

**MAINTENANCE
MANUAL
AND
INSTRUCTION
BOOK**

for

1950

350 c.c. and 500 c.c.

A·J·S

SPRING FRAME AND RIGID MODELS

PRICE 2/6 NETT



A·J·S

MOTOR CYCLES

PROPRIETORS: ASSOCIATED MOTOR CYCLES LIMITED

PLUMSTEAD · LONDON · S.E.18

WHEN CORRESPONDING REGARDING
SERVICE OR SPARES

ALWAYS QUOTE
THE COMPLETE ENGINE NUMBER
(Including all the Letters in It).

THIS ENABLES US TO IDENTIFY THE MACHINE

EACH SERIES OF FRAMES IS NUMBERED FROM ZERO
UPWARDS. THEREFORE THE QUOTATION OF A
FRAME NUMBER ONLY DOES NOT PERMIT A MACHINE
TO BE IDENTIFIED.

MAINTENANCE MANUAL AND INSTRUCTION BOOK

for

A·J·S

1950

SINGLE CYLINDER MOTOR CYCLES



Compiled and Issued by the Manufacturers :

A·J·S MOTOR CYCLES

(Proprietors : ASSOCIATED MOTOR CYCLES LIMITED)

Registered Offices :

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Price : TWO SHILLINGS and SIXPENCE

EDITION CM-13

1950 A.J.S. MODELS

350 MODEL 16M RIGID FRAME

350 MODEL 16MS SPRING FRAME

350 MODEL 16MC COMPETITION

500 MODEL 18 RIGID FRAME

500 MODEL 18S SPRING FRAME

500 MODEL 18C COMPETITION

350	— Bore 69 mm.	Stroke 93 mm.	Capacity 347 c.c.
500	— Bore 82.5 mm.	Stroke 93 mm.	Capacity 498 c.c.

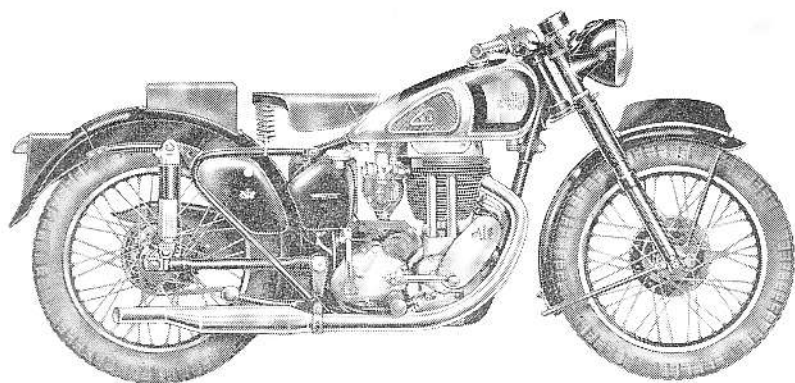
INTRODUCTION

Motorcycling is one of the most economical and pleasurable modes of transport. It is our sincere wish that every "A.J.S." owner should obtain, from his mount, the service, comfort and innumerable miles of low-cost travel that we have earnestly endeavoured to build into it. However, it must be remembered that, although a motor cycle is of simple design and construction, it is, nevertheless, a highly specialised piece of engineering. In consequence, it must be intelligently and efficiently maintained in order to provide unfailing reliability.

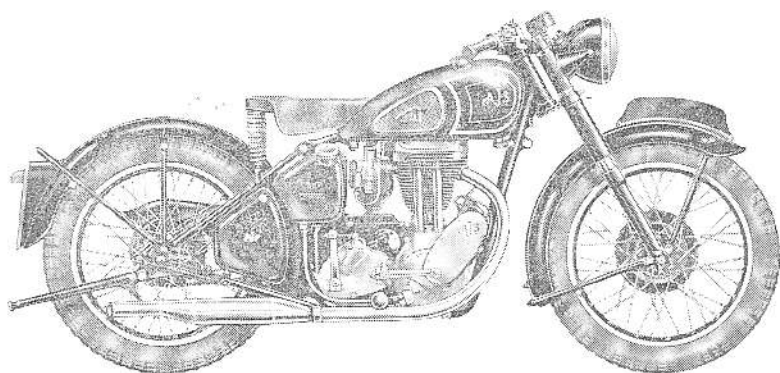
In this book are non-technical instructions for carrying out all the maintenance operations likely to be called for in strenuous service and illustrations are provided to assist. Neglect to make essential adjustments, only casual attention to lubrication and the lack of periodical maintenance attention will soon neutralise the best efforts of the designers and may bring needless trouble to the owner.

We are always pleased to give "A.J.S." owners the full benefit of our wide experience in matters relating to motor cycles of our manufacture and elsewhere will be found details of the particulars that should be given us when making such an enquiry.

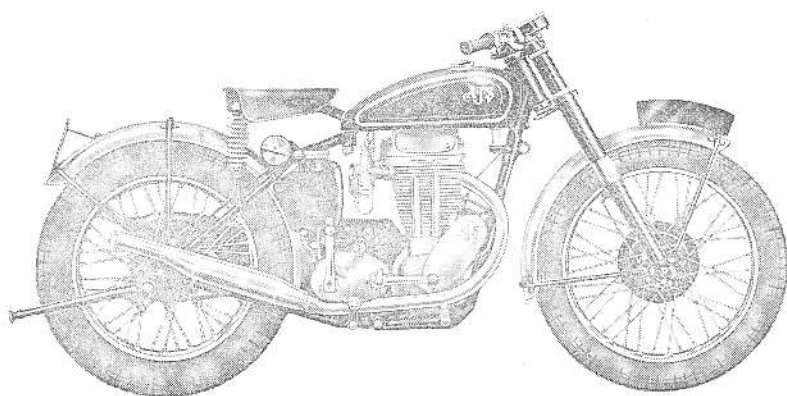
A.J.S. MOTOR CYCLES



16MS and 18S SPRING FRAME



16M and 18 RIGID FRAME



16MC and 18C COMPETITION

DATA

Identity

Make	A.J.S.
Models	350 c.c. 50/16M 50/16MS 50/16MC 500 c.c. 50/18 50/18S 50/18C
Engine Number	Stamped on left hand side of crankcase
Frame Number	Stamped on seat lug of main frame, on right hand side (below the saddle)
Number of Cylinders (all models)	One
Bore	350 c.c. Models—69 mm. (approx.) ($2\frac{3}{4}$ in.) 500 c.c. Models—82.5 mm. (approx.) ($3\frac{1}{4}$ in.)
Stroke	All Models—93 mm. (approx.) (3.6525 in.)
Engine capacity, in cubic centimetres	350 Models—50/16M, 50/16MS and 50/16MC—347 500 Models—50/18, 50/18S and 50/18C—498

THE MEASUREMENTS IN THE FOLLOWING DATA GIVE, IN MANY INSTANCES, OUR HIGH AND LOW MACHINING LIMITS. IN THOSE CASES THE HIGH LIMIT IS INDICATED BY (H) AND THE LOW BY (L)

Axles

The gear box main shaft is 10 $\frac{1}{4}$ inches in overall length

(Touring Models) ...	Part Number 10-C-20
(Competition Models) ...	Part Number 10-C-15

Bearings (ball and roller)

Location	Internal diameter	External diameter	Thickness	Part number
Driving side flywheel axle ball bearing ...	1 in.	2 $\frac{1}{4}$ in.	$\frac{5}{8}$ in.	RLS-8
Gear box main gear ball bearing ...	1 $\frac{33}{64}$ in.	62 mm.	16 mm.	177-X-1
Gear box main shaft ball bearing ...	17 mm.	40 mm.	12 mm.	68-X-1
Crankpin roller bearings (30 to a set) ...	—	$\frac{1}{8}$ in.	$\frac{1}{8}$ in.	STD-75

Bearings (bushes)

Location	Internal diameter	Part number
Bush, for timing side flywheel axle* ...	$\frac{7}{8}$ in. + .0005 in. (H) — .0000 in. (L)	STD-650
Bush, for camshaft	$\frac{1}{2}$ in. + .0005 in. (H) — .0005 in. (L)	STD-651 and STD-652
Bush, for overhead rocker axle*	$\frac{5}{8}$ in. + .00075 in. (H) — .00050 in. (L)	38-G4-E204
Bush, for gudgeon pin*	$\frac{7}{8}$ in. + .00050 in. (H) — .00025 in. (L)	L3-E89
Bush, for layshaft6125 ± .001 in.	181-X-1

*Reamed to stated internal diameter after fitting.

Brake Liners

Length	Width	Thickness	Radius	Quantity off	Part number
6 $\frac{5}{8}$ in.	$\frac{7}{8}$ in.	$\frac{3}{16}$ in.	3 $\frac{1}{2}$ in.	4 (2 per brake)	3836-2

Brake liner rivets

Diameter	Length	Material	Type	Head	Quantity per liner	Part number
$\frac{1}{4}$ in.	$\frac{3}{4}$ in.	Copper	Tubular	Tinmans No. 11	6	STD-113

Capacities

Location	British	Metric
Engine	350 c.c. 21-170 cub. in.	347 c.c.
Engine	500 c.c. 30-380 cub. in.	498 c.c.
Gear box	1 pint	568-2 c.c.
Front fork (each side)	10 fl. ozs.	284 c.c.
Rear leg (each leg)*	1½ fl. ozs.	50 c.c.
Rear wheel fork hinge bearing*	1½ fl. ozs.	42-6 c.c.
Fuel tank (Rigid and Spring frame)	3 gallons	13-638 litres
Fuel tank (Competition)	2½ gallons	10-2285 litres
Oil tank	4 pints	2-275 litres

*On Spring Frame Models only (50/16 MS and 50/18S).

Carburettor

	16M and 16MS	16MC	18 and 18S	18C
Type	76AL/1AK	76AE/1AK	89M/1AK	89B/1AK
Main jet size	150	150	180	180
Throttle valve size	6/4	6/4	29/4	29/4
Jet taper position	3rd notch from top	3rd notch from top	2nd notch from top	2nd notch from top

Connecting rod

Internal diameter small end	Internal diameter big end	Centres	Part number
7 in. + .00050 in. (H) 8 - .00025 in. (L)	1-70400 in. (H) 1-70375 in. (L)	6½ in.	010312

Chains

Models	Location	Pitch	Width	Number of Links	Part number
350 Competition	Front driving	½ in.	.305 in.	65	110046-65
350 Touring	Front driving	½ in.	.305 in.	66	110046-66
500 Competition	Front driving	½ in.	.305 in.	66	110046-66
500 Touring	Front driving	½ in.	.305 in.	67	110046-67
All rigid models	Rear driving	¾ in.	.380 in.	94	110056-94
All spring models	Rear driving	¾ in.	.380 in.	98	110056-98
All competition models	Rear driving	¾ in.	.380 in.	90	110056-90
All models	Dynamo	¾ in.	.225 in.	49	110038-49
All models	Magneto	¾ in.	.225 in.	46	110038-46

DYNAMO AND MAGNETO CHAINS ARE ENDLESS. "NUMBER OF LINKS" OF FRONT AND REAR DRIVING CHAINS INCLUDE ONE SPRING CONNECTING LINK PER CHAIN.

Chain whip (all models)

Front chain	Rear chain	Dynamo chain	Magneto chain
¾ in.	¾ to ¾ in.*	¾ in.	¾ in.

*When no load on the saddle the chain whip on Spring Frame Models is 1 ⅛ in.

Clutch

Model	Clutch thrust rod Overall length	Clutch thrust rod diameter	Part number	Clearance*
350	9 ⅞ in.	⅜ in.	28-X-56	⅛ in.
500	10 ⅞ in.	⅜ in.	28-X-57	⅛ in.

*This is the clearance between the operating plunger and the nose of the clutch lever located inside the kick-starter case.

Compression ratios

Model	With no compression plate	With one compression plate
350	6.35 to 1	5.88 to 1
500	7.24 to 1	6.00 to 1

Gear box ratios

	First gear	Second gear	Third gear	Fourth gear (top)
Standard	1 to 2.67	1 to 1.76	1 to 1.28	1 to 1
Competition	1 to 3.16	1 to 2.09	1 to 1.28	1 to 1

Gear ratios (models 16M-16S-18-18S)

Engine sprocket size	First gear	Second gear	Third gear	Fourth gear (top)	Part number
15 teeth	18.69 to 1	12.32 to 1	8.96 to 1	7 to 1	014015
16 teeth	17.5 to 1	11.54 to 1	8.39 to 1	6.56 to 1	014016
17 teeth	16.44 to 1	10.84 to 1	7.88 to 1	6.16 to 1	014017
18 teeth*	15.57 to 1	10.26 to 1	7.47 to 1	5.83 to 1	014018
19 teeth	14.6 to 1	9.6 to 1	7.0 to 1	5.49 to 1	014019
20 teeth	14.01 to 1	9.24 to 1	6.72 to 1	5.25 to 1	014020
21 teeth†	13.35 to 1	8.8 to 1	6.4 to 1	5.0 to 1	014021

*Standard Solo sprocket for Models 16M and 16S.

†Standard Solo sprocket for Models 18 and 18S.

Gear ratios (models 16C-18C)

Engine sprocket size	First gear	Second gear	Third gear	Fourth gear (top)	Part number
15 teeth	22.12 to 1	14.63 to 1	8.96 to 1	7 to 1	014015
16 teeth *	20.72 to 1	13.71 to 1	8.39 to 1	6.56 to 1	014016
17 teeth	19.46 to 1	12.87 to 1	7.88 to 1	6.16 to 1	014017
18 teeth †	18.44 to 1	12.20 to 1	7.47 to 1	5.83 to 1	014018
19 teeth	17.34 to 1	11.47 to 1	7.0 to 1	5.49 to 1	014019
20 teeth	16.59 to 1	10.97 to 1	6.72 to 1	5.25 to 1	014020
21 teeth	15.8 to 1	10.45 to 1	6.4 to 1	5.0 to 1	014021

*Standard Solo sprocket for Model 16C.

†Standard Solo sprocket for Model 18C.

Gudgeon pin

Model	External diameter	Length	Part number
350	7 in. -0010 in. 8 -0013 in.	2.248 +005 in. -005 in.	D3-E1614
500	7 in. -0010 in. 8 -0013 in.	2.781 +005 in. -005 in.	D5-E614

Ignition (magneto)

Model	Make	Type	Rotation	Point gap	Ignition point before top dead centre (with control in fully advanced position)
16M-16MS-18-18S	Lucas	NI-3-AO	Anti-clock	.012 in.	$\frac{1}{8}$ in. (39°)
16MC-18C	Lucas	NRI	Anti-clock	.012 in.	$\frac{1}{8}$ in. (39°)

Ignition (sparking plug)

Model	Make	Type	Thread	Reach	Point gap
Standard	K.L.G.	F80	14 mm.	$\frac{1}{2}$ in.	.015 in.
Competition	K.L.G.	FE80	14 mm.	$\frac{3}{4}$ in.	.015 in.

Lighting (dynamo)

Make	Type	Voltage	Rotation	Part number
Lucas	E3AR-A03-1	6	Anti-clock	200430

Lighting (bulbs)

Location	Type	Voltage	Wattage	Cap	Part number
Head lamp	Double filament	6	24 x 24	S.B.C.	168
Pilot	Single contact	6	3	M.B.C.	988
Rear lamp	Single contact	6	3	M.B.C.	988
Speedometer	Single contact	6	1.8	M.B.C.	53205

Upsize parts

The following are the only "upsize" variations provided for the 350 and 500 c.c. Single Cylinder machines.

Big-end rollers :
 .001 in. upsize
 Cylinder re-bore :
 .020 in. upsize
 Pistons and rings :
 .020 in. upsize

Pistons

Model	Top land diameter	Top of skirt diameter	Bottom of skirt diameter	Part number
350	2-6840 in.	2-7176 in.	2-7180 in.	013504
500	3-2166 in.	3-2490 in.	3-2494 in.	013505

All above measurements are subject to a tolerance limit of \pm or $-$.0005 in.

Piston rings

Model	Description	Diameter	Width	Depth	Quantity per piston	Part number
350	Compression	2 $\frac{3}{8}$ in.	.0625 in. (H) .0615 in. (L)	.100 in. (H) .092 in. (L)	2	D3-E311
350	Scraper	2 $\frac{3}{8}$ in.	.125 in. (H) .124 in. (L)	.100 in. (H) .092 in. (L)	1	38-G3-E111
500	Compression	3 $\frac{1}{4}$ in.	.0625 in. (H) .0615 in. (L)	.116 in. (H) .108 in. (L)	2	010636
500	Scraper	3 $\frac{1}{4}$ in.	.125 in. (H) .124 in. (L)	.116 in. (H) .108 in. (L)	1	010637
Piston ring gap—Normal						.006 in.
Permissible maximum						.030 in.
Piston ring clearance in groove						.002 in.

Spokes (350 and 500 rigid and spring frame models)

Location	Type	Gauge	Length underhead	Quantity	Part number
Front, left side	Butted	8 \times 10	5 $\frac{1}{8}$ in.	20	011018 (37-X-H51)
Front, right side	Butted	9 \times 11	8 $\frac{1}{8}$ in.	20	011014 (12399)
Rear, left side	Butted	7 \times 9	8 $\frac{1}{8}$ in.	20	011012 (39-8-H54)
Rear, right side	Butted	7 \times 9	8 $\frac{1}{8}$ in.	20	011012 (39-8-H54)

Spokes (350 and 500 Competition models)

Location	Type	Gauge	Length underhead	Quantity	Part number
Front, left side	Butted	8 \times 10	6 $\frac{1}{4}$ in.	20	012786
Front, right side	Butted	9 \times 11	9 $\frac{7}{8}$ in.	20	38-18T-H51
Rear, left side	Butted	6	8 $\frac{1}{8}$ in.	20	36-2-H51
Rear, right side	Butted	6	8 $\frac{1}{8}$ in.	20	36-2-H51

Speedometer

Models	Make	Graduated in	Maximum speed	Type number
350	Smith	Miles per hour	80	S-433-1-L
350	Smith	Kilometres per hour	140	S-433-5-L
500	Smith	Miles per hour	120	S-480-3-L
500	Smith	Kilometres per hour	180	S-480-7-L

Sprockets (engine)

Model	Number of teeth	Chain pitch	Chain width	Part number
16C	16	$\frac{1}{2}$ in.	.305 in.	014016
16M	16	$\frac{1}{2}$ in.	.305 in.	014018
18C	18	$\frac{1}{2}$ in.	.305 in.	014018
16S	16	$\frac{1}{2}$ in.	.305 in.	01402
18	18	$\frac{1}{2}$ in.	.305 in.	01402
18S	18	$\frac{1}{2}$ in.	.305 in.	01402

Sprockets (all models)

Location	Number of teeth	Chain pitch	Chain width	Part number
Clutch	40	$\frac{1}{2}$ in.	.305 in.	7-X-28
Gear box	16	$\frac{5}{8}$ in.	.380 in.	179-X-7
Rear wheel	42	$\frac{5}{8}$ in.	.380 in.	012570* 010293†

*Rigid Frame only.
†Spring Frame only.

Valves

Location	Diameter of head	Diameter of stem	Seat angle	Part number	Clearance with cold engine
350 inlet	1 $\frac{13}{32}$ in.	.3730 in. (H) .3720 in. (L)	45°	013985	Nil*
350 exhaust	1 $\frac{1}{2}$ in.	.3715 in. (H) .3705 in. (L)	45°	013986	Nil*
500 inlet	1.687 in.	.3730 in. (H) .3720 in. (L)	45°	013988	Nil*
500 exhaust	1.687 in.	.3715 in. (H) .3705 in. (L)	45°	013989	Nil*

*On Competition engines the clearance is made with a warm engine.

Valve guides

Location	Protrusion	External diameter	Internal diameter	Part number
Inlet valve	$\frac{1}{2}$ in.	$\frac{5}{8}$ in. + .00175 in. (H) + .00225 in. (L)	.3750 in. (L) .3735 in. (H)	39-12-E148
Exhaust valve	$\frac{9}{16}$ in.	$\frac{5}{8}$ in. + .00175 in. (H) + .00225 in. (L)	.3750 in. (L) .3735 in. (H)	014510

Valve timing (with .016 inch rocker clearance)

INLET VALVE			EXHAUST VALVE		
Opens before top dead centre ...	32°		Opens before bottom dead centre ...	65°	
Closes after bottom dead centre ...	63°		Closes after top dead centre ...	30°	

Valve timing pinion

Retained by nut, threaded $\frac{1}{16}$ in. by 26 threads per in. Left hand thread. Part number STD-221.

Weight

Weight of machine with empty tanks

Model	Standard Rigid frame	Spring frame	Competition
350	344 lbs.	375 lbs.	300 lbs.
500	353 lbs.	386 lbs.	303 lbs.

Wheels (tyres)

Models	Size	FRONT TYRE		Size	REAR TYRE	
		Pressure for solo	Pressure for pillion		Pressure for solo	Pressure for pillion
16M	19×3.25 in.	16 lbs.	16 lbs.	19×3.25 in.	21 lbs.	23 lbs.
18	19×3.25 in.	17 lbs.	17 lbs.	19×3.50 in.	17 lbs.	19 lbs.
16S	19×3.35 in.	17 lbs.	17 lbs.	19×3.25 in.	22 lbs.	24 lbs.
18S	19×3.25 in.	17 lbs.	17 lbs.	19×3.50 in.	24 lbs.	26 lbs.
16C	21×3 in.	19 lbs.		19×4 in.	16 lbs.	
18C	21×3 in.	19 lbs.		19×4 in.	16 lbs.	

Wheels (rims)

Location	Models	Diameter	Width	Gauge	Number of spoke holes	Size of nipples
Front rim	16M-18-16S-18S	19 in.	2 $\frac{1}{2}$ in.	15	40	.225 in.
Rear rim	16M-18-16S-18S	19 in.	2 $\frac{1}{2}$ in.	15	40	.250 in.
Front rim	16C-18C	21 in.	2 $\frac{1}{2}$ in.	15	40	.225 in.
Rear rim	16C-18C	19 in.	3 in.	15	40	.300 in.

Wheels (bearing end play)

Bearing end play002 in.

CONTROLS

- (1) **Throttle twist grip.** On right handlebar. Twist inwards to open. When fully closed engine should just idle when hot.
- (2) **Air lever.** Small lever on right handlebar. Pull inwards to increase air supply to carburetter. Once set, when engine has warmed up, requires no alteration for different road speeds. Should be fully closed when starting engine from cold.
- (3) **Ignition lever.** Small lever on left handlebar. Advances and retards ignition point. Pull inwards to advance on touring models (retard on competition models). Retard two-fifths of total movement for starting.
- (4) **Valve lifter lever.** Small lever close to clutch lever. Lifts exhaust valve from seat, releasing compression in combustion chamber, enabling engine to be easily rotated for starting. Also used for stopping engine if throttle stop is set as advised above.
- (5) **Clutch lever.** Large lever on left handlebar. Grip to release clutch so that drive to rear wheel is disconnected. Used when moving away from a standstill and when changing gear.
- (6) **Front brake lever.** Large lever on right handlebar. Grip to operate front wheel brake and, for normal braking, use in conjunction with rear brake application.
- (7) **Rear brake lever.** Pedal close to left side foot rest. Depress with left foot to apply rear brake. Apply gently and use increasing pressure as the road speed decreases.
- (8) **Gear change lever.** Pedal in horizontal position close to right foot rest. Controls selection of the four speeds, or ratios, between engine and rear wheel revolutions, with a "free," or neutral, position. See illustration 3.
- (9) **Kick-starter lever.** Vertical pedal on right hand side of gear box. Operated to start the engine.
- (10) **Lighting switch.** In top of head lamp. Controls lamps by a rotating lever which has three positions:
 - (1) "OFF" Lamps not on.
 - (2) "L" Pilot bulb in head lamp and rear lamp and speedometer lamp on.
 - (3) "H" Head and rear lamp and speedometer lamp on.
- (11) **Ammeter.** In top of head lamp. Indicates flow of electric current, in, or out, of battery. ("Charge" or "Discharge.")
- (12) **Horn switch.** Press switch on right handlebar. Depress button to sound horn.
- (13) **Gear box filler cap.** Located on top edge of kick-starter case cover. Allows insertion of lubricant and access to clutch inner wire.
- (14) **Footrest for rider.** One located each side of machine.
- (15) **Petrol tank filler cap.** Located in top of fuel tank. To release, slightly depress, turn fully to the left, and then lift away. There are two locking positions. The middle position, between the fully tightened down and "lift away" positions, is in the nature of a "safety" device to prevent loss that might be occasioned by unauthorised meddling.
- (16) **Oil tank filler cap.** Located on top edge of oil tank. The construction and operation is exactly as the petrol tank filler cap.
- (17) **Dipping switch.** Trigger switch on left handlebar. Used to select normal or "dipped" beam of head lamp when main lighting switch lever is in the "H" position. (The head lamp bulb has two filaments.)

All the controls are adjustable for position. If any adjustment is made to the rear brake pedal make certain the brake does not bind and also see there is not excessive free pedal movement before the brake comes "on."

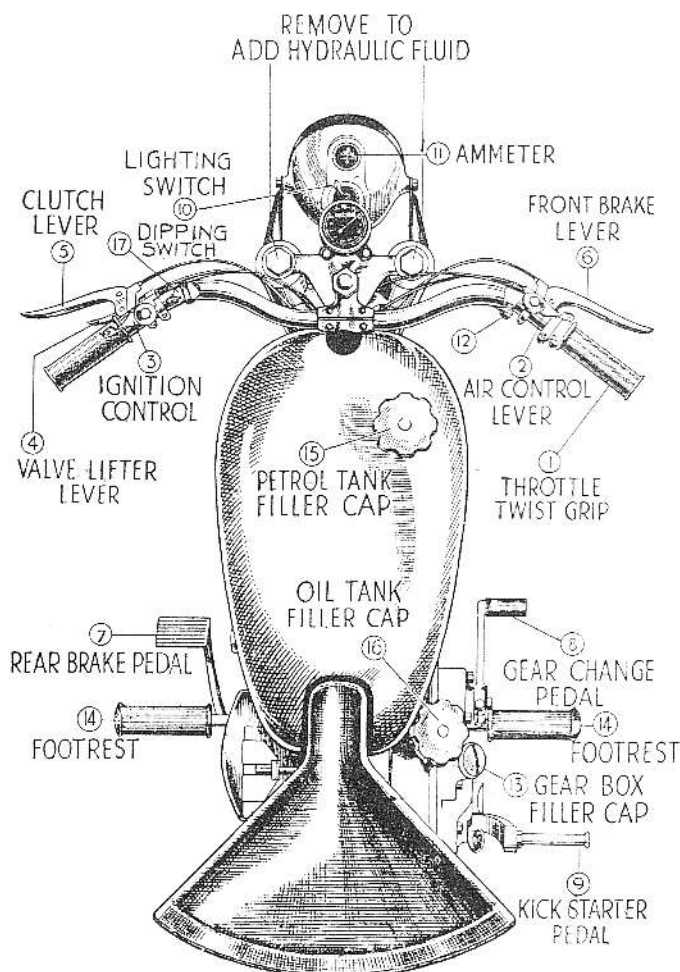


Illustration I

Showing Controls

Before using the machine, sit on the saddle and become familiar with the position and operation of the various controls. Pay particular attention to the gear positions.

DRIVING

FUEL

At the time of publishing this instruction book only one grade of motor fuel (Pool Spirit) is on sale, but it may be that soon the various grades of pre-war petrol will again be available when the use of best quality fuel is recommended because the small amount of economy that might be considered to accrue by using the cheaper grades is more than offset by the advantages obtained by using only Number One grades.

FUEL SUPPLY

Two fuel feed taps are situated underneath the rear end of the petrol tank. (One each side.) Both must be shut off when the machine is left standing for more than a few minutes.

The tap plungers work horizontally. To open, the hexagon knob (marked "**push on**") is pushed towards the body of the tap. To close, press the round milled knob (marked "**push off**").

Normally, only use the tap on the right hand side of the machine and then the other side will act as a reserve supply. Always re-fuel as soon as possible after being forced to call upon the reserve, and then, at once, close the "reserve" tap.

It will be noted that, by fitting two petrol feed taps, it is possible to remove the petrol tank from the machine without the necessity of first draining it of fuel.

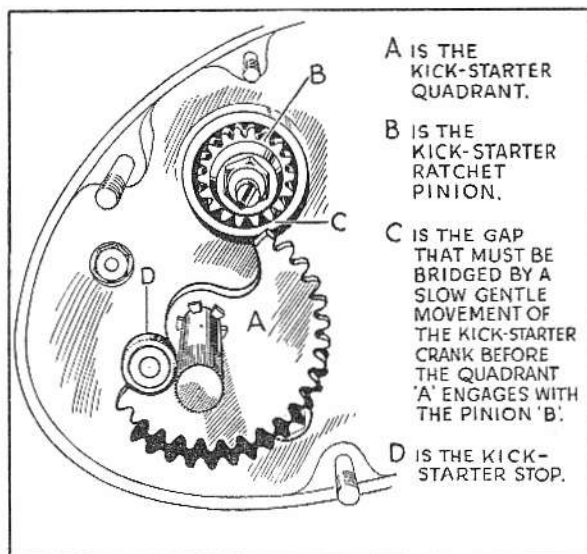


Illustration 2

Kick-starter
quadrant and ratchet pinion

STARTING THE ENGINE

- (a) See that there is sufficient fuel in the petrol tank.
- (b) See that there is sufficient oil in the oil tank.
- (c) See that the gear pedal is in the neutral position.
- (d) Push inward the hexagonal end of off-side petrol tap slide.
- (e) See that the air control lever is in the fully closed position.
- (f) Fully advance the ignition and then slack back the control lever two-fifths of its total movement.
- (g) Open the throttle not more than one-sixth of the total movement of the twist grip.
- (h) Depress the plunger on the top of the carburettor float chamber until it can be felt the chamber is full of petrol.
- (i) Raise the valve lifter lever and, while keeping it raised, turn over the engine several times by depressing the kick-starter pedal, three times, the object being to free the engine. (This only applies if the engine is cold.)
- (j) Depress the kick-starter until compression is felt, then raise the valve lifter lever and ease the engine just over compression. Then, after allowing the kick-starter pedal to return nearly to its normal position, give it a long swinging kick with the valve closed and the engine should immediately fire.

The kick-starter mechanism must be allowed to engage properly before putting heavy pressure on the kick-starter crank pedal pin. That means there are two definite and separate movements when operating the mechanism by depressing the crank.

The first is a slow and gentle movement which ends when it is felt the quadrant has engaged with the teeth on the ratchet pinion. (See illustration 2.)

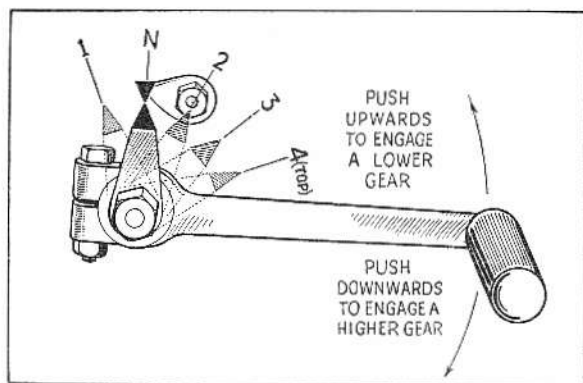


Illustration 3

Showing the relative positions taken up by the moving gear indicator when the various gears are engaged.

