removing a plug **1142**.

Referring to FIG. **54**, an operator **1160** is shown positioned on vehicle **100**. Operator **1160** is positioned at a first seating position region **1161** of seat **1142**. Hands **1162** of operator **1160** are gripping handlebars **500**. Feet of operator **1160** are positioned on running boards **1163** of vehicle **100**. In particular, the front portions of the feet of the operator are positioned in a foot rest region **1165** (see FIG. **14**) which is angled upward relative to the remainder of running boards **1163**. In the illustrated embodiment, a foot supporting surface of foot

rest region 1165 is angled upward relative to a foot supporting surface of the remainder of running boards by about 9 degrees, as indicated by angle 1174. The foot rest region 1165 has a foot containment member, illustratively a toe hook 1167, which extends over foot rest region 1165 to assist in keeping the foot of the operator positioned in foot rest region 1165.

As shown in FIG. 54, the hands 1162 of operator 1160 grip handlebar 500 forward of an axis 1170 of drive shaft 124. The position of the hips 1164, knees 1166, and ankles 1168 of operator 1160 are also shown. When seated in first seating position 1161, the knees 1166 of operator 1160 are forward of ankles 1168 and hips 1164 are elevated relative to knees 1166. By elevating hips 1164 relative to knees 1166, it is easier for operator 1160 to transition from a seated position as shown in FIG. 54 to a standing position or at least to a crouched position wherein the operator is spaced apart from seating surface 144 of seat 142.

In the illustrated embodiment, a line connecting the hips and knees (while the operator is seated on seat 142) is about 18 degrees above horizontal, as indicated by angle 1172. In one embodiment, the line connecting the hips and knees (while the operator is seated on seat 142) is at least about -2 degrees below horizontal to angles above horizontal. In one embodiment, the line connecting the hips and knees (while the operator is seated on seat 142) is up to about 25 degrees above horizontal. In one embodiment, the line connecting the hips and knees (while the operator is seated on seat 142) is above horizontal and is up to about 25 degrees above horizontal. In one embodiment, the line connecting the hips and knees (while the operator is seated on seat 142) is between about -2 degrees below horizontal and about 25 degrees above horizontal. In one example, the operator is an average size adult human.

As mentioned herein, in one embodiment, security control module 1014 alters the operation of vehicle 100 based upon whether or not a correct security code has been provided to vehicle 100. In one embodiment, a security code and other inputs are provided to ECU 742 through operator inputs 1016 and indications are provided back to the operator through a display 1018.

Referring to FIG. 57, an exemplary screen 1200 presented on display 1018 is shown. Screen 1200 is displayed when vehicle 100 is started and a secure mode is not active for vehicle 100. In a non-secure mode, vehicle 100 operates normally. In a secure mode, the engine rpm is limited to a level below an engagement rpm for CVT 824. The engine rpm may be limited by at least one of restricting the provision of fuel to engine 108 and interrupting the spark of the igniters of engine 108. The engine remains limited until a correct security code is provided. Referring to FIG. 58, a screen 1202 corresponding to when vehicle 100 is started in a secure mode is shown. In one embodiment, a timer also shuts off engine 108 after a predetermined time period if a valid security code has not been presented to security control module 1014. Exemplary security codes include manually entered numeric codes, manually entered alpha-numeric codes, biometric information provided to a reader, electromagnetic signals including security code information provided to a receiver, and other suitable methods of presenting a security code.

In one embodiment, the operator may select to have vehicle 100 start in a secure mode only at the next start and thereafter start in a non-secure mode. This situation is ideal for when the operator is parking their vehicle in a public or unfamiliar location, such as stopping for lunch on a trail. Referring to

FIG. 59, a screen 1204 corresponding to when a secure once (the next start) mode has been selected for vehicle 100 is shown.

In one embodiment, the operator may select to have vehicle 100 start in a secure mode at every start. Referring to FIG. 60, a screen 1206 corresponding to when a secure all (every start) mode has been selected for vehicle 100 is shown.

