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ENGINE PARTS AND YEAR GUIDE

IDENTIFYING PARTS

12th September 2010

by
John Ready

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1.1. INTRODUCTION.

This guide is produced to allow the author to collate the information needed to identify parts that I continue to acquire. I hope that this information is of value to other collectors.

My interest is assembling bikes which are correct for the year and model. Whilst all the bikes are not necessarily “correct” I am always on the look out for the “correct” part. Like all addicts, I will never “be finished”.

All Chapters of this guide are “works in progress” and so will be updated as new information comes to hand and time allows. I invite others to provide additional information and corrections.

1.2. ABBREVIATIONS.

1.3. DISCLAIMER.

This Restoration Guide has been prepared solely for the use of John Ready. Use by any other party is completely at the risk of that party.

John Ready neither undertakes or accepts any liability in any way whatsoever to other any, in respect of the data herein contained including any errors or omissions however caused.

1.4. COPYRIGHT STATEMENT.

All rights reserved. The copyright of this Restoration Guide is the property of John Ready. Neither the Restoration Guide nor any part of it may be used or reproduced by any method whatsoever or incorporated by reference or in any manner whatsoever in any other document without the prior written consent of John Ready.

Many images are those of other people from the internet. Unfortunately I cannot acknowledge these parties as I do not know who they are. Most are from the various Spare Parts Manuals produced by A.J. Stevens, Matchless and later by AMC. My thanks to those whose images allow this guide to function.

As the copyright, if any, cannot be identified, this publication is not for commercial gain but is designed to assist AJS and Matchless fanatics to sort their parts and ease the sourcing of parts for particular models.

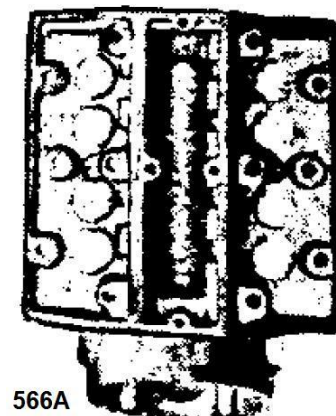
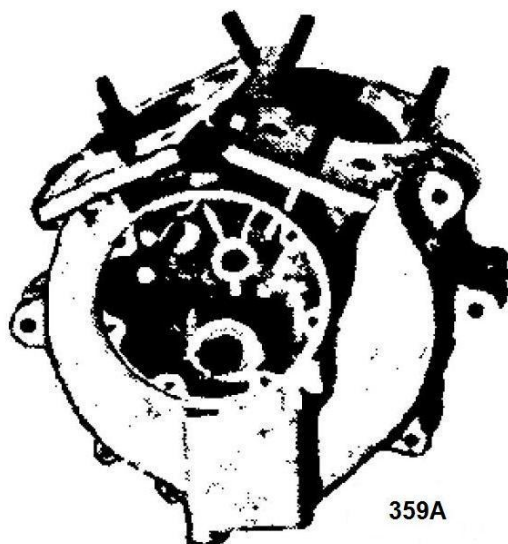
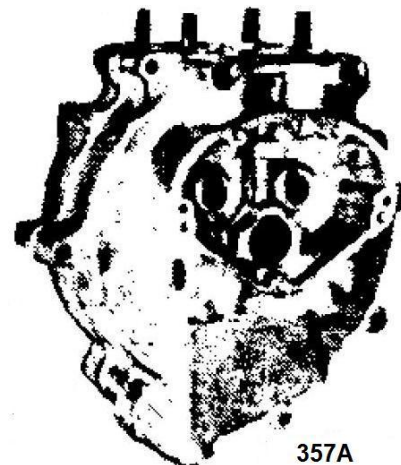
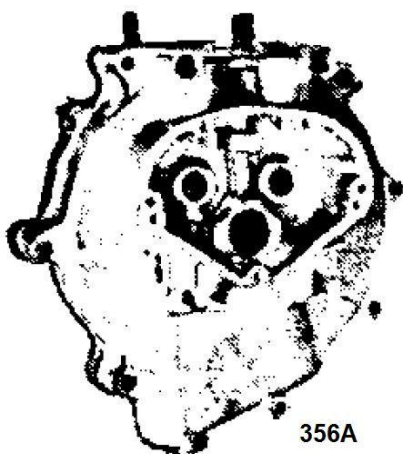
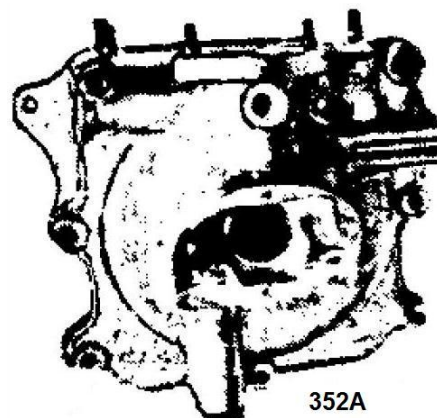
2. ENGINE.

2.1. CRANK CASES.

1955 saw a major change in both the driving side bearings and the timing side for a larger bush. A larger ball bearing was added to supplement the usual ball bearing.

