

Unscrew the cap retainer nuts, a turn at a time to avoid distortion, then remove the caps and connecting rods. Refit the nuts to their respective bolts to ensure correct reassembly.

Using a large impact screw driver, unscrew the oil tube retainer plug from the right end of the big-end journal. If difficulty is encountered, drill an $\frac{1}{8}$ in. diameter hole to $\frac{1}{4}$ in. depth in the crankshaft, to remove the centre punched indentation which locks the oil tube retainer plug in position.

Unscrew the flywheel bolt adjacent to the big end journal, then withdraw the oil tube using a hooked rod located in the flywheel bolt location hole (see Fig. B39).

Thoroughly clean all parts in paraffin (kerosene) then clean the oil drillings using a jet of compressed air. Particular attention should be given to checking that each oil drilling is free from blockage.

To remove the flywheel unscrew the remaining two bolts and press out the crankshaft from the right (plain bearing) using a press which can give a load of up to five tons. (Ensure that there is a centre punch mark on the right side of the flywheel before removing; this enables the flywheel to be replaced in its original position).

Replacing the flywheel is best done when the oil tube is correctly located into position. Offer the oil tube into the crankshaft with the flywheel bolt holes in the tube and crankshaft aligned. Insert a flywheel bolt temporarily to locate the oil tube in position.

Apply a hydraulic type thread sealant to the crankshaft threads, and screw in the plug tightly. Centre punch the crankshaft opposite the slot so that the plug is locked in position.

To reassemble the flywheel it should be heated to 100° centigrade then placed over the crankshaft (which should be cold) with the centre punch mark to the right. It will be necessary to turn the flywheel through 180° to get it over the crankshaft web. Turn it to its correct position relative to the crankshaft as soon as this is achieved, and align the bolt holes.

The flywheel bolts should be tightened to the torque figure given in GENERAL DATA using Triumph Loctite Sealant to obviate any possibility of the bolts working loose.

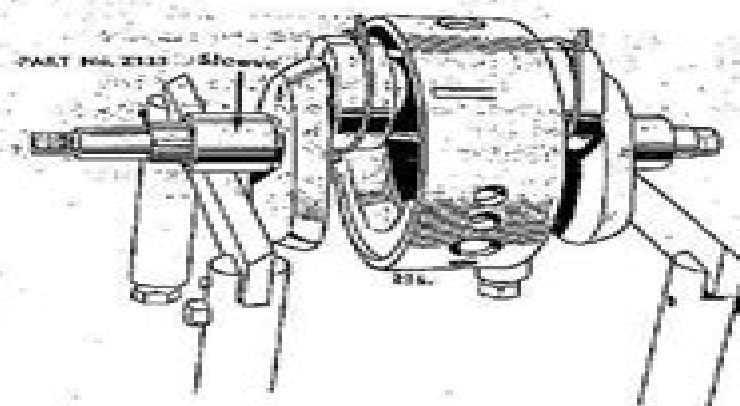


Fig. B40. Balancing the crankshaft (using sleeve Z133 on timing side)

If a new or reground crankshaft or a new flywheel has been fitted, the assembly should be rebalanced, using two service balance weights Z122 (490 gra. each). Place the assembly on two horizontal knife edges, resting it on the left and right main bearing diameters. Allow the assembly to come to rest, then mark the lowest point of the flywheel with chalk. Turn the assembly through 90° and if it returns to the same position drill a $\frac{1}{8}$ in. diameter hole centrally, adjacent to the chalk mark, to a depth of approximately $\frac{1}{4}$ in.

NOTE: A sleeve should be fitted over the L/H main bearing journal for this test. (See Fig. B40). Part No. Z133.

Repeat the balancing procedure, again making a chalk mark as necessary, and drill further holes until the assembly will come to rest in any position when placed on the knife edges. The drilled holes should have a distance of approximately $\frac{1}{2}$ in. between centres.

Finally, thoroughly wash the assembly in paraffin (kerosene) and check that the oil ways are free from blockage.

Triumph 350 500 1963 1974 Full Service Repair Manual

Raffaela Di Napoli



Triumph 350 500 1963 1974 Full Service Repair Manual:

Cars & Parts ,1993 **Subject Guide to Books in Print** ,1997 **Old Car Value Guide** ,1977 Cycle World ,1974

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Motor Sport William Boddy,1972 **Paperbound Books in Print** ,1984 TRIUMPH 350cc & 500cc UNIT