The moving gear indicator is attached to the control spindle and the fixed gear indicator is located on the kick-starter case cover.

The two indicators are only in line with each other when the foot gear change pedal is in the neutral position.

The first slow and gentle movement is essential to avoid damage to the teeth of the kick-starter quadrant.

After the engine has started, slowly open the air lever until it runs evenly. Then set the throttle so that the engine is running at a moderate speed (neither racing nor ticking over) and allow to warm up. While doing this, check the oil circulation as detailed in Para. 12. The machine can then be taken on the road.

NOTE—Do not race up the engine from cold and do not flood the carburettor to such an extent that petrol is dripping, because then, in the event of a backfire, there is a danger of such loose petrol igniting. This cannot possibly happen if the starting instructions are carefully followed, but, in the event of a fire, there is no cause for panic. Merely turn off the petrol tap to isolate the main supply, open wide the throttle and turn over the engine by operating the kick-starter pedal when suction will extinguish the fire.

STOPPING THE ENGINE

To stop the engine, close the throttle, raise the valve lifter lever and keep it raised until the engine has ceased to revolve.

ON THE ROAD

Having started and warmed up the engine, take the machine off the stand, sit astride it, free the clutch by pulling up the large lever on the left bar and engage the lowest gear. Next, slowly release the clutch lever and the machine will commence to move forward. As it does this, the engine speed will tend to drop as it picks up the load so it will be necessary to increase slightly the throttle opening, bit by bit, to keep the engine speed gently rising.

When well under way, disengage the clutch, slightly close the throttle, engage second gear and release the clutch lever, then open up the throttle to increase the speed of the machine. Repeat these operations in order to engage third and top gears.

To engage a higher gear the pedal is pressed downward with the toe and a lower gear is obtained by raising the pedal with the instep. To engage first gear from the neutral position, the pedal is therefore raised. After each pedal movement, internal springs return the pedal to its normal horizontal position.

The pedal must be moved to the full extent of its travel when selecting a gear, either up or down. It must not be "stamped down" or jabbed, but firmly and decisively moved till it stops. A half-hearted movement may not give full engagement. Keep the foot off the pedal when driving and between each gear change because, unless the lever can freely return to its normal central position, the next gear cannot be engaged. Finally, fully advance the ignition and leave it in that position unless it is necessary to retard in order to ease the engine and so prevent "pinkings" when pulling hard on a gradient.

STOPPING THE MACHINE

To stop the machine, close the throttle, declutch by lifting the large lever on the left handlebar, and gently apply both brakes, increasing the pressure on them as the road speed of the machine decreases. Place the gear change foot pedal in the neutral position and stop the engine.

Before leaving the machine, turn off the fuel supply.

IMPORTANT NOTICE

NEVER DRIVE AWAY AT HIGH SPEED WHEN STARTING A RUN WITH A COLD ENGINE. GIVE THE OIL A CHANCE TO WARM UP AND THIN OUT, PARTICULARLY WHEN THE MACHINE IS COLD. UNTIL THE OIL REACHES ITS NORMAL RUNNING TEMPERATURE THE CIRCULATION IS RESTRICTED. SEIZURES CAN BE AVOIDED BY TAKING THIS SIMPLE ESSENTIAL PRECAUTION.

RUNNING IN

Although it is customary to quote permitted maximum speeds on the various gears during the period of running in, these are really no guide to overdriving, the only essential thing to avoid being the use of large throttle opening.

If the precaution is taken of limiting the use of the throttle to about one-third of its opening during the first 1,000 miles, irrespective of the road speed, and whether on the level or climbing, the necessary conditions for running in will have been observed.

Special attention must be given, during the running in period, to such details as valve rocker adjustment, chains, brakes, contact breaker points, and steering head bearings, all of which tend to bed down in the first hundred miles or so. Particular note must be made of the adjustment of steering head bearings, which, if run in a slack condition, will be quickly ruined. After this bedding down process has taken place, adjustments to such details will probably only be necessary at lengthy intervals.

After about 1,000 miles have been covered larger throttle openings may be gradually indulged in for short bursts only.

Until at least 2,000 miles have been covered the owner of a new machine is strongly advised to curb his natural desire to learn the mount's maximum capabilities. Restraint in this direction will be amply repaid later.

NOTES ON DRIVING

If, at first, the lowest gear will not engage, release the clutch lever and after a second or two, make another attempt. This condition may exist in a new machine, but it tends to disappear after a little use.

Always endeavour to make the movements of hand (on the clutch) and foot (on the gear pedal) as simultaneous as possible, and remember, in all gear changes, a steady pressure of the foot is desirable. This pressure should be maintained until the clutch is fully released. It is not sufficient just to jab the foot pedal and then release the clutch lever. When actually in motion, it will be found sufficient to merely free the clutch a trifle, to ease the drive when changing gear and, with reasonable care, changes of gear then can be made without a sound.

Do not unnecessarily race the engine or let in the clutch sufficiently suddenly to cause the rear wheel to spin. Take a pride in making a smooth get-away.

When changing up to a higher gear, as the clutch is freed, the throttle should be slightly closed so that the engine speed may be reduced to keep in step with the higher gear ratio. Conversely, when changing down to a lower gear, the throttle should be regulated so that the engine speed is increased to keep in step with the lower gear ratio.

Do not slip the clutch to control the road speed.

The clutch must only be used when starting from a standstill and when changing gear. It must **NOT** be operated to ease the engine, instead of changing gear, or be held out, in order to "free-wheel."

The exhaust valve may be lifted, when the machine is being slowly ridden, with first gear engaged, down exceptionally steep, or difficult, gradients to prevent the rear wheel locking on a loose surface.

The exhaust valve lifter is **NOT** used in normal driving on main and secondary roads. When travelling slowly, such as may occur in traffic or on a hill, and the engine commences to labour, it is then necessary to change to a lower gear. Engine "knocking" or "pinking" and a harshness in the transmission are symptoms of such labour and although relief can sometimes be found by retarding the ignition, it is generally much better to change down. A good driver is able to sense such conditions and will make the change before the engine has reached the stage of distress. The gear box is provided to be used and consequently full use should be made of the intermediate gears to obtain effortless running and smooth hill climbing.

Keep the feet clear of the brake and gear pedals when not actually using them and keep the hand off the clutch lever when not in use.

Drive as much as possible on the throttle, making the minimum use of the brakes.

When using the machine on wet or greasy roads, it is generally better to apply **BOTH** brakes together, because sudden or harsh application of either brake only, under such conditions, may result in a skid.

In all conditions, it is advisable to make a habit of always using both brakes together rather than habitually using the rear brake and reserving the front brake for emergency.

CHECKING OIL CIRCULATION

Provision is made to observe the oil in circulation and it is advisable to do this before each run.

If the filler cap on the oil tank is removed the bent over end of the oil return pipe will be noticed some two inches below the level of the filler cap orifice and the returning oil can be seen running from it. This check should be made immediately after starting the engine from cold. This is because while the engine is stationary, oil from all parts of the interior of the engine drains back into the crankcase sump, so that, until this surplus is cleared, the return flow is very positive and continuous. Therefore, if the oil circulation is deranged, the fact is apparent at once by the lack of a steady return flow.

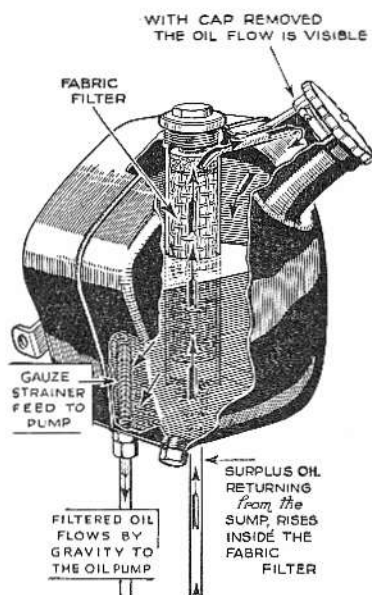


Illustration 4

Showing the oil tank with the felt filter in its cylindrical housing and the metal strainer mounted on the entry end of the feed pipe union. Also shows the direction of flow of oil from tank to engine and return flow from engine to tank via the small spout, located so that it can be inspected by removing the tank filler cap

For the convenience of Owners, **SPARES STOCKISTS** are appointed for most districts. To save delay, and the delivery surcharge, customers are recommended to always first apply to their nearest Agent or spares stockist.

LUBRICATION

LUBRICANTS TO USE

Efficient lubrication is of vital importance and it is false economy to use cheap oils and greases.

We recommend the following lubricants to use in machines of our make :

FOR ENGINE LUBRICATION

SUMMER

Mobiloil D	(SAE-60)
Triple Shell	(SAE-50)
Essolube " Racer "	(SAE-60)
Price's Energol 60	(SAE-60)
Castrol " Grand Prix "	(SAE-60)

WINTER

Mobiloil A	(SAE-30)
Double Shell	(SAE-30)
Essolube 30	(SAE-30)
Price's Energol 30	(SAE-30)
Castrol XL	(SAE-30)

FOR GEAR BOX LUBRICATION

Mobiloil D	(SAE-60)
Triple Shell	(SAE-50)
Essolube 50	(SAE-50)
Price's Energol 60	(SAE-60)
Castrol Grand Prix	(SAE-60)

FOR HUB LUBRICATION AND ALL FRAME PARTS USING GREASE

Mobilgrease No. 2
Shell **Retinax** Grease **C.D.**
Esso Grease
Price's **Belmoline C**
Castrolease Medium

FOR TELEDRAGLIC FRONT FORKS AND TELEDRAGLIC REAR LEGS

Mobiloil Arctic	(SAE-20)
Single Shell	(SAE-20)
Essolube 20	(SAE-20)
Price's Energol 20	(SAE-20)
Castrolite	(SAE-20)

FOR REAR CHAINS

Tallow

When buying oils and greases it is advisable to specify the **Brand** as well as the grade and, as an additional precaution, to buy only in sealed containers or from branded cabinets.

FILLING THE GREASE GUN

The standard grease gun consists of a barrel having a spring loaded end cap, to which is fixed a central steel piston in the shape of a long rod. This piston fits into a small cylinder made in one with the screwed top cap, on the end of which is the cupped nozzle that fits over the grease nipples. In the barrel of the gun, and sliding on the central piston rod, is a cork piston.

The grease must be filled on the **TOP** of the cork piston. The gun may be filled by inserting the grease in the barrel of the gun by means of a lath or similar "spoon."

However, it is better to obtain the grease packed in the special containers that are supplied, having loose collars in which are holes so that, by placing the barrel of the gun over the hole of the central floating plate and pressing downwards, the gun is instantly charged with grease. Twisting the gun, and, at the same time, taking it away from the floating plate, leaves the top of the gun barrel flush with grease, and then all that remains to be done is to replace the screwed top cap.

ENGINE LUBRICATION SYSTEM

This is by dry sump system. Oil feeds, by gravity, from the oil tank to the pump in the crankcase. The pump forces oil to various parts, which then drains to the bottom of crankcase sump. The pump then returns oil to the tank. This process is continuous while the engine is revolving. The pump is designed to return more oil to the tank than it can force into the engine. Therefore the crankcase sump is kept clear of excess oil. A felt cartridge filter, in the oil tank, removes foreign matter collected by the oil in its passage through the engine. A metal gauze strainer is fitted to the oil feed pipe in the oil tank to prevent pieces of fluff, etc., which may find their way into the tank when replenishing, from entering the oil pump. (See Illustration 4.)

Felt filter and metal strainer should be cleaned in petrol each time the oil tank is drained.

ENGINE OIL PUMP

The pump has only one moving part. This is the plunger which revolves and reciprocates. Rotation is caused by the worm gear on the timing side flywheel axle. Reciprocation is caused by the guide pin which engages in the profiled groove cut on the plunger. Oil is fed to the pump through the lower of the two oil pipes between tank and crankcase and is returned through the upper pipe.

If, for any reason, the crankcase halves are separated, **the oil pump plunger must be removed from its housing before attempting to separate the crankcase halves.**

ENGINE OIL CIRCULATION

The oil pump forces oil through :—

- (a) A passage cut through the timing side flywheel axle, timing side flywheel and crank pin to lubricate the big-end bearing. The splash passes to interior of cylinder, to lubricate the cylinder and piston, and then falls into the crankcase sump.
- (b) A passage in crankcase, controlled by ball valve, direct to the cylinder, to assist in cylinder and piston lubrication and then falls into the crankcase sump.
- (c) A passage in timing gear case where it "builds up" to a predetermined level to lubricate the timing gears and then falls into the crankcase sump.
- (d) Through a pipe from the front of oil pump housing to the rocker box by which all rocker gear and valve stems are lubricated and then falls through the push rod cover tubes and tappet guides to the timing gear case and, from there, drains into the crankcase sump, as detailed in Para. (c).

The oil pump extracts oil in the crankcase sump and returns it to oil tank. On its way it passes through the felt cartridge filter located in the oil tank.

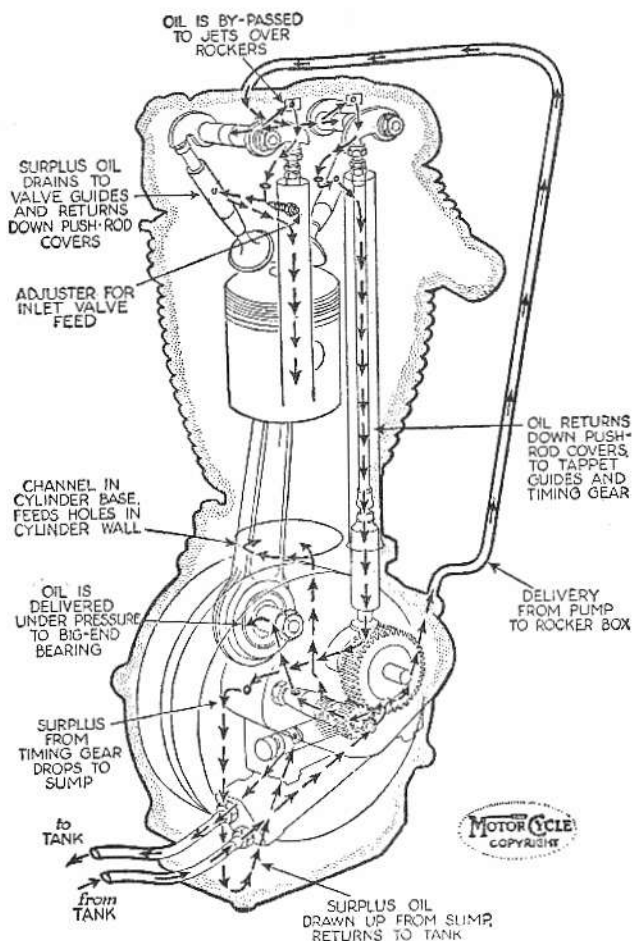


Illustration 5

Engine Oil Circulation

THE OIL TANK AND FILTERS

The level of oil in the supply tank should never be allowed to fall below the low level mark and, upon replenishment, should not be higher than one inch from the filler cap orifice, otherwise, when starting the engine, the bulk of oil in the crankcase sump may be greater than the space available in the tank.

The oil filter is made in cylindrical form of thick felt and is supported by a tubular wire cage. The felt is not detachable from the cage.

A metal gauze strainer (secured to the feed pipe union) stands in the oil tank.

After the first 500 miles, again at 1,000 miles, and subsequently at 5,000 mile intervals, it is recommended that the oil tank is drained, the oil filters cleaned in petrol and the tank replenished with new oil.

For access to oil filter :—

Unscrew the hexagonal headed cap on top of oil tank and withdraw the dished washer and spring. Then insert a finger in the felt filter and gently raise same until the top end touches the underneath of saddle. Then by encircling the filter with the hand it will be found possible to exert sufficient upward pressure on the flexible saddle top to permit the filter to be completely withdrawn without distortion. Care is needed to avoid kinking the filter.

To re-fit filter :—

Reverse above instructions.

NOTE—If, after the filter has been removed from the tank, it is damaged, so that the felt is perforated, or the ends distorted, it is essential to discard it and to fit a new filter.

Be careful to avoid damaging the filter or the cork washer under the hexagonal cap.

For access to metal strainer (after oil has been drained from tank) :—

Remove oil feed pipe from union screwed into bottom of oil tank. This is pipe nearer to rear wheel and is removed by unscrewing its union nut.

Spring away pipe from union.

Unscrew union from bottom of oil tank. Metal strainer is integral part of this union.

To re-fit metal strainer :—

Reverse above instructions.

ADJUSTMENT OF OIL FEED

The internal flow of oil is regulated by fixed restrictions. No adjustment is provided except for the oil feed to the inlet valve stem. This adjustment is made by a needle pointed screw located in the right side of cylinder head. (See Illustration 6.) It is locked in position by a nut. The approximate correct setting is one-sixth of a complete turn from the fully closed position. Once set it requires little, or no, adjustment.

Inlet valve squeak indicates the oil feed adjustment is not open enough. Excessive oil consumption, a smoky exhaust or an oiled sparking plug, generally indicates the oil feed adjustment is open too much.

EXHAUST VALVE STEM LUBRICATION

The exhaust valve stem is lubricated by oil fed through a passage drilled in the cylinder head. No adjustment is provided. All excess oil is by-passed back to the timing gear case.

LUBRICATION POINTS TO REMEMBER

A dirty, or choked, felt oil filter causes heavy oil consumption. This is because the return flow of oil to the oil tank is slowed, or even almost completely stopped, thereby allowing an excess of oil to "build up" in the crankcase sump, much of which passes to the piston.

A clogged metal strainer, in the gravity feed pipe, will also cause improper, or no, oil circulation. This can only occur as the result of adding dirty oil when replenishing the tank.

Both end caps on pump plunger housing must be air-tight.

Check oil circulation before starting each run.

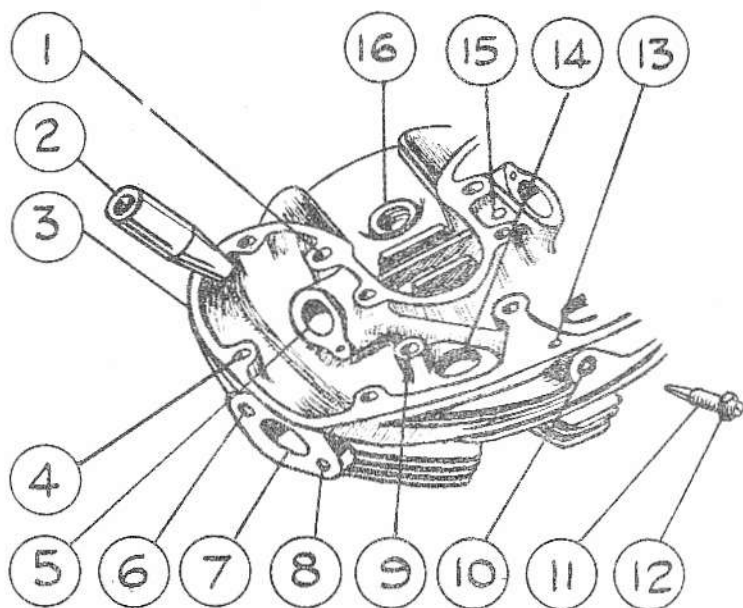


Illustration 6

The inlet valve guide is shown withdrawn as also is the inlet valve stem adjusting screw (with lock nut)

(By courtesy of "Motor Cycling")

- | | |
|--|---|
| 1 PLAIN HOLE, TO ACCOMMODATE CYLINDER HEAD RETAINING BOLT. | 10 TAPPED HOLE, TO ACCOMMODATE NEEDLE SCREW. |
| 2 GUIDE, FOR VALVE. | 11 NEEDLE SCREW, ADJUSTING OIL FEED TO INLET VALVE. |
| 3 CYLINDER HEAD. | 12 LOCK NUT, FOR NEEDLE ADJUSTING SCREW. |
| 4 TAPPED HOLE, TO ACCOMMODATE ROCKER BOX RETAINING BOLT. | 13 PLAIN HOLE, FOR OIL FEED TO INLET VALVE. |
| 5 PLAIN HOLE, TO ACCOMMODATE VALVE GUIDE. | 14 PLAIN HOLE, TO ACCOMMODATE PUSH ROD COVER TUBE TOP GASKET. |
| 6 TAPPED HOLE, TO ACCOMMODATE CARBURETTER RETAINING STUD. | 15 PLAIN HOLE, FOR OIL FEED TO EXHAUST VALVE. |
| 7 INLET PORT. | 16 TAPPED HOLE, FOR SPARKING PLUG. |
| 8 TAPPED HOLE, TO ACCOMMODATE CARBURETTER RETAINING STUD. | |
| 9 PLAIN HOLE, TO ACCOMMODATE CYLINDER HEAD RETAINING BOLT. | |

GEAR BOX LUBRICATION

Use one of the grades of Oils already specified. In no circumstances must heavy grease be used.

Lubricant is inserted through the filler cap orifice mounted on top edge of kick-starter case cover.

The gear box must not be entirely filled with oil, and, under normal conditions, the addition of two fluid ounces of oil every 1,000 miles will be sufficient.

Excessive oil will cause leakage.

A screwed drain plug in gear box shell, low down at rear, facilitates gear box flushing and change of lubricant.

HUB LUBRICATION

Keep hubs packed with grease. This prevents entry of water and dirt. Grease nipples in centre of hubs. Inject small quantity of grease. Excessive grease may impair efficiency of brakes.

CHAIN LUBRICATION

Front driving chain and dynamo chain run in oil bath. (Front chaincase.) Use engine oil. Maintain level to height of the inspection cap opening.

Oil in front chaincase also lubricates the engine shock absorber. Transmission harshness generally indicates level of oil in chaincase is too low.

Remove chaincase inspection cap each week, inspect level of oil, top-up as necessary.

To remove inspection cap :—

Unscrew knurled screw about four turns.

Slide cap sideways, till the back plate can be slipped through the opening, and take away the complete cap assembly.

When replacing inspection cap, centralise cork washer and then fully tighten knurled screw. Essential this is kept tight otherwise cap assembly will be lost.

Rear driving chain should be removed for lubrication. Clean chain in paraffin, drain and wipe. Immerse in bath of molten tallow, leave for several minutes, remove and allow excess lubricant to drain off and then replace on machine. Engine oil is a poor substitute for tallow and, if used, chain should be allowed to soak for several hours.

Lubricate rear chain every three thousand miles in Summer and every thousand miles in Winter.

Magneto chain runs in case packed with grease. A grease nipple is fitted to the case cover. Inject small quantity of grease every thousand miles.

BRAKE EXPANDER LUBRICATION

Grease nipple on each brake expander bush. (One on each brake cover plate.) Use grease sparingly. Excessive grease may impair efficiency of brakes.

BRAKE ROD JOINT LUBRICATION

A few drops of engine oil on each brake rod yoke end pin and on the threaded portion of brake rod. (One pin on yoke each end of brake rod and on bottom of foot brake cable.)

BRAKE PEDAL LUBRICATION

Grease nipple in heel of foot brake pedal.

SPEEDOMETER LUBRICATION

One grease nipple on top of speedometer gear box attached to right side of rear wheel spindle. (No other part of the speedometer requires lubrication.)

STAND FIXING BOLT LUBRICATION

Several of the parts of a motor cycle that have a very small amount of movement, such as the hinge bolts of the stands, should be lubricated.

STEERING HEAD BEARING LUBRICATION

One grease nipple on Front Frame Head Lug and another on right hand side of Handlebar Lug.

CONTROL LEVER LUBRICATION

Occasionally a drop of engine oil on all moving parts of the handlebar control levers.

If twist grip is too stiff : remove two screws binding the two halves of the clip. This releases the grip which may be pulled off the handlebar. Smear handlebar, the drum on which the inner wire is wound and the friction spring on the half clip with grease and replace.

WHEN ORDERING SPARES
ALWAYS QUOTE
THE COMPLETE ENGINE NUMBER
(Including all the Letters in it).

THIS ENABLES US TO IDENTIFY THE MACHINE.

EACH SERIES OF FRAMES IS NUMBERED FROM ZERO
UPWARDS. THEREFORE THE QUOTATION OF A FRAME
NUMBER ONLY DOES NOT PERMIT A MACHINE TO
BE IDENTIFIED.

LUBRICATION CHART

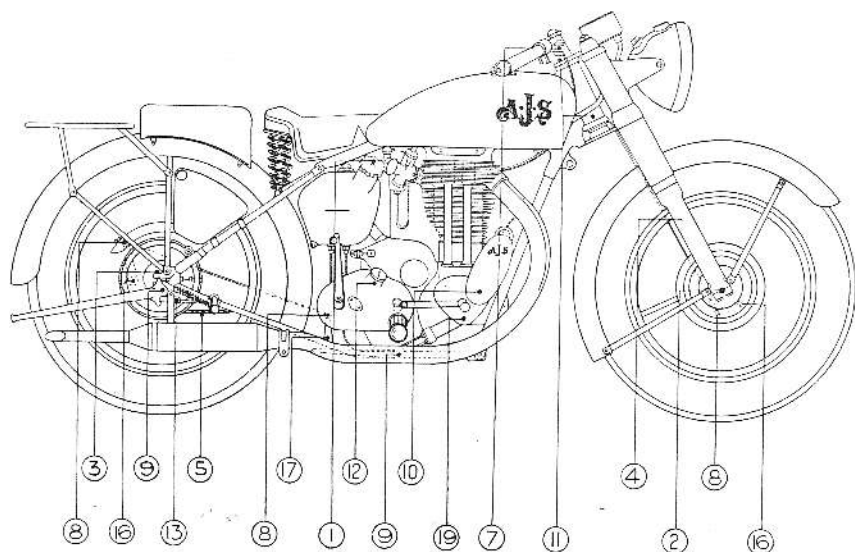


Illustration 7

Lubrication Chart

Engine Oil Locations

- 1 MAIN OIL TANK.
- 7 CONTROL LEVER MOVING PARTS.
- 8 BRAKE ROD JOINTS.
- 9 FRONT PROP. AND REAR STAND HINGE PINS.
- 19 FRONT CHAIN CASE.
- 12 GEAR BOX.

Hydraulic Fluid Location

- 4 FRONT FORKS.

Tallow Location

- 5 REAR CHAIN.

Grease Locations

- 2 FRONT HUB.
- 3 REAR HUB.
- 10 MAGNETO CHAIN CASE.
- 11 STEERING HEAD BEARINGS.
- 13 SPEEDOMETER GEAR BOX.
- 16 FRONT AND REAR BRAKE EXPANDERS.
- 17 BRAKE PEDAL SPINDLE.

When buying oils and greases it is advisable to specify the **Brand** as well as the grade and, as an additional precaution, to only buy in sealed containers or from branded cabinets.

MAINTENANCE

SADDLE ADJUSTMENT

Saddle adjustment is provided at both front and rear ends. Importance is attached to the desirability of owners selecting the adjustment most to their liking. At the front end, the adjustment consists of three evenly spaced positions for the hinge bolt, accessible only upon removal of the petrol tank. At the rear end, adjustment is obtained by altering the position of the lower spring fixing nuts upon the screwed studs to which the springs are attached.

PERIODICAL MAINTENANCE

Regular maintenance, attention to lubrication, and certain adjustments must be made to ensure unfailing reliability and satisfactory service. This necessary attention is detailed below, and owners are strongly recommended to follow carefully these suggestions, and to make a regular practice of doing so from the first.

The reference numbers, in brackets, refer to the locations specified on the Lubrication Chart, Illustration 7.

DAILY

- Oil tank** Inspect oil level (1) and top-up if necessary. Check oil circulation.
- Petrol tank** Check level and re-fill if necessary.

WEEKLY

- Oil tank** Check level (1) and re-fill if necessary.
- Tyres** Check pressures and inflate if necessary.

EVERY 500 MILES

- Oil tank** Drain at first 500 miles and re-fill with new oil, and clean felt filter. (1.)
- Chaincase** Check level of oil when machine is standing vertically on level ground, when level of oil should not be less than $\frac{3}{16}$ " below bottom edge of inspection orifice. (19.)
- Rear chain** If dry, apply engine oil with a brush. (5.)
- Battery** Inspect each cell for level of electrolyte and top-up with distilled water if necessary.

EVERY 1,000 MILES

- Oil tank** Drain at first 1,000 miles and re-fill with new oil. (1.)
- Rear chain** Remove and soak in molten tallow in bad weather. (5.)
- Gear box** Add 2 fluid ounces of specified oil. (12.)
- Hubs** Inject small amount of grease. (2-3.)
- Expanders** Inject small amount of grease. (16.)
- Steering head** Inject small amount of grease. (11.)
- Small parts** Smear all moving parts with engine oil and wipe off surplus.

EVERY 3,000 MILES

- Rear chain** Remove and soak in molten tallow in Summer. (5.)
- Brake pedal** Inject small amount of grease. (17.)
- Speedometer** Inject small amount of grease into speedometer gear box. (13.)
- Magneto** Oil wick on contact breaker.
Smear tappet with thin oil.
Clean contact breaker points and re-set if necessary.
- Plug** Clean sparking plug and re-set points if necessary.
- Steering head** Test steering head for up and down movement and adjust if necessary.
- Bolts and nuts** Check all nuts and bolts for tightness and tighten if necessary, but beware of over-tightening.
- Rockers** Check O.H.V. rocker adjustment and correct if necessary.

EVERY 5,000 MILES

- Oil tank** Drain and re-fill with new oil. (1.)
- Filters** Clean metal mesh filter in oil tank. (Illustration 4.)
Clean felt fabric filter in oil tank.
- Magneto** Clean as detailed in Electrical section.
- Dynamo** Clean as detailed in Electrical section.
- Front fork** Check each side of front fork for hydraulic fluid content and, if necessary, top up. (4.)
- Rear legs** Check each leg for hydraulic fluid content and, if necessary, top-up. (1-13.)
- Carburettor** Remove carburettor float chamber and clean its interior.

EVERY 10,000 MILES

- Magneto and Dynamo** Get a **Lucas Service Station** to dismantle, clean, lubricate and generally service.

ENGINE SERVICE

ACCESS

For almost all service work to the upper parts of the engine, it is necessary, in order to obtain accessibility, first, to remove the petrol tank. The two petrol taps facilitate this operation by removing the need to first drain the tank of petrol.

