

SERVICE

SHOP DOPE

No. 328

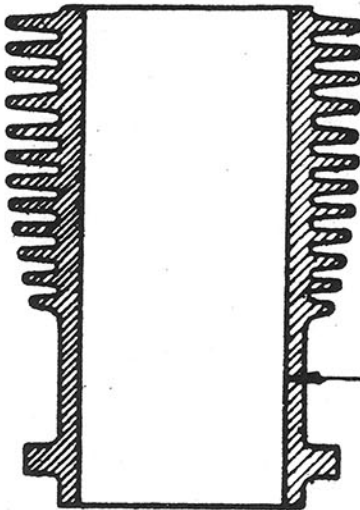
June 4, 1952

CYLINDER REBORING AND PISTON FITTING INFORMATION

Supersedes Shop Dope Sheet No. 253

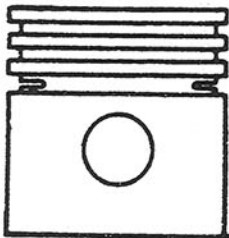
(Note: Dimensions given are standard size.)

TOP



Standard bore
dimension of
cylinder.

45" (1935 and later)	2.745"
74" (1935 and 1936, and all 80")	3.422"
74" Side Valve (1937 to 1948)	3.3125"
61" Overhead Valve (1936 and later)	3.3125"
74" Overhead Valve (1941 and later)	3.4375"
125 c.c. Model (1948 and later)	2.0625"
Model K	2.745"



All Models except 125 c.c. Model — piston should be fitted .001" to .002" clearance in cylinder, checking fit at bottom of skirt, front to rear.

125 c.c. Model — piston should be fitted .003" to .004" clearance in cylinder, checking fit at bottom of skirt, front to rear.

HARLEY-DAVIDSON MOTOR CO.

Milwaukee, Wisconsin

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The **Old Sportster and K-model Research Group (OSKRG)** is a group of individuals who have spent years researching the minute differences in the parts, fit, finish, and configuration of the Harley-Davidson 1952-1956 K-Models, and (early) 1957-1969 Sportster models.

The results of our research is published on our website
www.harleyKmodel.com