An exemplary operation of security control module 1014 is represented. The operation of security control module 1014 is presented wherein the operator provides inputs through a Mode button 1210 and a Sel button 1212 of operator inputs 1016 and provides information to the operator through display 1018. However, the methods of operator input and feedback may be accomplished in different manners.

In one embodiment, the security code is entered with mode button 1210 and sel button 1212, as follows. To enable one of the secure modes, the operator 1160 will press and hold the mode button 1210 and sel button 1212 on the display 1018 for a predetermined time, such as 3 seconds while the brake is in a parking brake locked position. In one example, the vehicle 100 must be running with an engine RPM of 3500 or less, and a ground speed of 0 to set or change security modes.

When the operator presses and holds mode button 1210 and sel button 1212 for the predetermined time, the display 1018 will change from normal display mode wherein a tachometer reading and a speed reading are displayed to a security set mode. In the security set mode, the left most digit 1220 of display 1018 becomes active and displays a "0" which blinks at a rate of 2 HZ. The operator releases mode button 1210 and sel button 1212. Subsequent pressing and releasing of sel button 1212 increments the active digit by 1 for each press and release cycle. Pressing mode button 1210 accepts the value for the left digit and moves the cursor to the middle digit. The left digit will no longer blink, but the middle digit will now blink. Subsequent pressing and releasing of sel button 1212 increments the active digit by 1 for each press and release cycle. Pressing mode button 1210 accepts the value for the middle digit and moves the cursor to the right digit. The left digit and the middle digit will no longer blink, but the right digit will now blink. Subsequent pressing and releasing of sel button 1212 increments the active digit by 1 for each press and release cycle. Pressing mode button 1210 accepts the value for the right digit and moves the cursor to the right digit. The left digit and the middle digit will no longer blink, but the right digit will now blink. At anytime in the process, if no buttons are pressed for 5 seconds, the display 1018 exits the security mode and return to normal display mode and no security code will be set.

Pressing mode button 1210 again will set cursor back on left most digit, holding mode button 1210 for a predetermined time period, such as 3 seconds, will bring up the "ONCE" or "ALL" selection. The display 1018 will first show "ONCE". Pressing and holding mode button 1210 for a predetermined time, such as 3 seconds will select the ONCE security mode wherein the security code is required only for the next start. Pressing the sel button 1212 will toggle the lower display to show "ALL". Pressing and holding mode button 1210 for a predetermined time, such as 3 seconds will select the ALL security mode wherein the security code is required for each subsequent start. Once one of the ONCE security mode and the ALL security mode has been selected, the entered code is displayed on the top segment line of display 1018, "ONCE" or "ALL" on the middle segments line, and "CODE" on the bottom. The code will flash for a predetermined time period, such as 3 seconds. The code and security mode will then be written to the ECU 742 and display 1018 will return to normal function. At anytime in the process, if no buttons are pressed

for 5 seconds, the display **1018** exit the security mode and return to normal display mode and no security code will be set.

Referring to FIG. **61**, vehicle **100** is started, as represented by block **1250**. A check is made to see if a security mode is active or not, as represented by block **1252**. If a security mode is not active, vehicle **100** is allowed full functionality, as represented by block **1266**. If a security mode is active, the operator is prompted to enter the security code, as represented by block **1254**. The operator is given a predetermined period of time, such as thirty seconds, to enter the security code before engine **108** is shut-off. With the vehicle running at idle and a ground speed of 0, the operator presses and holds the mode button **1210** and sel button **1212** for a predetermined time, such as 3 seconds. A check is made to determine if the code entered matches what is stored in the ECU **742**, as represented by block **1256**. If the entered code does not match the code stored in the ECU **742**, the display will show "Secure" "Err", as represented by block **1258**. A check is made to see if the thirty second window has expired, as represented by block **1260**. If not, the operator is given another chance to enter a security code, as represented by block **1254**. If the thirty second window has expired, vehicle **100** is shut off, as represented by block **1262**.

If the entered code matches the code stored in ECU **742**, a check is made to determine if the security mode was "ONCE" or "ALL", as represented by block **1264**. If the security mode was set to "ALL" then vehicle **100** is allowed full functionality, as represented by block **1266**. If the security mode was set to "ONCE" then the security mode is disabled, as represented by block **1268**, and then vehicle **100** is allowed full functionality, as represented by block **1266**. Further, the current security code is cleared when security is turned OFF. Display **1018** will toggle to show "Secure" "OFF".