The 1/4" bottom engine bolt was upgraded to a 5/16"

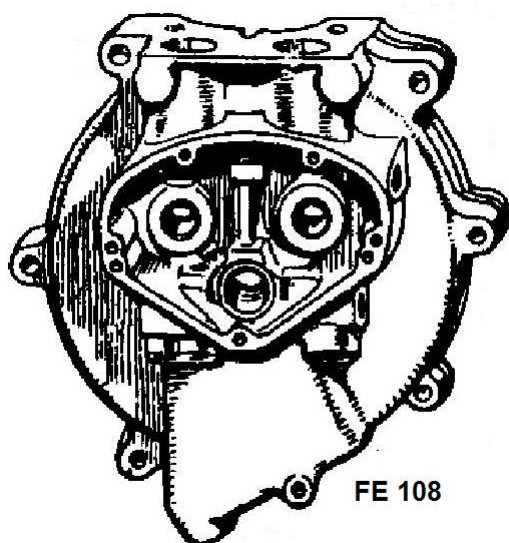
1932 Matchless



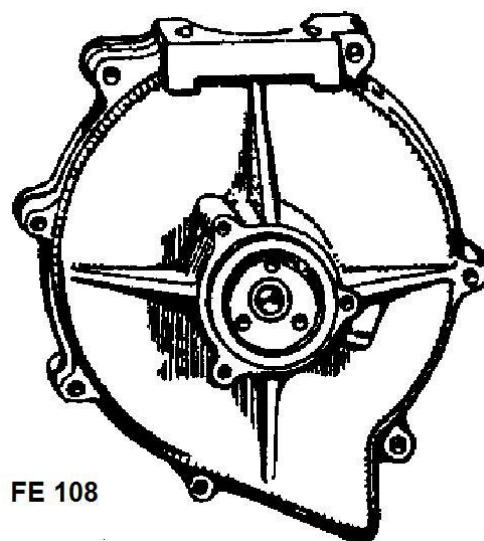
AJS & Matchless Parts and Year Guide - Engine

1934 – 1935 Matchless.

34 F

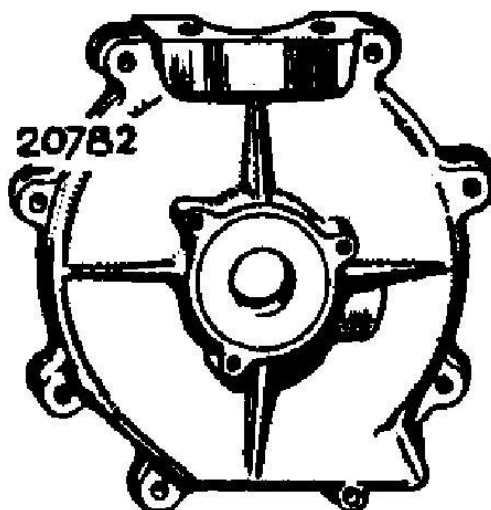


FE 108

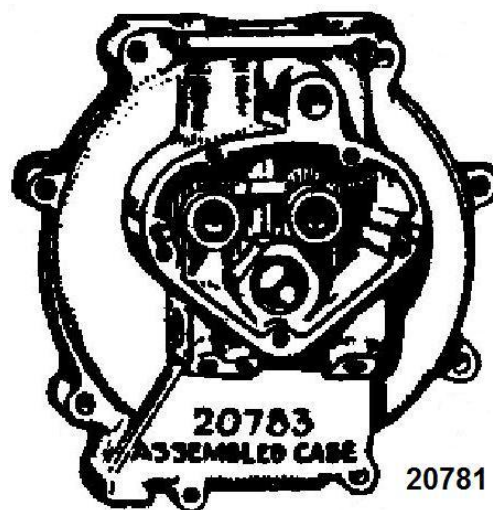


FE 108

1935 AJS



20782

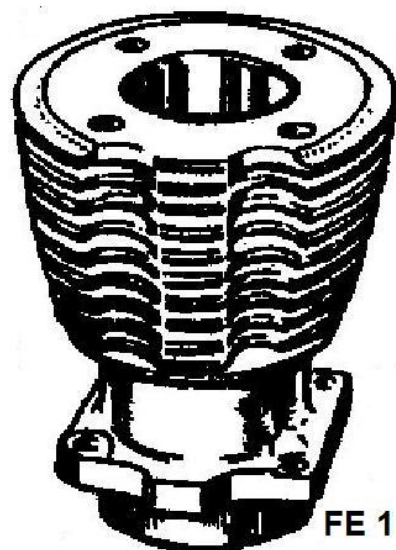


20783
ASSEMBLED CASE

20781

2.2. CYLINDERS

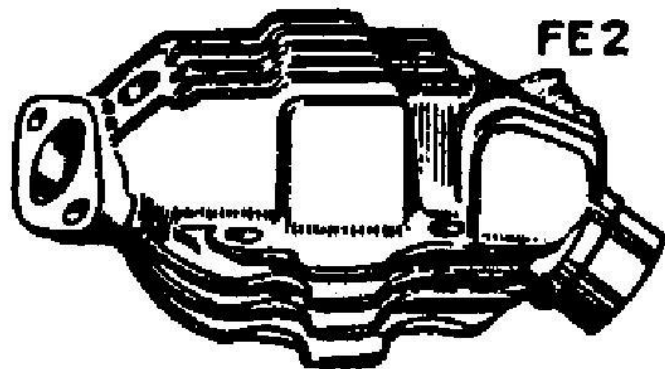
1934 – 1935 Matchless
1935 AJS



2.3. CYLINDER HEADS

1934 – 1935 Matchless

1935 AJS



2.4. TIMING COVER.

2.4.1. SINGLES.

Two types of ignition systems were utilised by both AJS and Matchless. These were Coil Ignition and Magneto.

