

## Cylinder Inspection

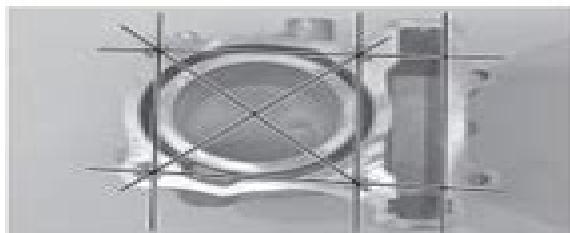
Refer to "Cylinder Head Assembly / Cam Chain Guide / Cylinder Removal and Installation" (Page 1D-28).

### Cylinder Distortion

Check the gasket surface of the cylinder for distortion with a straightedge and thickness gauge, taking a clearance reading at several places as indicated. If the largest reading at any position of the straightedge exceeds the limit, replace the cylinder.

**Special tool**  
09900-20803

**Cylinder distortion**  
[Limit]: 0.05 mm (0.002 in)



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### Cylinder Bore

Check the cylinder wall for any scratches, nicks or other damage. Measure the cylinder bore diameter at six places.

**Special tool**  
09900-20530

**Cylinder bore**  
[Standard]: 62.000 – 62.015 mm (2.4410 – 2.4415 in)



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## Piston Removal and Installation

Refer to "Cylinder Head Assembly / Cam Chain Guide / Cylinder Removal and Installation" (Page 1D-28).

### Removal

- 1) Place a clean rag over the cylinder base so as not to drop the piston pin circlip (1) into the crankcase.
- 2) Remove the piston pin circlip.

- 3) Draw out the piston pin (2) and remove the piston (3).



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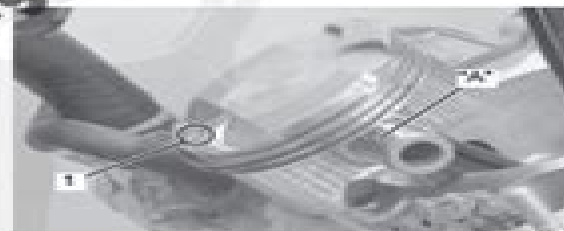
### Installation

- 1) When installing the piston, apply molybdenum oil solution onto the piston pin.

#### NOTE

When installing the piston, the indent (1) on the piston head must be faced to exhaust side.

"A": Assembly lubrication (Molybdenum oil solution)

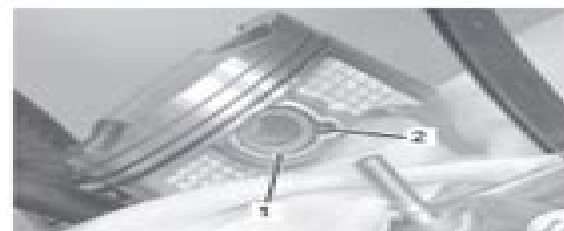


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- 2) Place a clean rag over the cylinder base so as not to drop the piston pin circlip (1) into the crankcase.
- 3) Install a new piston pin circlip.

#### NOTE

End gap of the circlip should not be aligned with the cutaway (2) in the piston pin bore.



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# Zahn R150 Parts Manual

**Padhraic Smyth**



**Zahn R150 Parts Manual:**

**Quick Reference Parts Manual** Engine Service Association,1976      Boughton Instruction & Parts Manual for Model C. 125 ,      **Parts Manual for All "K" Models, 1952 to 1956** Harley-Davidson Motor Company,1956\*      *Master Replacement Parts Service Manual* Auto Parts Company,1922

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