At anytime the engine is at idle and the track speed is zero, an operator may enter a security setup, as represented by block **1270**. A check is made to see if a security mode is currently active, as represented by block **1272**. If a security mode is not currently active, an operator may enter a three digit security code as outlined herein, as represented by block **1274**. Once the code has been entered, the operator is presented options for the security system, as represented by block **1276**. Returning to block **1272**, if a security mode is currently active, the operator is required to enter the security code, as represented by block **1278**. A check is made to see if the entered code matches the stored code, as represented by block **1280**. If the code does not match the stored code, display **1018** is returned to normal display, as represented by block **1282**. If the code matches the stored code, then matches the operator is presented options for the security system, as represented by block **1276**.

The operator is able to toggle through various options for the security system. A first option is to set the security mode to "ONCE", as represented by blocks **1284** and **1286**. A second option is to set the security mode to "ALL", as represented by blocks **1288** and **1290**. A third option is to turn the security mode to "OFF", as represented by blocks **1292** and **1294**. If none of the three options are selected or a predetermined time period, such as five seconds, passes without further input the system will exit and no changes will be saved, as represented by block **1296**.

In one embodiment, multiple security codes may be set. In the security codes may be used to operate vehicle **100** in various modes. For instance, a first code may be used for a novice mode wherein the acceleration and top speed of vehicle **100** is limited, a second code may be used for a cruise mode wherein acceleration is optimized for fuel economy, a

third code is for an expert mode wherein the acceleration and top speed and other parameters, such as braking, are optimized for an expert rider, and a fourth code is for normal operation. In one example, any security code having a "1" as the right digit will cause vehicle **100** to operate in the novice mode, any security code having a "2" as the right digit will cause vehicle **100** to operate in the cruise mode, any security code having a "3" as the right digit will cause vehicle **100** to operate in the expert mode, and any security code having a "4"- "0" as the right digit will cause vehicle **100** to operate in the normal mode.

In one embodiment, ECU **742** stores vehicle speed and tachometer readings for a predetermined time period for potential playback to the operator. The operator when vehicle **100** is idling at zero speed may through operator inputs **1016** select to playback their stored speed and tachometer readings.

In one embodiment, ECU **742** will cause vehicle **100** to shutdown after a predetermined time period if the water temperature of cooling system **630** is above a set value. This allows an operator to start vehicle **100** and then be spaced apart from vehicle **100** as it warms up.

What is claimed:

1. A vehicle comprising:

a frame including at least one mounting lug and at least one tubular component coupled together through a structural adhesive;

the mounting lug including an extension portion having a diameter larger than the tubular component that overlaps the tubular component, the extension portion defining a cavity intermediate the mounting lug and tubular component, the cavity being defined by an annular recess on one of the mounting lug or the tubular component and a lip at an end of the mounting lug extension portion closing off the cavity;

at least one mechanical coupler positioned at a location spaced from the annular recess, the at least one mechanical coupler locating the tubular component relative to the mounting lug;

a plurality of ground engaging members including one or more front ground engaging members supporting a front portion of the frame and one or more rear ground engaging members supporting a rear portion of the frame;

a power train system supported by the frame and operatively coupled to at least one of the plurality of ground engaging members; a straddle seat supported by the frame; and

a steering assembly operatively coupled to at least the one or more front ground engaging members to orient the one or more front ground engaging members, wherein at least one of the plurality of ground engaging members is an endless track operatively coupled to the power train, and in that the mounting lug and the tubular component cooperate to provide at least a portion of a tunnel covering at least a portion of the endless track.

2. The vehicle of claim 1, wherein the mechanical coupler is a rivet.

3. The vehicle of claim 1, wherein the mounting lug includes a port where the port is in fluid communication with an adhesive chamber provided between the mounting lug and the tubular component.