Early A J Stevens manufactured units had the magneto's mounted in front of the engine and often in front of the main front frame down tube. Around 1930 they started using MagDynos and these were mounted behind the cylinder.

Magdynos, which have a dynamo fitted above the magneto in a common housing and utilising a common drive were a feature of AJS and Matchless motorcycles from 1930 until 1936 and were fitted behind the cylinder.

In 1935 AJS and Matchless introduced separate magnetos and generators for their "sporty" OHV models whilst the MagDyno continued on the "touring" models. One of the most obvious differentiations between Matchless and AJS models is the location of the Magneto. The AJS fitted the magneto in front of the cylinder, whilst it was fitted behind on the Matchless. This difference continued until the end of the 1951 model run.

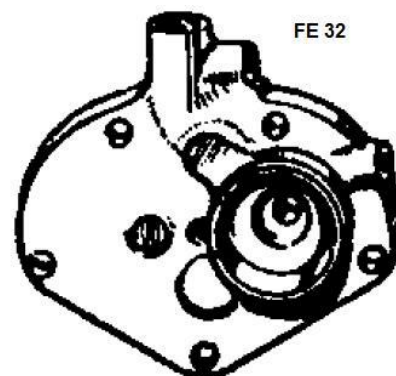
After 1936 the Magdyno was only fitted to the AJS and Matchless V-twins.

In 1952 the magneto on the Matchless moved to the front of the cylinder.

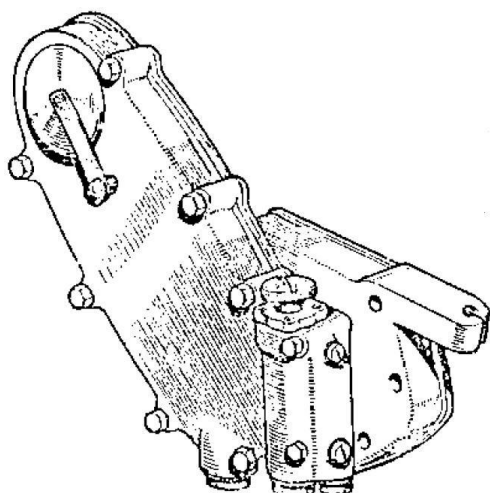
1958 saw all road models move to coil ignition although the magneto was continued on the competition machines.

1934 Matchless

This timing cover was introduced for the "sloper" models with coil ignition.



1930 – 1936 AJS



The timing cover and MagDyno chain cover were like the diagram here but different part numbers covered the 250cc, the larger 350cc and again for the 500cc engines. It is likely there were changes and superseded part numbers during this time.

THIS SECTION NEEDS MORE WORK but requires other Spare Parts Manuals to complete for models and years around this time.

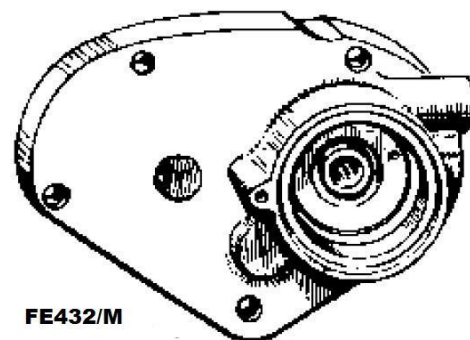
The cover contains the oil pump and this had a venerer adjustment on (some models?)

1935 – 1939 AJS and Matchless

This cover, FE432/M is fitted to all coil ignition models during between 1935 (earlier?) and 1939.

Note the curved cut out to allow the cover to clear the valve lifter assembly mounted in the crankcase.

The Matchless spare parts manual lists the 1935 cover as FE 432/L.

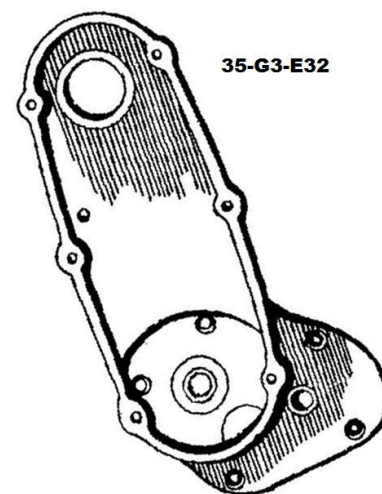


1935 – 1951 Matchless.

1935 saw the introduction of the rear mounted magneto on many Matchless singles that lasted right through until the end of the 1951 models.

In 1935 the 35-G3-E32 cover was only used on the G3 Clubman model. In 1936 this cover was fitted for all magneto ignition models.

This cover had an “A” added to the end of the part number after the war and so must have undergone a minor change. The casting number stayed the same so it is presumable that the change may have been to the camshaft bushes or other machining.



There is a small steel cap used to seal off the bush for the exhaust camshaft bush.