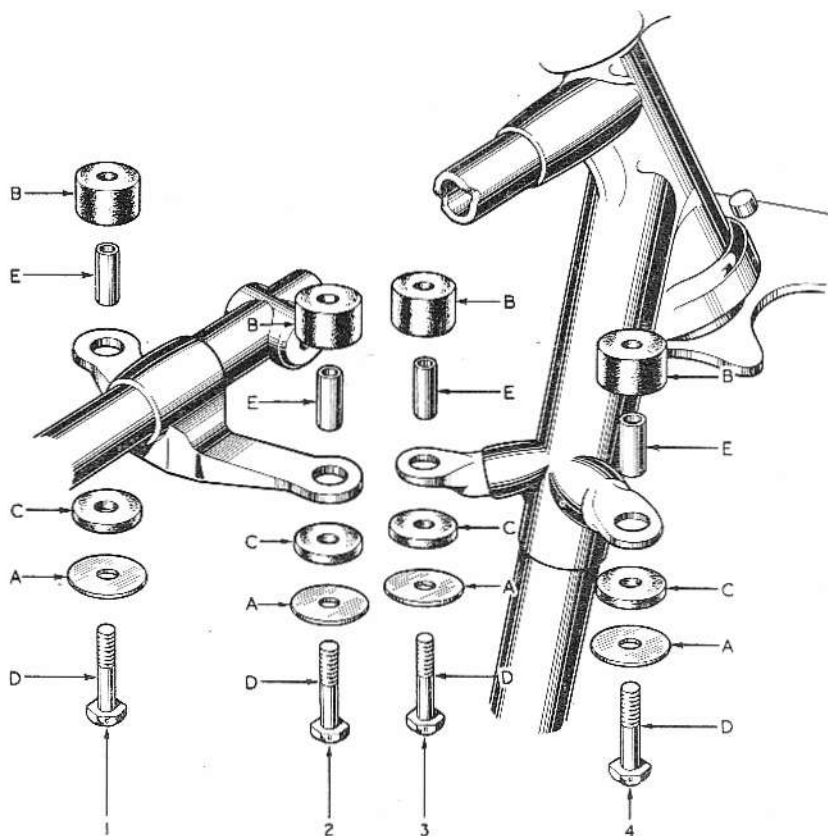


Illustration 8

Showing details and order of assembly, of the fuel tank fixing bolts and components

						Part Number	
A	...	METAL WASHER	014999	1 1/4" diameter.
B	...	THICK RUBBER PAD	014995	3/8" high.
C	...	THIN RUBBER PAD	014996	1/8" high.
D	...	TANK FIXING BOLT	014997	1 1/4" x 7/8" x 26.
E	...	SLEEVE FOR FIXING BOLT	014998	1 1/8" long.

TO REMOVE THE PETROL TANK

Close both petrol taps and disconnect the petrol feed pipe from each tap. (Use two spanners, one to hold the tap and the other to unscrew the union nut on the petrol pipe.)

Cut the wires interlacing the four fixing bolts.

Unscrew the tank fixing bolts and the tank is then free to be taken away.

NOTE—The disposition of the various rubber and metal washers and tubular spacers should be specially observed so that they may be correctly replaced.

The tank fixing bolts, with rubber and metal washers and spacers in all positions are identical.

TO REPLACE THE PETROL TANK

Proceed in reverse order to removal. Screw firmly home the four fixing bolts and interlace them, in pairs, with 22 gauge copper wire.

TO REMOVE THE ROCKER BOX

Remove the petrol tank.

Remove the three nuts and fibre washers retaining the rocker box side cover and take away the cover.

Disconnect the oil pipe feeding oil to the rocker box.

Turn over engine until both valves are completely closed.

On 500 c.c. model, remove engine steady bracket by removing bolt from frame clip and nuts and washers from the rocker box bolt extensions.

Remove the nine bolts retaining rocker box to cylinder head.

Disconnect valve lifter cable.

Tilt upward the right hand side of rocker box and extract the two long pushrods. Lay these aside so they may be identified and replaced in their original position.

The rocker box may then be lifted off.

TO REPLACE THE ROCKER BOX

Carefully clean the top of cylinder head and lower face of rocker box.

Revolve engine until both tappets are down, i.e., the top dead centre of firing stroke. Lay the composition jointing washer on cylinder head. This must be faultless. If necessary, renew.

Lay the rocker box in position then slightly raise the right hand side to allow the long push rods to be inserted into their original respective positions.

Insert all nine rocker box fixing bolts and note that the bolt with short head is in the centre right hand position and on 500 c.c. models the bolts with threaded extensions are fitted one each side of the central short head bolt.

Tighten each bolt in turn bit by bit until all are fully home.

On 500 c.c. models replace the engine steady stay.

Turn engine over several times to ensure parts have bedded home.

Re-fix valve lifter cable.

Re-fix rocker box oil pipe union nut using two spanners to ensure that the union screwed into rocker box does not turn while the nut is being tightened.

Check tappet clearances and re-set if necessary.

Inspect rubber fillet on rocker box side cover and renew if not perfect.

Replace the side cover ensuring that a fibre washer is fitted under each of the three retaining nuts.

Beware of over tightening these nuts, the joint being made by the rubber fillet excessive pressure is not necessary.

Replace the petrol tank.

DECARBONISATION

Instead of the usual stipulated mileage interval between periods of decarbonisation, it is recommended that this is undertaken only when the need for same becomes apparent because of excessive pinking, loss of power or generally reduced performance. When undertaken, unless it is thought necessary to inspect the piston and rings, the cylinder barrel is best left undisturbed. The various stages in decarbonisation are described below.

TO REMOVE THE CYLINDER HEAD

Remove

The petrol tank.

The sparking plug.

The rocker box.

Remove the exhaust system by :

Remove nut, and washers, retaining exhaust pipe to its stay.

Remove nut, and washers, retaining silencer to its stay.

Remove complete exhaust system, by pulling away from stays and then downwards, from the exhaust port in cylinder head.

Remove carburetter by :

Unscrew two carburetter retaining nuts.

Take away carburetter and rest on saddle.

Remove

The four bolts retaining cylinder head to barrel, and head is free to be taken away. While doing this the push rod cover tubes will come away with the head.

If the cylinder head bolts resist removal, brush paraffin round their heads and leave for a time to soak before making further effort.

TO REMOVE AND REPLACE THE VALVES

Remove the cylinder head.

Attach the special valve spring compressing tool, Part No. 014605, to cylinder head with the two bolts provided (Part No. 41-G3L-M38), see illustration 9. Then compress the springs by screwing in evenly the two long bolts, the reduced tips of which will engage with the countersunk depressions on the valve spring collar. The split collet can then be withdrawn leaving the valve free. To remove the compressor slacken each of the long bolts little by little in turn until they are clear of the valve spring top cap. After removing the compressor tool the whole spring assembly can be lifted off. To ensure accurate replacement it will be observed that the valve spring block to which the prong ends of the hairpin valve springs are attached, is provided with a dowel pin which engages a hole in the valve guide boss.

To replace valves :—

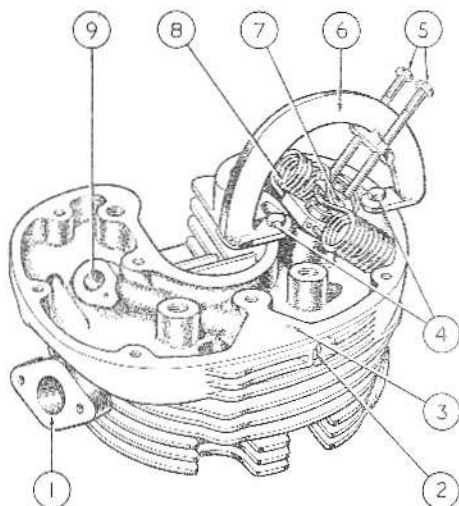
After cleaning valve guide bores with rag smear each valve stem with clean oil and reverse procedure above.

IMPORTANT NOTE :—

If for any reason valve springs are removed from their fixing block it is important to see that upon replacement the spring with narrow spaced prongs is entered into the block from the chamfered end.

Illustration 9

Showing application of
valve spring compressor



- | | |
|---|---|
| 1 INLET VALVE PORT. | 5 BOLTS, IMPINGING ON VALVE SPRING COLLAR WHICH, UPON BEING SCREWED DOWN, EXPOSE VALVE COLLET THEREBY PERMITTING ITS REMOVAL. |
| 2 ORIFICE FOR SCREW ADJUSTING OIL FEED TO INLET VALVE. | 6 BODY OF VALVE SPRING COMPRESSOR. |
| 3 OIL PASSAGE FROM ROCKER BOX TO INLET VALVE GUIDE. | 7 COLLAR, RETAINING VALVE SPRINGS. |
| 4 BOLTS, RETAINING VALVE SPRING COMPRESSOR TO CYLINDER HEAD. | 8 VALVE SPRINGS. |
| | 9 ORIFICE FOR VALVE GUIDE. |

NOTE—The special valve spring compressor tool is not part of the standard tool kit but is obtained from any of our dealers complete with bolts for attachment at the list price of 4s. 3d. (Part No. 014605.)

It is essential that the collets are correctly located on the valve stems. It will be observed that the collet has two grooves machined in the bore and those two grooves must register with the two rings on the valve stem. If fitted so that only one of the grooves engages the ringed valve stem, damage will almost certainly result.

On 350 c.c. the inlet valve head is larger in diameter than the exhaust. Therefore inlet and exhaust valves are not interchangeable and no mistake can be made when replacing same in the cylinder head.

On 500 c.c. both valve heads are identical in dimensions but are made of different materials. Therefore, upon removal, valves should be laid aside so that they may be identified for re-fitting. In case of doubt, see marking "In" or "Ex" on top of stem above collet grooves.

REMOVING CARBON DEPOSIT

Do not use a sharp implement for removing carbon deposit from the interior of the cylinder head and the piston crown. A blunt piece of soft brass will be found quite suitable and the use of such will obviate the risk of making deep scratches. Care is necessary to avoid damaging the valve seatings and in no circumstances should any abrasive material, such as emery, or emery cloth, be used for cleaning and polishing.

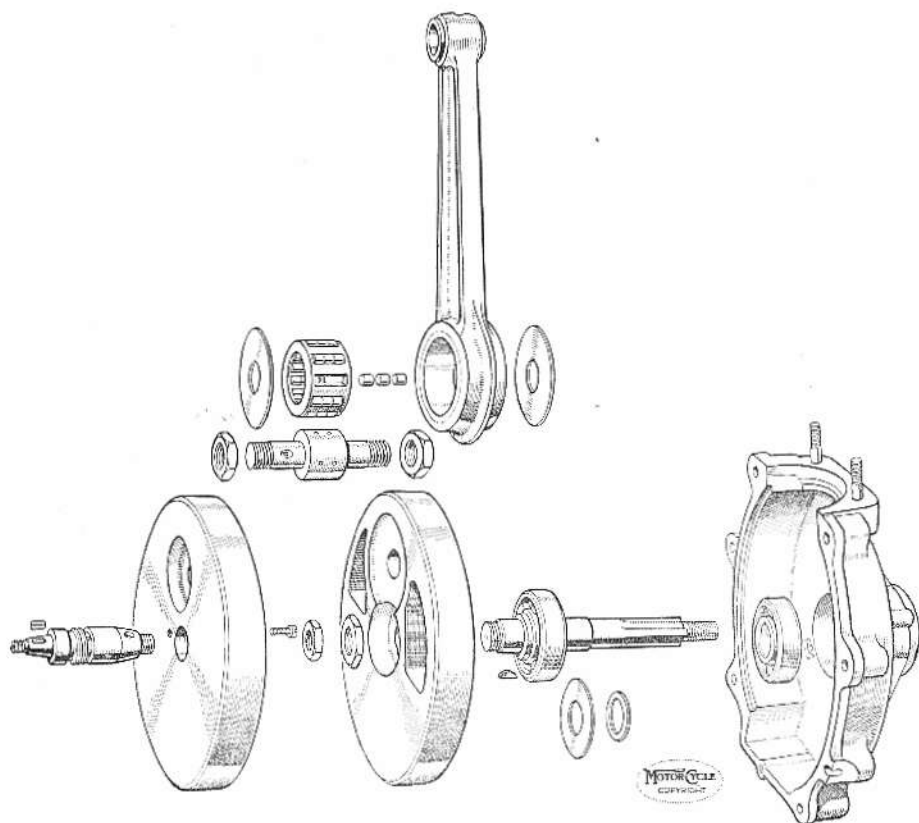


Illustration 10

Showing flywheel in exploded form

VALVE GRINDING

Before commencing valve grinding, carefully examine the face of each valve and, if any are found to be deeply pitted, have them refaced. (Most garages have suitable equipment for that purpose.) Any attempt to remove deep pit marks by grinding will inevitably cause undue and undesirable widening of the seats.

As a rule, inlet valves require very little attention and one light application of fine grinding paste should be sufficient to restore an even matt finish to both valve face and seat. The exhaust valves may require two, or even three, applications but, as already mentioned, excessive grinding is both unnecessary and harmful.

The grinding is accomplished by smearing a thin layer of fine grinding paste (obtainable ready for use at any garage) on the valve face and then, after inserting the valve in the head, partially revolve, forwards and backwards, while applying light finger pressure to the head, raising the valve off its seat and turning to another position after every few movements. (Never revolve the valve continuously in one direction.)

When the abrasive ceases to bite, remove the valve and examine its face.

The grinding may be considered to be satisfactorily completed when a continuous matt ring is observed on both valve face and seat.

After grinding, all traces of abrasive must be carefully washed off with petrol and a piece of rag, moistened in petrol, should be pulled through the bore of each valve guide to remove any abrasive that may have entered.

A holder for the valve, when grinding in the valve, can be supplied at a cost of 1 7d. The part number is 11520A.

TO REPLACE THE CYLINDER HEAD

A gasket is fitted between cylinder head and barrel. (*Touring models only*).

The top ends of the push rod cover tubes have rubber gaskets between tubes and head, they are a push fit and metal washers are located between the top edges of the gaskets and the cylinder head recesses. If the cover tubes are pulled away from the head, the gaskets will probably remain in position in the head.

It should be noted that a compression plate is a standard fitment on all 500 c.c. machines.

A rubber gland is fitted at the bottom of each cover tube.

Replace the cylinder head by :

Carefully clean the top edge of the cylinder barrel and the under face of the cylinder head.

Fit the cover tubes, with their rubber gaskets and metal washers, into the cylinder head.

Place the cylinder head gasket in position on the top edge of the cylinder barrel.

Place a rubber gland round each tappet guide.

Place the cylinder head in position.

Ensure each cylinder head securing bolt has a plain steel washer on it and then replace the bolts and engage each a few turns.

Finally, screw down the cylinder head securing bolts, in turn, bit by bit, till all are fully home.

Replace

The rocker box, carburetter, exhaust system, and the petrol tank.

NOTE—If old gaskets are re-fitted they must be in an undamaged state otherwise new must be used.

TO REMOVE THE CYLINDER BARREL AND PISTON

Remove

The cylinder head.

The four nuts retaining cylinder barrel to crankcase.

Take away

Cylinder barrel. (Ensure piston is not damaged in doing this. Steady piston with hand as barrel is withdrawn.)

Fill throat of crankcase with clean rag to prevent entry of foreign matter.

Remove

One gudgeon pin circlip. It is immaterial which circlip is removed. Use special pliers included in tool kit.

Gudgeon pin by pushing it out of piston.

Take away piston.

NOTE—The gudgeon is an easy sliding fit in both piston and connecting rod small-end bush.

Rings may be removed from a piston by "peeling off" with a knife, or by introducing behind the rings three pieces of thin steel spaced at 120° from each other and then sliding off the rings. (Do not scratch the piston.)

TO REPLACE THE PISTON AND CYLINDER BARREL

All parts must be clean.

Place rings on piston. (Scraper first then the two compression.)

Smear gudgeon pin with engine oil.

Refit piston by :

Introduce piston over connecting rod, so that slit in piston faces to the front of the machine.

Introduce gudgeon pin in piston and pass it through connecting rod small-end bush and centralise it.

Re-fit circlips. (Use special pliers). Use rotary action when bedding circlips in their grooves and make sure each circlip lies snugly in its groove. This is **essential** otherwise considerable damage will result.

Re-fit cylinder barrel by :

Take new cylinder base washer. Coat one side with liquid jointing compound and apply it to cylinder base. Ensure jointing does not choke any of the cylinder base oil holes.

Smear cylinder bore and piston with engine oil.

Space piston rings so that the gaps are evenly spaced at 120° to each other.

Remove rag from crankcase throat.

Fit barrel over piston. Ensure each piston ring is fully compressed into its groove, in turn, as the barrel passes over it.

Replace cylinder barrel holding down nuts, screwing each down, in turn, bit by bit, till all are fully home.

CAM CONTOUR

On the flanks of the cams are quietening curves which are very slight inclines from the base circles to the feet of the humps.

Therefore, it is necessary to ensure the tappet ends are on the base circles when checking valve clearances and valve timing.

It is for this reason valve clearances must be checked when the piston is at the top of its compression stroke, at which position both tappets are well clear of the quietening curves.

VALVE TIMING

Inlet valve timing

Inlet valve opens 32° before top dead centre.

Inlet valve closes 63° after bottom dead centre.

Exhaust valve timing

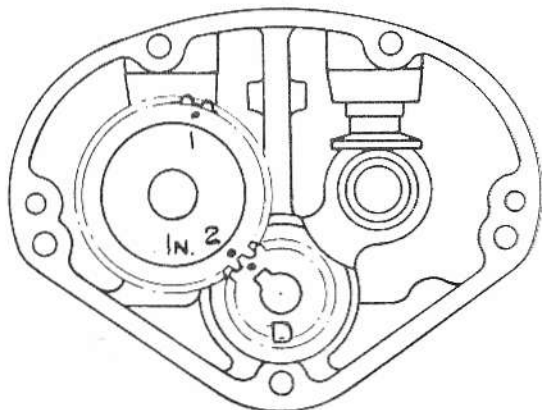
Exhaust valve opens 65° before bottom dead centre.

Exhaust valve closes 30° after top dead centre.

(See page 96 for particulars of special timing disc graduated in degrees.)

Illustration 11

Inlet Camshaft timing marks
(Use mark "2")



When checking the valve timing the tappet clearances must be set to $.016$ inch so that the tappets may be well clear of the quietening curves of the camshafts.

The timing gears are marked to facilitate their replacement.

To re-set the valve timing, by using the marks on the gears, proceed as follows :—

Turn over the engine till the mark on the small timing pinion (D in Illustration 11) is in line with the centre of the inlet (rear) camshaft bush. Insert the inlet camshaft so that the No. 2 mark on it is in mesh with the mark on the small timing pinion (D).

Rotate the engine in a **forward** direction till the mark on the small timing pinion (D in Illustration 12) is in line with the centre of the exhaust (front) camshaft bush. Insert the exhaust camshaft so that the No. 2 mark on it is in mesh with the mark on the small timing pinion (D).

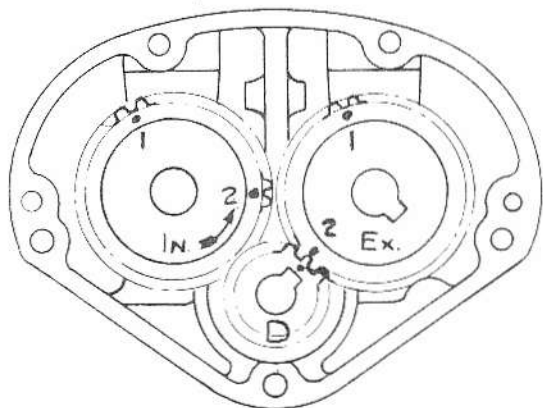


Illustration 12

Exhaust Camshaft timing marks
(Use mark "2")

TAPPET ADJUSTMENT

The top ends of the two long push rods have screwed extensions. These are locked in position by nuts, thereby providing tappet adjustment.

The correct tappet clearances, on touring models, with valves closed and engine cold, is **NIL** (warm engine on competition models). This means the push rods should be free enough to revolve and, at the same time, there should be no appreciable up and down play.

Prepare to adjust tappets by :

Set piston to T.D.C.

Remove the three nuts, and fibre washers under them, retaining tappet cover to rocker box.

Take away cover.

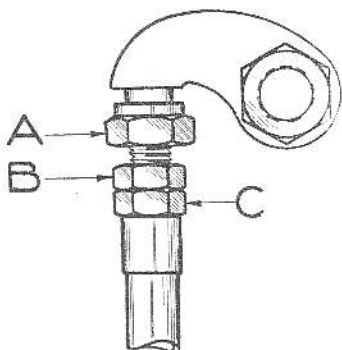
Adjust tappets on all 350 and 500 models by :

With spanners, hold the body C, either valve (Illustration 13) and slacken lock nut B. Then screw, in or out, the head A until the clearance is nil.

Tighten lock nut B and re-check the clearance.

Treat other valve in like manner.

Illustration 13
Tappet adjustment



Finally

Check adjustments so that, with no up and down movement, the long push rods are free to revolve when the valves are closed.

Complete adjustment by :

Replace rocker tappet cover taking care to replace the fibre washer that is under each retaining nut.

Do not over-tighten the nuts because the joint is made with a rubber fillet and undue pressure is not necessary.

NOTE—The part marked C in Illustration 13 is the top end of the long push rod. It is threaded and the adjusting screw A screws into it.

In normal conditions tappet adjustment should not be necessary more frequently than about every five thousand miles or after decarbonising and grinding valves. If adjustment is found necessary more frequently the cause should be investigated at once.

TO RE-TIME THE IGNITION

The maximum advance is $\frac{1}{2}$ " (39°).

Have available a stout screwdriver, or an old type tyre lever with turned up end, and a piece of stout wire $5\frac{1}{2}$ " long.

Before setting the ignition firing point it is essential the magneto contact breaker points are correctly adjusted. Therefore always check these first.

Serious damage may result from the ignition being set too far advanced. (Causing detonation).

Check contact breaker points by :

Remove contact breaker cover.

Check setting of contact breaker points, and, if necessary, re-set same.

Set ignition firing point by :

Remove :—

The sparking plug high tension cable from plug.

The sparking plug.

The magneto chain case cover.

The rocker box tappet cover.

Unscrew, several turns, nut retaining magneto sprocket to camshaft. (No need to remove nut).

Lever off sprocket until it is loose on the taper of the shaft. (Use stout screw-driver or old type tyre lever.)

Turn over engine till both valves are closed.

Insert rod through sparking plug hole, feel piston, by rocking engine forwards or backwards till it is felt the piston is at the top of its stroke.

Mark rod flush with top face of sparking plug hole. Remove rod and measure $\frac{1}{2}$ " above the flush mark and record position on rod.

Place handlebar ignition control lever in fully advanced position.

Replace rod in sparking plug hole.

Slightly rotate engine **BACKWARDS** until upper mark on rod is flush with top face of sparking plug hole. (To rotate engine, engage top gear and turn back wheel by hand.) Rotate sprocket on magneto armature shaft, in anti-clockwise direction (as seen from sprocket end of magneto), till the contact breaker points are just about to separate. (To find the exact moment for the commencement of the point separation, place a piece of tissue paper between the points and turn the armature shaft (by the sprocket on it) until the paper is just released, and no more, upon a gentle pull.)

Tighten nut on camshaft and ensure engine, and/or magneto shaft, does not move in doing so.

Re-check the setting which must be $\frac{1}{2}$ " before top dead centre. (With the ignition handlebar control lever in the fully advanced position.)

See page 96 for particulars of special timing disc graduated in degrees.

Replace

Rocker box tappet cover, Contact breaker cover, Magneto chain case cover, Sparking plug, and Sparking plug wire.

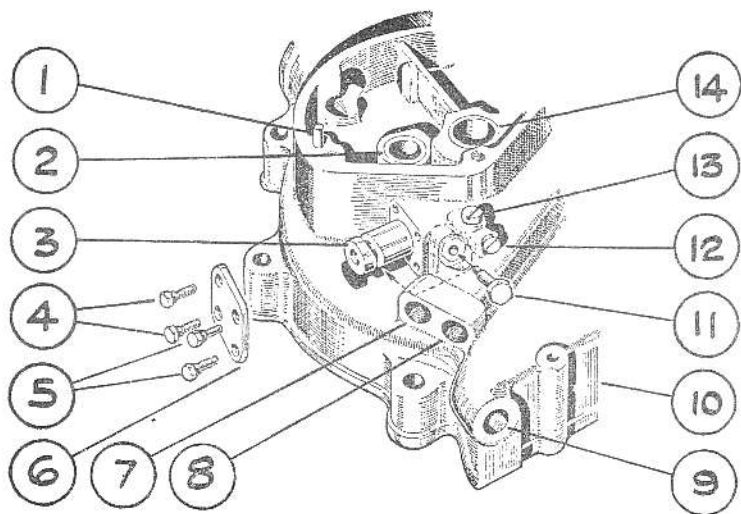


Illustration 14

The rotating oil pump plunger is here shown partially withdrawn, together with the guide screw which registers in the plunger profiled groove, thereby providing the reciprocating movement

(By courtesy of "Motor Cycling")

- | | |
|--|---|
| 1 DOWEL PEG, LOCATING TIMING GEAR COVER. | 9 TAPPED HOLE, TO ACCOMMODATE CRANKCASE DRAIN PLUG. |
| 2 BUSH, FOR INLET CAMSHAFT. | 10 CRANKCASE, TIMING SIDE. |
| 3 PLUNGER, FOR OIL PUMP. | 11 GUIDE SCREW AND PIN, FOR OIL PUMP PLUNGER. |
| 4 BOLT, FIXING REAR END CAP. | 12 PLUG SCREW, FOR OIL PASSAGE. |
| 5 BOLT, FIXING REAR END CAP. | 13 PLUG SCREW, FOR OIL PASSAGE. |
| 6 REAR END CAP, FOR OIL PUMP. | 14 BUSH, FOR TIMING SIDE FLYWHEEL AXLE. |
| 7 TAPPED HOLE, FOR PIPE RETURNING OIL TO OIL TANK. | |
| 8 TAPPED HOLE, FOR PIPE FEEDING OIL TO OIL PUMP. | |

TO REMOVE AND REPLACE THE OIL PUMP PLUNGER

Remove

Lower end of rocker box oil feed pipe by unscrewing union nut.

Both oil pump end caps.

Oil pump plunger guide screw with pin. (See illustration 14, No. 11.)

Oil pump plunger, by pushing at front and extracting from rear end of its housing.

Replace by :

Reversing above procedure.

NOTE—Remember there is a paper washer under each oil pump end cap and, when fitting a new paper washer to the front cap, ensure the oil passage in the front cap is not obstructed by the paper washer.

Make certain that the guide screw pin is correctly located in its groove (cut in the plunger) before tightening down otherwise serious damage will result when the engine is revolved. **NOTE** :—The guide screw pin is inserted in the screw relieved end first.

OVERSIZE PARTS AND RE-BORING CYLINDER BARREL

Pistons and rings, .020" larger than standard, are available. This degree of oversize is such that it is essential for the cylinder barrel to be re-bored to accommodate it. We can provide that service at prices quoted in the Spares List.

On the 350 c.c. the cylinder standard bore is $2.7187 \pm .0005$ ". The 500 c.c. cylinder standard bore is $3.250 \pm .0005$ ".

When the wear at the top of the barrel reaches .008" the barrel should be bored out .020" oversize and a new oversize piston and rings fitted.

Crankpin rollers .001" larger than standard can be supplied. We recommend only skilled mechanics should fit these because it is almost general that the big-end journals and sleeves require "lapping" to ensure a correct fit.

WORKSHOP SERVICE

Motor cycle repairers may require service information other than that detailed and, in those cases, our Service Department will always be pleased to assist on receipt of details of the required matter.

The instructions regarding repairs should be clear and definite, otherwise the cost may be greater than expected. We shall be pleased to give estimates for repairs if parts are sent to us for that purpose. If the estimate is accepted, no charge is made for the preliminary examination, but, should it be decided not to have the work carried out, it may be necessary to make a charge to cover the cost of whatever dismantling and re-assembly may have been done to prepare the estimate.

Parts sent to us as patterns, or for repair, should have attached to them a label bearing the sender's full name and address. The instructions regarding such parts should be sent under separate cover.

CORRESPONDENCE

Our routine is organised into different departments. Therefore delay cannot be avoided if matters relating to more than one department are contained in one letter.

Consequently when communicating with more than one department it is desirable to do so on SEPARATE SHEETS. Each sheet should bear the sender's name and address. **IN PARTICULAR**, requests for **TECHNICAL ADVICE** should not be on the same sheets as **ORDERS FOR SPARE PARTS**.

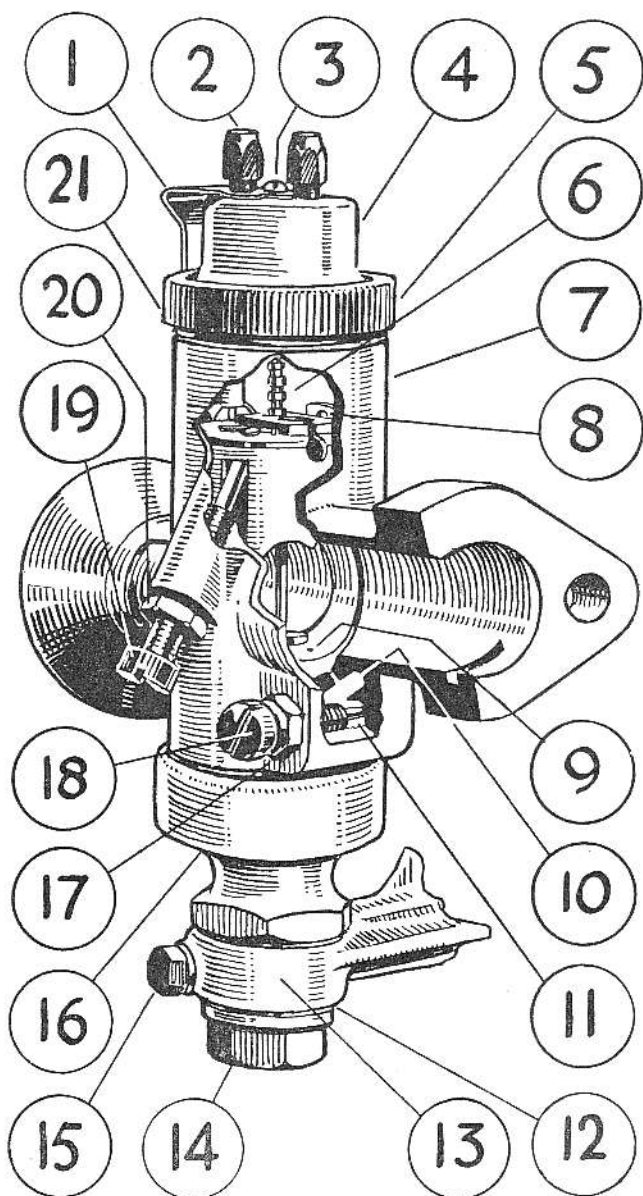


Illustration 15

Showing the mixing chamber with details of the pilot jet with its air adjusting screw and the throttle stop screw

CARBURETTER SERVICE

The information given in this section includes all that will normally be required by the average rider. For further details, particularly those connected with racing and the use of special fuels, we refer the enquirer to the manufacturers of the carburetter, **Messrs. Amal Ltd., Holford Works, Perry Barr, Birmingham.**

Our **Spare Parts Department** does not stock every part of the carburetter but confines its stock to those parts that, from time to time, may need replacement as the result of wear. Those parts include floats and float needles, jet taper needles, needle jets and washers. For most other parts application should be made, through the local Dealer, to the Manufacturers.

