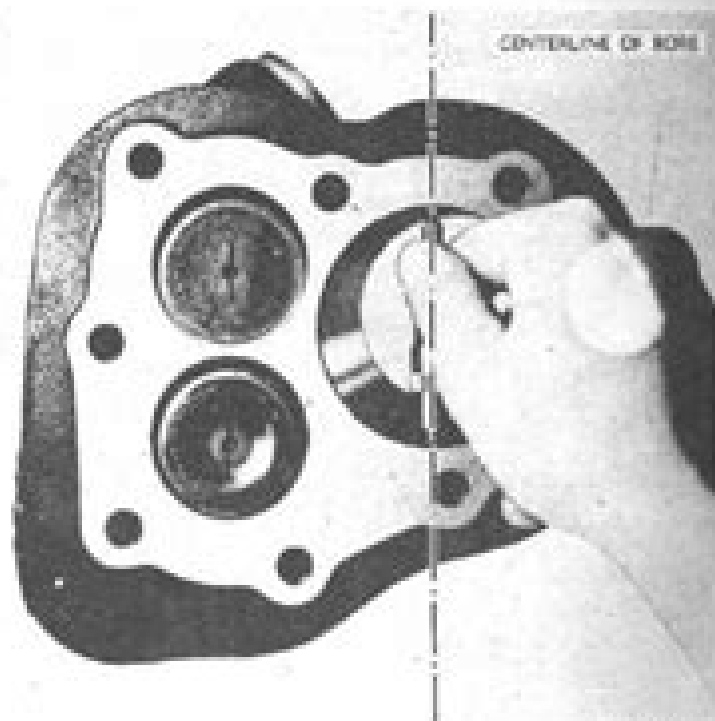


refaced from time to time, the valve seats widen and the valves will seat in a lower position when fully closed. Also, passage around valves when fully open is somewhat restricted. To correct this condition, cut additional clearance above valve seat so top edges of angular valve face and valve seat match exactly.

(3) **Valve Springs** (Fig. 10). Inspect each valve spring in comparison with a new one. If free length of spring is $\frac{1}{16}$ inch, or less



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Figure 9—Measuring Cylinder Bore One-half Inch From Top, with Inside Calipers (81-C-304)

than length of new spring, replace with a new spring. New valve springs will average $2\frac{1}{16}$ inches free length. Compression of new spring will be between 95 and 105 pounds when compressed to $1\frac{1}{4}$ inches.

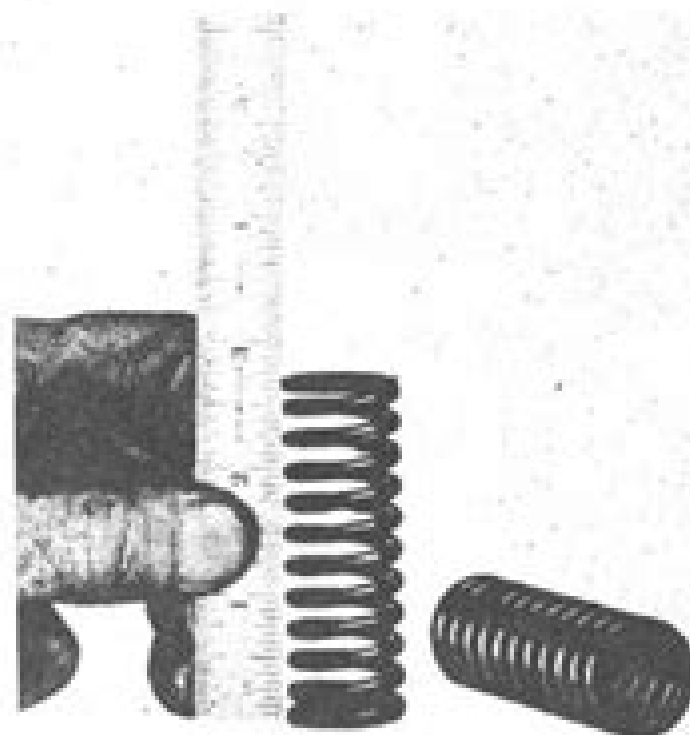
9. REPAIR OF CYLINDER AND VALVES.

a. **Cylinder.** Cylinders can be refinished oversize either with a hone only, or with a boring bar followed by a finishing hone. Cylinders

DISASSEMBLY, CLEANING, INSPECTION, REPAIR AND ASSEMBLY

heavily worn or deeply scored are first re-bored to nearly the required oversize and then are finish-bored to exact size.

(1) When refitting cylinders oversize, add the oversize step apparently required to clean up bore to standard cylinder bore size; this gives the exact size to which cylinder should be refinished; example: 2.745 inches (standard bore) plus 0.028 inch (oversize) equals



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Figure 10—Measuring Length of Valve Springs

2.765 inches (size to which cylinder should be refinished). Check carefully with micrometers to be sure of refitting to this size (Fig. 9). If this is accurately done, oversize pistons furnished in various oversize steps will fit with normal clearance (0.0015 to 0.0025 inch). Oversize pistons have their oversize stamped on their head; for example: 10, 20, etc.

b. Valve Guides.

(1) If valve stem and guide clearance exceeds 0.006 inch, press out guides and install new ones. Press or drift guides out of cylinder

Harley Solo 45 Wla 1929 1952 Workshop Repair Service Manual

Kathleen Armour



Harley Solo 45 Wla 1929 1952 Workshop Repair Service Manual:

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