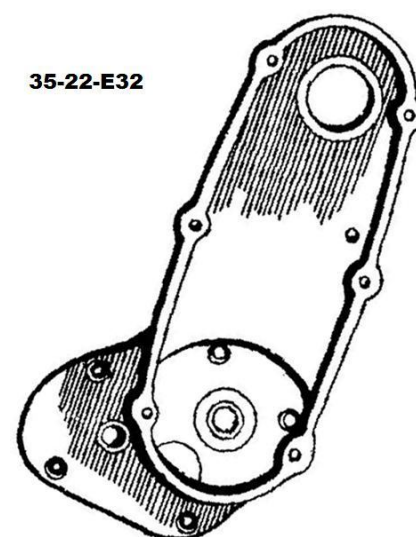
I have a cover that looks identical except that the magneto chain part is laid back about 10 degrees more than the Matchless. The part number D8/#####cast into the cover and the only way to pick it from other covers is to lay them over each other. It has been suggested that this may come from a “Matchless” engine produced for another manufacturer.

AJS 1935 – 1937.

This was a short lived cover and was very similar to the Matchless with the main difference being that the magneto was mounted in front of the cylinder. This also allows the magneto drive chain to be shorter and thus the cover is also shorter than the Matchless equivalent.

This part number was introduced in 1935 season bikes for only the 14, 22 and 26 “sporting” models.

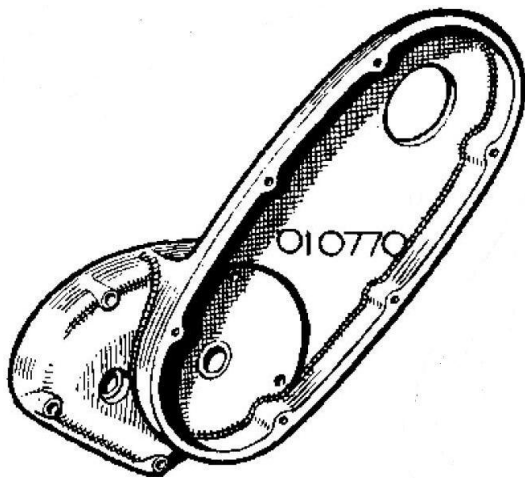
The cover was used on all single cylinder magneto ignition models from 1936.



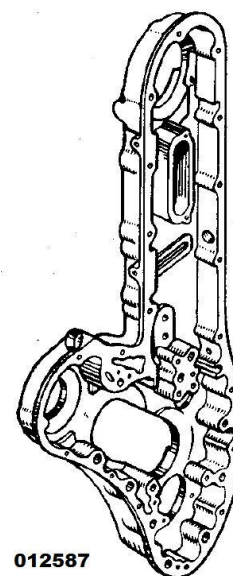
AJS 1938 – 1948.

AJS & Matchless Parts and Year Guide - Engine

To allow the timing cover to clear the crankcase mounted valve lifter the AJS cover from 1938 through to 1948 used an almost parallel timing cover with semicircular ends. The Part No. is 38-22-E32 and is cast, as 38/22/E32, into the inside of the timing cover behind where the magneto chain runs.



AJS 1949 - 1949 7R

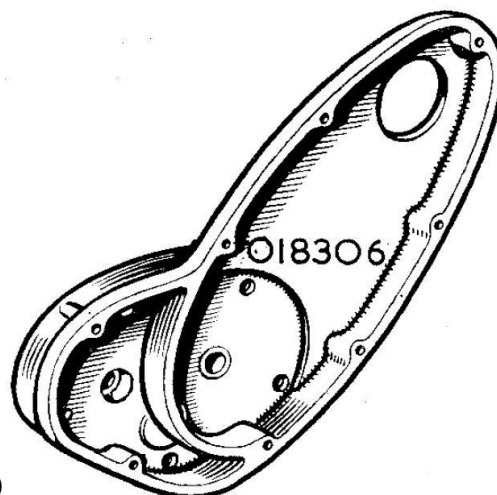


AJS 1949 – 1955.

A new timing case was introduced which had more of a sweep to it so that it tapered at the top. This new part has 016883 cast into the case behind where the magneto chain runs.

Part No. 010770

MATCHLESS 1952 – 1955.



2.4.2. TWINS

2.5. MAGNETO CHAIN COVER.

There was a significant difference between the AJS and Matchless from 1936 until 1952. The front mounted magneto on the AJS allowed considerable differentiation of the two Marques now produced by the Collier's brothers of Matchless since acquiring the AJS Stevens business in 1935.

but retained the “flying M” cast into the magneto chain cover. Both the timing and chain cover had a different shape to the AJS.

In both AJS and Matchless the magneto chain covers were filled with grease until 1951 when the grease nipple was removed from the outside chain cover and oil was used instead of the grease.

1954 saw the introduction of an automatic advance - retard to the 500cc touring models which necessitated a major change to the magneto outer cover. This now had a large boss at the top which made room for the advance - retard mechanism mounted on the end of the magneto shaft.

In 1936 AJS and Matchless both dropped the Magdyno and started fitting separate magnetos and dynamos. It is unsure why this change was undertaken but it certainly allowed the colliers brothers to differentiate between their two brands of AJS and Matchless. The AJS returned to having the magneto mounted in front of the engine although this now meant in front of the cylinder and above the crankcase.