CARBURETTER FUNCTION

The petrol level is maintained by a float and needle valve and, in no circumstances, should any alteration be made to this. In the event of a leaky float, or a worn needle valve, the part should be replaced with new. (Do not attempt to grind a needle to its seat.)

The petrol supply to the engine is controlled, firstly, by the main jet and, secondly, by means of a taper needle (see 6, Illustration 15) which is attached to the throttle valve and operates in a tubular extension of the main jet.

The main jet controls the mixture from three-quarters to full throttle, the adjustable taper needle from three-quarters down to one-quarter throttle, the cut-away portion of the intake side of the throttle valve from one-quarter down to about one-eighth throttle, and a pilot jet, having an independently adjusted air supply, takes care of the idling from one-eighth throttle down to the almost closed position. These various stages of control must be kept in mind when any adjustment is contemplated. (See 18, Illustration 15, for location of the pilot jet air adjustment screw.) The pilot jet consists of a small hole drilled in the choke, or jet block.

The size of the main jet should not be altered save for some very good reason. See "DATA" for details of standard sizes of jet, throttle valve, choke and jet taper needle. With the standard setting it is possible to use nearly full air in all conditions, except, perhaps, when the engine is pulling hard up hill or is on full throttle, when some benefit may be obtained by slightly closing the air control.

Weak mixture is always indicated by popping, or spitting, at the air intake.

A rich mixture usually causes bumpy, or jerky, running and, in cases of extreme richness, is accompanied by the emission of black smoke from the exhaust.

See Illustration 15

- | | |
|--|--|
| 1 SPRING CLIP, LOCKING THE FIXING RING. | 11 THREADED HOLE, TO ACCOMMODATE PILOT JET AIR ADJUSTING SCREW (18). |
| 2 CABLE ADJUSTER, FOR BODY TOP. | 12 FIBRE WASHER, FOR HOLDING BOLT. |
| 3 SCREW, SECURING LOCKING CLIP TO BODY TOP. | 13 PART OF FLOAT CHAMBER. |
| 4 TOP, FOR MIXING BODY. | 14 BOLT, HOLDING FLOAT CHAMBER TO MIXING BODY. |
| 5 RING, FIXING TOP TO MIXING BODY. | 15 PLUG SCREW, FOR PETROL PASSAGE IN FLOAT CHAMBER. |
| 6 TAPER NEEDLE, FOR NEEDLE JET (TOP NOTCHED END SHOWN). | 16 UNION NUT, FOR MIXING BODY BASE. |
| 7 MIXING BODY. | 17 LOCK NUT, FOR PILOT JET AIR SCREW. |
| 8 CLIP, LOCATING JET TAPER NEEDLE. | 18 SCREW, FOR PILOT JET AIR ADJUSTMENT. |
| 9 AIR BALANCE PASSAGE. | 19 STOP SCREW, FOR THROTTLE. |
| 10 PASSAGE TO ALLOW MIXTURE FROM THE PILOT JET MIXING CHAMBER TO PASS TO THE CARBURETTER MAIN BORE AND THENCE TO THE INLET PORT OF THE ENGINE. | 20 LOCK NUT, FOR THROTTLE STOP SCREW. |
| | 21 RING, FIXING TOP TO MIXING BODY. |

CARBURETTER ADJUSTMENT

To ascertain if the setting is correct, a rough test is to warm up the engine and, with the ignition fully retarded and the air about three-quarters open, gradually open the throttle to full open, during which the engine should respond without a misfire, but, upon a sudden opening of the throttle, it should splutter and stop. (The engine should not be run for more than a few seconds with the ignition fully retarded.)

To check the setting of the pilot jet and its air control, warm up the engine, then, with the ignition about two-thirds advanced and the air about three-quarters open, the engine should idle positively and evenly when the throttle is almost closed. If it fails to do so, adjust the pilot jet air screw (18, Illustration 15) inwards, or outwards, until even firing is obtained. (The pilot jet air screw is at the base of the mixing chamber and its position is locked by a nut. See 17 and 18, Illustration 15.) This adjustment is not unduly sensitive, and it should be possible to obtain the correct adjustment in a few seconds. In the event of the adjustment of the air screw failing to provide the required result it is possible the pilot jet is obstructed with dirt. The pilot jet is actually a passage drilled in the sprayer base, or choke, and is very small, so there is always latent danger of this becoming choked.

Upon removing the float chamber and the large nut at the bottom of the mixing chamber, the sprayer base can be pushed out of the mixing chamber and the jet can be cleared by using a strand of fine wire.

Before concluding that incorrect carburation is responsible for heavy petrol consumption, and before carrying out any of the tests and adjustments described above, it is most important to make sure the ignition is set correctly. Late ignition usually causes a great increase in petrol consumption.

TWIST GRIP ADJUSTMENT

A screw is provided in one of the halves of the twist grip body to regulate the spring tension on the grip rotating sleeve. This screw, which is locked by a nut, must be screwed into the body to increase the tension.

The most desirable state of adjustment is that when the grip is quite free and easy to operate but, at the same time, will stay in the position in which it is placed.

The complete twist grip can be moved on the handlebar by slackening the two screws that clamp together the two halves of the body. The most desirable position is that in which the throttle cable makes the cleanest and most straight path to the under-side of the petrol tank.

During assembly, all control inner cables are coated with a graphite lubricant. This lasts practically indefinitely, but should a new inner wire be fitted this must be similarly treated during assembly.

CARBURETTER TUNING INFORMATION

Poor idling may be due to :

Air leaks. Either at junction of carburetter and inlet port, or by reason of badly worn inlet valve stems or guides.

Faulty engine valve seatings.

Sparking plug faulty, or its points set too closely.

Ignition advanced too much.

Contact breaker points dirty, pitted, loose, or set too closely.

High-tension wire defective.

Pilot jet not operating correctly.

Rockers adjusted too closely.

Heavy petrol consumption may be due to :

Late ignition setting.

Bad air leaks. Probably at carburetter joint.

Weakened valve springs.

Leaky float. (Causing flooding.)

Taper needle extension insufficient.

Poor compression, due to worn piston rings or defective valve seatings. (Test compression with throttle wide open.)

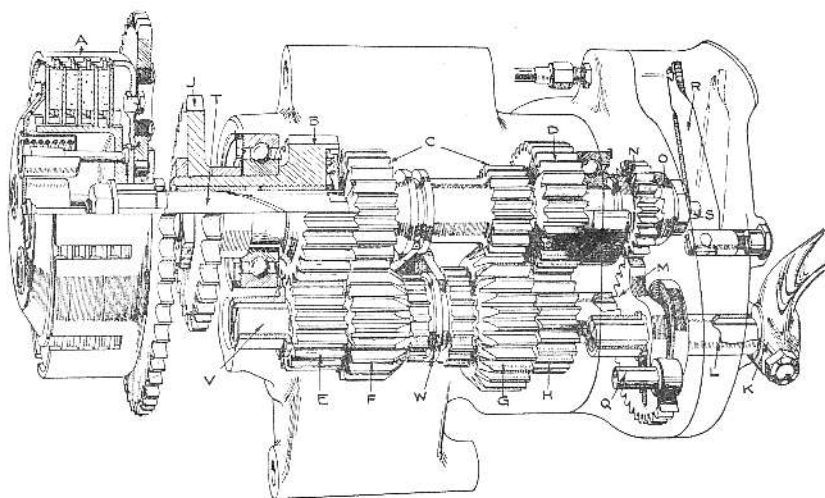


Illustration 16

The Transmission of power, or drive, through the gears may easily be traced on above illustration.

TRANSMISSION SERVICE

THE GEAR BOX

The gear box provides four speeds and has a positive foot change, operated by the right foot, and a kick-starter.

It is retained to the frame by being clamped between the two engine rear plates by two bolts. The bottom fixing bolt acts as a pivot. The top fixing bolt passes through the gear box top lug and the rear plates, which are slotted, thereby allowing a swinging fore and aft movement of the gear box to enable the front driving chain to be adjusted. That movement is controlled by a bolt that has an eye encircling the gear box top fixing bolt and which passes through an eye block secured to the right-hand side engine rear plate. Two nuts threaded on the eye bolt, one on each side of the eye block, provide means of accurately tensioning the front chain and, after that adjustment, locking the eye bolt in its required position.

TRANSMISSION OF POWER THROUGH THE GEARS

(See Illustration 16.)

First, or lowest, gear

Sliding gear (C) on mainshaft (T) is in mid-way position, i.e., disengaged from gears B and D.

Layshaft sliding clutch (W) moves to right and engages with gear (G). Power passes through clutch A, to mainshaft T, to mainshaft sliding gear C, to layshaft gear G, to layshaft clutch V, to layshaft gear E, to main gear B, to chain sprocket J.

Second gear

Sliding gear (C), on mainshaft, is in mid-way position, i.e., disengaged from gears B and D. Layshaft sliding clutch (W) moves to left and engages with gear (F).

Power passes through clutch A, to mainshaft T, to mainshaft sliding gear C, to layshaft gear F, to layshaft clutch W, to layshaft V, to layshaft gear E, to main gear B, to chain sprocket J.

Third gear

Sliding clutch (W), on layshaft, is in mid-way position, i.e., disengaged from gears F and G.

Mainshaft sliding gear (C) moves to right and engages with gear D.

Power passes through clutch A, to mainshaft T, to mainshaft sliding gear C, to mainshaft gear D, to layshaft gear H, to layshaft V, to layshaft gear E, to main gear B, to chain sprocket J.

Fourth, or top gear

Sliding clutch (W), on layshaft, is in mid-way position, i.e., disengaged from gears F and G. Mainshaft sliding gear (C) moves to left and engages with main gear B.

Power passes through clutch A, to mainshaft T, to mainshaft sliding gear C, to main gear B, to chain sprocket J.

NOTE—Clutch A is connected to the engine sprocket by the front driving chain and chain sprocket J is connected to the rear wheel by the rear driving chain.

TO REMOVE FRONT CHAINCASE AND CLUTCH ASSEMBLY

To remove outer half of front chaincase

Place tray under chaincase to catch oil.

Remove screw binding chaincase metal band at its rear.

Remove metal band.

Remove rubber band.

Remove nut and washer, in centre of chaincase front.

Take away outer half of chaincase.

To remove front driving chain and clutch assembly

Engage top gear, apply rear brake, and unscrew engine sprocket nut.

Unscrew the nuts retaining the clutch springs.

Take away the clutch spring pressure plate with the clutch springs and clutch spring cups, and flatten the turned up part of the lock washer that is under the large central nut.

Remove front chain connecting link and take away chain.

Engage top gear, apply rear brake, and unscrew nut retaining the clutch centre to the gear box mainshaft.

Remove the lock and plain washers from gear box mainshaft.

Remove complete clutch assembly by pulling it away, as one unit from gear box mainshaft.

Take care not to lose any of the twenty-four clutch sprocket bearing rollers which may be displaced when the clutch centre and sprocket assembly is withdrawn from the mainshaft. The clutch centre is a sliding fit on the mainshaft and an extractor should not be required.

To remove dynamo chain and back half of chaincase

Remove the spring lock ring on dynamo sprocket retaining nut.

Take away lock washer surrounding dynamo sprocket nut.

Apply spanner (RTK-I, included in tool kit) to the two flats on the back of the dynamo sprocket and, holding same, unscrew the nut retaining the dynamo sprocket.

Release dynamo sprocket with suitable extractor.

Take away, as one assembly, the dynamo sprocket, dynamo chain and engine shock absorber assembly. (The dynamo chain is "endless.")

Straighten tabs on lock washers under the three bolts retaining the back half of chaincase to the boss on the crankcase and remove the three bolts.

Remove the long headed bolt (under battery carrier) fixing rear chain guard to front chaincase.

Remove nut on centre fixing bolt, and spacer behind it, and back half of chaincase can be taken away.

TO RE-FIT THE FRONT CHAINCASE AND CLUTCH

Fit back half of front chaincase by :

Place on face of crankcase boss some liquid jointing compound.

Ensure the spacer is in position on the centre fixing bolt. This is located between the engine plate and the chaincase. (On 350 models is 1-61/64" long and on 500 models is 1-13/32" long.)

Place in position rear half of front chaincase.

Fit long headed bolt, holding rear chain guard to front chaincase, but do not fully tighten.

Fit to crankcase boss the three lock washers and bolts retaining case to boss.

Fully tighten the three bolts and turn up the tabs of the three lock washers.

Fit spacer (inside chaincase, $\frac{7}{8}$ " long) to the centre fixing bolt.

Fit nut to centre fixing bolt and fully tighten.

Fully tighten long headed bolt holding rear chain guard to front chaincase.

Fit dynamo sprocket and chain and engine shock absorber by :

Ensure dynamo sprocket key is in position (in dynamo armature shaft.)

Ensure the spacing collar, which fits between crankcase ball bearing and the back of the engine sprocket, is in position on the driving side flywheel axle.

Take dynamo driving chain and place it round the small sprocket of the engine sprocket assembly and the sprocket that fits on the dynamo shaft and fit these three parts, in one movement, to the driving side flywheel axle and the dynamo shaft.

Fit the dynamo shaft plain washer and sprocket retaining nut, screwing nut with fingers only.

Hold the dynamo sprocket by applying spanner RTK-I to the flats on the back of the sprocket and fully tighten the sprocket retaining nut. (This holding relieves the dynamo shaft of all bending and twisting strains while the sprocket retaining nut is being tightened.)

Fit the dynamo sprocket retaining nut lock washer and lock ring. Ensure the lock ring lies snugly in the groove cut in the nut.

Fit engine shock absorber cam, spring, cap washer and retaining nut but do not fully tighten nut.

Fit the clutch centre and sprocket by :

Place on the gear box main shaft the thicker of the two clutch sprocket roller bearing retaining washers.

Place on the gear box main shaft the clutch sprocket roller bearing ring.

With grease, stick in place on the bearing ring the twenty-four clutch sprocket bearing rollers.

Introduce clutch sprocket over the rollers.

Place on the gear box main shaft the thin clutch bearing retaining washer.

Push on the splined end of the gear box main shaft the clutch centre.

Fit the plain washer, lock washer and nut that retains the clutch centre but do not fully tighten the nut.

Fit the front chain and lock the clutch centre nut by:

Replace the front driving chain. Ensure the spring connecting link is fitted so that the closed end of the spring clip faces the direction of rotation.

Engage top gear, apply the rear brake and then fully tighten the nut that retains the clutch centre to the gear box mainshaft.

Turn up the edge of the lock washer so that it tightly abuts against a flat of the nut.

Fit the clutch plates and springs by :

Slide into position, in the clutch case attached to the clutch sprocket, a steel plain clutch plate. (On 350 touring models the first plate must be the one extra thick plate, ensure the recessed part of the steel plate faces to the clutch centre and thereby overhangs the flange of the clutch centre.)

Slide into place a clutch friction plate (plate with fabric inserts) and follow with a steel plain plate, then another friction plate and so on, alternatively, till all plates are fitted. (Five plain plates and four friction plates on 350 c.c. ; six plain, and five friction on 500 c.c. and all competition models.)

Drop into the spring pressure plate the clutch spring cups.

Show up the spring pressure plate and insert over the studs the clutch springs, retaining each one a few turns, as fitted, with a clutch spring adjusting nut.

Fully tighten the clutch spring adjusting nuts.

Slacken back, four complete turns, each clutch spring adjusting nut. (An old and broad screwdriver, specially slotted on the engaging edge, is the most suitable tool for clutch spring adjustment.)

Engage top gear, apply rear brake and then fully tighten the engine shock absorber retaining nut.

Check front driving chain for adjustment.

Check dynamo driving chain for adjustment.

Fit outer half of front chaincase by :

Ensure faces of both halves of chaincase are clean.

Place a line of liquid jointing compound on the face of the front half of chaincase.

Take off, from the rear brake rod, the adjusting knurled nut and fully depress the brake pedal and then place in position the front half of the front chaincase.

Fit to the centre fixing bolt the plain washer and nut and, when tightening the nut, move the front half of the chaincase, as may be necessary, for it to exactly register with the back half.

Ensure the rubber and metal bands are clean and undamaged.

Place round the edge of the chaincase some liquid jointing compound.

Press in position the rubber band so that its two free ends meet at the rear of the larger end of the chaincase.

Fit the metal band, starting at the front end of the chaincase and drawing together the two free ends of the band with one hand while, with the other hand, replacing its binding screw.

Fully tighten the metal band binding screw.

Allow time for the liquid jointing to set **(AT LEAST ONE HOUR)** and then remove the inspection cap from the chaincase and pour in engine oil to the level of the bottom edge of the inspection cap orifice and then replace the cap.

NOTE—If, after replacing a front chaincase, it is found not to be oil tight, the general reason is distortion of the two joint faces. These faces must be undamaged and, on test, should closely fit to a surface plate. They must also be absolutely clean before replacement and the edges must be in exact register, one with the other. Any distortion caused by accidental impact must be remedied before refitting.

If any doubt exists, **CHECK for DISTORTION BEFORE ASSEMBLY.**

THE CLUTCH (See Illustration 17)

Clutch operating lever A is moved in direction of arrow to disengage the clutch.

Operation of clutch handlebar lever moves lever A in direction of arrow and causes it to press against operating plunger B, which, in turn, presses against steel ball C, against the clutch thrust rod D which pushes against the clutch spring pressure plate F.

This action compresses the clutch springs M so that their pressure is released from compressing the clutch plain plates G and the clutch friction plates H, thereby allowing the engine to drive the clutch sprocket L without imparting power, and motion, to the gear box mainshaft T. Consequently no power is transmitted to the rear wheel and the clutch is said to be "out" or free.

On allowing the clutch handlebar lever to return to its normal position the clutch operating lever becomes "free" and the clutch spring pressure causes the clutch thrust rod D, the steel ball C and the operating plunger B to move to the right.

The whole of the clutch spring pressure is thereby transferred to the clutch spring pressure plate F and this forces the steel plates G tightly against the clutch friction plates H so that power, transmitted by the engine to clutch sprocket L, is transferred through clutch case J to friction plates H, to steel plates G, to clutch centre E which causes the gear box mainshaft to revolve.

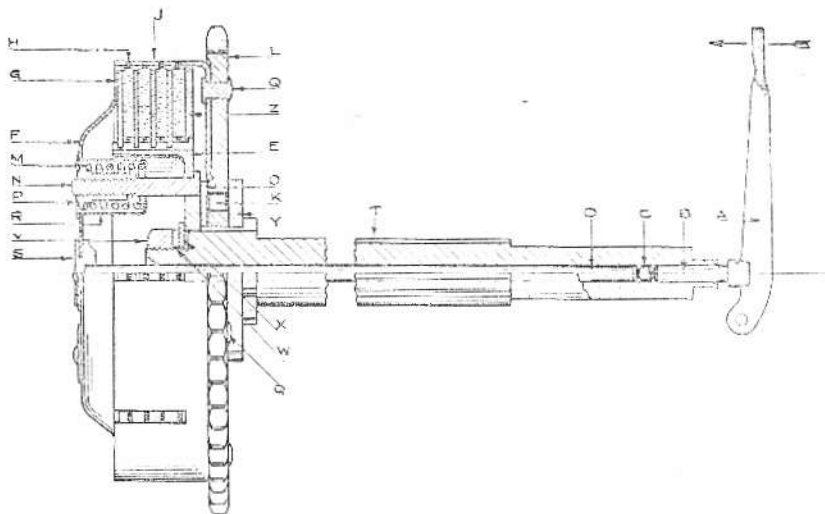


Illustration 17

Showing clutch, gear box main shaft and clutch operating mechanism

CLUTCH SPRING ADJUSTMENT

If clutch slip is experienced the most probable cause is incorrect cable adjustment.

If the clutch cable adjustment is found to be correct, i.e., there is the clearance of $\frac{1}{32}$ inch mentioned in the following paragraph, the clutch spring adjustment nuts should be adjusted.

To adjust clutch spring adjustment nuts :

Obtain access to clutch spring adjustment nuts by removing outer half of front chaincase.

Screw home one-half of a complete turn, each clutch spring adjustment nut and then test for clutch slip.

If necessary, repeat, by screwing home a further half-turn but be careful to adjust each of the nuts a similar amount.

If, to remedy clutch slip, it is necessary to screw nearly home the five nuts, this is a clear indication that, either the clutch springs have lost their strength, and/or, the fabric inserts in the clutch friction plates have worn so that they are past further useful service. In which case, replace with new.

The standard setting of the clutch spring adjusting nuts is obtained by fully tightening all five nuts and then unscrewing each exactly four complete turns.

CLUTCH ADJUSTMENT

Minor adjustment of the clutch operating mechanism is obtained by screwing, in or out, the clutch cable adjuster located in the back of the kick-starter case.

Major adjustment of the clutch operating mechanism is obtained by altering the position of the fulcrum pin of the clutch operating lever in the kick-starter case. (Lever A in Illustration 17 and 175-X-4 in Illustration 18.)

The Major adjustment is explained below.

175-X-4 is the gear box clutch operating lever, and 66-X-7 is the pin on which it hinges.

329-X is the operating lever fork and this slides in the kick-starter case cover, its position being determined by the sleeve nut 331-X.

Cap 328-X is secured to the outside of the kick-starter case cover, being fixed by the two screws 333-X and acts as a locking device for the sleeve nut 331-X.

It is essential that there is about $\frac{1}{32}$ " clearance between the operating plunger 330-X and the nose on operating lever 175-X-4 when the clutch is in the engaged, or driving, position. This clearance is easily checked by removing the filler cap when it should be possible, with finger pressure only, to move the clutch withdrawal lever 175-X-4, the top end of which lies just beneath the filler cap orifice, about $\frac{3}{32}$ " to and fro. This amount of free movement at the extreme tip represents approximately the clearance of $\frac{1}{32}$ " specified above.

It will be appreciated that, as the result of wear on the fabric inserts in the clutch friction plates, the plates will tend to close up towards each other. This increases the effective length of the clutch thrust rod. On the other hand, the clutch control inner wire tends to stretch in use. These two actions will neutralise each other but the fact remains that, from time to time, it is necessary to adjust the rod clearance and also take up cable stretch. Clutch slip caused by the clutch thrust rod permanently bearing on the spring pressure plate will rapidly ruin the fabric inserts and thrust rod. In addition, the heat generated by this may be so intense that the hardening of the clutch springs and the two ends of the thrust rod may be adversely affected.

Therefore, the importance of correct adjustment, and inspection of same to see the adjustment is maintained, must be stressed.

Obtain adjustment of clutch mechanism by :

Remove the two screws 333-X.

Take away the cap 328-X.

Adjust the sleeve nut 331-X as may be necessary, as follows :

To increase clearance between clutch operating lever 175-X-4 and operating plunger 330-X, turn sleeve nut in a right-hand, or clockwise, direction.

To decrease clearance between clutch operating lever 175-X-4 and operating plunger 330-X, turn sleeve nut in a left-hand, or anti-clockwise, direction.

One or two turns should be ample.

Replace cap and screws.

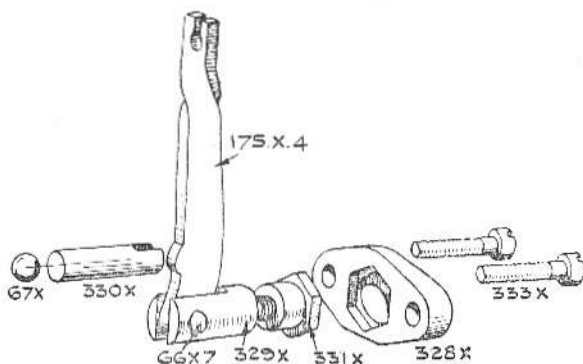


Illustration 18

Details of clutch operating lever

175-X-4	LEVER, OPERATING CLUTCH.	331-X	SLEEVE, OR NUT, FOR OPERATING LEVER FORK.
67-X	BALL (STEEL), FOR OPERATING PLUNGER.	328-X	CAP, COVERING SLEEVE (SCREWED TO KICK-STARTER CASE COVER).
330-X	OPERATING PLUNGER.	333-X	SCREW, FIXING CAP TO KICK-STARTER CASE COVER.
66-X-7	PIN, OR AXLE, FOR OPERATING LEVER.		
329-X	FORK, FOR OPERATING LEVER.		

CLUTCH CABLE ADJUSTMENT

Minor adjustment of the clutch operating mechanism is obtained by :

Slacken lock nut on the cable adjuster screwed into the back of the kick-starter case.

To decrease the effective length of the clutch control cable, i.e., to take up play between the control and the clutch thrust rod, unscrew the cable adjuster from the kick-starter case. A few turns should be ample.

To provide a greater amount of play, screw into the kick-starter case the cable adjuster.

Finally, tighten lock nut on cable adjuster.

NOTE—The amount of play, or free movement, can easily be discovered by virtue of the greatly increased resistance of the handlebar clutch control lever as the de-clutching action commences.

To remove a clutch control cable

Remove the oil filler cap from the kick-starter case cover.

Screw right home the clutch cable adjuster that is located in the back of the kick-starter case.

Disengage, from the operating lever, the clutch cable inner wire by operating through the oil filler cap opening.

Completely unscrew the clutch cable adjuster.

Disengage, from the handlebar operating control lever, the clutch inner wire.

Pull cable, by its lower end, till removed from the machine, easing it through the frame cable clips while doing so.

To replace a clutch control cable

Reverse the above instructions and, finally, adjust as detailed in the previous paragraph.

FRONT CHAIN ADJUSTMENT

Tighten the front chain by :

Slacken : Nut on right-hand side of gear box top fixing bolt.

Nut on right-hand side of gear box bottom fixing bolt.

Forward nut on the adjusting eye-bolt. (Two or three turns.)

Remove inspection cap from front chaincase.

Screw up the rear nut on adjusting eye-bolt until, with the finger through the inspection cap orifice, it can be felt that the chain is dead tight. Then slack off the rear nut and carefully tighten the forward nut until the correct chain tension is obtained, after which securely tighten the rear nut to lock the assembly. (The correct chain whip is $\frac{3}{8}$ inch.) Check the adjustment in more than one position and adjust, as above, at tightest place. **It is important that these instructions to over-tighten and then slack back are carefully followed.**

Tighten nuts on gear box top and bottom fixing bolts.

Replace chaincase inspection cap.

REAR CHAIN ADJUSTMENT (Spring Frame Models)

To provide rear chain adjustment the rear wheel is bodily moved in the rear frame fork ends which are open ended and slotted.

The rear wheel centre spindle has two cams attached to it. These cams abut against projections in each of the rear fork two slotted ends. The projection on the right-hand fork end is adjusted at the Factory and its position is locked by a nut. That adjustment is provided to ensure the rear wheel is positioned in line with the front wheel and, once it has been determined during assembly, there should be no necessity ever to alter it again.

The chainside cam has a hexagonal body to accommodate a spanner and is turned, forwards or backwards, to position the rear wheel so that the rear driving chain is correctly tensioned. (Both cams turn together.)

The correct chain tension is such that, when the machine is on the centre stand, finger pressure applied to the chain, midway between gear box sprocket and rear wheel sprocket, in an upward and downward direction, allows a total movement, up and down, of $1\frac{1}{8}$ ". The rear wheel should be rotated to several positions and tests made at each, because chains never wear evenly and there is usually one position where the chain is tighter than in any other. The adjustment of $1\frac{1}{8}$ " total whip should be set for the tightest position found.

(When off the stand, and with the rider on the saddle, this measurement is reduced to about $\frac{1}{2}$ " total whip, which is the correct adjustment when on the road.)

To adjust the rear chain

Place the machine on the centre stand.

Slacken nut to right of speedometer gear box.

Slacken exterior nut on left-hand end of rear wheel spindle.

Push forward the wheel so that both cams are in contact with the projections on the rear fork ends.

Apply adjustable wrench L-TK-12 to hexagonal body of chainside cam, and, while maintaining a forward pressure on the wheel, to ensure contact of the two cams, turn, with the wrench, until the chain whip of $1\frac{1}{8}$ ", detailed above, is obtained. Then holding the wheel in that position, fully re-tighten the spindle exterior nut.

Finally, fully tighten the nut to the right of the speedometer gear box after being satisfied that the gear box is in such a position that no strain is being placed on the driving cable.

REAR CHAIN ADJUSTMENT (Rigid Frame Models)

To provide rear chain adjustment the rear wheel is bodily moved in the frame fork ends, which are open ended and slotted.

Tighten rear chain by :

Place machine on rear stand.

Slightly slacken nuts on rear wheel solid spindle (left side first).

Slacken nut on each chain adjusting bolt, two or three turns. (These bolts screw into forward end of each frame fork end.)

Screw, in turn, each chain adjusting bolt, further into the fork ends until the chain tension is correct. Each bolt must be turned the same amount. The chain whip should be $\frac{3}{8}$ " to $\frac{1}{2}$ ".

Check adjustment, in more than one position, by partly revolving the rear wheel.

Tighten wheel spindle nuts.

Re-check chain tension.

Tighten nuts on chain adjusting bolts.

NOTES ON REAR CHAIN ADJUSTMENT

Before tightening the rear chain, check the front chain adjustment, and, if attention is necessary, adjust the front chain first.

Altering the adjustment of the front chain upsets the adjustment of the rear chain. Therefore, after making a front chain adjustment, always check the rear chain adjustment and re-set if necessary.

Altering the adjustment of the rear chain may upset the adjustment of the rear brake. Therefore, after making a rear chain adjustment, always check the brake adjustment and re-set if necessary.

The whip of chains should always be tested mid-way between the two sprockets, and the sprockets should be turned and tests made in several positions. This is because chains never wear evenly, and there is usually one position where the chain is tighter than in any other. The adjustment should be set for the tightest position found.

Always re-check the chain tension after making it and tightening all bolts and nuts.

DYNAMO CHAIN ADJUSTMENT

The dynamo armature shaft is eccentric to the body of the dynamo. Therefore, by partially revolving the dynamo in its housing the distance between the two dynamo driving sprockets can be varied, thereby allowing latitude for chain adjustment.

Tighten dynamo chain by :

Remove inspection cap from front chaincase.

Slacken dynamo clamping strap bolt.

Apply spanner RTK-1 to the flats cast on the dynamo end plate (left-hand side of dynamo) and rotate dynamo, in an anti-clockwise direction till, by passing a finger through the inspection cap opening, it can be felt the chain tension is correct.

The chain whip should be about $\frac{1}{4}$ ". Ensure, when feeling tension, the front driving chain is not confused with the dynamo chain which lies behind the front driving chain.

Tighten dynamo clamping strap bolt.

Re-check chain tension.

Replace chaincase inspection cap.

MAGNETO CHAIN ADJUSTMENT

The magneto platform hinges on one of its fixing bolts. This provides sufficient movement for adjustment to the magneto driving chain.

Tighten magneto chain by :

Remove magneto chain case cover.

Slacken nuts on bolts supporting magneto platform.

Insert a screwdriver under that end of the magneto platform which is slotted and lever upwards until the chain tension is correct.

The chain whip should be about $\frac{1}{4}$ ".

