

The TRIUMPH Corporation

SERVICE BULLETIN

January 7, 1965

65/1

TO ALL EASTERN TRIUMPH DEALERS:

Suggested "Flat Rate" Labor Schedule for Triumph Unit Construction Motorcycles.
This schedule is offered as a guide to all dealers.

* OPERATION NUMBER	OPERATION TITLE	SUGGESTED NUMBER OF HOURS	
		ALL TWIN MODELS "B" & "C" RANGE	SINGLE CYL. "A" RANGE
1	Remove & install Engine/Gearbox Unit	4	2-1/2
2	Rebuild Engine/Gearbox Unit	15	9
3	"Top End" Rebuild	6	3
4	Engine Tune-Up	1-3/4	1-1/4
5	Replace Oil Pump	1	1-1/2
6	Overhaul Primary Drive	2	1-1/2
7	Rebuild Gearbox & Primary Drive	4	3-1/2
8	Rear Drive Chain	1/4	1/4
9	Replace & Rebuild Front Wheel Assembly	1-1/4	1-1/4
10	Replace & Rebuild Rear Wheel Assembly	1-1/2	1-1/2
11	Wheel Repair	1-3/4	1-3/4
12	Replace Gas Tank	1	3/4
13	Replace Oil Tank	1	1
14	Replace Front Frame Section	9	6
15	Replace Damaged Front Fork Assembly	3	3
16	Overhaul Front Fork	2	1-1/2
17	Replace Wiring Harness	2-1/2	2-1/2
18	Electrical Test	1/2	1/2

* See description of "Operation Details".

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OPERATION DETAILS1. Remove and install engine/gearbox unit.

Remove unit from frame, clean up frame and engine plates. Clean oil tank.
Install new or reconditioned engine, tune-up and road test.

2. Rebuild engine/gearbox unit.

Completely dismantle engine, gearbox and inspect all parts. Replace parts as necessary including cleaning prior to reassembly. Complete reassembly ready for installation in frame.

3. "Top End" Rebuild.

Dismantle to crankcase level. Check pistons, cylinder bore and pin bushings. Replace parts as necessary.

Dismantle cylinder head and rocker boxes. Reface valve seats and grind valves. Assemble, adjust and road test.

4. Engine Tune-Up.

Adjust Valve clearance, clean and adjust contact points, check ignition timing (Use TRI-COR IGNITION TIMER). Clean, and adjust carburetor. Clean and adjust spark plugs. Road test.

5. Replace Oil Pump.

Dismantle to gain access to oil pump. Clean or replace pump. Assemble and check ignition timing.

6. Overhaul Primary Drive.

Dismantle primary drive and clutch. Clean and replace parts including alternator if necessary. Assemble, adjust and road test.

7. Rebuild Gearbox and Primary Drive.

Dismantle gearbox and primary drive. Clean, check and replace parts as required. Make adjustments as required and road test.

8. Rear Drive Chain.

Lubricate and adjust rear chain. Adjust rear brake control.

9. Replace and Rebuild Front Wheel Assembly.

Remove front wheel. Transfer bearings, brake parts, tire and tube from damaged wheel to new "wheel less internals". Assemble and adjust brake.

10. Replace and Rebuild Rear Wheel Assembly.

As front wheel. Transfer bearings, brake parts, sprocket, etc., from damaged wheel to new "wheel less internals". Assemble and adjust rear chain and brake.

11. Wheel Repair.

Replace wheel rim and spokes as required. True and align wheel.

12. Replace Gas Tank.

Replace gas tank. Transfer accessories including taps and fuel.

13. Replace Oil Tank.

Remove oil tank. Clean oil tank and filter or replacement with new. Assemble.

14. Replace Front Frame Section.

Dismantle. Fit new front frame. Assemble, adjust and road test.

15. Replace Damaged Front Fork Assembly.

Remove fork assembly, Transfer accessories. Assemble. Adjust head bearings and road test.

16. Overhaul Front Fork.

Remove lower legs, replace bearings, oil seals and rubber boots as necessary. Assemble. Check head bearing adjustment, add oil and road test.

17. Replace Wiring Harness.

Removal of wiring harness. Does not include work on any other electrical components. Assemble new harness.

18. Electrical Test.

Test all electrical components using TRI-COR Test Set following written instructions.