Matchless 1935 – 1947.

The Clubman models – G3 and G80 had magneto ignition provided by a separate magneto.

For these models they introduced a new magneto chain cover, the 35-G3-E29. This has a **raised** “flying M” logo located in the centre of the cover.

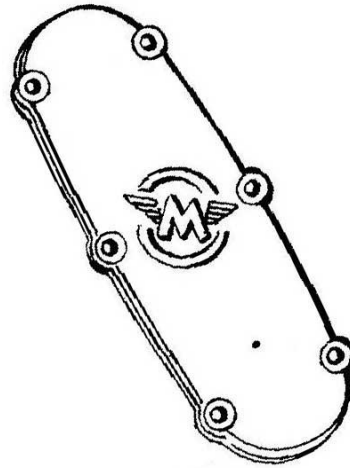


AJS 1936 – 1937.

This cover features a “roundel” shaped AJS logo centred over the Magneto shaft and matched the AJS logo on the rocker box cover of the time.



Matchless 1948 – 1951.

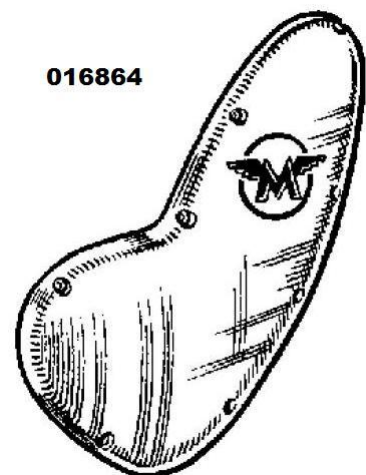


AJS 1938 – 1963.



Matchless 1952 – 196?

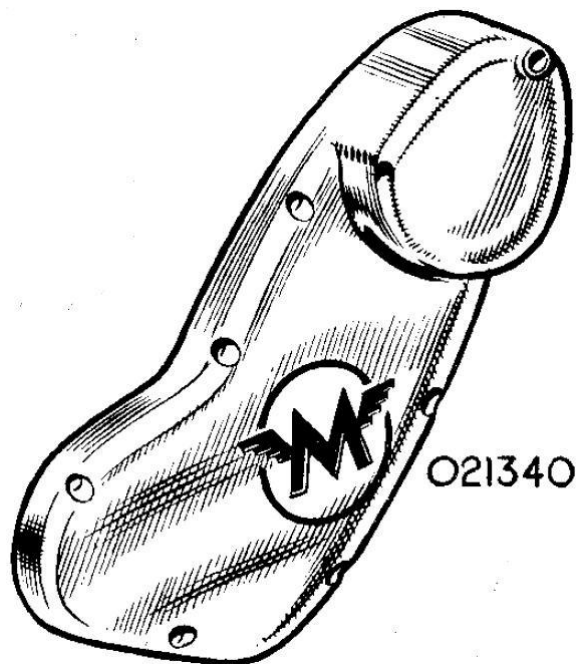
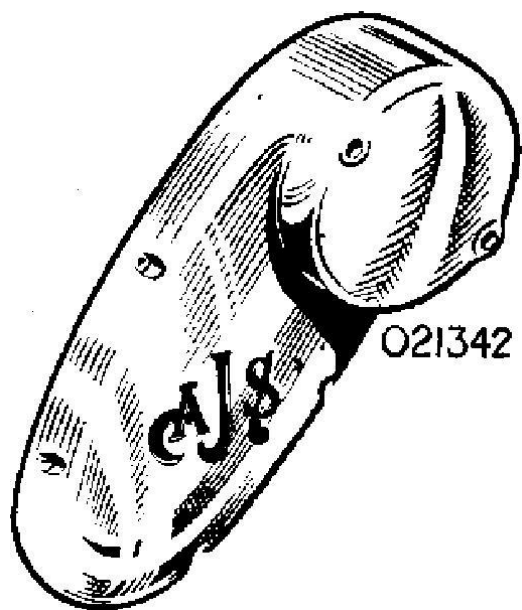
016864



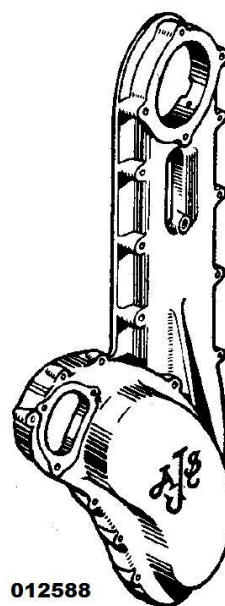
AJS 1954 - 1958

AJS & Matchless Parts and Year Guide - Engine

The 500 single road models utilised an automatic advance - retard mounted on the magneto. This necessitated a large boss in the cover for the magneto chain case. The Part Number for this is 021342.



AJS 1949 - 1949 7R



2.6. CAMSHAFTS.

1955 saw a different camshaft introduced for the rigid 350 and 500 competition models to better suit trials riding which these machines were now almost exclusively made for.

