

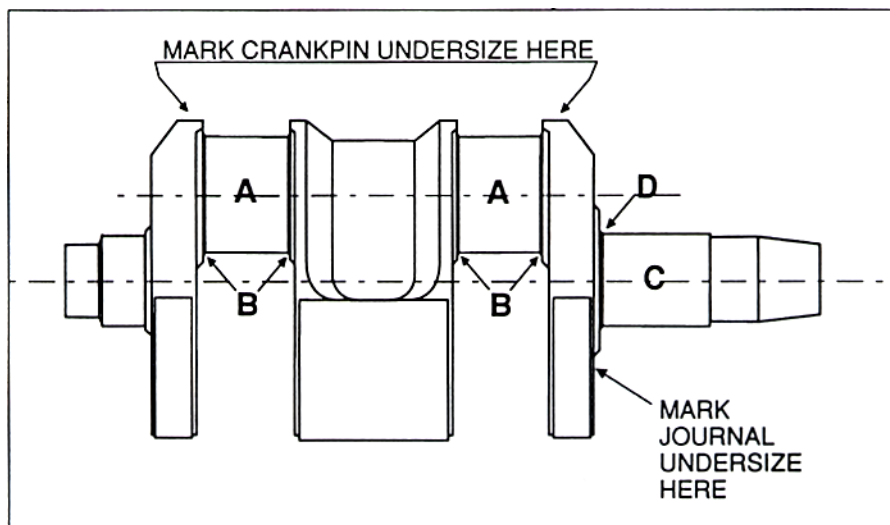


Sunbeam Service Sheet No. 18

Subject: Crankshaft Regrinding

Date: December 1956

If the overall wear on the crankpins or rear journal exceeds .002", or if the bearing surfaces have been damaged, it will be necessary to re-grind the crankshaft to the dimensions given below.



CRANKPINS:

First Re-grind:

Grind the crankpins 'A' to 1.6150"/1.6145" with a face radius at 'B' of .125"/.129". Mark the tops of the webs - .010". Use undersize bearing shells, Part No. 89-695.

Second Re-grind:

Grind the crankpins 'A' to 1.6050"/1.6045" with a face radius at 'B' of .125"/.129". Mark the tops of the webs - .020". Use undersize bearing shells, Part No. 89-81.

REAR JOURNAL:

Grind the journal 'C' to 1.4895"/1.4890" with a face radius at 'D' of .125"/.129". Mark the side of the web - .010". Use undersize bearing bush, Part No. 89-89.

SERVICE DEPARTMENT
B.S.A. CYCLES LIMITED