



INSTRUCTIONS

-J02359

REV. 12-23-02

Kit Numbers 22444-0200, 22445-02, 22446-02, 22447-02, 22447-02, 22448-02, 22449-02, 22450-02, 22451-02 and 22452-02

SCREAMIN' EAGLE TWIN CAM (HTCC Heads) STROKER FORGED PISTON KIT

General

These High Compression forged stroker piston kits are designed for installation on Harley-Davidson Twin Cam motorcycles with stroker flywheels, HTCC heads and 1550 big bore cylinders installed.

<u>Kit Number</u>	<u>Description</u>
22444-02	Forged Piston Kit, Standard (pair)
22445-02	Forged Piston Kit, + .005 (pair)
22446-02	Forged Piston Kit, + .010 (pair)
22447-02	Front, Forged Piston Kit, Standard
22448-02	Rear, Forged Piston Kit, Standard
22449-02	Front, Forged Piston Kit, + .005
22450-02	Rear, Forged Piston Kit, + .005
22451-02	Front Forged Piston Kit, + .010
22452-02	Rear, Forged Piston Kit, + .010

NOTE

1550 Kits require separate purchase of two head gaskets (part number 16787-99). These are available from your Harley Davidson Dealer.

For optimal performance, exhaust seals should be replaced with Screamin' Eagle Exhaust Seals (Part Number 17048-98).

See Service Parts Page a list of kit contents.

WARNING

The rider's safety depends on the correct installation of this kit. If the Service Manual instructions are not within your capabilities or you do not have the correct tools to install this kit, have your Harley-Davidson dealer perform this installation. Incorrect installation of this kit could result in death or serious injury.

CAUTION

This engine related performance part is intended for High Performance or Racing applications and is not legal for sale or use on pollution controlled motor vehicles. This kit will reduce or void the limited vehicle warranty. Engine related performance parts are intended for the experienced rider only.

WARNING

To avoid death or serious injury, do not smoke or allow open flame or sparks anywhere in the area when working on fuel system components. Gasoline is extremely flammable and highly explosive under certain conditions.



Figure 1. Kit Contents (Kit Part Number 22444-02 Shown)

WARNING

To protect against shock and accidental start-up of vehicle, disconnect the negative battery cable before proceeding. Inadequate safety precautions could result in death or serious injury.

WARNING

Always disconnect the negative battery cable first. If the positive battery cable should contact ground with the negative cable installed, the resulting sparks may cause a battery explosion which could result in death or serious personal injury.

SERVICE MANUAL REQUIRED

This Instruction Sheet refers to the applicable Service Manual for many procedures; therefore, Harley-Davidson recommends that you do not attempt to install this kit without having a copy of the Service Manual covering your model available. Service Manuals are available from your Harley-Davidson dealer.

Installation Notes

1. **Disassembly** - Follow the procedures in the ENGINE section of the Service Manual to remove cylinder heads, cylinders and pistons.
2. **Inspection Of Parts** - Follow the procedures in the ENGINE section of the Service Manual for Inspection of Parts.
3. **Boring And Honing** - Follow the procedures in the ENGINE section of the Service Manual for Boring and Honing instructions.
4. **Assembly** - Follow the procedures in the ENGINE section of the Service Manual to install cylinder heads, cylinders and pistons.

NOTES

- Install rings with dots or bevels facing up. Rings with no markings can be installed either side up.
- 1550 Cylinders do not use O-rings (part number 11273) on the top cylinder dowels. Therefore, do not install them when using torque plates or at final assembly of engine.
- Re-jetting, and/or re-timing of engine, may be required to realize full potential of this performance product.
- All dimensions listed are given in inches. Piston dimensions to be measured .38 inches above lowest part of skirt.
- Always follow the break-in procedure outlined in the appropriate owner's manual after rebuilding an engine.

Specifications	
PISTONS	
Fit in cylinder	.0025-0035
Compression ring gap	
Top	.009-.015
Second	.019-.029
Oil control rail gap	.010-.030

Service Wear Limits	
PISTONS	
Fit in cylinder	.005
Compression ring gap	
Top	.025
Second	.039
Oil control rail gap	.030