Tighten nuts on platform supporting bolts.

Re-check chain tension.

Place supply of grease on magneto driving chain.

Replace magneto chain cover.

ENGINE SHOCK ABSORBER

The engine shock absorber is a spring device for smoothing out the impulses transmitted by the engine.

The engine sprocket is a free fit on the driving side flywheel axle. It has, integral with it, a face cam that engages with a similar face cam ("shock absorber cam") which is keyed to the driving side flywheel axle by splines. A spring keeps the shock absorber cam in close engagement with the cam on the sprocket, and, the shock absorber cam being driven by the engine, over-rides the sprocket cam under the influence of the engine impulses. The shock absorber spring is compressed by the over-riding of the cams, thereby absorbing the shocks.

It is essential the faces of the cams are adequately lubricated otherwise the shock absorbing action will be nullified and this is automatically taken care of, providing the level of the oil in the front chaincase is maintained according to the instructions given in the "Lubrication Section."

The shock absorber spring is retained by a cap washer and a retaining nut which must be fully tightened.

The dynamo sprocket is integral with the engine sprocket.

Behind the engine sprocket (between the sprocket and the crankshaft roller bearing) is a spacing collar which is a sliding fit on the driving side flywheel axle and in no circumstances must this be omitted.

NOTE—At the first sign of transmission harshness examine front chaincase for correct oil level, and dismantle and lubricate the shock absorber parts if the harshness continues. For access to the shock absorber parts it is necessary to remove the outer half of the front chaincase.

The order of assembly of the engine shock absorber is

- 1 The spacing collar between the crankshaft roller bearing and the engine sprocket.
- 2 The engine sprocket.
- 3 The shock absorber cam.
- 4 The shock absorber spring.
- 5 The cap washer.
- 6 The retaining nut.

FORK & FRAME SERVICE

STEERING HEAD ADJUSTMENT

The steering head frame races are of the floating self-aligning type and have spherical seats. Therefore they do not fit tightly in the head lug.

Occasionally test the steering head for correct adjustment by exerting pressure upwards from the extreme ends of the handlebars.

It is particularly important that the adjustment is tested after the first one hundred miles because of the initial settling down that always occurs in that period.

Should any shake be apparent, adjust the steering head bearings.

Adjust steering head bearings by :

Jack up the front of the machine so that all weight is taken off the front wheel. (A box under each footrest serves that purpose.)

Slacken the nuts on the two fork crown studs.

Slacken the domed nut at top of the steering column.

Screw down the nut underneath the domed nut a little at a time (using spanner R-TK-3) and, while doing so, test the head assembly for slackness by placing the fingers over the gap between handlebar lug and frame top lug, at the same time exerting upward pressure by lifting from the front edge of the front mudguard.

Continue to tighten the lower adjusting nut until no perceptible movement can be felt and yet the steering head is perfectly free to turn, then tighten down the domed nut in order to lock the adjustment.

Tighten the two fork crown pinch stud nuts.

Remove packing from under footrest.

FRONT FORKS (TELEDRAULIC)

Owing to the unusual construction of the "TELEDRAULIC" fork it is desirable to understand what happens in use and, in order to follow clearly the descriptions and subsequent assembly and adjustment instructions, reference to Illustrations 19 and 20 will be necessary.

As will be seen from the general arrangement drawing, Illustration 20, the main members of the forks are two long tubes. These are of heavy gauge and are externally ground to very fine limits. These fork main, inner, tubes are firmly fixed to the handlebar clip lug by the top bolts 014354 and are clamped to the fork crown by the clamping studs 011755 and nuts 011635. Upon the external of these tubes are mounted the springs and sliding members, to which latter the front wheel, mudguards and front stand are fixed.

The telescopic action of the sliders, combined with the hydraulic dampers, described later, explain the word "Teledraulic," coined for the description of the fork.

The hydraulic dampers are of the shuttle type operating above the steel bushes at the lower ends of the main inner tubes.

The sliding members (sliders) operate on the steel bushes at the lower ends of the main inner tubes and on plastic bushes secured to the top ends of the sliders themselves. Above each plastic bush is an oil seal which is provided to overcome any possibility of the hydraulic fluid leaking into the spring chamber.

The hydraulic fluid used is a thin oil of the grade specified in the Lubrication Section and, henceforth in these instructions, is referred to as "oil."

The normal level of oil is well above the bottom extremity of the main inner tubes. Bearing this in mind, it is at once clear that the upward movement of the sliders, upon impact with road bumps, in addition to meeting resistance from the springs also causes oil to be swept down by the close fitting steel bushes. This oil is forced upward through the open ends of the main inner tubes, through the holes A (Illustration 19) and then past the shuttle which the escaping oil raises off its seat, then past the exterior of the shuttle into the upper part of the slider. As the oil level inside the main inner tube rises, air trapped above the holes A is compressed, thereby forming an air buffer acting as auxiliary to the main springs. This displacement of oil, upon impact, imposes a certain amount of damper effect, the extent of which increases with the violence of the shock, or, in other words, the bigger the bump the more damping takes place. Upon the recoil movement the shuttle returns to its seat and oil, trapped above, has, as its important source of escape, the small passage between the bore of the shuttle and the main inner tube, upon which it operates. Once past this restriction the oil can freely enter the lower chamber via the holes A. This very restricted passage for the oil causes a considerable damper effect to the recoil movement.

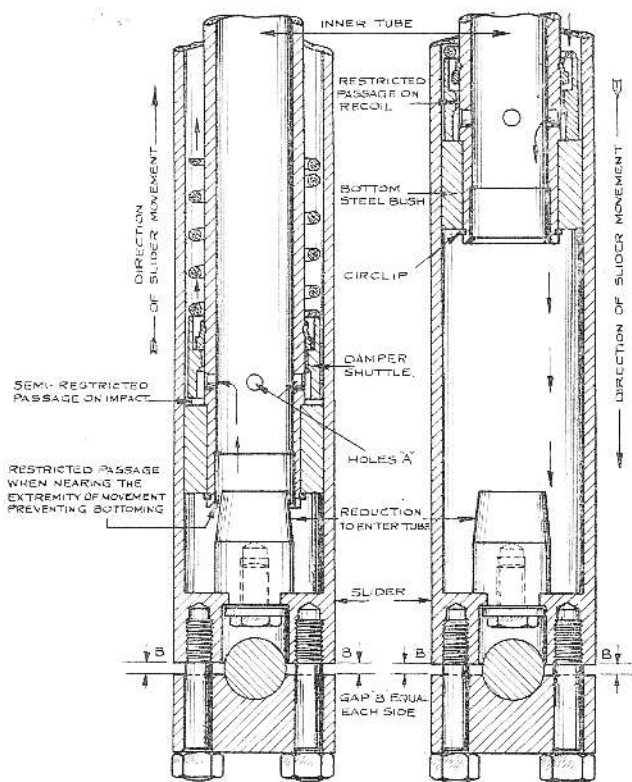


Illustration 19

It will thus be gathered that, on the shock movement of the sliders, slight damping action occurs, with a greatly increased damper action on the reverse movement, both actions automatically increasing in effect the more violent the movement.

Before concluding this description, it should be mentioned that, upon a very violent impact, as a result of which the springs are almost fully compressed, the damping of the upward movement of the sliders is automatically increased by the greatly restricted passage for the displaced oil, due to the lower ends of the main inner tubes encircling the tapered damper cones 012954. Thus "bottoming" is prevented, no matter how violent the impact.

FRONT FORK "TOPPING UP"

No part of the **TELEDRAULIC** Front Fork requires individual lubrication, but it is advisable to check the oil content, used primarily for hydraulic damping, every five thousand miles.

Each fork main inner tube contains 10 fluid ounces (equal to 284 c.c.) of oil.

To check the oil content of front fork

Have motor cycle vertical and raised (a box under each footrest will do) so that the front wheel is well clear of the ground. Remove the bolts from the upper ends of the fork inner tubes.

Have a graduated measure of not less than 10 fluid ounces capacity available in which to catch and measure the oil.

Treat each side of fork separately.

Remove drain plug from bottom of a slider and catch oil that runs out. The amount should be about 8 to $8\frac{1}{2}$ fluid ounces.

Replace drain plug and work the forks up and down a few times and again remove drain plug and catch oil. It may be necessary to repeat this operation several times to ensure the extraction of the maximum amount of oil.

The total amount of oil withdrawn should be $9\frac{1}{2}$ fluid ounces. If less than this amount, add to bring to $9\frac{1}{2}$ ounces and, after replacing firmly the drain plug, pour the $9\frac{1}{2}$ ounces of oil into the main inner tube via the top open end and then replace the hexagonal headed top bolt taking care to tighten firmly down. The top bolt has a rubber ring encircling it to ensure an air tight joint. See that the rubber ring is undamaged.

Treat the other slider in a like manner.

The top screwed plugs **must** be re-fitted while the weight is off the front wheel, therefore make sure they are tightened firmly **BEFORE** removing the packing placed under the footrests.

NOTE—Although the oil content of each side is specified as 10 fluid ounces, it is not possible to drain completely all the oil via the drain plug. This explains the lesser quantity of $9\frac{1}{2}$ ounces, mentioned above. However, if the fork has been completely dismantled and then re-assembled in a "dry" state it should be noted that, in that event, the correct quantity of oil to add to each main inner tube is 10 fluid ounces.

TO REMOVE THE COMPLETE FRONT FORK ASSEMBLY

Support the machine with the front wheel clear of the ground. (A box, of suitable height, under each footrest is the best method.)

Remove front wheel by method described in Wheel Section.

Remove front stand and front mudguard.

Detach the switch panel that is held to the top of the head lamp by three screws.

Disconnect speedometer driving cable from the speedometer head.

Detach the speedometer light bulb with its holder.

Remove the two bolts retaining the head lamp and take same away.

Remove the two bolts retaining the speedometer head and take same away.

Remove the handlebar half clip and lay the handlebars, complete with controls, upon a pad on top of the petrol tank.

Detach the front brake cable from the forks. (First remove the slotted yoke end and then completely unscrew the cable adjuster.)

Remove the bolt from top of each main inner tube.

Remove domed lock nut at top of steering column.

Remove lock nut on steering column.

Use a soft mallet to tap upward the handlebar lug until it disengages with the fork stem (steering column) and the fork assembly can then be withdrawn. (Take care to avoid loss of the 56 steering head steel balls.)

To re-fit a complete front fork assembly

Stick, with grease, 28 balls in fork crown ball race.

Stick, with grease, 28 balls in main frame top ball race.

Proceed to fit fork assembly by reversing the instructions given above to dismantle.

TO REMOVE A FORK SLIDER (either side)

Support the machine with the front wheel clear of the ground.

Remove extension from the slider by unscrewing. Two holes are in its side for the application of hook spanner 010438.

Remove front wheel, front stand and front mudguard.

Withdraw slider by giving it a sharp downward jerk. If difficulty is experienced, apply a little heat to the enlarged top end of the slider. This will cause sufficient expansion to release the oil seal which is normally a snug push-in fit in the top of the slider.

To re-fit a fork slider

The re-assembly is carried out in exactly reverse order, again, if necessary, applying a little heat to enable the oil seal to be pushed down into the slider top before screwing in the extension.

After completion the oil which has escaped **MUST BE** returned via the top end of the main inner tube as already described in "Topping up."

TO REMOVE A FORK MAIN INNER TUBE (either side)

Remove the fork slider as already described in the preceding paragraph.

Remove the bolt at the extreme top of the main inner tube.

Loosen nut on fork crown clamping stud.

The entire main inner tube assembly can now be drawn down through the fork crown lug.

To re-fit a fork main inner tube

Upon re-assembly the main inner tube assembly is first pushed home, by hand, as far as possible and then drawn right home by screwing in the top hexagon headed bolt.

When this bolt is tightened fully down then proceed to tighten securely the fork crown clamping stud nut. The slider is then refitted. The remainder of the assembly is quite straight-forward if carried out in the reverse order to the dismantling.

NOTE—If any oil has been lost in the process of dismantling and re-assembly, it should be topped up, upon completion, as already described.

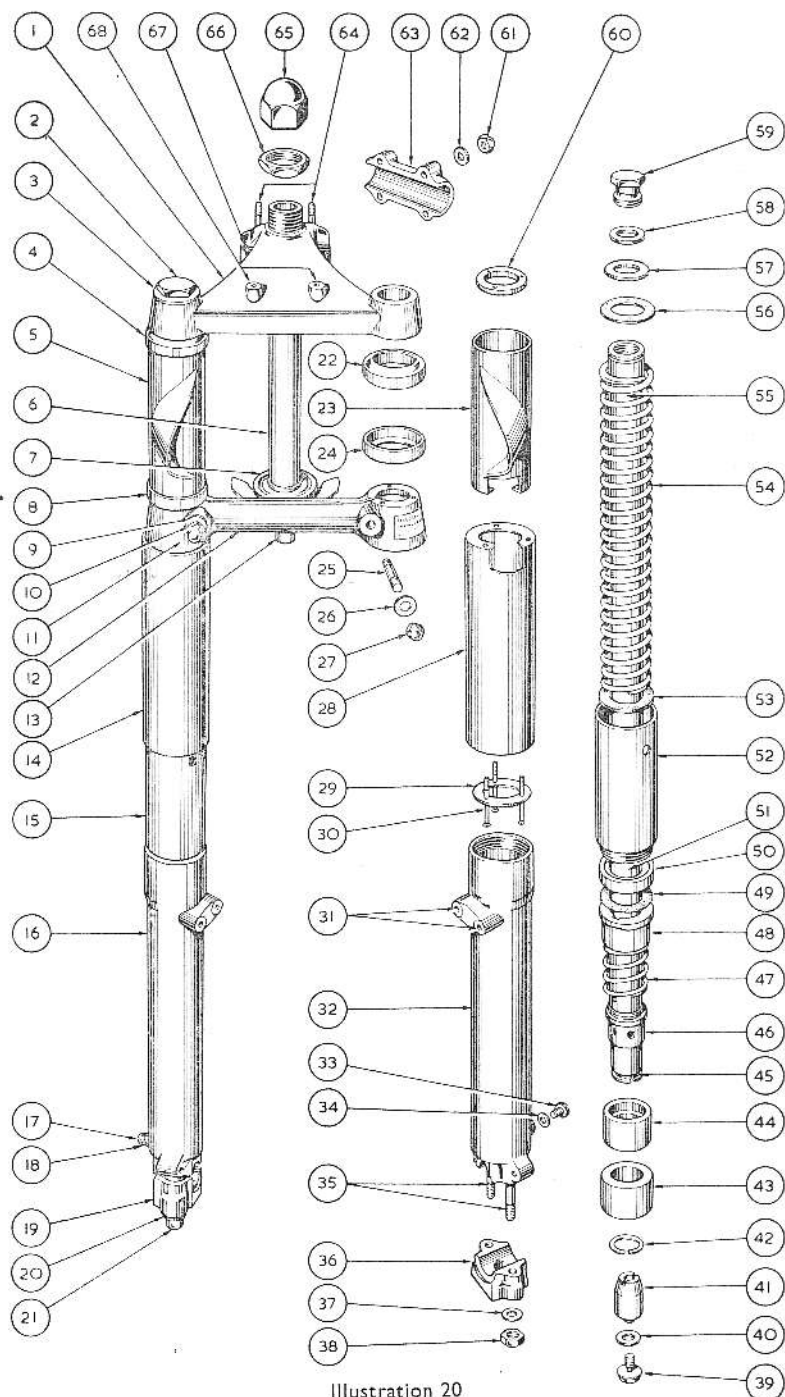


Illustration 20

REF. NO.	PART NUMBER	DESCRIPTION
1	013631	LUG, FOR HANDLEBAR AND STEERING HEAD.
2	014354	BOLT, TOP, FOR FORK INNER TUBE.
3	40-G12M-FF190	WASHER, PLAIN, FOR FORK INNER TUBE TOP BOLT.
4	40-G12M-FF185	CAP, FOR FORK TOP COVER TUBE, TOP LOCATION.
5	013694	TUBE, FORK COVER, TOP, RIGHT WITH LAMP LUG.
6	—	STEM, FOR FORK CROWN (NOT SOLD SEPARATELY).
7	STD-805	BALL RACE, FOR FORK CROWN.
8	012569	CAP, FOR FORK TOP COVER TUBE, BOTTOM LOCATION.
9	STD-11	WASHER, PLAIN, FOR FORK CROWN PINCH STUD.
10	011635	NUT, FOR FORK CROWN PINCH STUD.
11	—	FORK CROWN (NOT SOLD SEPARATELY).
12	013861	FORK CROWN ASSEMBLY (CROWN, STEM AND CIRCLIP).
13	—	BOSS, ON FORK CROWN, THREADED TO ACCOMMODATE STEERING DAMPER PLATE FIXING BOLT.
14	41-G3L-FF184B	TUBE, FORK COVER, BOTTOM.
15	014341	EXTENSION, FOR FORK SLIDER.
16	013632	SLIDER, FOR FORK, WITH CAP, STUDS AND NUTS.
17	STD-485	SCREW, PLUG, FOR FORK SLIDER OIL DRAIN HOLE.
18	STD-203	WASHER, FIBRE, FOR FORK SLIDER DRAIN HOLE SCREW.
19	013509	CAP, FOR FORK SLIDER.
20	STD-11	WASHER, PLAIN, FOR FORK SLIDER CAP SECURING STUD.
21	STD-4	NUT, FOR FORK SLIDER CAP SECURING STUD.
22	40-G12M-FF185	CAP, FOR FORK TOP COVER TUBE, TOP LOCATION.
23	013695	TUBE, FORK COVER, TOP, LEFT WITH LAMP LUG.
24	012569	CAP, FOR FORK TOP COVER TUBE, BOTTOM LOCATION.
25	011755	STUD, PINCH, FOR FORK CROWN.
26	STD-11	WASHER, PLAIN, FOR FORK CROWN PINCH STUD.
27	011635	NUT, FOR FORK CROWN PINCH STUD.
28	41-G3L-FF184B	TUBE, FORK COVER, BOTTOM.
29	40-G12M-FF127	PLATE, PLAIN, LOCATING BOTTOM COVER TUBE.
30	40-G12M-FF129	SCREW, RETAINING BOTH LOCATING PLATES.
31	—	HOLES, THREADED, TO ACCOMMODATE BRAKE ANCHOR STAY.
32	013632	SLIDER, FOR FORK, WITH CAP, STUDS AND NUTS.
33	STD-485	SCREW, PLUG, FOR FORK SLIDER OIL DRAIN HOLE.
34	STD-203	WASHER, FIBRE, FOR FORK SLIDER DRAIN HOLE SCREW.
35	40-G12M-FF195	STUD, SECURING CAP TO FORK SLIDER.
36	013509	CAP, FOR FORK SLIDER.
37	STD-11	WASHER, PLAIN, FOR FORK SLIDER CAP SECURING STUD.
38	STD-4	NUT, FOR FORK SLIDER CAP SECURING STUD.
39	40-G12M-FF94	BOLT, FIXING DAMPER CONE TO SLIDER.
40	40-G12M-FF80	WASHER, FIBRE, FOR DAMPER CONE FIXING BOLT.
41	012954	CONE, FOR FORK DAMPER.
42	40-G12M-FF192	CIRCLIP, LOCATING INNER TUBE BOTTOM BUSH.
43	40-G12M-FF191	BUSH, BOTTOM, FOR FORK INNER TUBE.
44	013347	SHUTTLE, FOR DAMPER.
45	40-G12M-FF192	CIRCLIP, LOCATING INNER TUBE BOTTOM BUSH.
46	—	STOP SHOULDER, A PART INTEGRAL WITH THE FORK INNER TUBE, WHICH, WITH SHUTTLE 013347, FORMS THE DAMPER VALVE.
47	011126	SPRING, BUFFER, FOR FRONT FORK.
48	40-G12M-FF41	BUSH, PLASTIC, GUIDE, FOR FORK INNER TUBE.
49	014297	WASHER, COMPOSITION (NOT NOW USED).
50	40-G12M-FF91	OIL SEAL, FOR FORK INNER TUBE.
51	013348	TUBE, FORK, MAIN, INNER.
52	014341	EXTENSION, FOR FORK SLIDER.
53	40-G12M-FF126	WASHER, LEATHER, FOR FORK SPRING SEATING.
54	012972	SPRING, MAIN, FOR FRONT FORK (SOLO).
55	013348	TUBE, FORK, MAIN, INNER.
56	40-G12M-FF126	WASHER, LEATHER, FOR FORK SPRING SEATING.
57	40-G12M-FF190	WASHER, PLAIN, FOR FORK INNER TUBE TOP BOLT.
58	014355	RING (RUBBER) SEALING, FOR INNER TUBE TOP BOLT.
59	014354	BOLT, TOP, FOR FORK INNER TUBE.
60	40-G12M-FF128	PLATE, THREADED, LOCATING TOP COVER TUBE.
61	014278	NUT, FOR HANDLEBAR CLIP STUD.
62	STD-12	WASHER, PLAIN, FOR HANDLEBAR CLIP STUD.
63	013629	CLIP, HALF ONLY, FOR HANDLEBAR LUG.
64	012870	STUD, FOR HANDLEBAR CLIP.
65	L4-FF46	NUT, LOCK (DOMED) FOR FORK CROWN STEM.
66	STD-236	NUT, ADJUSTING, FOR FORK CROWN STEM.
67	STD-51	NIPPLE, GREASE, FOR HANDLEBAR LUG.
68	—	HOLES TO ACCOMMODATE BOLTS FIXING SPEEDOMETER HEAD.

TO ASSEMBLE THE TELEDRAULIC FRONT FORKS

Assuming that the fork has been completely dismantled, proceed as follows :

Prepare by making five sub-assemblies

- (a) One fork crown and cover tube assembly.
- (b) Two main inner tube assemblies.
- (c) Two slider assemblies.

(a) Make the fork crown and cover tube assembly by :

Take a fork crown (with stem and stem circlip which three parts are only sold as one assembly), secure it in a vice and fit the two top and bottom cover tubes, right and left, in turn, by :

Place a plain locating plate inside a bottom cover tube (long tube).

Place a screwed locating plate inside a top cover tube (short tube).

Place a bottom cap on the lower end of the top tube.

Place the bottom tube in position against the fork crown.

Place the top tube in position against the fork crown.

Bind together the two cover tubes by three screws.

NOTE—The screws are inserted from the bottom, and the holes in the locating plates, the cover tubes and the fork crown are not evenly spaced. Therefore, before inserting the first screw, the plates and tubes must be positioned so that all holes in the two plates, the two tubes and the fork crown will register with each other.

Fit the remaining top and bottom cover tubes in a like manner.

Fit the fork crown ball race to the fork crown, load the race track with grease and fill it with 28 steel balls ($\frac{3}{16}$ " diameter).

Lay over the steel balls a frame ball race (a race with a spherical seat).

The assembly is now complete.

Prepare handlebar lug by :

Fit on the handlebar clip lug the two top cover tube top caps.

Press into position the ball race (plain race with vertical sides).

Remove the handlebar half clip.

(b) Make an inner tube assembly by :

Take a main inner tube and lay it down so that the internally threaded end is to the left.

Pass over the left-hand end of the tube, in the order mentioned :

A buffer spring.

A plastic bush. (Flanged end last.)

An oil seal. (Visible spring side first) see note below.

A slider extension. (Screwed end first.)

A leather washer.

A fork spring.

A leather washer.

Then, over the right-hand end pass, in the order mentioned :

A damper shuttle.

A steel bush.

Then, fit a circlip.

This completes the assembly and the second assembly should be made in a like manner.

NOTE—Great care must be exercised when fitting the oil seal and this is best done by :
Cut a piece of thin foil sheeting 4" x 3" and wrap round the screwed end of the main inner tube. Then gently slide the oil seal over the wrapped foil, using a rotary motion in the opposite direction to the overlap of the foil, and taking particular care to apply first that side of the oil seal in which the spring is visible. This is of the utmost importance.

Make the second inner tube assembly in exactly a like manner.

Make a slider assembly by :

Fit the oil drain screw plug. (This screw has a fibre washer under it.)

Carefully fit the damper cone (Part number 012954) so that its spigot end engages in the recessed hole at the bottom of the slider inside and secure it with the fixing bolt 40-G12M-FF94, which has fibre washer 40-G12M-FF80 under it. Firmly, but carefully, tighten this bolt. (A thin walled tubular spanner will be required for this operation and it must be noted that, unless the bolt is well tightened, oil leakage will result. It is to prevent that leakage that a fibre washer is fitted under the head of the bolt.)

Make the second slider in a like manner.

The five sub-assemblies must now be fitted to the machine in the following manner :

Fit the fork crown, steering column and handlebar lug (a) by

Support the machine, by boxes under the footrests, so that it is just above its assembled height.

Place a spherical base ball race in the top of the frame head lug, fill the ball track with grease and load with 28 steel balls $\frac{3}{16}$ " diameter.

Pass up, through the frame head lug, the fork crown and stem assembly, which has already been prepared, and gently slide on to it the handlebar lug (with ball race already fitted) ensuring, while doing so, that the top cover tubes enter the caps fitted to the underneath side of the handlebar lug into which the caps snugly fit.

Fit a head stem adjusting nut. (Do not fully tighten.)

Fit a head stem domed lock nut. (Do not fully tighten.)

Ensure the grease nipples are fitted in the main frame head lug and the handlebar lug (One in each.)

Fit the inner tube assemblies (b) to the fork crown assembly by

Take one inner tube assembly, introduce the top end (the internally threaded end) to the fork crown (immaterial which side) and push it upwards till it engages with the handlebar clip lug and then gently force it home.

Fit the top washer and hexagonal bolt and screw right home. (This will draw the inner tube assembly fully into correct position.)

Fit a fork crown pinch stud to the crown, apply a washer and nut but do not fully tighten.

Fit the second inner tube assembly in a like manner.

Fit a slider (c) by

(The sliders are interchangeable but that in the left position requires two studs for the mudguard bridge fixing.)

Pass a slider up over the steel bottom bush and the upper plastic bush of one of the main inner tubes. Gently press down the oil seal into the upper threaded end of the slider, using only the fingers and, if there is a difficulty in doing so, apply a little heat to expand the enlarged end of the slider. Very little heat should be required to cause sufficient expansion to permit easy entry of the oil seal which should be pressed down far enough to leave exposed several turns of the thread cut internally in the slider.

Screw in, by hand, as far as possible, the slider extension but do not fully tighten down.

Fit the second slider in a like manner.

Fit the front mudguard, front stand, front wheel and make final adjustments by:

Fit front mudguard by placing in position so that the holes in the left side of the bridge engage with the two studs mounted in the top end of the left slider. Then secure the right side by the two washers and bolts. Fully tighten bolts.

Fit the brake cover plate stay to the two studs mentioned above and replace the two washers and nuts. Fully tighten nuts. If the front brake cable and its adjuster are not already fitted to the cover plate stay, do so now, leaving the final positioning of the adjuster till after the cable has been connected to the brake expander lever.

Fit mudguard stays.

Fit front stand.

Fit front wheel by : Hold the left side cap on the front wheel spindle and offer up wheel so as to engage that cap with its retaining studs. Fit the washers and nuts and lightly tighten the nuts. Fit the right side cap with washers and nuts and lightly tighten the nuts.

NOTE—The caps must not be interchanged and it is most important that the gaps, fore and aft, between the cap and the end of the fork slider are equal. The gaps are indicated by Arrows B in Illustration 19.

Fit bolt retaining cover plate stay to cover plate and fully tighten same.

Lightly tighten nut on left-hand end of front wheel spindle.

Fully tighten the four nuts clamping the front wheel spindle in the slider caps. (Do not over-tighten.)

Fully tighten nut on left-hand end of front wheel spindle.

Fully tighten the two screwed slider extensions. These each have two holes at their top ends to accommodate hook spanner 010438. (The holes are only exposed when all weight is relieved from the front wheel.)

Test fork for freedom of action and, if any stiffness is felt, loosen the nuts on the right-hand side spindle cap, and work fork up and down. Then tighten spindle cap clamping nuts.

Attach brake control cable yoke end to the brake expander lever and adjust brake. (See Wheel Section.)

Adjust steering head by method already described.

Fix head lamp to lamp lugs and replace instrument panel in top of headlamp.

Securely tighten the nuts on the two fork crown pinch studs. This is very important.

Fix speedometer head and replace driving cable and lighting bulb and holder in head.

Finally, to complete the assembly :

Remove top bolts from both fork main inner tubes.

Pour into each inner tube 10 fluid ounces of hydraulic fluid (one of the oils recommended in the Lubrication Section).

Examine the rubber ring on each top plug and, if damaged, replace.

Re-fit the two top plugs while the forks are still extended, i.e., with the front wheel clear of the ground. Fully tighten plugs.

NOTE—During assembly, absolute cleanliness is essential because any dirt, or other abrasive matter, left on the various sliding parts, will cause damage and rapid wear.

REAR SUSPENSION (Spring Frame Models)

The rear wheel is mounted in a fork that is hinged just behind the gear box. The hinge has robust plain bearings lubricated from a reservoir of $1\frac{1}{2}$ fluid ounces (42.6 c.c.) of engine oil which is sufficient to last almost indefinitely. Provision is, however, made for replenishment should same ever be required. A small screw will be observed in the right-hand end cap of the hinge bearing, upon removal of this screw, oil can be injected into the reservoir, the screw orifice operating as a level control.

The rear wheel fork is suspended on springs located in the two “TELEDRAULIC” legs joining the rear of the fork to the main frame rear loops, and the spring action is damped by hydraulic dampers identical in design to those used in the “TELEDRAULIC” Front Fork Assembly.

The hydraulic fluid used is one of the grades of oil specified in the Lubrication Section for use in the “TELEDRAULIC” Front Forks. It is introduced to each leg through the filling orifice of each pivot body.

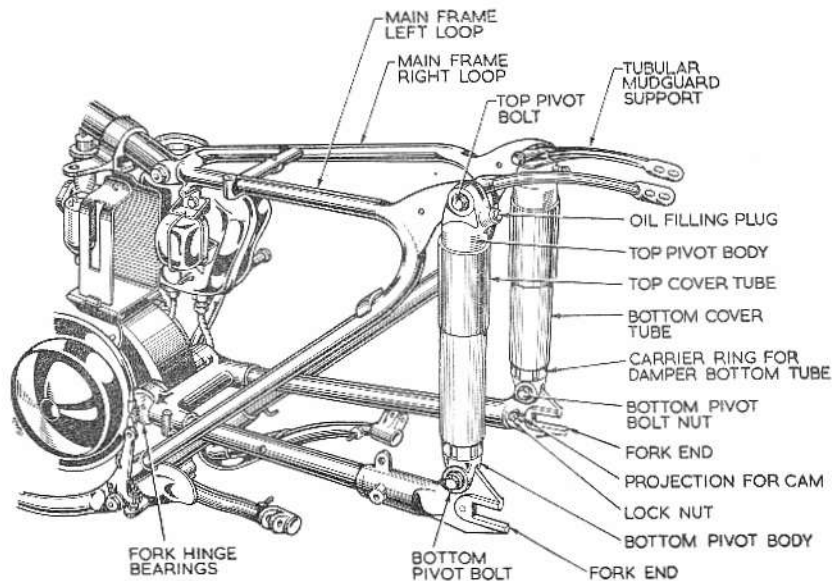


Illustration 21

Showing rear sprung frame and “TELEDRAULIC” legs

TELEDRAULIC LEGS (Spring Frame Models)

Each leg must contain exactly $1\frac{3}{4}$ fluid ounces (50 c.c.) of oil to provide correct hydraulic damping. The result of oil shortage is too lively an action but, as oil shortage can only occur as the result of leakage, it is very unlikely to be encountered and, unless serious doubts exist as to correct functioning, owners are advised to leave well alone.