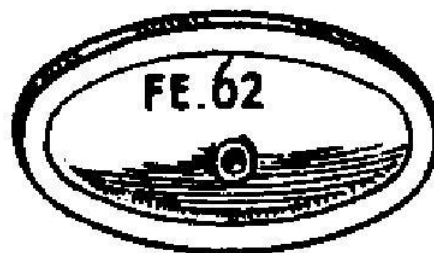
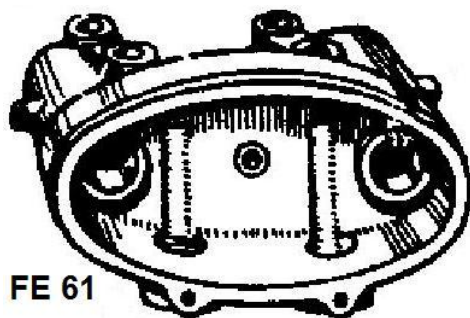
The high lift and racing camshafts were also dropped.

2.7. OVERHEAD ROCKERS.

1955 saw changes made to both the inlet and exhaust rocker arms.

2.8. ROCKER BOX.

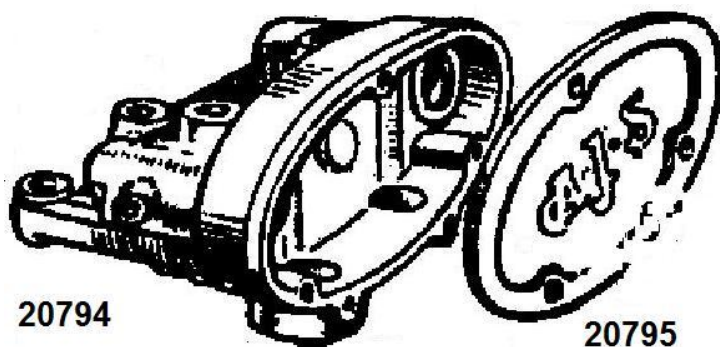
1934 Matchless



1935

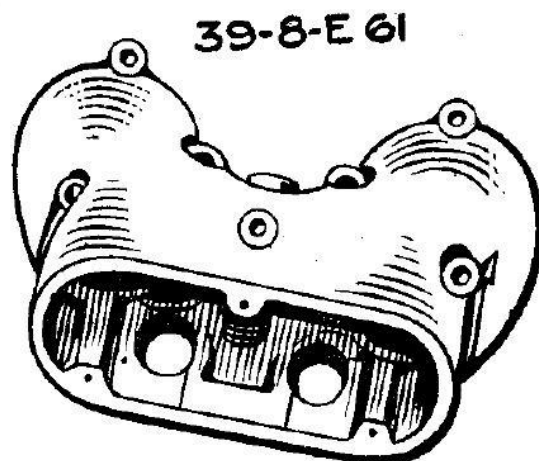
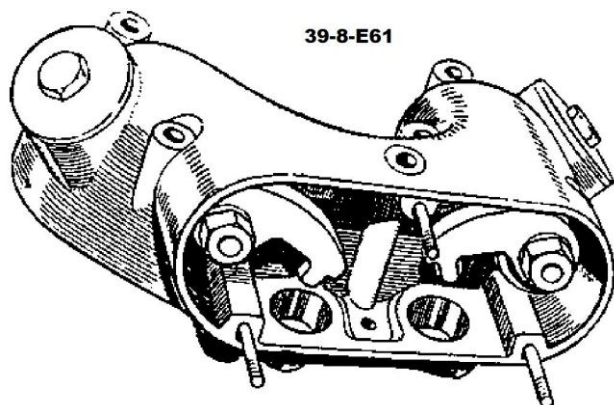
AJS & Matchless

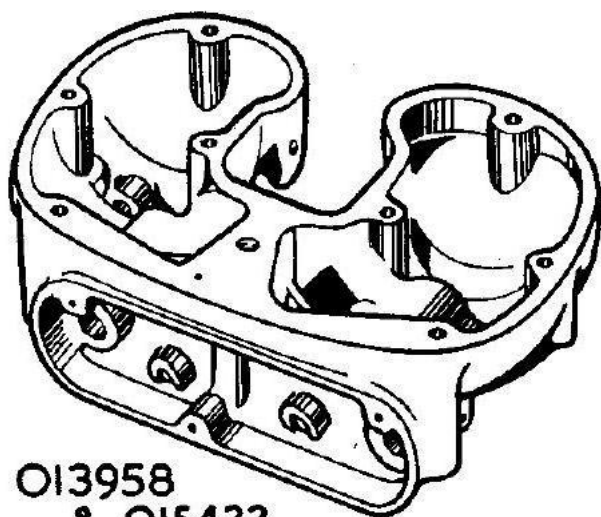
Narrow oval cover with exposed rockers & springs on the 250 and a flattened oval on 350 and 500 OHV's.



