

# SERVICE BULLETIN AND TECHNICAL DATA

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FWN/EF 65/1

## SERVICE BULLETIN AND TECHNICAL DATA

Norton 650 and 750.

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### CONNECTING RODS

An improved type of Connecting Rod, Part No. 25275, has been introduced for the above models, first fitted to Engine No. 111920. As the new type Connecting Rod is heavier, replacements must be made in pairs, as Engine balance will be affected if Connecting Rods of different weights are used.

NOTE It is imperative that the cap nuts for the new type rods are torqued to 25 ft. lbs.

### REV. COUNTER

A new type timing cover 25187 was first fitted to Engine No. 111378, to enable the Rev Counter Drive to be vertically mounted so that the Drive Cable will be clear of the exhaust pipe. The screws fixing the Rev Counter Drive have Part No. 012873.

### FRONT BRAKE

On early models made before June 1963, the Front Wheel Spindle was a close fit in the front brake plate spindle aperture. Subsequently, this aperture was enlarged to the extent of 1/32", thus permitting the Brake Shoes to be centralised by releasing the Wheel Spindle Nut and whilst maintaining pressure on Brake Shoe Expander Lever - then re-tightening the Spindle Nut - the Brake Shoes will be centralised.

### CLUTCH

The throw out ramp on Clutch Operating Lever 040029, has been modified in shape to make clutch separation much easier.

## JUBILEE ES400 NAVIGATOR

### ROCKER COVER GASKET 20867

A material change has been introduced to make this gasket more effective on the above models. Jointing compound must not be used with this gasket, otherwise the material will become plastic.

### KICKSTARTER PAWL 045205

Heat treatment for this component has been amended to make the pawl more durable. New type has same Part No. but can be identified by its dark colour.

### OIL SEAL 20765

An essential service - Tool Part No.25279, is now available at a cost of 6/-d nett. The use of this tool enables the timing cover to be assembled without deforming the oil seal - causing oil leakage into the contact breaker compartment.

### ES 400

### STARTER SPROCKET KEY E3-681

A loose starter motor sprocket nut will cause this key to shear. In such an event, the sprocket should be lapped on the taper with grinding paste to restore the taper fit. Use a chain bar to hold the sprocket whilst tightening the sprocket nut.

### MATCHLESS TWIN MODELS

#### REV. COUNTER DRIVE

The Rev. Counter drive housing cap was modified for the 1964 season. To rectify oil leakage due to the oil seal breaking down - substitute the rev counter housing cap first fitted for the modified type 030436, use also, oil seal backing washer 030437, which supports the seal to stop breakdown. Machines made for the 1964 season, are fitted with the modified parts.

#### To Assemble the Housing Cap.

1. Use a new oil seal - insert it into the housing cap with flat metal backing portion - facing outwards.
2. Gently press home until the seal abuts against the smaller diameter in the housing.
3. Insert the metal backing washer with the reduced portion towards the oil seal.
4. Carefully locate the retaining circlip in its groove.
5. Assemble the housing cap with a rotary motion on to the oil distributor shaft.

### NORTON 650 and 750 Models

#### OIL TANK

Cases are known, (on early models), where the bracket on top of the oil tank has fractured at the point where the bracket is attached to the tank. The fracture is caused by a strain imposed when the fixing bolt is tightened. The use of washers or a small distance piece placed between the bracket and the frame attachment will relieve any strain on the bracket - when the fixing bolt is tightened.

## ALL HEAVYWEIGHT MODELS

### LUCAS ALTERNATOR

The air gap between the rotor and the pole pieces of the stator coil is .020" when the stator is centralised. If there is contact between the rotor and coil pole pieces the rotor can be centralised by:-

1. Taking off the stator sufficiently to clear the rotor.
2. Attach to the rotor, (by magnetic attraction), three strips of feeler gauge material approximately .010" thick in equi-distant positions, with the ends turned down.
3. Re-fit the stator - firmly tighten the fixing nuts.
4. Withdraw the steel strips when a concentric air gap is assured.

### AMAL, LUCAS & SMITH.

### SPARE PARTS

A price revision has been notified by both Messrs. Lucas and Messrs. Amal, which becomes effective February 1st, 1965, and by Messrs. Smiths which becomes effective 1st May, 1965.

As the increase is not general, apply to the makers concerned for details.

### HEAVYWEIGHT GEAR BOX

### KICKSTARTER PAWL 040017

Premature wear on this pawl can be caused by the pawl "ratchetting" against the segments in the low gear pinion. A stronger kickstarter return spring is now in use to overcome crank movement by inertia. The kickstarter crank should be positioned about 20 degrees away from the vertical - otherwise the calf of the rider's leg will make contact with the crank and cause the pawl to ratchet.

### 1962/63 SCEPTRE - MERCURY MODELS ONLY

### IGNITION TIMING

The maximum ignition advance quoted in the Rider's Handbook is 39 degrees fully advanced. It has been established that a better engine performance can be obtained if the ignition timing is re-set to a maximum of 34 degrees, fully advanced.

### NORTON INSTRUCTION BOOKS

### NORTON HEAVYWEIGHT F106/F HANDBOOK

The additional reading matter, also added illustrations, used in the current issue has made it necessary to revise the recommended selling price to 9/- subject.

NORTON GASKET SETS

REDUCED PRICES

As a result of keen buying it is now possible to supply Gasket Sets at a reduced cost. The amended prices and part numbers are shown in the following table.

PART NO.		MODEL	YEAR	REVISED PRICE
F17-1062	Full Set	Jubilee	1959-1963	£1.13. -d.
P17-1063	Decarb	Jubilee	1959-1964	12. 8d.
S19-1062	Fullset	Navigator	1961-1963	1.18.10d.
S19-1063	Decarb	Navigator	1961-1963	11. 6d
D12-1062	Full Set	88 & 650 STD	1949-1963	1. 3. 7d
D12-1063	Decarb	88 & 650 STD	1949-1963	9. 1d
S650-1062	Full Set	650 SS	1961-1963	1. 6. 4d
S650-1063	Decarb	650 SS	1961-1963	9. 1d
T750-1062	Full Set	Atlas	1962-1963	1. 8. 7d
T750-1063	Decarb	Atlas	1962-1963	10. 6d
25272	Full Set	Jubilee	1964	1.13.5d
25271	Full Set	Navigator	1964	1.14.4d
25270	Decarb	Navigator	1964	8.11d
24919	Full Set	Electra	1964	1. 9. -d
24920	Decarb	Electra	1964	11.10d
25287	Full Set	88SS, 650SS	1964	1. 4. 8d
25284	Decarb	- " -	1964	7. 9d
25288	Full Set	Atlas	1964	1. 4. 3d
25285	Decarb	Atlas	1964	7. 7d
25289	Full Set	All G15	1964	1. 3.10d
25286	Decarb	All G15	1964	8. 5d

10th March, 1965.