Should the need arise, however, the oil content of each leg should be separately checked.

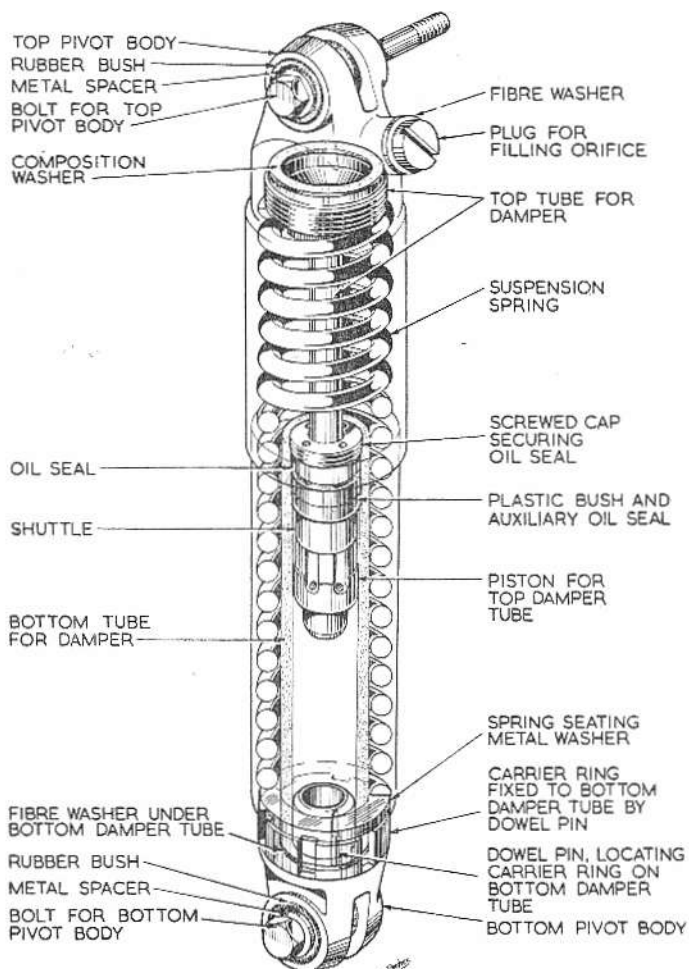


Illustration 22

Showing " Ghost " view of " TELEDRAULIC " leg

To check oil content of "TELEDRAULIC" leg and top-up :

Deal with one leg at a time.

Remove top securing bolt, taking care to observe the location of the spacing washer on it.

Remove bottom securing bolt and take away the leg.

Hold leg, vertically, in a vice gripping the lower pivot body.

Using hook spanner 010438 slacken the serrated carrier ring.

Reverse the position of the leg in the vice grip.

By hand, unscrew the bottom pivot body (which will now be uppermost).

After removing the pivot body, gently withdraw the serrated carrier ring, taking care not to lose the dowel pin by which the ring is locked to the bottom damper tube, the open end of which, with oil content, will now be visible.

Withdraw the outer cover tubes with spring.

Carefully pour the oil out of the open end of the bottom damper tube into a suitable container. (Preferably a graduated measure that can hold not less than two fluid ounces.)

When oil ceases to drain out, remove the filler plug and, gripping the bottom damper tube with one hand, telescope the assembly several times and the remainder of the oil will be pumped out.

Unless, for some reason, further dismantling is desired, the leg can now be re-assembled in reverse order, taking care to tighten securely the serrated carrier ring.

Next, holding the leg in a vice, filler plug uppermost, carefully pour in the specified quantity of oil, pausing now and again to move the top end up and down to expel air.

Upon being satisfied that the exact quantity of oil has been applied (no more, no less) re-fit the filler plug and re-attach the "TELEDRAULIC" leg, taking care to re-fit the spacing washer correctly on the top fixing bolt and to tighten securely the nuts on the two bolts.

Deal similarly with the other leg.

Although necessarily lengthy in description, this operation, providing the foregoing instructions are carefully followed, will be found quite simple.

PROP STAND

The prop stand hinges on a bolt that has a screwdriver slot in its head. The bolt passes through a lug brazed to the frame and screws into the jaw of the stand leg and is then locked by a nut and split pin. It is essential all parts are quite clean when replaced and that the nut is fully tightened. Smear the hinge bolt with engine oil before replacing it.

CENTRE STAND (Spring Frame Models)

The centre stand is mounted on a bolt set across the bottom rear of the main frame and is removed by taking off a nut of the centre bolt and pushing bolt through the frame. During removal and replacement the stand should be in a horizontal position in order to take off as much of the tension of the return spring as is possible.

FRONT STAND

The front stand is intended to operate **only as a support** and care is necessary, when using, to avoid passing the vertical position. No stops are provided and dragging the machine backward, with the stands down, is likely to fracture the lugs on the aluminium sliders of the forks to which the stand is attached.

Do not attempt to use the FRONT STAND unless the machine is already supported by the centre stand.

REAR STAND (Rigid Frame Models)

A plain steel washer is fitted under the **HEAD** of each of the two bolts that retain the rear stand to the fork ends. The washers should **NOT** be fitted **UNDER** the nuts of those bolts.

TO REMOVE OIL TANK AND BATTERY CARRIER

Two studs on the seat tube, one facing to the front, the other facing to the rear, engage with two right-angle stays on the oil tank and two similar stays on the battery carrier, and two washers and two nuts, fitted to the studs, retain the oil tank and battery carrier in position.

Remove oil tank and battery carrier by :

Drain oil tank.

Disconnect negative wire from the battery where it is attached to the seat lug bolt by a screw.

Disconnect positive wire from the battery at the point, close to the battery, where there is a double screwed connector. (Pull back the rubber sleeve to reveal the two main components of the connector. Hold one component in a wrench, or pliers, while the second component is unscrewed from it.)

Remove battery from carrier.

Disconnect oil feed pipe from bottom of oil tank.

Disconnect oil return pipe from bottom of oil tank.

Disconnect vent pipe from back of oil tank.

Disconnect voltage control unit from carrier side. Only two bolts to remove. No need to disconnect any of the electric cables.

Remove bolt retaining rear stay from oil tank to rear mudguard.

Remove screw, in base of carrier, retaining carrier to stay that is supported by the front chaincase.

Remove the two nuts and washers retaining the oil tank and battery carrier to the two studs.

Oil tank and battery carrier are now free to be taken away and, when doing so it is necessary to give each a slight rotary movement in order to disengage from the frame studs.

NOTE—The frame studs are brazed to the frame.

To re-fit

Locate tank and battery carrier on their two fixing studs and, before doing anything else, fit both oil pipes. Then reverse the instructions given above.

If, for any reason, the oil pipes have been removed from oil tank and engine, always re-fit the engine ends first.

TO REMOVE THE REAR CHAIN GUARD (Spring Frame Models)

Remove the rear wheel. (See Wheel Section.)

Remove the bolt retaining the front end of the chain guard to the rear fork.

Remove the bolt retaining the rear end of the chain guard to the rear fork. (There are two spacers on this bolt, one is between the two sides of the guard and the other is between the head of the fixing bolt and the guard.)

TO REMOVE THE REAR CHAIN GUARD (Rigid Frame Models)

Remove

The rear portion of rear mudguard.

The bolt retaining the front, top, end of the chain guard to the front chaincase.

The bolt retaining the front, bottom, end of the chain guard to the rear frame.

The bolt retaining the rear, top, end of the chain guard to the rear frame.

The chain guard is then free to be taken away.



WHEELS AND BRAKES

TO REMOVE FRONT WHEEL

Place machine on both stands.

Remove the split pin, and pin, retaining yoke end of front brake cable to the brake expander lever.

Remove bolt retaining brake anchor stay to brake cover plate.

Slacken the nut on the left-hand end of front wheel spindle.

Remove the four nuts retaining the caps to the fork sliders, which will permit the removal of the two caps and, putting pressure on the front wheel (in order to decrease the effective height of the wheel spindle) the wheel can be withdrawn towards the front.

NOTE—The two caps **MUST** be re-fitted in same order and position as originally. Therefore, lay them aside so that the order and position of assembly will be correctly made.

When replacing the front wheel, observe the instructions already given in the Fork and Frame Section and remember to depress the wheel when placing in position to get the wheel spindle between the two sets of studs that retain the slider caps.

Do not attempt to use the FRONT STAND unless the machine is supported by the centre stand (on SPRING FRAME MODELS) or by the REAR STAND (on RIGID FRAME MODELS).

NOTE—In the case of Spring Frame Models, it is advised to place under the centre stand a wood batten $\frac{7}{8}$ " thick in order to obtain a safe balance. It is necessary to apply pressure to the wheel while removing, in order to flatten the tyre slightly and so permit the wheel spindle to pass the clamping studs on fork sliders.

TO REMOVE REAR WHEEL (Spring Frame Models)

Take a piece of wood $\frac{7}{8}$ " in thickness and, with the centre stand resting on the wood, place the machine on the centre stand. Remove the bolt, washer and nut, in rearmost position on each tubular member fixing the hinged portion of the rear mudguard.

Disconnect the snap connector in the wire of the rear lamp.

Disconnect rear brake rod from brake expander lever, by removal of split pin and yoke end pin.

Revolve rear wheel till the chain connecting link is in its most possible rear-most position.

Remove connecting link and allow chain to come right away from the rear wheel sprocket but ensure it hangs so it cannot come away from the gear box sprocket.

Disconnect speedometer cable from speedometer gear box by unscrewing the cable gland nut.

Slacken the nut, on the rear wheel spindle that positions the speedometer gear box.

Slacken both exterior nuts on the rear wheel spindle three complete turns.

Using adjustable wrench L-TK-12, apply it to the hexagonal body of the adjusting cam on the left-hand end of the wheel axle and turn the cam till, by pushing the wheel forwards, the wheel is in its most forward possible position.

Hold left-hand side of wheel tightly forward against the cam stop and pull backwards the right-hand side of the wheel so that the brake cover plate disengages with the square headed anchor bolt. Then, raise the hinged portion of the rear mudguard and pull wheel away from the fork ends.

TO REMOVE REAR WHEEL (Rigid Frame Models)

Place machine on rear stand.

Disconnect rear lamp wire at connection near rear wheel spindle.

Disconnect speedometer driving cable. (Unscrew gland nut on cable.)

Disconnect rear chain connecting link. (Allow chain to hang clear of the rear wheel sprocket without becoming disengaged from the gear box small sprocket.)

Remove the two nuts securing rear portion of rear mudguard to its front portion.

Loosen nut and washer from bolt securing mudguard side bridge and tool box stay to tubular stay.

Remove adjusting nut from rear brake rod.

Slacken the two nuts (unscrew about four turns) retaining the rear mudguard side stays to their studs.

Slacken the two nuts on the rear wheel spindle.

Remove the rear portion of the rear mudguard, with its stays, leaving tool box and stay in position.

Remove the rear wheel from the fork ends by twisting it sideways to release and clear the rear brake cover plate anchor bolt and then withdrawing it to the rear.

Re-fit in the reverse order but, before finally tightening the rear wheel spindle nuts, ensure the speedometer gear box is so positioned that the speedometer driving cable can be correctly replaced.

When the wheel alignment is correct a piece of thin string stretched taut across both wheels, about four inches from, and parallel to, the ground, should just touch each tyre at both sides of the wheel centres.

Alternatively, a straight wooden batten, about five feet long, is handy to use for checking wheel alignment. This should be applied, as in the case of string, parallel to and about four inches from the ground.

NOTE—Always check the rear chain tension and the rear brake adjustment after making an alteration to the rear wheel position.

TO RE-FIT REAR WHEEL (Spring Frame Model)

Reverse the above procedure but leave the tightening of the nut that locates the speedometer gear box for the final operation, i.e., after the speedometer cable has been re-connected and the exterior axle nuts have been tightened.

It will be found easier to re-fit the wheel to the fork ends with the brake cover plate hanging free and then, holding the wheel on its left-hand side, as far forward in the fork end as is possible, to swing the right-hand side backwards, lifting up the free cover plate so that the slot in it is positioned to engage with the square headed anchor bolt and then swinging the right-hand end of the axle forwards till engagement has been completed.

After re-fitting the rear wheel, check the rear chain adjustment, and, if necessary, re-set it. Then check the rear brake adjustment and, if necessary, re-set it.

WHEEL BEARINGS AND ADJUSTMENT

The wheel bearings are of taper roller type. The inner bearings for the rollers are integral with the wheel spindle in the case of the front wheel, and are separate tracks that are threaded on the centre spindle in the case of the rear wheel. (Reference to Illustration 24 will make that clear.) The outer cups for the rollers are pressed into the hub shell. They have a fixed location one side and an adjustable location on the other. The fixed location is provided by a circlip in a groove cut in one end of the hub shell, while the adjustable location is regulated by a screwed ring that is threaded into the opposite end of the hub and the position of which can be locked by an encircling nut.

On the rear wheel the adjusting ring is located on the left-hand side of the hub while, on the front wheel, the adjustment is on the right-hand side.

It is rarely necessary to make adjustment to wheel bearings. It is most important they are not adjusted too tightly as this would quickly ruin them. There must always be a slight amount of end play. This should be about .002", which represents a just perceptible rim rock. (Not more than $\frac{1}{64}$ " rock.)

To adjust the rear wheel bearings the wheel must first be removed from the machine, but those of the front wheel can be dealt with *in situ*.

A service method of ensuring correct adjustment is :

Slacken the lock nut.

Tighten the adjusting ring until all slackness has been taken up.

Slacken back the adjusting ring exactly one-half turn.

Tighten the lock nut, making sure that, when doing so, the adjusting ring does not creep round.

TO DISMANTLE A FRONT WHEEL BEARING

These instructions need reference to the upper part of Illustration 24.

Remove wheel from machine.

Remove nuts, and brake cover plate with shoes, etc., from left-hand side of wheel.

Turn to right-hand side and slacken lock nut. (11.)

Completely unscrew the adjusting ring (10) and take it away with the lock nut (11) still on it.

Carefully apply steady pressure on the threaded end of the wheel spindle which will, in turn, eject from the opposite end of the hub the cup housing for the oil seal (9), the oil seal (8), the metal washer (7) that is behind the oil seal and the outer cup (6). These may be lifted away as they emerge.

The front wheel spindle (6), with its two sets of rollers in cages, may now be lifted out of the hub.

Turn to the left-hand end of the hub, carefully apply steady pressure on the visible washer (avoiding fouling the circlip that can be seen in the hub end), so that the complete left-hand assembly of oil seal and outer cup is pushed a trifle further into the hub shell. This will take off pressure on the circlip, thereby making its extraction an easy matter.

Extract circlip (1), and then, reversing the hub, apply pressure on the inside edge of the outer cup (6), so that it is forced out of the hub. As it emerges it will push in front of it, the oil seal external plain washer (2), the oil seal (3), with its encircling spacer collar (4) and the oil seal inner plain washer (5), all of which can be lifted away as they appear, to be finally followed by the cup (6).

The dismantling is then completed.

To re-fit, reverse the above procedure, remembering that, after cup (6), washer (5), spacer (4), oil seal (3) and washer (2) have been inserted in the plain end of the hub, to re-fit the circlip (1) and then carefully to apply steady pressure on the inner edge of the cup (6) to force the above entire assembly tightly back against the circlip (1).

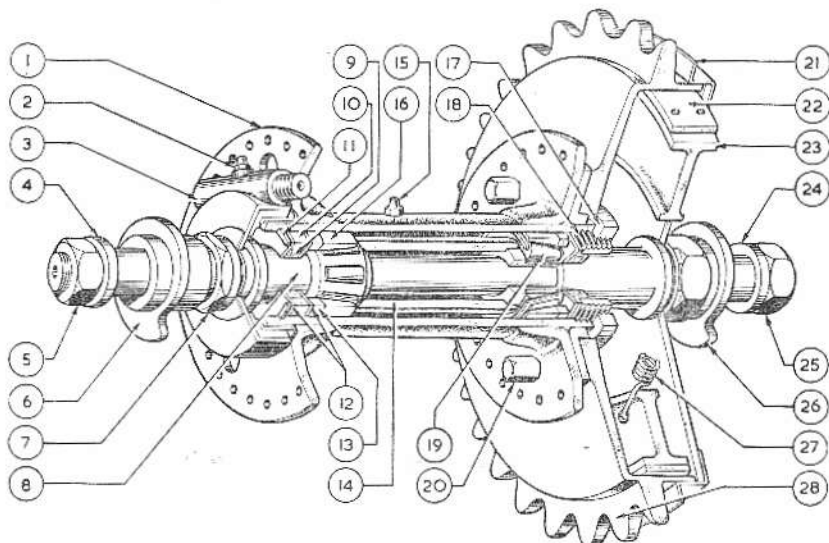


Illustration 23

**Showing rear hub, rear chain sprocket, brake and speedometer gear box
(Spring Frame Model)**

- | | |
|--|---|
| 1 RIGHT-HAND SIDE HUB FLANGE. | 14 SPACER, BETWEEN THE TWO TAPER ROLLER BEARINGS. |
| 2 GREASE NIPPLE ON SPEEDOMETER GEAR BOX. | 15 GREASE NIPPLE, IN HUB SHELL. |
| 3 SPEEDOMETER GEAR BOX. | 16 OUTER RACE OF RIGHT SIDE TAPER ROLLER BEARING. |
| 4 SPIGOT BUSH, FITS IN RIGHT-HAND FORK END. | 17 NUT, LOCKING BEARING ADJUSTING RING. |
| 5 NUT, ON CENTRE SOLID SPINDLE. | 18 RING, FOR ADJUSTING BEARING. |
| 6 RIGHT-HAND SIDE CAM. | 19 ROLLER (PART OF LEFT SIDE TAPER ROLLER BEARING). |
| 7 NUT, LOCKING SPEEDOMETER GEAR BOX IN POSITION. | 20 BOLT, SECURING BRAKE DRUM AND SPROCKET TO HUB. |
| 8 SPACER, BETWEEN SPEEDOMETER GEAR BOX AND RIGHT-HAND SIDE TAPER ROLLER BEARING. | 21 REAR BRAKE COVER PLATE. |
| 9 OIL SEAL. | 22 BRAKE LINING. |
| 10 COLLAR, ENCIRCLING RIGHT-HAND OIL SEAL. | 23 BRAKE SHOE. |
| 11 CIRCLIP, LOCATING RIGHT-HAND SIDE TAPER ROLLER BEARING. | 24 SPIGOT BUSH, FITS IN LEFT-HAND FORK END. |
| 12 WASHER, RETAINING OIL SEAL (ONE EACH SIDE OF SEAL). | 25 NUT, ON CENTRE SOLID SPINDLE. |
| 13 SPACER, BETWEEN OIL SEAL INNER WASHER AND TAPER BEARING. | 26 LEFT-HAND SIDE CAM. |
| | 27 SPRING, FOR BRAKE SHOE. |
| | 28 BRAKE DRUM AND SPROCKET. |

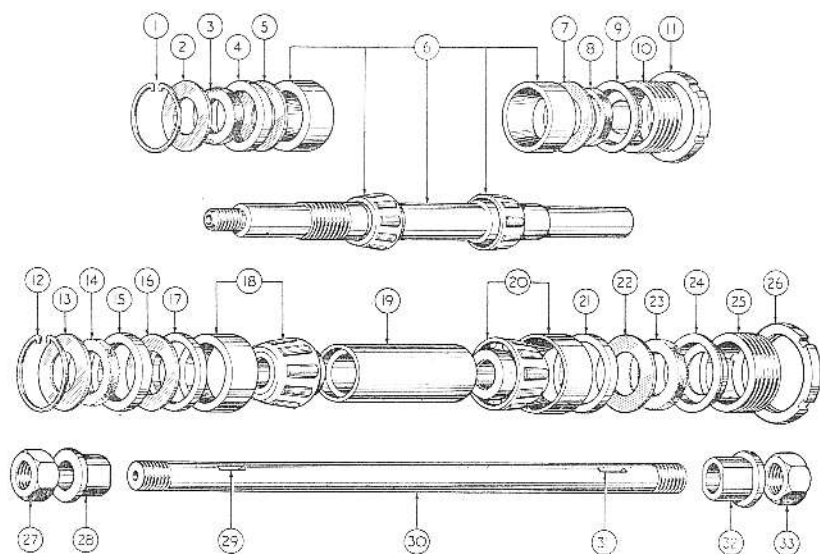


Illustration 24

Showing exploded view of hub bearing components in the order of assembly. Upper part is that of front bearings (Rigid and Spring Frame Models). Lower part is that of rear bearings (Spring Frame Model only)

- | | |
|---|--|
| 1 CIRCLIP. | 19 SPACER, BETWEEN BEARINGS. |
| 2 WASHER, METAL, OUTSIDE OIL SEAL. | 20 TAPER BEARING (OUTER CUP, CAGE FOR ROLLERS AND ROLLERS). THESE ARE NOT SUPPLIED SEPARATELY. ALSO ROLLERS ARE NOT SUPPLIED SEPARATELY. |
| 3 OIL SEAL. | 21 SPACER BETWEEN OIL SEAL WASHER AND TAPER BEARING. |
| 4 SPACING COLLAR, ENCIRCLING OIL SEAL. | 22 WASHER, METAL, BETWEEN OIL SEAL AND SPACER. |
| 5 WASHER, METAL, BETWEEN OIL SEAL AND TAPER BEARING. | 23 OIL SEAL. |
| 6 OUTER RACES (2 OFF). CENTRE SPINDLE, ROLLERS IN CAGES (2 SETS). THESE ARE NOT SUPPLIED SEPARATELY. ALSO, ROLLERS ARE NOT SUPPLIED SEPARATELY. | 24 CUP, HOUSING, FOR OIL SEAL. |
| 7 WASHER, METAL, BETWEEN OIL SEAL AND TAPER BEARING. | 25 ADJUSTING RING. |
| 8 OIL SEAL. | 26 LOCK NUT, FOR ADJUSTING RING. |
| 9 CUP, HOUSING, FOR OIL SEAL. | 27 NUT, EXTERNAL, FOR REAR WHEEL SPINDLE. |
| 10 ADJUSTING RING. | 28 BUSH, FOR REAR WHEEL SPINDLE (FITS IN FORK END). |
| 11 LOCK NUT, FOR ADJUSTING RING. | 29 KEYWAY, TO ACCOMMODATE KEY LOCKING CAM TO REAR WHEEL SPINDLE. |
| 12 CIRCLIP. | 30 REAR WHEEL SOLID CENTRE SPINDLE. |
| 13 WASHER, METAL, OUTSIDE OIL SEAL. | 31 KEYWAY, TO ACCOMMODATE KEY LOCKING CAM TO REAR WHEEL SPINDLE. |
| 14 OIL SEAL. | 32 BUSH, FOR REAR WHEEL SPINDLE (FITS IN FORK END). |
| 15 SPACING COLLAR, ENCIRCLING OIL SEAL. | 33 NUT, EXTERNAL, FOR REAR WHEEL SPINDLE. |
| 16 WASHER, METAL, BETWEEN OIL SEAL AND SPACER. | |
| 17 SPACER, BETWEEN OIL SEAL WASHER AND TAPER BEARING. | |
| 18 TAPER BEARING (OUTER CUP, CAGE FOR ROLLERS AND ROLLERS). THESE ARE NOT SUPPLIED SEPARATELY. ALSO ROLLERS ARE NOT SUPPLIED SEPARATELY. | |

TO DISMANTLE A REAR WHEEL BEARING

SPRING FRAME MODELS

These instructions need reference to the lower part of Illustration 24.

Remove wheel from machine.

Remove brake cover plate, with brake shoes, centre solid spindle with cams, spacers, bushes, nut and speedometer gear box.

Turn to left-hand side and slacken lock nut (26).

Completely unscrew the adjusting ring (25) and take it away with the lock nut (26) still on it.

Turn to the right-hand end of the hub and carefully apply steady pressure on the visible steel washer (avoiding fouling the circlip that can be seen in the hub end), so that, in turn, the cup housing (24) for the oil seal, the oil seal (23), the metal washer (22) that is behind the oil seal, the spacing ring (21) that is between the metal washer and the taper bearing, and outer cup (20) are ejected. These may be lifted away as they emerge.

The rollers in cage (20), the centre spacer (19) and the rollers in cage (18) may now be lifted out of the hub.

Turn to the right hand end of the hub, carefully apply steady pressure to the visible washer (avoiding fouling the circlip that can be seen in the hub end), so that the complete right-hand assembly of oil seal and outer cup is pushed a trifle further into the hub shell. This will take off pressure on the circlip, thereby making its extraction an easy matter.

Extract circlip (12).

Through the open end of the hub carefully apply steady pressure to the inner edge of the outer cup (18) so that it is forced out of the hub.

As it emerges, it will push, in front of it, the oil seal plain washer (13), the oil seal (14) with its encircling spacer collar (15), the oil seal internal plain washer (16) and the spacing ring (17) between the metal washer and the taper bearing, to be finally followed by the cup (18).

The dismantling is then completed.

To re-fit, reverse the above procedure, remembering that, after cup (18), spacer (17), washer (16), oil seal (14), spacer (15) and washer (13) have been inserted in the plain end of the hub, to re-fit the circlip (12) and then carefully to apply steady pressure on the inner edge of the cup (18) to force the above entire assembly tightly back against the circlip (12).

RIGID FRAME MODELS

To dismantle the rear wheel bearing on a rigid frame model the procedure described above may be followed, remembering the inner races for the taper bearings and the central spacer between the two bearings are all integral.

FRONT BRAKE COVER PLATE

It is most important the front brake cover plate is correctly positioned.

It is retained to the front wheel spindle by an inside nut (part number 40-G12M-H47) and an outside nut (part number 013483). Between the inside nut and the brake cover plate is a locating washer (part number 11913.)

The inside nut should be positioned so that, when the locating washer is placed next to it, the outside face of the washer is $\frac{1}{16}$ " proud of the outer edge of the brake drum. (Tested by placing a straight edge across the edge of the brake drum.)

The outside nut is fitted so that its hexagonal side is against the brake cover plate

BRAKE DRUMS

The front wheel brake drum is retained to the wheel by ten countersunk screws.

The rear wheel brake drum is integral with the rear wheel sprocket and is retained to the wheel hub by six bolts and nuts. Under each nut is a lock washer of the "tab" type and it is essential these are always in position.

Harshness in transmission can be caused by the drum retaining bolts and nuts being loose. Rear wheel spokes will break for the same reason.

BRAKE SHOES

The front and rear brake shoes, springs and expanders are interchangeable. The two shoes in each brake are **NOT** identical, they are "handed."

One end of each shoe bears on a fulcrum fixed in the brake cover plate. The other end accommodates a detachable thrust pin. By inserting washers under a thrust pin its effective height can be increased, thereby compensating for wear on the brake linings.

BRAKE SHOE ADJUSTMENT

Brake adjustment, to compensate for lining wear, is normally made by means of a finger adjuster on the rear brake rod and a cable adjuster for the front brake cable.

After a very considerable mileage this continual adjustment causes the brake cam to occupy a position whereby the available leverage is considerably reduced and, as a result, the brake loses efficiency.

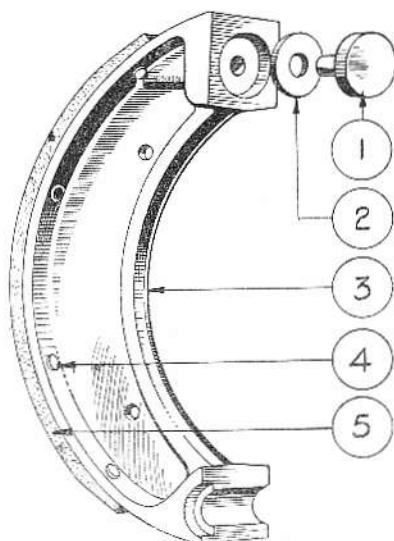


Illustration 25

To overcome this a hardened headed thrust pin is fitted to each shoe to enable a packing washer to be fitted under the head as, and when, required. Eight of these washers (STD-174) are provided in the tool kit. When wear of the brake linings is taken up in this manner it is then necessary to unscrew considerably the adjusting nut on the rear brake rod, or screw in the cable adjuster of the front brake cable, and afterwards adjust the brake, as described afterwards.

When a brake cover plate has been disturbed, it is advisable, upon re-assembly, to centralise the shoes in the brake drum to ensure equal pressure to each. In the case of the front wheel this is best done before re-fitting the wheel to the machine, but in the case of the rear wheel it is best done after re-fitting. If brake shoes tend to squeak, when the brake is applied it is generally an indication the brake shoes are not centralised in the drum.

- (1) Brake shoe thrust pin.
- (2) Thrust pin packing washer.
- (3) Brake shoe.
- (4) Rivet, securing brake shoe lining.
- (5) Brake shoe lining.

Centralise brake shoes by :

Ensure the nut binding the the cover plate to the wheel spindle is slightly slack.

Place on the brake expander lever a tubular spanner (to increase the leverage), and, while maintaining pressure on the tubular spanner (to expand fully the brake shoes), fully tighten the spindle nut binding the cover plate to the spindle.

FRONT BRAKE ADJUSTMENT

Major adjustment of the front brake shoes is made on the brake thrust pins, by fitting packing washers under the pins, as already described.

Minor adjustment of the front brake shoes is made by altering the position of the brake cable adjuster on the fork assembly. Unscrew the adjuster to "take up" the front brake.

The adjuster is locked in position by a nut.

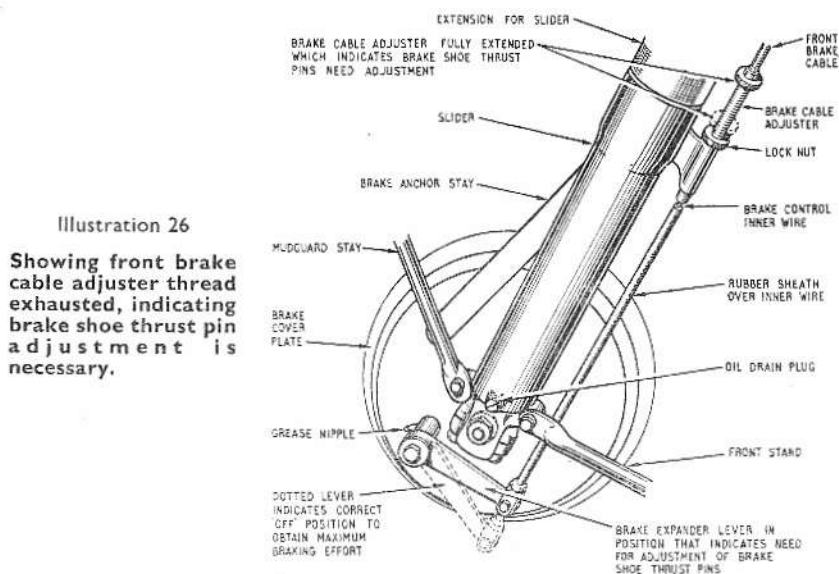
Adjust front brake by :

Place machine on both stands.