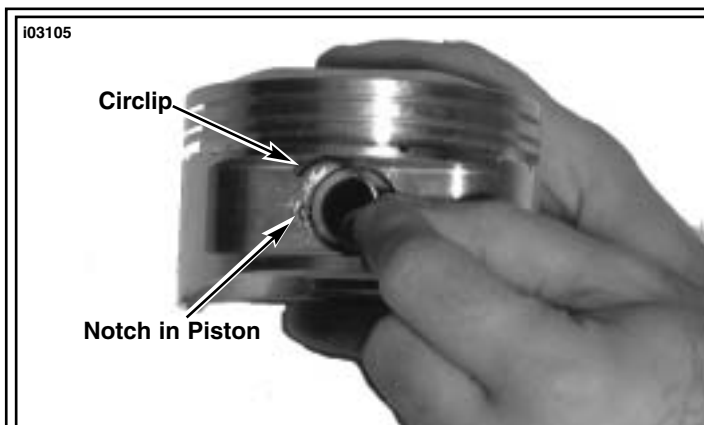


Figure 2.

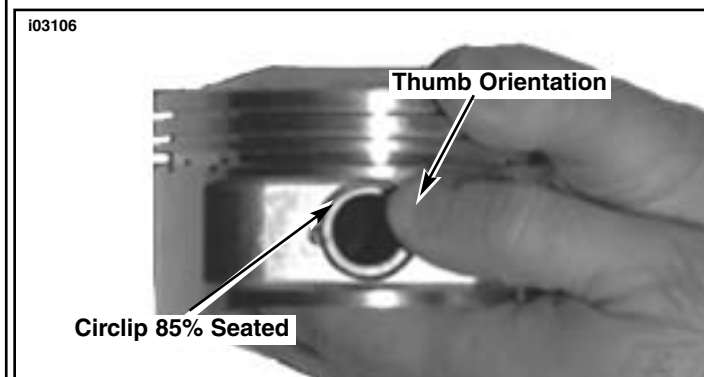


Figure 3.

NOTE

To install Piston Pin Circlips, use the following procedure.

NOTE

Piston in photo not Included in kit. Shown for Circlip installation purposes only.

1. See Figure 2. Insert open end of circlip into notched section of piston.
2. See Figure 3. Using thumb oriented as shown, press firmly until approximately 85% of circlip is seated.
3. Being careful not to scratch or mar piston, use a small bladed screwdriver to wedge circlip into remainder of groove. Repeat for remaining circlips.

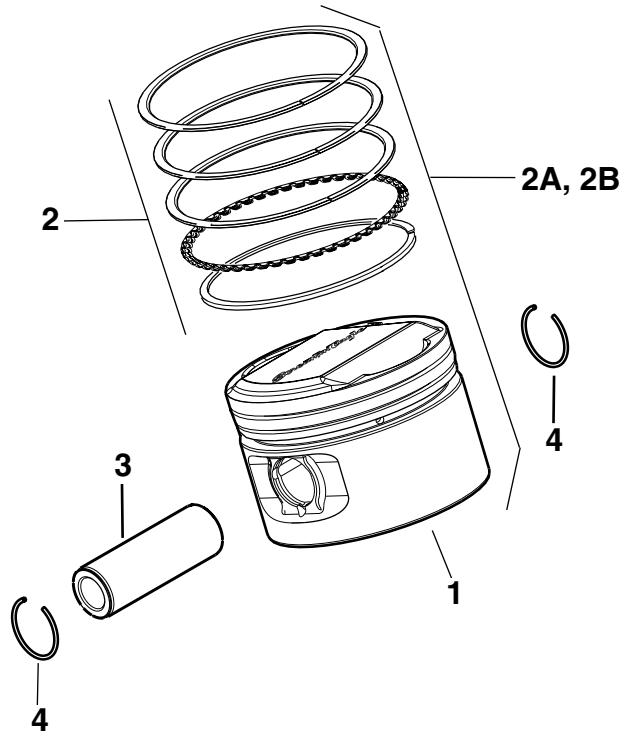


Service Parts

Kit Nos. 22444-02 and others Date 12/02

S.E. Twin Cam Stroker Piston Kit

i03104



Item	Description	Part Number	Item	Description	Part Number
1	Piston	not sold	2B	Rear Piston and Ring Set Kits	
2	Ring set			Piston and ring set (Standard)	22448-02
	Standard (2)	22457-03		Piston and ring set (+.005)	22450-02
	+.005 (2)	22458-03		Piston and ring set (+.010)	22452-02
	+.010 (2)	22459-03			
2A	Front Piston and Ring Set Kits		3	Piston pin (2)	22455-03
	Piston and ring set (Standard)	22447-02	4	Piston pin circlip (4)	22456-03
	Piston and ring set (+.005)	22448-02			
	Piston and ring set (+.010)	22451-02			