4. The vehicle of claim 3, wherein the at least one mechanical coupler is secured to the mounting lug and the tubular component prior to the structural adhesive being positioned in the adhesive chamber through the port in the mounting lug.

5. The vehicle of claim 1, wherein the mounting lug is a first material and the tubular component is a second material, the second material being different from the first material.

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6. The vehicle of claim 1, wherein the structural adhesive surrounds an exterior of one of the mounting lug and the tubular component.

7. The vehicle of claim 1, wherein the structural adhesive is an acrylic based adhesive.

8. A vehicle comprising:

a frame including at least one mounting lug and at least one tubular component coupled together through a structural adhesive;

the mounting lug including an extension portion having a diameter larger than the tubular component that overlaps the tubular component, the extension portion defining a cavity intermediate the mounting lug and tubular component, the cavity being defined by an annular recess on one of the mounting lug or the tubular component and a lip at an end of the mounting lug extension portion closing off the cavity;

at least one mechanical coupler positioned at a location spaced from the annular recess, the at least one mechanical coupler locating the tubular component relative to the mounting lug;

a plurality of ground engaging members including one or more front ground engaging members supporting a front portion of the frame and one or more rear ground engaging members supporting a rear portion of the frame;

a power train system supported by the frame and operatively coupled to at least one of the plurality of ground engaging members; a straddle seat supported by the frame; and

a steering assembly operatively coupled to at least the one or more front ground engaging members to orient the one or more front ground engaging members, wherein the frame includes a tunnel, a front portion positioned forward of the tunnel, and a mid portion positioned between the front portion and the tunnel; the plurality of ground engaging members include a pair of skis operatively coupled to the front portion of the frame through respective front suspensions and an endless track operatively coupled to the power train; at least a portion of the endless track is covered by the tunnel; and the mounting lug is a cast member and the tubular component is an extruded tubular member.

9. The vehicle of claim 8, wherein the mechanical coupler is a rivet.

10. The vehicle of claim 8, wherein the mounting lug includes a port where the port is in fluid communication with an adhesive chamber provided between the mounting lug and the tubular component.

11. The vehicle of claim 10, wherein the at least one mechanical coupler is secured to the mounting lug and the tubular component prior to the structural adhesive being positioned in the adhesive chamber through the port in the mounting lug.

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12. The vehicle of claim 8, wherein the mounting lug is a first material and the tubular component is a second material, the second material being different from the first material.

13. The vehicle of claim 8, wherein the structural adhesive surrounds an exterior of one of the mounting lug and the tubular component.

14. The vehicle of claim 8, wherein the structural adhesive is an acrylic based adhesive.

15. A method of assembling a snowmobile frame, comprising the steps of:

providing a first frame member of the snowmobile and a second frame member of the snowmobile, where the first and second frame members overlap to define a closed intersection;

positioning the first frame member of the snowmobile relative to the second frame member of the snowmobile;

aligning the first and second frame members together by joining the first frame member of the snowmobile to the second frame member of the snowmobile with a mechanical coupler which passes through an opening in at least one of the first frame member of the snowmobile and the second frame member of the snowmobile;

defining a cavity intermediate the first and second frame members within the closed intersection, the cavity being defined by an annular recess on one of a mounting lug or a tubular component and a lip at an end of the mounting lug extension portion closing off the cavity; and

securing the first frame and second frame members of the snowmobile by filling the cavity with a structural adhesive after joining the first frame member to the second frame member with the mechanical coupler, the mechanical coupler being spaced apart from the structural adhesive.

16. The method of claim 15, wherein the first frame member of the snowmobile and the second frame member of the snowmobile cooperate to form an adhesive chamber for receiving the structural adhesive.

17. The method of claim 16, wherein the step of securing the frame member of the snowmobile to the second frame member of the snowmobile with a structural adhesive includes the step of introducing the structural adhesive into at least one port provided in the first frame member of the snowmobile, the at least one port being in fluid communication with the adhesive chamber.

18. The method of claim 16, wherein the annular recess is defined on an inside diameter of the extension, wherein the annular recess defines the lip at a free end of the extension, the lip having an inside diameter substantially equal to the outer diameter of the corresponding tube.

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