Slacken lock nut on cable adjuster.

Unscrew the cable adjuster till, by rotating the front wheel, it can be felt the brake shoes are just touching the brake drum.

Then screw back the adjuster two complete turns and tighten the lock nut.



REAR BRAKE ADJUSTMENT

Major adjustment of the rear brake shoes is made on the brake thrust pins, by fitting packing washers under the pins, as already described.

Minor adjustment of the rear brake shoes is made by altering the position, on the brake rod, of the knurled adjusting nut. Screw the nut further on the rod to "take up" the rear brake.

Adjust rear brake by :

Place machine on centre stand if spring frame, otherwise on rear stand.

Screw further on the brake rod the knurled adjusting nut till, by rotating the wheel, it can be felt the brake shoes are just touching the brake drum.

Then unscrew the adjusting nut two complete turns. (The adjusting nut is automatically locked in position in virtue of the two projecting noses on it engaging in accommodating slots cut in the clip which connects the brake rod and brake expander lever and being retained in that position by the spring which encircles the rear end of the brake rod.)

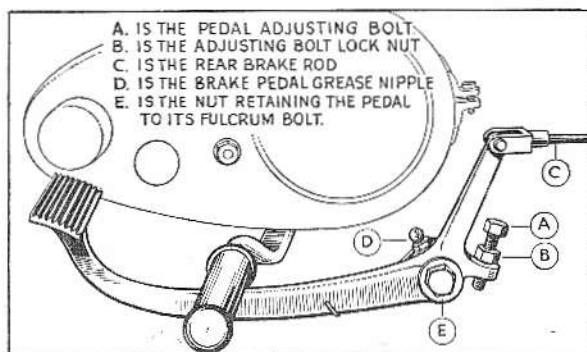


Illustration 27

Showing the rear brake pedal with its adjusting bolt and lock nut. To permanently raise the toe end of the pedal, slacken lock nut (B) and unscrew the adjusting bolt (A).

(Check back brake adjustment after).

(RIGID FRAME MODELS)

BRAKE PEDAL ADJUSTMENT

The position of the rear brake pedal can be adjusted within narrow limits. This is done by means of a bolt screwed into the heel of the pedal. The adjusting bolt is locked by a nut.

The best position, for normal use, is to position the pedal so that, when the brake is "off," it is just clear of the under-side of the footrest arm.

After altering the adjustment of the brake pedal, rear brake adjustment should be checked.

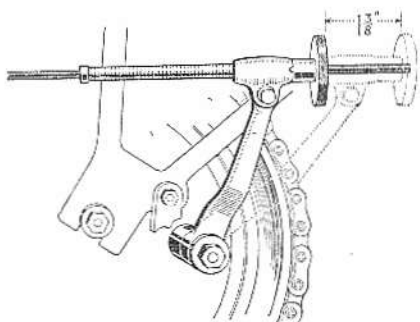


Illustration 28

Showing brake rod adjustment exhausted, indicating brake shoe thrust pin adjustment is essential.

(RIGID FRAME MODELS)

RIMS AND SPOKES

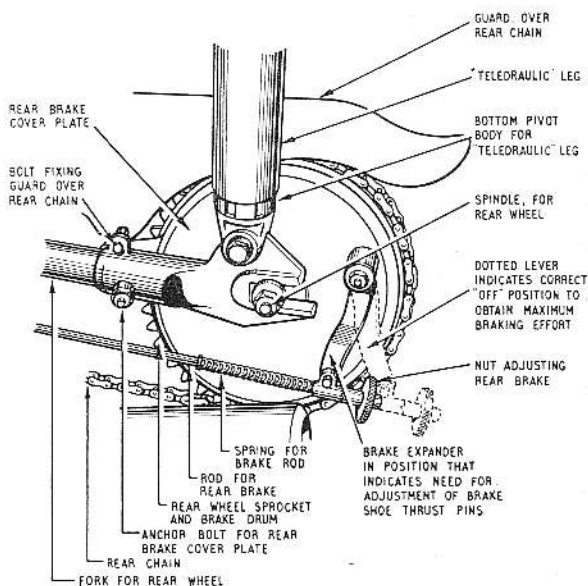
The front and rear rims are each drilled for forty spokes, but they are not interchangeable because the nipple holes in the front rim are smaller than those in the rear rim. See "DATA."

The dimensions of spokes will be found in "DATA."

Illustration 29

Showing brake rod adjustment exhausted, indicating the need for brake thrust pin adjustment.

(SPRING FRAME MODELS)



TYRES AND SERVICE

Obtaining satisfactory life and service from the tyres is largely a matter within the user's control because the first essential is correct inflation. Check tyre pressures with a low pressure gauge at least once a week. Inflate as may be necessary.

Avoid unnecessary, or "stunt," acceleration and fierce braking, which wear out tyres by causing wheel spin and skid.

Do not drive in tram lines. It is dangerous, especially when wet, and the uprisng edges of worn rails will damage the tyres.

Remove flints, etc., that become embedded in the tread and, if any oil gets on the tyres or spokes, clean it off with petrol.

Make sure the front and rear wheels are in track. When the wheel alignment is correct, a piece of thin string stretched taut across both wheels, about four inches from, and parallel to, the ground, should just touch each tyre at both sides of the wheel centres.

Alternatively, a straight wooden batten, about five feet long, is handy to use for checking wheel alignment. This should be applied, as in the case of string, parallel to and about four inches from the ground.

Always check the rear chain adjustment, and the rear brake adjustment, after making an alteration to the rear wheel position.

TYRE REMOVAL

It is not essential to remove a wheel from the machine to repair a puncture but it will usually be found desirable and more convenient to do so.

Take off outer cover and remove inner tube by :

Remove cap from tyre valve.

Remove nut from tyre valve.

Remove the " inside " from tyre valve. This allows inner tube to deflate. Most valve caps have a reduced and slotted top to engage with the valve " inside " in order to unscrew it.

Push edge of cover, that is diametrically opposite to the valve, **RIGHT INTO WELL OF RIM** and, using tyre levers 40-G3-TK29, pick up edge of cover **NEAR VALVE** so that it comes off over the edge of the rim.

Work off the remaining edge of the cover till it is clear of the rim. This is quite easy and there is no reason to use force.

Push upwards **valve stem** through its hole in the rim, and the inner tube is then free to be taken away.

Remove cover from rim by pushing it right into well of rim and, diametrically opposite, picking it up with the tyre lever and then working it off all the way round.

TYRE FITTING

Re-fit inner tube and outer cover by :

Place one edge of cover right into well of rim, with the three white dots on the cover side **adjacent to the valve hole**, and, commencing diametrically opposite, and using the hands only, work the cover over the edge of the rim.

Replace the valve " inside " and slightly inflate the inner tube. (Do not distend the tube.) Fit the valve into its hole in the rim and replace its nut, only screwing it on the valve stem about half an inch.

Tuck in the inner tube so that it lies snugly in the cover. Ensure it is not twisted. Smear some soapy water round the free edge of the cover. This is a great help in fitting and in ensuring the cover centralises itself on the rim and should always be employed if at all possible.

Introduce the free edge of the cover into the rim at the spot diametrically opposite to the valve. Get this edge right into the well of the rim and then, by working round the cover, equally on either side of the valve position, the cover will slip into place without excessive exertion, fitting the part nearest to the valve last of all.

Slightly inflate the inner tube and inspect for the inner tube being trapped between the outside edge of the cover and the rim at the spots where the valve is located.

Half inflate tyre, spin wheel and test for trueness because it is essential the pattern of the tread runs evenly and the cover must be manipulated till that occurs. This **centralisation of the cover is most important**.

Inflate to required pressure.

Screw fully home the nut on the valve.

Replace the valve cap.

TYRE PRESSURES

The following are correct minimum inflation pressures for specified loads per tyre :

Load per tyre, 200 lb.	Pressure 16 lb. per square inch
do. 240 lb.	do. 18 lb. do.
do. 280 lb.	do. 20 lb. do.
do. 350 lb.	do. 24 lb. do.
do. 400 lb.	do. 28 lb. do.
do. 440 lb.	do. 32 lb. do.

The best method of ascertaining the correct pressure is to actually weigh the loads on the front and rear tyres. This should be done on a weighbridge and is a service that can usually be provided by British Railways at a Goods Depot or by a Corporation at its Depot.

When the weights are known the table above can then be used.

As a rough guide it may be stated that, with a rider of average weight and with normal equipment, solo, the pressure should be 18 lb. for the front tyre and 22 lb. for the rear.

PILLION PASSENGERS

The addition of weight to the rear of a motor cycle may affect its steering. Therefore the rider must make some allowance for the difference in the "feel" of the machine when a passenger is carried.

The rear tyre pressure must be increased to carry satisfactorily any increased load.

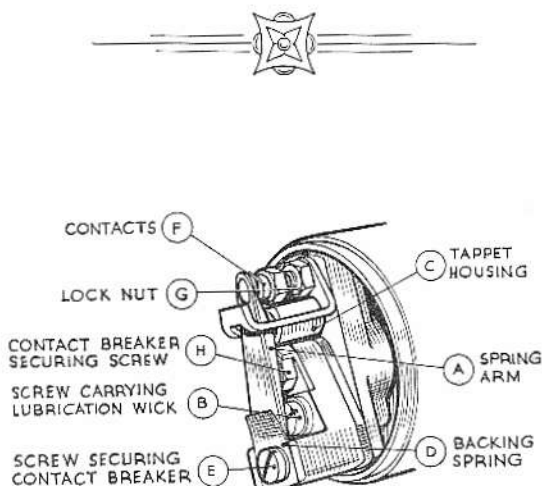


Illustration 30

Showing Contact Breaker

ELECTRICAL SERVICE

ELECTRICAL EQUIPMENT

LUCAS electrical equipment is fitted and this comprises three independent electrical circuits, as follows :

- (1) **IGNITION**—Magneto, High-tension wires, Sparking plugs and Cut-out switch.
- (2) **CHARGING**—Dynamo Automatic Voltage Control Unit and Battery.
- (3) **LIGHTING AND ACCESSORIES**—Lamps, Horn, Switches and wiring.

IGNITION CIRCUIT

A LUCAS type NI/3/AO magneto is fitted (Type NRI to competition models) and the only service attention this requires is occasional lubrication of the contact breaker cam and tappet, infrequent adjustment of the contact breaker points and complete servicing at intervals of about ten thousand miles. To lubricate the contact breaker cam and tappet it is necessary to remove the complete contact breaker from the magneto.

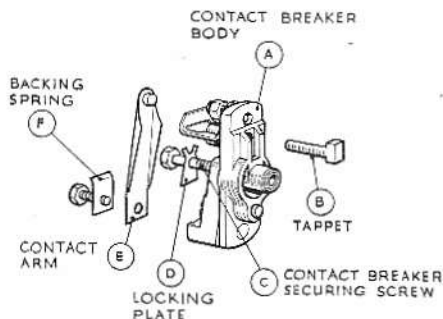


Illustration 31

Showing component details of Contact Breaker

Remove contact breaker by :

Swing away the flat blade retaining the contact breaker cover.

Pull away the contact breaker cover.

Remove the screw E, Illustration 30, retaining the contact breaker spring arm A, Illustration 30, to the contact breaker body and take away the backing spring F, Illustration 31, and the spring arm E, Illustration 31. There is a spring washer under the screw.

Unscrew the screw B, Illustration 30, carrying the lubrication wick and take away the fibre insulating bush encircling the screw.

Straighten the tab on the lock washer D, Illustration 31, under the central screw H, Illustration 30, retaining the contact breaker body A, Illustration 31, to the armature shaft and, with spanner LTK-5, remove the central screw.

Finally, lever off the contact breaker.

The above instructions do not apply to competition models fitted with **Racing Magnetos** Type NRI.

Lubricate contact breaker cam and tappet by :

Remove contact breaker as described above.

Saturate, with a few drops of thin machine oil, the wick mounted in the core of its carrying screw B, Illustration 30.

Push out of the contact breaker body the tappet B, Illustration 31, wipe it with a soft cloth, smear it with thin machine oil and then replace it.

NOTE—When replacing the contact breaker parts, ensure the backing spring F, Illustration 31, is fitted so that its bent over end faces outwards.

Contact breaker points.

The contact breaker point separation should be from .010 to .012".

Clean contact breaker points by :

Remove the contact breaker cover.

Examine contacts. (F, Illustration 30.)

If they are dirty, oily, or burnt, they must be cleaned with a fine carborundum stone, or **very fine** emery cloth, and afterwards wiped with a cloth that has been moistened with petrol.

Cleaning is made easier if the contact breaker spring arm A, Illustration 30, is removed.

Examine the contact breaker spring arm and wipe away any rust.

Check and adjust contact breaker point setting by :

Remove contact breaker cover.

Turn over engine till the contact breaker points F, Illustration 30, are fully open.

Insert the gauge (part of spanner LTK-5) between the two contact points. If the setting is correct the gauge should be a sliding fit.

If there is an appreciable variation from the gauge slacken the lock nut G, Illustration 30, on the adjusting point and turn the contact point (apply spanner LTK-5 to its hexagon head) until the gap is set to the gauge. (Screw the point into the contact breaker body to increase the gap, or outwards, to decrease it.)

Finally, tighten the lock nut and re-check the setting.

The above instructions do not apply to competition models fitted with **Racing Magnetos** Type NRI.

SPECIAL NOTE—Check the contact breaker point gap after the first one hundred miles and five hundred miles. Owing to the initial settling down, there is a tendency for the gap to alter in the first few hundred miles of use. This may seriously affect the ignition setting. Subsequent adjustment will only be required at long intervals but it is as well to check the gap every two thousand miles. (When the engine is decarbonised is always an opportune time.)

Complete service (dismantling, cleaning, lubrication of the armature shaft bearings, etc.) should be entrusted to a Lucas Service Station and should be done about every ten thousand miles.

SPARKING PLUG

The sparking plug has a thread of 14 mm. and the reach is $\frac{1}{2}$ " ($\frac{3}{4}$ " reach on competition models). The point gap is .015". Check the point gap every time the engine is decarbonised and, if necessary, re-set the points.

The K.L.G. Type F80 "Corundite" Plug is fitted to Rigid and Spring Frame models, and FE80 to competition models.

See the plug is fitted with its external seating washer.

Firmly tighten the plug by using the standard box spanner and tommy bar (Part No. 17634.) All that is required is a GAS-TIGHT joint. Therefore do not over tighten, which will not make a gas-tight joint more gas-tight, but can, and possibly will, distort and damage the body of the plug.

Set the gap to .015 inch. NEVER TRY TO MOVE THE CENTRAL ELECTRODE. To widen, or narrow, the gap between the electrodes, only move the earth (or bent over) electrode. Check the gap first with a gap gauge.

If it is too wide, tap the earth electrode (the bent-over one) towards the central electrode. Use any handy metal tool to do this, provided it is light enough in weight to be controllable.

Check the gap between each tap and stop when the gauge is a nice sliding fit between the two electrodes.

If the gap is too narrow to start with, gently lever the earth electrode away from the central electrode by using a small screwdriver, and then tap back to the correct position.

Do not move the electrodes apart by forcing anything between them.

For maximum efficiency, plugs should be cleaned at every 3,000 miles. To take the plug to pieces for cleaning, unscrew the gland nut by holding the smaller hexagon on the gland nut upside down in a vice and then using the box spanner to unscrew the larger hexagon on the body.

Then lift away the central electrode assembly which should be washed in petrol or paraffin. Then, using fairly coarse glass paper, remove the carbon deposit and wash again.

The central firing point should be cleaned with fine emery cloth. The inside of the body should be scraped clean with a knife and finally rinsed in petrol.

There is an internal washer, between the insulator and its seating in the body. On re-assembly lightly smear this with thin oil and then screw up the gland nut sufficiently tight to give a gas-tight joint.

Finally adjust the gap to .015".

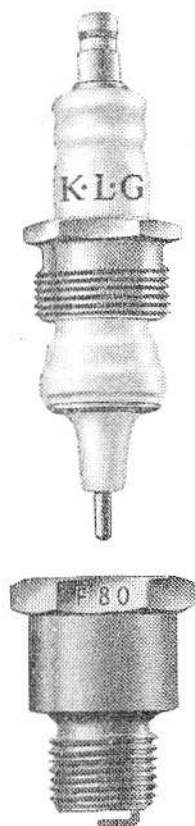


Illustration 32

CHARGING

A LUCAS type E 3AR-AOS-1 dynamo is fitted. It is anti-clockwise in rotation. The cutting in speed is 1250-1500 r.p.m. at 7 volts and at 1,850 to 2,200 revolutions per minute it gives an output of 5 amps at 7 volts. The replacement part number is 200430. The positive brush is insulated and the negative brush is earthed. The two exterior terminals are marked "D" and "F," indicating the respective terminals for the Positive and Field wires that lead to similarly marked terminals on the Regulator Unit.

Inspect commutator and brush gear every 5,000 to 6,000 miles. (Maker's Recommendation.)

Remove the dynamo (see below for instructions.)

Remove the cover band to inspect commutator and brush gear.

The brushes are held in contact with the commutator by means of springs. Move each brush, see they are free to slide in their holders, if dirty, or if sticking, remove and clean with a cloth moistened with petrol. Take care to replace brushes in their original positions, otherwise they will not "bed" properly on the commutator.

If, after long service, the brushes have become worn to such an extent that the brush flexible wire is exposed on the running face, or if the brushes do not make good contact with the commutator, they must be replaced by genuine LUCAS brushes.

The commutator must be free from any trace of oil or dirt and should have a highly polished appearance. Clean a dirty, or blackened, commutator by pressing a fine dry cloth against it while the engine is slowly turned over by means of the kick-starter. (It is an advantage to remove the sparking plugs before doing this). If the commutator is very dirty, moisten the cloth with petrol.

At every 10,000 miles, the complete dynamo should be handed to a **Lucas Service Station** for dismantling, replacement of worn parts, cleaning and lubrication.

Electrical breakdown of the dynamo is most unusual and therefore before assuming this unit is defective, it should be tested as follows :

Check that the dynamo, regulator and battery are correctly connected.

Test Dynamo in position by :

- (a) Remove the two wires from the dynamo terminals and connect the two terminals with a short length of wire.
- (b) Start the engine and set to run at normal idling speed.
- (c) Connect the positive lead of a moving coil voltmeter (calibrated not less than 0 to 10 volts) to either of the two dynamo terminals and connect the negative lead to a good earth point on the dynamo or engine.
- (d) Gradually increase the engine speed, when the voltmeter reading should rapidly rise and without fluctuation.

Do not allow the voltmeter reading to rise above 10 volts. -

Do not race the engine in an attempt to increase the voltage. It is sufficient to run up the engine to a speed of 1,000 r.p.m.

If the above reading is obtained the dynamo is in order.

If there is no reading, check the brush gear.

If there is a low reading of approximately $\frac{1}{2}$ volt, the field winding may be at fault.

If there is a low reading of approximately $1\frac{1}{2}$ to 2 volts, the armature winding may be at fault.

If the tests, mentioned above, clearly indicate the dynamo is not charging, it is then desirable to remove the dynamo from the machine in order to make further tests and repairs or replacements.

TO REMOVE DYNAMO

- (a) Remove outer portion of front chaincase. (See page 43.)
- (b) Remove spring circlip, lock washer, nut and plain washer under nut that retains the chain sprocket to the dynamo armature shaft.
- (c) Using a sprocket withdrawal tool, or wedges between sprocket and dynamo body, release the sprocket from the dynamo shaft.
- (d) Slacken nut on right-hand end of the gearbox top fixing bolt.
- (e) Remove nut on left-hand end of the gearbox bottom fixing bolt, and drive bolt out. (It may be necessary to remove the oil return pipe from the oil tank to do this, and this necessitates draining the oil tank first.)
- (f) Disconnect cables attached to Dynamo end cover by unscrewing central bolt fixing the retaining plate to the cover.
- (g) Sufficiently unscrew the bolt clamping the dynamo in the engine rear plates to allow the dynamo to have free movement.
- (h) Pull back the bottom of the gearbox as far as possible.
- (i) Rotate dynamo till the locating plate on its body is in a position to enable it to pass the cut away parts of the engine plates, and then withdraw the dynamo from the kick-starter side of the machine.

TO RE-FIT DYNAMO

Reverse the procedure described above. See page 44 for instructions on re-fitting the dynamo chain, and, finally, check adjustment of front and rear chains. (See pages 49 and 50.)

The cut-out and regulator unit (A.V.C.), is type **MCR-I-L31**, and the replacement part number is 35108-A.

Although the voltage regulator and the cut-out are combined structurally, they are electrically separate.

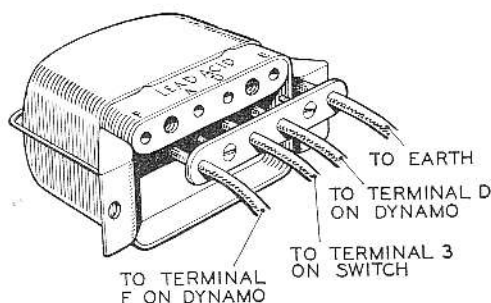


Illustration 33

Showing connections to
regulator and cut-out unit

The regulator is set to maintain a pre-determined generator voltage at all speeds and regulates the output of the dynamo to the battery according to the state of charge of the battery. The charge rate is at its maximum when the battery is discharged, automatically tapering off to a minimum as the battery becomes charged and its voltage rises.

Normally, during day-time running, when the battery is in good condition, the dynamo gives only a trickle charge, so that the ammeter reading will seldom exceed 1 to 2 amperes. The cut-out is an automatic switch which is connected between the dynamo and the battery. When the engine is running fast enough to cause the voltage of the dynamo to exceed that of the battery the cut-out allows the battery to be charged by the dynamo. On the other hand, when the engine speed is low, or the engine is stationary, the cut-out disconnects the battery from the dynamo, thereby preventing current flowing back from the battery to the dynamo, a proceeding that would soon cause the battery to become completely discharged.

The regulator and cut-out are accurately set during manufacture. If, under normal running conditions, it is found that the battery is continually in a low state of charge, or is being constantly over-charged, then the regulator setting should be checked by a qualified electrician and, if necessary, re-set. Whenever possible, this should be carried out by a Lucas Service Depot or Agent.

The A.V.C. Unit is retained to the battery carrier by two bolts with nuts. The four terminals of the A.V.C. Unit are plainly marked by the letters F.A.D.E. Wires from F and D go to similarly marked terminals on the dynamo. The A terminal is connected to one of the ammeter terminals and the E terminal is "earthed."

We specially warn against unskilled meddling with the settings of the regulator and the cut-out contacts.

Battery

The battery fitted is LUCAS type **PUW-7E-4**. This is a lead-acid battery in which the electrolyte is in free liquid form. The voltage is 6 and the capacity is 12 ampere hours. The negative terminal is earthed to the frame.

The maintenance period of a battery is expressed in terms of **time** and not miles, as is general with all other parts of the machine.

The routine maintenance **MUST** be carried out, irrespective of if the machine is used, or not.

Maintenance once every 14 days

Remove battery cover, brush dirt from top of battery and remove vent plugs. (There are three vent plugs.)

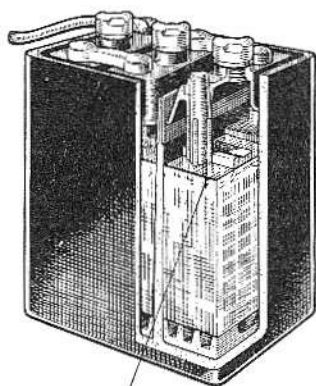
NOTE—NEVER bring a naked light near a battery when the vent plugs have been removed, or when the battery is being charged, as the gas given off by the electrolyte is highly explosive.

The specific gravity of the electrolyte indicates the state of charge of the battery. Table "A" shows what the specific gravity of the electrolyte should be, at various temperatures, when the battery is fully charged. Check the gravity by means of a hydrometer, and if it is below the figures shown for the appropriate temperature in table "B," the battery should be charged as soon as possible by the normal running of the motor cycle. If this cannot be arranged, the battery should be charged from an external source.

If the level of the electrolyte is so low that a hydrometer reading cannot be taken, no attempt should be made to take a reading after adding distilled water until the battery has been on charge for at least 30 minutes.

NEVER transfer the electrolyte from one cell to another.

NEVER leave a battery in a discharged condition. It must be put on charge as soon as possible.



ELECTROLYTE LEVEL

Illustration 34

**Lucas PUW-7E-4
Battery**

Table "A"	Temperature	Table "B"
1.270	120° F.	1.220
1.280	100° F.	1.230
1.285	80° F.	1.235
1.295	60° F.	1.245
1.305	40° F.	1.255
1.310	20° F.	1.260
1.320	0° F.	1.270
1.325	-21° F.	1.275

Check if the electrolyte in each cell is level with the top of the separators. Top-up, if necessary, with distilled water. Do not allow the distilled water to come into contact with metals—always only use a glass or earthenware container and funnel.

If a battery is found to need an excessive amount of topping-up, steps should be taken to find out the reason. For example, the battery may be receiving an excessive charge, in which case the regulator setting may need adjustment. If one cell in particular needs topping-up more than another, it is likely the case, or container, is cracked, in which event the battery must be replaced and arrangements made to clean up the battery carrier.

Metal parts should be well cleaned and, if possible, washed, with a solution of ammonia, or bicarbonate of soda, in water.

Vent plugs should be kept clean and air passages in them kept free. Re-fix vent plugs tightly.

Keep the battery, and surrounding parts, particularly the tops of the cells, clean and dry. Brush away any sand, dust or road slush.

Battery electrolyte, which contains sulphuric acid in a diluted form, is destructive to practically everything except rubber, lead, glass or earthenware. Therefore, rags used to clean battery tops, etc., should be thrown away afterwards. If put back in the tool box they will cause the tools to rust.

Assuming the temperature of the electrolyte is about 60° F. a test with a hydrometer quickly shows the state of charge, as under :

Reading 1.280 to 1.300 indicates fully charged.

Reading about 1.210 indicates half discharged.

Reading below 1.150 indicates fully discharged.

LIGHTING AND ACCESSORIES

Headlamp

A LUCAS type **SSU-700-P** headlamp is fitted. The replacement part number is 50788-B. It has a panel mounted on its top, retained by three screws, in which is the main switch and ammeter and it also supports the cable harness. See Illustration 35. The main bulb has a double filament. One filament provides the main driving beam and the other a dipped beam, brought into operation by the dipping switch on the left handlebar as may be required. The pilot bulb is the same as used in the rear lamp and is mounted outside the reflector, illumination being arranged through a small circular window in the reflector.

The reflector and front glass are made up as one assembly and the two components are not sold as separate spares.

Focussing the main driving beam

The main bulb is adjustable in its holder. It is secured by a clamp bound with one screw and, upon slackening the screw, the bulb may be pushed inwards, and outwards, as required, thereby providing movement to enable the light beam to be focussed.

It is best to make the focussing adjustment in the dark with the machine so positioned that the light falls on a wall some distance away.

To focus the light beam, place the machine as suggested above, slacken the clamp binding screw, pull inwards, or outwards, the bulb till, with the light switched on, the smallest circle of light is obtained. Then set the lamp, by slightly slackening its two fixing bolts, so that it is tilted in such a manner that the light beam is projected slightly below the horizontal, after which tighten the two fixing bolts.

To remove the headlamp front and interior

Slacken the screw on the top of the lamp body at the front, pull the rim outward from the top and, as the front comes away, raise slightly to disengage the bottom tag from the lamp shell. The cap which carries the bulbs is secured to the reflector by means of two spring plungers. To remove the cap, depress one plunger and tilt the cap bodily. The reflector and front glass unit is secured to the rim by means of five spring clips. These can be disengaged from the turned up inner edge of the rim by pressing with a screwdriver blade and, at the same time, working away from the edge.

To replace the headlamp front and interior

Lay reflector and glass unit in the rim so that the block on the reflector back engages with the forked bracket on the rim.

Replace, by springing in, the five spring clips so that they are evenly spaced around the rim.

Offer up assembly to the lamp shell, engaging the bulb carrier cap in the position in which the pilot bulb is against the small window of the reflector. Engage bottom tag on lamp rim with the small slit in the shell and gently force the top of the rim back into the shell, after which re-tighten the locking screw on the top of the lamp body.

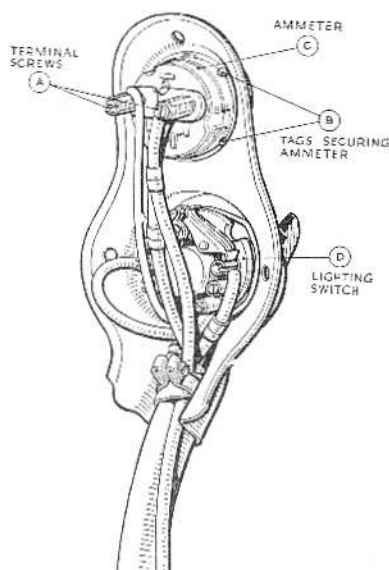


Illustration 35

Showing lamp panel containing ammeter (at top) switch and cable harness

The ammeter fitted is type CZ-27 and the replacement part number is 364455

Rear lamp

A LUCAS type 467/2 rear lamp is fitted. The body, with bulb holder, is secured to the rear number plate by two nuts and spring washers.

The cover, carrying the red glass, is secured to the body by a sleeve nut. Upon removing this nut, the cover and glass may be taken away to permit bulb replacement. Details of lamp bulbs are given in "DATA."

Snap wire connector

The LUCAS snap connector, as shown in Illustration 36, is made up of four components. Two are tubular sleeves, having pointed extremities, and which are soldered to the ends of the two wires to be connected. The third part is the centre split ferrule, into which the two sleeves snap and the fourth component is a rubber sleeve which covers the whole connector. That rubber sleeve serves the dual purpose of insulating the various metal parts and also preventing same from separation as the result of vibration.

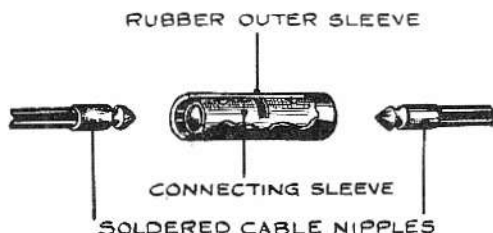


Illustration 36

Lucas snap connector
Part number 900269

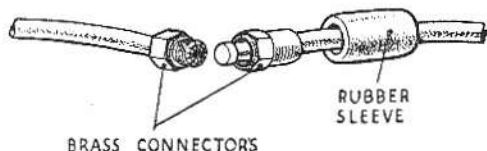
One snap connector is used in the rear lamp wire (the wires have red coloured sleeves) and another is used in the wire connecting the regulator unit to the output side of the ammeter in the head lamp. (The wires have purple and white coloured sleeves.)