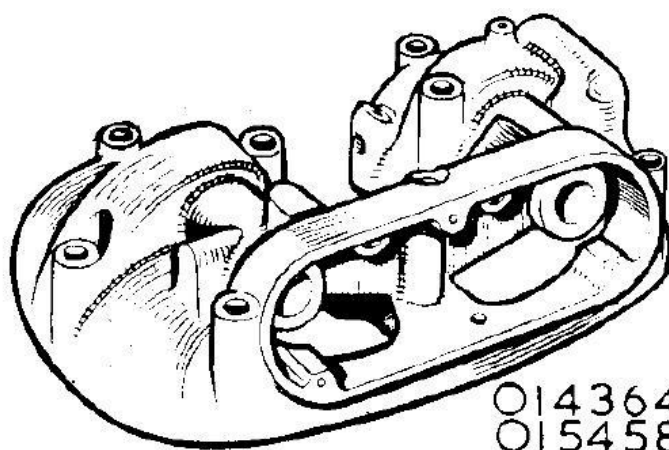
1939

AJS & Matchless





O13958
& O15422

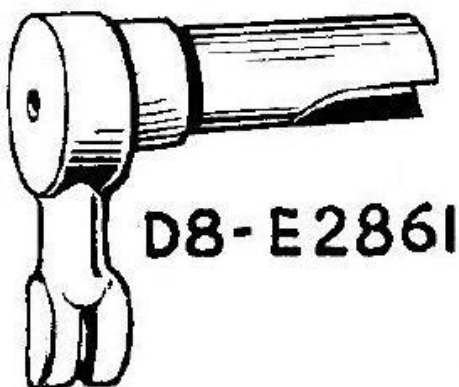


O14364
O15458

2.9. VALVE LIFTER.

1935 – 1948 AJS and Matchless.

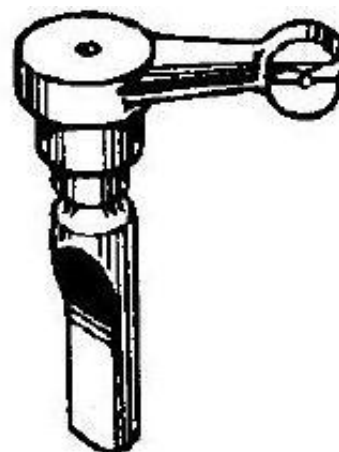
The valve lifter was fitted into the crankcase and worked directly on the exhaust tappet.



D8-E2861

1949 – 1964 AJS and Matchless.

The valve lifter was fitted in the rocker box and worked directly on the exhaust rocker.



O13969

2.10. ROCKER BOX BOLTS.

JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
Rocker Box	010930	1946	Bolt, fixing rocker box, with extension	2	18	AJS
		1947	Bolt, fixing rocker box, with extension	1	18	AJS
					G80	=M=
		1948	Bolt, fixing rocker box, with extension	1	18	AJS
	013602	1947	Bolt, fixing rocker box, long head	5	18	AJS
				6	16M	AJS
		1948	Bolt, fixing rocker box, long head	5	18	AJS
				6	16M	AJS
	014175	1949	Bolt, fixing rocker box, short	4	18	AJS
					16M	AJS
					16MC	AJS
					18C	AJS
		1950	Bolt, fixing rocker box, short, 1 3/4" by 5/16" by 22	4	18	AJS
					16M	AJS
					16MC	AJS
					16MS	AJS
					18C	AJS
					18S	AJS
	014176	1949	Bolt, fixing rocker box, long	2	18	AJS
				4	18C	AJS
					16M	AJS
					16MC	AJS
		1950	Bolt, fixing rocker box, long, outside, 2 3/4" by 5/16" by 22	2	18	AJS
					16M	AJS
					16MS	AJS
					18S	AJS
	014177	1949	Bolt, fixing rocker box, with extension	2	18	AJS
		1950	Bolt, fixing rocker box, long, inside, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					18S	AJS
	015353	1951	Bolt, fixing rocker box, short, 1 15/16" by 5/16" by 22	4	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1952	Bolt, fixing rocker box, short, 1 15/16" by 5/16" by 22	4	18	AJS

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JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1953	Bolt, fixing rocker box, short, 1 15/16" by 5/16" by 22	4	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
					G3L	=M=
					G3LC	=M=
					G3LCS	=M=
					G3LS	=M=
					G80	=M=
					G80C	=M=
					G80CS	=M=
					G80S	=M=
		1954	Bolt, fixing rocker box, short, 1 15/16" by 5/16" by 22	4	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1955	Bolt, fixing rocker box, short, 1 15/16" by 5/16" by 22	4	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
	015354	1950	Bolt, fixing rocker box, long, inside, 2 15/16" by 5/16" by 22	2	16MC	AJS
					18C	AJS
		1951	Bolt, fixing rocker box, long, 2 15/16" by 5/16" by 22	2	18	AJS
					18C	AJS
					18CS	AJS
				4	18S	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS

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JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
					16MS	AJS
		1952	Bolt, fixing rocker box, long, 2 15/16" by 5/16" by 22	2	18	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
				4	16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
		1953	Bolt, fixing rocker box, long, 2 15/16" by 5/16" by 22	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
					G3L	=M=
					G3LC	=M=
					G3LCS	=M=
					G3LS	=M=
					G80	=M=
					G80C	=M=
					G80CS	=M=
					G80S	=M=
		1954	Bolt, fixing rocker box, long, 2 15/16" by 5/16" by 22	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
		1955	Bolt, fixing rocker box, long, 2 15/16" by 5/16" by 22	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
	015355	1950	Bolt, fixing rocker box, long, inside, 2 15/16" by 5/16" by 22 with extension 5/16" by 26	2	18C	AJS
		1951	Bolt, fixing rocker box, long, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS

