

Delkron Twin Cam Cylinder Instructions

Congratulations you have just purchased the finest cylinder available today for your Twin Cam engine. Thank you for your purchase and we at Delkron know you will get many years of enjoyment from this product if you follow our assembly instructions.

- Inspect cylinder for any damage that may have occurred in shipping. Delkron is not responsible for freight damage and all claims should be made immediately with the carrier.
- CLEAN the cylinders with HOT SOAPY WATER. First the HOT water will open the pores of the metal, this is important, secondly the soap will help break down the honing oil and aid in cleaning the silicon carbide honing grit from the pores of the liner. If possible submerge the cylinder in the hot soapy solution and scrub the bore with a soft white towel. This step is important and must be done. Spraying the cylinder with break clean or similar aerosol cleaners alone will not clean the cylinder properly.
- Once you have cleaned the cylinder with hot soapy water. Blow the cylinder dry with compressed air thoroughly.
- Next take some clean engine oil preferably non-synthetic and a clean white cloth and work the bore until the rag comes out clean. Initially you will see grey material on the rag. Work the bore until this is gone and the cloth is clean.
- Once the cylinder is thoroughly cleaned Delkron recommends checking the deck height of the piston in the cylinder.
- Install the top ring only on the piston and install the base gasket if one is used.
- For optimum performance Delkron recommends setting the deck height at zero. This means at Top Dead Center the flat part of the piston is level with the top of the cylinder. This should be checked over the wrist pin with a feeler gauge and straight edge if a depth mic is not available.
- Delkron manufactures it's cylinders to a stock length spec 4.937" unless customer makes arrangements for a custom length.
- It is common for a Twin Cam piston to be .005" to .015" below deck and if using a .020" base gasket you may need to deck the cylinder as much as .035" to achieve .000" deck. All machine work should be done by a qualified machinist.

It is the sole responsibility of the assembler to ensure the cylinders are clean, the ring end gaps are set per piston manufacturers instructions and all clearances are checked before final assembly. If you are not confident of your skill level please let a qualified professional do the work. Failure to follow cleaning and assembly instructions will void any warranty claims.

Delkron
8090 Auburn Rd
Concord, OH 44077
866-335-5766 Phone Toll Free 61713