CONSTRUCTION TWINS 1963-1974 WORKSHOP MANUAL Floyd Clymer,Velocepress,2022-08-26 260 pages and more than 290 illustrations and charts size 8 25 x 10 75 inches This publication is a reproduction of the Triumph factory workshop manual part number 99 0843 0948 0950 The original workshop manual part number 99 0843 was subsequently updated and merged with workshop manual 99 0948 This merged double manual also included a supplement part number 99 0950 which extended the coverage up to the 1974 models The supplement was appended to the double manual such that Section A Lubrication System is followed by a Section AA Lubrication System supplement and Section B Engine is followed by a Section BB Engine supplement etc etc This combination of 99 0843 0948 0950 was published as a single workshop manual applicable to the entire range of 350cc and 500cc unit construction twins from 1963 through 1974 This reprint is a faithful reproduction of that combination manual There were a number of running changes made throughout the 11 year production run of these models and the way the factory identifies the point where those changes took place is by referencing engine numbers within each individual section of this manual To assist in identifying the appropriate information applicable to those changes the supplements were appended to the end of each appropriate section Consequently it is important to note with regard to any maintenance and repair instructions and also the specifications in the General Data GD section that wherever engine numbers are stated the data will be specific to that particular series Therefore the reader is encouraged to read the entire section plus the supplemental section prior to commencing any work paying close attention to any engine number notations Owners of the 350cc and 500cc machines are subjected to considerable confusion surrounding the appropriate selection of the multitude of originals and reprints of the various 350cc and 500cc manuals that have recently flooded the online marketplace Based on our research at least six manuals were issued for different series of engine numbers throughout the 11 year production run However the 99 0843 0948 0950 combination manual is the most comprehensive manual for the entire line of 350cc and 500cc unit construction twins produced from 1963 to 1974 It covers all engine numbers from H29733 through H67331 plus the later 1969 through 1974 alpha numeric series engine numbers unfortunately it is somewhat scarce and difficult to find In addition many of the changes made towards the end of the production run necessitate the use of the supplement and we are pleased to offer this reprint of the combination manual as a service to all Triumph 350cc and 500cc unit construction owners The 1963 to 1974 models covered are Tiger 100 T100SS Tiger 1963 1965 T100 Tiger 1966 T100S Tiger 1967 1970 T100T T100R Daytona 1966 1974 T100C Trophy 1966 1972 Speed Twin 5TA 1963 1966 Tiger 90 T90 1963

1969 Twenty One 3TA 1963 1966 *Autocar & Motor*, 1992-11-04 [Motor Cycling and Motoring](#), 1986 **The Autocar**, 1985 **Books in Print Supplement**, 1985 **Triumph Service-repair Handbook: 500-750cc Twins, 1963-1974** Clymer Publications, 1974 **TRIUMPH 1957-1963 UNIT-CONSTRUCTION 350cc & 500cc TWINS - FACTORY MANUAL No.4 UP TO ENGINE No.H29733**, 2023-12-25 180 pages and more than 70 illustrations and charts size 6 625 x 10 25 inches This publication is a faithful reproduction of the Triumph Factory manual No 4 Ref 26 67 published in May 1967 for the 1957 to 1963 unit construction 350cc and 500cc twins The original publication states Up to Engine No H29733 which would include the 350cc and 500cc unit construction twins built between 1957 and 1963 In addition this coverage is confirmed by the statement Up to and including 1963 printed to the bottom of the original front cover However Triumph also included a supplement for the T100SS from engine No H25252 1962 onwards and the T90 from engine No H29733 1963 onwards This addition of a later model supplement can create confusion in the selection of an appropriate manual as some of the models covered by this earlier manual remained in production up through the mid to late 1960 s However Triumph owners should be guided by the statement Up to and including 1963 on the front cover and owners of Triumph models from engine No H29733 1963 onwards are directed to the later manual ISBN 9781588502674 which actually picks up where this manual leaves off and provides coverage for the 350cc and 500cc unit construction twins from 1963 through 1974 THE VARIOUS 1957 to 1974 350cc 500cc MANUALS EXPLAINED 1957 1963 MODELS The original small format 51 2 x 81 2 stapled booklet style manual No 4 Ref 26 67 that included coverage for the 350cc and 500cc unit construction models from 1957 up to engine No H29733 1963 was ultimately superseded with the publication of a large format 81 2 x 11 3 ring bound manual part number 99 0843 The 99 0843 manual was somewhat of an oddball as it included a statement to the title page that it covered from engine No H65573 1969 Apparently this publication was intended to cover the 1969 to 1971 models only as a subsequent manual issued in 1971 included data for the earlier models 1963 1971 MODELS In August 1971 the 99 0843 manual was subsequently merged with manual number 99 0948 under part number 99 0843 0948 with backdated coverage from engine No H29733 1963 As the 99 0948 manual was published in August 1971 but coverage was retroactive to 1963 it is obvious that Triumph had compiled the data from the earlier manuals and merged them into a single 1963 to 1971 publication 1963 1974 MODELS The final version of this manual included a supplement 99 0950 that extended coverage through the 1974 model year This supplement was merged with the previous 1971 publication and issued under part number 99 0843 0948 0950 The supplement was appended such that Section A is followed by a Section AA supplement Section B by a Section BB supplement etc etc This manual both backdates and extends coverage and is the most comprehensive manual for the 1963 to 1974 series of 350cc and 500cc unit construction twins It is available under ISBN 9781588502674

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