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JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
					18C	AJS
					18CS	AJS
					18S	AJS
		1952	Bolt, fixing rocker box, long, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1953	Bolt, fixing rocker box, long, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
					G3L	=M=
					G3LC	=M=
					G3LCS	=M=
					G3LS	=M=
					G80	=M=
					G80C	=M=
					G80CS	=M=
					G80S	=M=
		1954	Bolt, fixing rocker box, long, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					16M	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1955	Bolt, fixing rocker box, long, 2 3/4" by 5/16" by 22 with extension 5/16" by 26	2	18	AJS
					16M	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
	015356	1950	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	2	16MC	AJS
					18C	AJS
		1951	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS

AJS & Matchless Parts and Year Guide - Engine

JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1952	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1953	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
					G3L	=M=
					G3LC	=M=
					G3LCS	=M=
					G3LS	=M=
					G80	=M=
					G80C	=M=
					G80CS	=M=
					G80S	=M=
		1954	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
		1955	Bolt, fixing rocker box, centre position, 3 5/16" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MC	AJS
					16MCS	AJS
					16MS	AJS
					18C	AJS
					18CS	AJS
					18S	AJS
	015373	1950	Bolt, fixing rocker box, centre position, 3 5/32" by 5/16" by 22	1	18	AJS
					16M	AJS
					16MS	AJS
					18S	AJS

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JR Group	JR-Part No.	Year	Description (Common)	No. Off	Model	Brand
	021444	1954	Bolt, fixing rocker box, long, with extension	2	16MC	AJS
		1955	Bolt, fixing rocker box, long, with extension	2	16MC	AJS
	39-8-E451	1941	Bolt, fixing rocker box, long head	6	G3L	=M=
		1946	Bolt, fixing rocker box, long head	5	18	AJS
				6	16M	AJS
		1947	Bolt, fixing rocker box, long head	5	G80	=M=
				6	G3L	=M=
	39-8-E452	1941	Bolt, fixing rocker box, short head, centre	1	G3L	=M=
		1946	Bolt, fixing rocker box, short head, centre	1	18	AJS
					16M	AJS
		1947	Bolt, fixing rocker box, short head, centre	1	18	AJS
					16M	AJS
					G3L	=M=
					G80	=M=
		1948	Bolt, fixing rocker box, short head, centre	1	18	AJS
					16M	AJS
		1949	Bolt, fixing rocker box, short head, centre	1	18	AJS
					16M	AJS
					16MC	AJS
					18C	AJS

Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
Crankpin	017020	1	18	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16M	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MC	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MCS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18C	1951	AJS
				1952	AJS

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Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
				1953	AJS
				1954	AJS
				1955	AJS
				1951	AJS
			18CS	1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
				1951	AJS
			18S	1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			G3L	1953	=M=
			G3LC	1953	=M=
			G3LCS	1953	=M=
			G3LS	1953	=M=
			G80	1953	=M=
			G80C	1953	=M=
			G80CS	1953	=M=
			G80S	1953	=M=
	39-G8-E17	1	18	1946	AJS
				1947	AJS
				1948	AJS
				1949	AJS
				1950	AJS
			16M	1946	AJS
				1947	AJS
				1948	AJS
				1949	AJS
				1950	AJS
			16MC	1949	AJS
				1950	AJS
			16MS	1950	AJS
			18C	1949	AJS
				1950	AJS
			18S	1950	AJS
			G3L	1941	=M=
				1947	=M=
			G80	1947	=M=
Crankpin, bare	36-X-E17	1	2	1938	AJS
			2A	1938	AJS
	37-G8-E17	1	9	1938	AJS

Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
Rod, connecting with liner and bush	010312	1	18	1947	AJS
				1948	AJS
				1949	AJS

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Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16M	1947	AJS
				1948	AJS
				1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MC	1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MCS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MS	1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18C	1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18CS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18S	1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			G3L	1947	=M=

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Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
				1953	=M=
			G3LC	1953	=M=
			G3LCS	1953	=M=
			G3LS	1953	=M=
			G80	1947	=M=
				1953	=M=
			G80C	1953	=M=
			G80CS	1953	=M=
			G80S	1953	=M=
Rod, connecting, with liner and bush	37-G8-E44	1	18	1946	AJS
			16M	1946	AJS
			G3L	1941	=M=

Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
Ring, felt, for rocker axle sleeve	012722	2	18	1948	AJS
				1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16M	1948	AJS
				1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MC	1949	AJS
				1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MCS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			16MS	1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
			18C	1949	AJS
				1950	AJS

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Description (Common)	JR-Part No.	No. Off	Model	Year	Brand
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18CS	1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			18S	1950	AJS
				1951	AJS
				1952	AJS
				1953	AJS
				1954	AJS
				1955	AJS
			G3L	1953	=M=
			G3LC	1953	=M=
			G3LCS	1953	=M=
			G3LS	1953	=M=
			G80	1953	=M=
			G80C	1953	=M=
			G80CS	1953	=M=
			G80S	1953	=M=
	D8-E1865	2	18	1946	AJS
				1947	AJS
			16M	1946	AJS
				1947	AJS
			G3L	1941	=M=
				1947	=M=
			G80	1947	=M=
				1947	=M=