

1948

REPUBLIC 5073

*Allied Motorcycle Distributors, Inc.*

IMPORTERS OF THE WORLD'S  
FINEST MOTORCYCLES

2014 "M" STREET, NORTHWEST  
WASHINGTON 6, D. C.

CABLE ADDRESS  
ALMOOI

SB-6

A.J.S. AND MATCHLESS

SERVICE DATA

350cc - 500cc  
(Single cylinders)

We have asked the factory to give us the minimum and maximum clearances to be used when overhauling an engine and they have given us the following list of tolerances.

Timing Side Bush	7/8"	plus (.00075 Dia. reamed in position. plus (.00025
Rocker Axle Bush	5/8"	plus (.001 Dia. reamed in position. minus (.000
Cam Wheel Bush	1/2"	plus (.0005 Dia. reamed in posi- minus (.0005 tion.
Gudgeon Pin Bush	7/8"	plus (.00050 Dia. reamed in positior. minus (.00025
Valve Guide Internal Dia.	H equals .3750" L equals .3735"	Dia.
Valve Guide Projects Through Head	Inlet 1/2" Exhaust 5/8"	
Valve Stem Dia.	H equals .3715" L equals .3705"	
Valve Seat Angle	45 degrees (90 degree inclusive)	
Cam Wheel Axle Dia.	1/2" (Minus .00125 (Minus .00175	
Driving Side Shaft Dia.	1" (Minus .0007 (Minus .0002	H equals .874" Over L equals .873" Splines
Crankpin Dia:-Roller Path	H equals 1.20375" L equals 1.20350"	
Crankpin Dia:-Shaft-Taper	.8770 to .8790	
Connecting Rod Sleeve	H equals 1.70400" L equals 1.70375"	When Assem.

Rollers	1/4" Long X 1/4" Dia.	
Timing Side A/cle Dia.	7/8" (Minus .0030 (Minus .0035	
Pump Shaft Dia.	23/32" (Minus .00075 (Minus .00125	Large End
	9/16" (Minus .00075 (Minus .00125	Small End
Gudgeon Pin Dia.	7/8" (Minus .0010 (Minus .0013	
Tappet Guide Projection Through Crankcase	1/4"	
Rocker End Float	Nil	
Cam Wheel End Float	Nil	
Flywheel End Float (Shock Absorber removed)	.0250"	
Rocker Steel Sleeve Dia.	H equals .6235" L equals .6230"	
Cylinder Bore Size 350c.c.	2-23/32" (Plus .0005 (Minus .0005	
Cylinder Bore Size 500c.c.	3-1/4" (Plus .0005 (Minus .0005	
Stroke	3-21/32"	
Piston Skirt Size	Above G.P. H equals 2.7170" L equals 2.7162"	
	Below G.P. H equals 2.7178" L equals 2.7162"	
Piston Skirt Size	Above G.P. H equals 3.2484" L equals 3.2476"	
	Below G.P. H Equals 3.2492" L equals 3.2476"	
Fork Spring O/A Length 1947 Type	10-1/32" Free Length	
1947 Distance Piece	3/4"	
Fork Spring O/A Length 1948 Type	11" Free Length	