Screwed wire connector

A LUCAS screwed connector of the type shown in Illustration 37 is used in the wire connecting the positive terminal of the battery to the input side of the ammeter (the wire has yellow and black coloured sleeves) in the head lamp. It is made up of four parts. One part, a metal sleeve, is threaded internally and accommodates a collet which is placed on the end of one of the wires to be connected in such a manner that the wire ends protrude through the centre of the collet. The third metal part screws into the first and has passing through it the second of the wires to be connected. The wire ends are splayed out and the act of screwing the two threaded parts together binds the ends of the two wires, thereby making a good electrical contact that can be immediately broken as, and when, it is wished to remove the battery from the machine. A rubber sleeve encircles the whole assembly, serving the dual purpose of insulation and prevention of loss through vibration.

Illustration 37

Lucas screwed wire connector
Part number 571395



Terminals

The earth wires (two—one from regulator, the other from negative terminal of battery) and the high-tension wires (two—one on sparking plug end of each wire from magneto to sparking plug) have terminals of the solid sleeve type having an eye at the extreme end. To make such a connection, it is necessary to bare the end of the wire for $\frac{3}{8}$ " , pass the terminal over the wire so that the bared end fully enters the reduced core of the terminal and then flatten that part by either pinching in a vice or by hammering.

The two earth wires, mentioned above, are connected to the "earth" by securing them to the left side of the seat lug bolt (which is situated just under the saddle) by means of a washer and a screw. It is essential that the connections are kept clean and the screw must be kept fully tight.

Horn

The horn push switch, situated on the right handlebar, must make good electrical contact with the metal part of the handlebar and, if there is reason to suspect the bar is corroded at that point, the switch should be unclipped, the bar and switch cleaned and then replaced.

Fuses

There are no detachable fuses in LUCAS motor cycle electrical equipment.

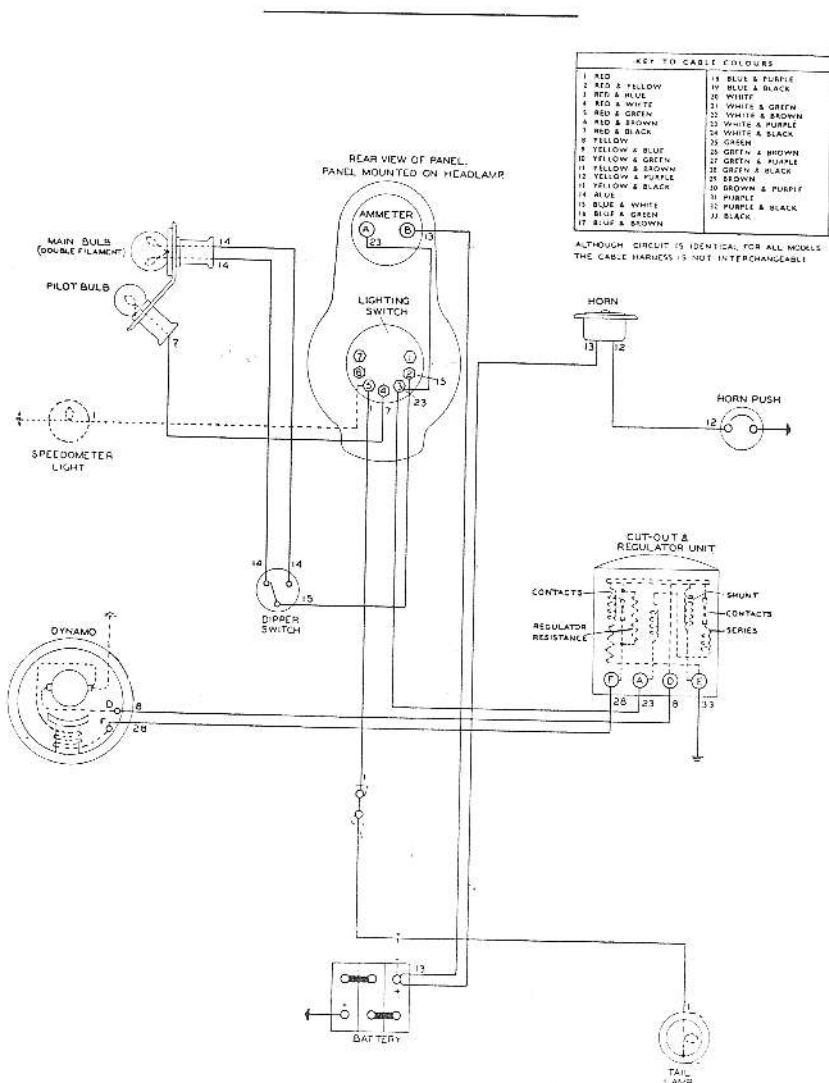


Illustration 38

Theoretical wiring diagram

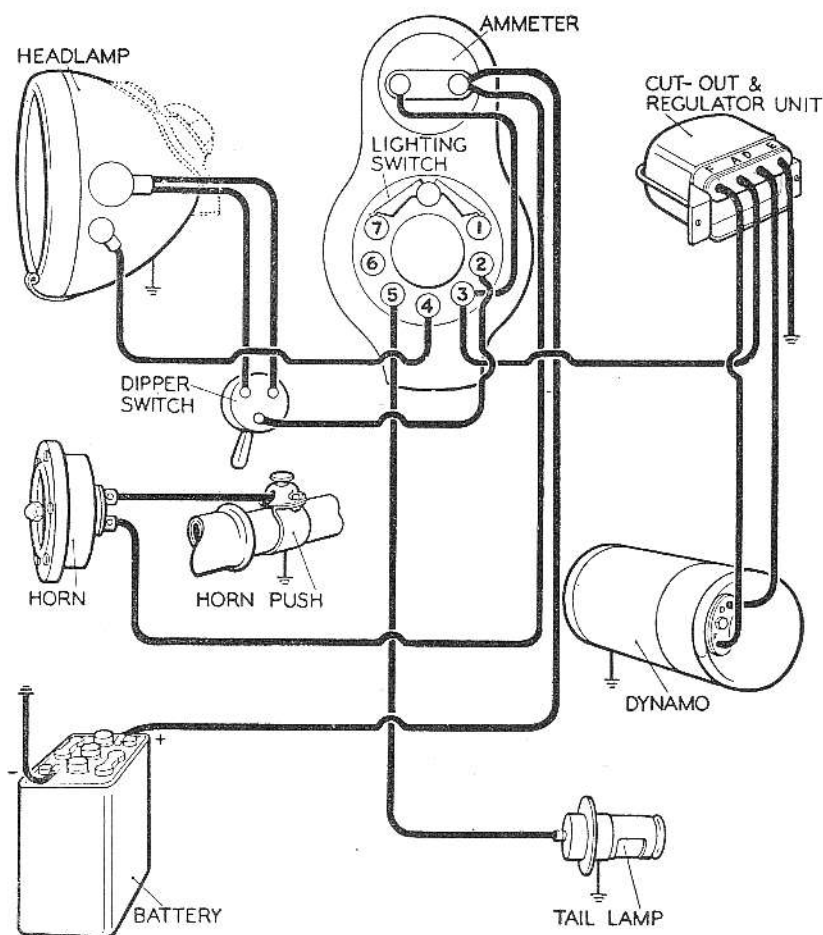


Illustration 39

Pictorial wiring diagram

USEFUL INFORMATION

In the following five paragraphs are particulars of failures and troubles that can occur, together with the probable reasons. These troubles are arranged in the order of their probability.

TRACING TROUBLES

Engine fails to start, or is difficult to start, may be due to :

- Throttle opening too large.
- Air lever in open position.
- Ignition not set just off fully advanced position.
- Lack of fuel because of insufficient flooding.
- Lack of fuel because of pipe, or tap, obstruction.
- Excessive flooding of carburettor.
- Pilot jet choked.
- Oiled up, or fouled, sparking plug.
- Stuck up engine valve.
- Weak, or broken, valve spring.
- Valve not seating properly.
- Contact points dirty.
- Incorrect contact point gap.
- Water on high-tension pick-ups.
- Moisture on sparking plug.

Engine misses fire may be due to :

- Defective, or oiled, sparking plug.
- Incorrect contact point gap.
- Contact breaker rocker arm sticking.
- Contact breaker points loose.
- Rocker adjustment incorrect.
- Oil on contact breaker points.
- Weak valve springs.
- Defective sparking plug wire.
- Partially obstructed petrol supply.

Loss of power may be due to :

- Faulty sparking plug.
- Lack of oil in tank.
- No rocker clearance, or too much clearance.
- Weak, or broken, valve spring.
- Sticky valve stem.
- Valve not seating properly.
- Brakes adjusted too closely.
- Badly fitting, or broken, piston rings.
- Punctured carburettor float.
- Engine carbonised.
- Choked silencer.

Engine overheats may be due to :

Lack of proper lubrication. (Quality or quantity of oil.)
Faulty sparking plug.
Air control to carburettor out of order.
Punctured carburettor float.
Engine carbonised.
Weak valve springs.
Pitted valve seats.
Worn piston rings.
Ignition setting incorrect.
Choked silencer.

Engine stops suddenly may be due to :

No petrol in tank, or choked petrol supply.
High-tension wire detached from sparking plug.
Choked main jet.
Oiled up, or fouled, sparking plug.
Water on high-tension pick-up, or sparking plug.
Water in float chamber.
Vent hole in petrol tank filler cap choked.

EXCESSIVE OIL CONSUMPTION

Excessive oil consumption may be due to :

- (a) Clogged, or partly clogged, oil filter.
- (b) Stoppage, or partial stoppage, in the pipe returning oil from the engine to the oil tank.
- (c) Badly worn, or stuck up, piston rings. (Causing high pressure in the crankcase.)
- (d) Air leak in dry sump oiling system.
- (e) Worn inlet valve stems.

EXCESSIVE PETROL CONSUMPTION

Excessive petrol consumption may be due to :

- (a) Leaks in the petrol feed system. (Damaged fibre washers, loose union nuts on piping, defective float needle action.)
- (b) Incorrect ignition setting. (Ignition not advanced sufficiently.)
- (c) Defective engine valve action.
- (d) Incorrect use of air control lever.
- (e) Moving parts of carburettor badly worn. (Only possible after very considerable mileage.)
- (f) Bad air leak at carburettor junction, or inlet manifold joint.

ABNORMAL TYRE WEAR

Abnormal tyre wear may be due to :

- (a) Incorrect tyre pressure.
- (b) Wheels not in alignment.
- (c) Harsh driving methods. (Misuse of acceleration and braking.)

CLEANING THE MACHINE

Do not attempt to rub, or brush, mud off the enamelled surfaces because this will soon destroy the sheen of the enamel. Mud, and other road dirt, should be soaked off with water.

The best method is to use a small hose, taking care not to direct water on to the engine, carburetter, magneto and other such parts. As a poorer substitute, a pail of water and a sponge may be used.

After washing down with water, the surplus moisture should be removed with a chamois leather, and, when the enamelled surfaces are thoroughly dry, they may be polished with a good wax polish and soft dusters.

Such parts as the engine crankcase and the gear box can be cleaned by applying paraffin with a stiff brush, and, with a final application of petrol, will come up like new.

CHROMIUM PLATING

Under some climatic conditions, a rusty looking deposit may be observed on ferrous parts that are chromium plated. This is not ordinary rust (ferric oxide) but is a salt deposit that, in most cases and in its early stages, can be quickly and easily removed with a damp chamois leather. In stubborn cases it may be necessary to use a special chromium cleaning compound.

The safest precaution during Winter is to wipe over all chromium plated parts with a soft rag in "**TEKALL**," which is a lanoline base rust preventative marketed in small tins and available at most garages. This material, so applied, leaves an almost invisible film that is impervious to moisture and its use cannot be too highly recommended to owners who value the appearance of their mounts.

In Summer, when those conditions do not prevail, chromium parts should be frequently cleaned with a damp chamois leather and afterwards polished with a soft duster, or, better still, with a polisher of the "**Selvylt**" type.

If a polish is used it must be one of the special compounds for chromium plating only. Ordinary metal polishing liquids, in particular, must not, on any account, be used because these, almost without exception, contain acids, which attack chromium.

NOTE—"Tekall" is a product of **20th Century Finishes Ltd., 175-177, Kirkgate, Wakefield**, and is retailed in $\frac{1}{2}$ pint and 1 pint tins. It can be obtained from our Spare Parts Department, as follows:

$\frac{1}{2}$ pint tin "Tekall," Part number 011957, price 2/—, plus 6d. postage.

1 pint tin "Tekall," Part number 011958, price 2/6, plus 6d. postage.

REPAIRS

The instructions regarding repairs should be clear and definite, otherwise the cost may be greater than that expected. We shall be pleased to give estimates for repairs if parts are sent to us for that purpose. If the estimate is accepted, no charge is made for the preliminary examination, but, should it be decided not to have the work carried out, it **MAY** be necessary to make a charge to cover the cost of whatever dismantling and re-assembly may have been done to prepare the estimate.

Customers desiring that old parts which are replaced with new during the course of overhaul or repair be retained must make the fact known prior to the work being put in hand because, normally, such parts, having no further useful life, are scrapped upon removal.

Parts sent to us as patterns, or for repair, should have attached to them a label bearing the sender's full name and address. The instructions regarding such parts should be sent under separate cover.

If it is necessary to bring a machine, or parts, to the Works for an urgent repair, **IT IS ESSENTIAL** you **MAKE AN APPOINTMENT** beforehand to **AVOID DISAPPOINTMENT**. This can be done by letter or telephone.

CORRESPONDENCE

Our routine is organised into different departments, therefore delay cannot be avoided if matters relating to more than one department are contained in one letter.

Consequently, it is desirable, when communicating with more than one department, to do so on **SEPARATE SHEETS**, each of which should bear your name and address. **IN PARTICULAR**, requests for **TECHNICAL ADVICE** should not be on the same sheets as **ORDERS FOR SPARE PARTS**.

When writing on a technical matter, or when ordering spares, it is essential to quote the **COMPLETE ENGINE NUMBER**. Some numbers have one, or more, letters incorporated in them and these letters **MUST BE QUOTED**, otherwise model identification is not possible.

PROPRIETARY FITTINGS

No expense is spared to secure and fit the most suitable, and highest quality, instruments and accessories for the standard equipment of our machines.

Nevertheless, our Guarantee does not cover such parts and, in the event of trouble being experienced, the parts in question should be returned to, and claims made, direct on the actual manufacturers who will deal with them on the terms of their respective guarantees.

Those manufacturers are :

Carburettors	Messrs. Amalgamated Carburettors Ltd., Holford Works, Perry Barr, Birmingham.
Chains	The Renold and Coventry Chain Co. Ltd., Didsbury, Manchester.
Electrical equipment	Messrs. Joseph Lucas Ltd., Great King Street, Birmingham, 19.
Gear boxes	Messrs. Burman and Sons Ltd., Ryland Road, Birmingham, 15.
Sparking Plugs	K.L.G. Sparking Plugs Ltd., Putney Vale, London, S.W.15.
Speedometers	Messrs. S. Smith and Sons (M.A.) Ltd., Cricklewood, London.
Tyres	Messrs. Dunlop Rubber Co. Ltd., Fort Dunlop, Birmingham.

All the above manufacturers issue instructive literature regarding their products which is obtainable by writing to them.

SERVICE

The **Service and Repair Department** is situated in **Burrage Grove, Plumstead, London, S.E.18**, and is open on Mondays to Fridays from 8.30 a.m. to 1.0 p.m.—2.0 p.m. to 5.30 p.m. It is closed on Saturdays, Sundays and National Holidays.

It exists for the purposes of :

- (a) Giving technical assistance verbally or through the post.
- (b) Supplying spare parts over the counter or through the post.
- (c) Repairing and re-conditioning machines, or parts of machines, of our make.

Burrage Grove is the first turning on the left from Burrage Road when entering Burrage Road from the Plumstead Road. (See final paragraph below.)

The nearest Railway Station is **WOOLWICH ARSENAL, SOUTHERN REGION RAILWAY**. This Station is five minutes walk from our Service Depot in Burrage Grove. There is an excellent service of electric trains from Charing Cross, Waterloo, Cannon Street and London Bridge Stations, Southern Region Railway.

Bus routes 53, 53a, 54, 99 and 122. Trolleybus routes, 696 and 698, and Tram routes 36, 38 and 40, pass the end of Burrage Road (one minute from the Service Depot).

Bus routes 21a, 75 and 161 and Tram routes 44, 46 and 72 serve **Beresford Square** which is three minutes walk from the **Service and Repair Department**.

Visitors from the North can pass into Woolwich via the Free Ferry between North Woolwich and Woolwich. North Woolwich is a British Railways terminus and is also served by Bus and Trolleybus routes 101, 569, 669 and 685. There is also a tunnel under the River Thames at this point for foot passengers. The Free Ferry accommodates all types of motor vehicles and there is a very frequent service. The Southern landing stage is less than a mile from the Service Depot.

Visitors arriving by road, if they are strangers to the locality, should enquire for **Beresford Square, Woolwich**. Upon arrival there, the road skirting the Royal Arsenal should be followed in an Easterly direction for about four hundred yards, and Burrage Road is the second turning on the right after leaving the Square. Burrage Grove is then the first turning on the left.

The above information revised by LONDON TRANSPORT EXECUTIVE December, 1948

THE DRIVER AND THE LAW

The driver of a motor cycle **MUST** be **INSURED** against Third Party Claims and **MUST** be able to produce an **INSURANCE CERTIFICATE** showing that such an insurance is in force.

If your Insurance Certificate specifies you can only drive one particular machine you **MUST NOT DRIVE** any other machine unless its owner has a current Certificate covering "**ANY DRIVER**" and it is advisable to remember that, in the absence of such a provision the penalties for doing so are very heavy.

The driver of a motor cycle **MUST** hold a current **DRIVING LICENCE**. If you are a learner and hold a Provisional Driving Licence, your machine must show, front and back, the standard "**L**" plates in red and white and you must not take a **PILLION PASSENGER** unless that passenger is the holder of a current **UNRESTRICTED** driving licence.

As soon as you receive your driving licence, sign it in the appropriate place and do so each time it is renewed. It is an offence not to.

Make sure you are well acquainted with the recommendations set down in the "Highway Code," a copy of which can be obtained from any main Post Office.

THE MACHINE AND THE LAW

Every motor cycle used on the public roads must be registered and carry the registration numbers and licence disc allotted to it. The dealer, from whom the machine is bought, will, generally, attend to all matters legally essential before it is used on the public roads.

To register a new machine

Send to the Local Registration Authority the following :

- (a) Form " RFI/2," duly completed.
- (b) The certificate of insurance.
- (c) The invoice you received from your dealer when you purchased the machine.
- (d) The appropriate registration fee.

In due course you will receive :

- (1) A Registration Book. (Commonly called the " log " book.)
- (2) A Licence Disc.
- (3) Your Insurance Certificate.
- (4) Your Invoice.

The Registration Book and the Licence Disc will bear the registration numbers that have been allotted to your machine and will also show the date the Road Licence expires.

Your number plates must then be painted, in white upon a black background, with the registration numbers in characters of even thickness as follows :

The numbers on the front plate must be $1\frac{3}{4}$ " high, $1\frac{1}{4}$ " wide and $\frac{5}{16}$ " thick with spaces of $\frac{1}{2}$ " between each two characters.

The numbers on the rear plate must be $2\frac{1}{2}$ " high, $1\frac{3}{4}$ " wide and $\frac{3}{8}$ " thick with spaces of $\frac{1}{2}$ " between each two characters.

The Licence Disc must be enclosed in a water-tight container, having a transparent front, and this must be fixed to the machine in a conspicuous position, near the front and on the left-hand side.

It is not legally necessary to carry your Driving Licence, Insurance Certificate and Registration Book while driving your machine.

Speedometer

A speedometer **MUST** be fitted and it **MUST BE** so **ILLUMINATED** that it is possible to read the dial after lighting up time.

Lamps

During the official "**LIGHTING UP**" hours the machine must exhibit a white light facing forwards and a red light facing rearwards. The rear number plate must be adequately illuminated by a white light.

Each electric light bulb **MUST** be marked with its "Wattage." (Beware of cheap, imported, bulbs that do not have this marking.)

All motor cycles made by us have electric equipment that complies with the law regarding position, size of bulbs, marking on bulbs and the correct illumination of the rear number plate.

GUARANTEE

We give the following guarantee with our motorcycles, motorcycle combinations and sidecars, which is given in place of any implied conditions, warranties or liabilities whatsoever, statutory or otherwise, all such implied conditions, warranties and liabilities being in all cases excluded. Any statement, description, condition or representation contained in any catalogue, advertisement, leaflet or other publication shall not be construed as enlarging, varying or overriding this guarantee. In the case of machines (a) which have been used for "hiring-out" purposes or (b) any motorcycle and/or sidecar used for any dirt track, cinder track or grass track racing or competitions (or any competition of any kind within an enclosure for which a charge is made for admission to take part in or view the competition) or (c) machines from which the trade mark, name or manufacturing number has been removed, no guarantee, condition or warranty of any kind is given or is to be implied.

We guarantee, subject to the conditions mentioned below, that all precautions which are usual and reasonable have been taken by us to secure excellence of materials and workmanship, but this guarantee is to extend and be in force for six months only from date of purchase, and damages for which we make ourselves responsible under this guarantee are limited to the free supply of a new part in exchange for the part of the motorcycle, motorcycle combination or sidecar which may have proved defective. We do not undertake to replace or refix, or bear the cost of replacing or refixing, such new part in the motorcycle, motorcycle combination or sidecar. We undertake, subject to the conditions mentioned below, to make good at any time within six months any defects in these respects. As motorcycles, motorcycle combinations and sidecars are easily liable to derangement by neglect, or misuse, this guarantee does not apply to defects caused by wear and tear, misuse or neglect.

The term "misuse" shall include amongst others the following acts:—

1. The attaching of a sidecar to a motorcycle in such a manner as to cause damage or calculated to render the latter unsafe when ridden.
2. The use of a motorcycle or of a motorcycle and sidecar combined, when carrying more persons or a greater weight than that for which the machine was designed by the manufacturers.
3. The attaching of a sidecar to a motorcycle by any form of attachment not provided, supplied or approved by us or to a motorcycle which is not designed for such use.

Any motorcycle, motorcycle combination or sidecar sent to us to be plated, enamelled or repaired will be repaired upon the following conditions, i.e., we guarantee that all precautions which are usual and reasonable have been taken by us to secure excellence of materials and workmanship, such guarantee to extend and be in force for three months only from the time such work shall have been executed or until the expiration of the six months above referred to, and this guarantee is in lieu and in exclusion of any common law or statute warranty or condition, and the damages recoverable are limited to the cost of any further work which may be necessary to amend and make good the work found to be defective.

CONDITIONS OF GUARANTEE

If a defective part should be found in our motorcycles, motorcycle combinations or sidecars, or in any part supplied by way of exchange before referred to, it must be sent to us CARRIAGE PAID and accompanied by an intimation from the owner that he desires to have it repaired or exchanged free of charge under our guarantee, and he must also furnish us at the same time with the number of the machine, the date of the purchase or the date when the alleged defective part was exchanged as the case may be.

Failing compliance with the above, such articles will lie here AT THE RISK OF THE OWNER, and this guarantee and any implied guarantee, warranty or condition shall not be enforceable.

We do not guarantee specialities such as tyres, saddles, chains, electrical equipment, lamps, etc., or any component parts supplied to the order of the Purchaser differing from standard specifications supplied with our motorcycles, motorcycle combinations, sidecars or otherwise.

TOOLS AND SPECIAL EQUIPMENT

TOOLS

The standard tool kit, issued with each new machine, contains :

1	I7520	Tool bag.
1	38-G3-EQ2	Tyre inflator.
2	W40-G3-TK29	Tyre levers.
1	LTK-15	Pliers.
1	11024	Gudgeon pin circlip pliers.
1	LTK-13	Screwdriver.
1	LTK-20	Grease gun.
1	LTK-12	Adjustable wrench.
1	I7634	Sparking plug box spanner and tommy bar I7634-T.
1	RTK-1	Dynamo spanner.
1	RTK-3	Triple spanner.
2	W41-G3L-TK1	Double end spanner. Small.
1	W41-G3L-TK2	Double end spanner. Large.
1	460076	Contact point spanner and gauge.
1	11914-S	Hub lock nut hook spanner. (Front hub bearings and rear hub on rigid frame models.)
1	3263	Double end spanner.
1	010438	Hub lock nut hook spanner (rear hub bearings on spring frame models).

OPTIONAL EQUIPMENT

The following items of optional equipment are available. They are described and priced in the Spares List.

- (a) Air cleaner.
- (b) Mudguard type pillion seat.
- (c) Pillion footrests, bolted on, to fold up when not in use and specially designed for these machines. (Not on competition)
- (d) Detachable luggage carrier. (Not on competition).
- (e) Timing disc 015955. A circular timing disc, graduated in degrees and made of ivory. A very useful device. Price 3/6, plus 6d. postage.
- (f) Valve holder, for valve grinding. Part number 11520-A.

SPARES LIST

An illustrated and priced spares list is available at a cost of 2/6 post free.

GASKET SETS

For convenience in ordering, four standard sets of engine washers and gaskets as well as the washers used in the petrol and oil feed systems are stocked. Two sets are for the 350 c.c. machines and the others for the 500 c.c. and full details of contents and prices are included in the Spares List.

BADGES

Neat monogram badges are now available at a cost of 1/6, plus 6d. postage. They can be supplied as a tie pin, as a brooch or for fitting in a button hole. When ordering state type required.

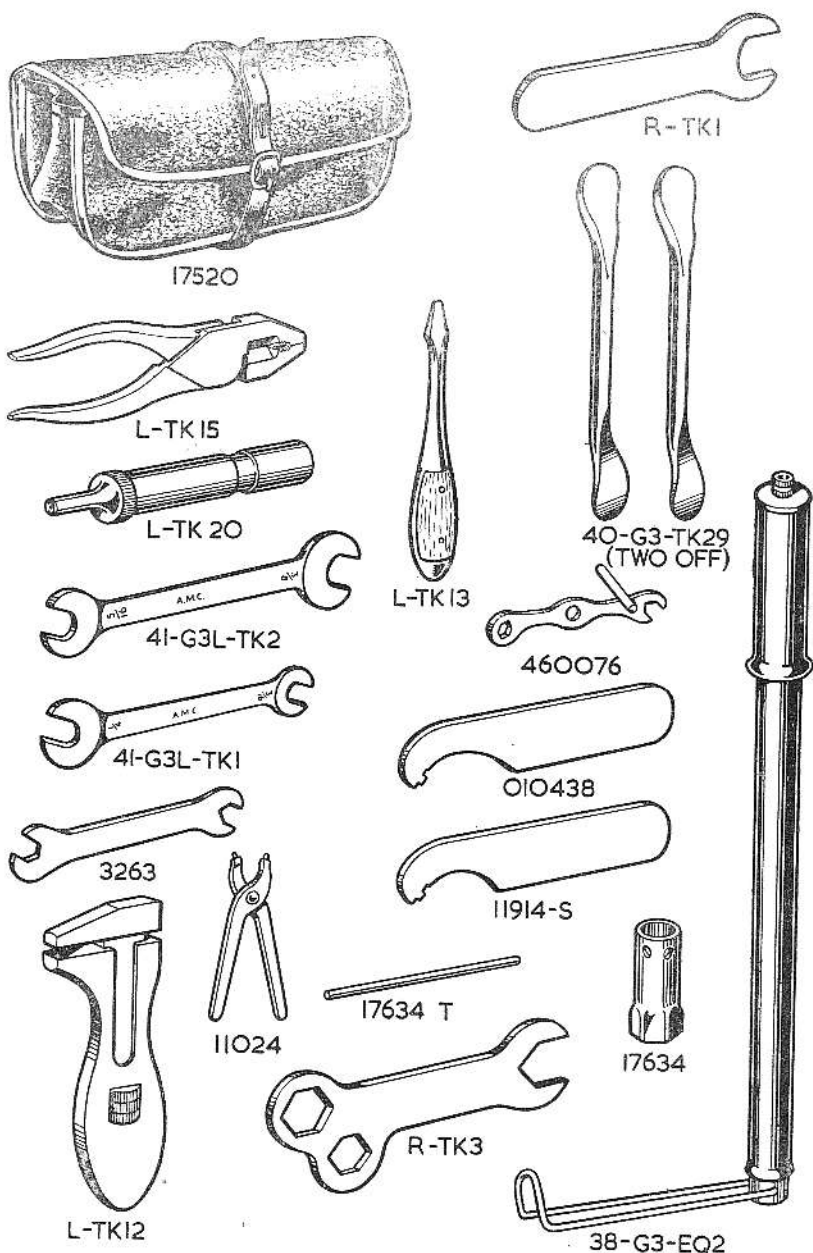


Illustration 40

FREE SERVICE SCHEME

FREE SERVICE SCHEME

All owners of **NEW MODELS** are entitled to one **FREE SERVICE AND INSPECTION** at 500 miles, or, at latest, three months after taking delivery.

This service is arranged by the supplying dealer to whom the **Free Service Voucher** must be handed. This voucher, together with the Instruction Manual, are supplied by us upon receipt of the signed application card to be found in the tool box upon taking delivery of a new motor cycle.

The **INSPECTION AND SERVICE** consists of :

(a) Check, and, if necessary, adjust :

- | | |
|-----------------------------|-------------------------------------|
| (1) Rocker clearances. | (6) Wheel bearings. |
| (2) Contact breaker points. | (7) Brakes. |
| (3) Sparking plugs. | (8) Forks, legs, and steering head. |
| (4) Clutch. | (9) Alignment of wheels. |
| (5) Chains. | (10) Tyre pressures. |

(b) Tighten all external nuts and bolts, including cylinder-bolts.

(c) Top-up battery and check all lighting equipment.

(d) Clean out carburetter and adjust mixture.

(e) Adjust and lubricate all cables.

(f) Grease all nipples.

(g) Drain oil system. Clean filter and replenish.

(h) Check oil level in front chaincase.

(i) Top-up gear box.

(j) Test machine on the road.

NOTE—Oils, greases and materials used are chargeable to the customer.



WHEN ORDERING SPARES IF IN DOUBT REGARDING THE NAMES
AND PART NUMBERS OF THE PARTS YOU REQUIRE, PLEASE
SEND THE OLD PARTS TO SERVE AS PATTERNS.

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GENUINE A·J·S SPARES

PURCHASED FROM
AN AUTHORISED "A·J·S" DEALER OR
FROM THE FACTORY, ARE IDENTICAL
WITH THE PARTS ORIGINALLY BUILT
INTO YOUR MOTOR CYCLE.

BY USING GENUINE SPARES YOU ARE ASSURED THEY
WILL FIT ACCURATELY AND GIVE SATISFACTORY SERVICE

CHAS. F. THORN & SON, LTD.

PRINTERS

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