

SERVICE INFORMATION



STANDARD AND TRIUMPH VEHICLES

(NOT FOR PUBLICATION)

No. SPORTS/5/B

ENGINE DIMENSIONS

Date NOVEMBER 1954

Attached hereto is a summary of the engine dimensions and clearances which may be found of use in your Service Department when dealing with normal repair and reconditioning work.

This Sheet gives Important service Information and should be filed by your Service Dept. in the Service Information Folder.

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No. SPORTS/5/B

ENGINE DIMENSIONS

Date NOVEMBER 1954

TRIUMPH SPORTS T.R.2

ENGINE DIMENSIONS

Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Crankshaft:</u>			
Journal Diameter	2.4795"– 2.4790"		
		0.0010" to 0.0025"	
Bearing Internal Diameter	2.4815"– 2.4805"		
Bearing Housing Internal Diameter	2.6255"– 2.6250"		
<u>Crankshaft End Float:</u>			
Intermediate Journal Length	1.7507"– 1.7498"		
		0.0048" to 0.0117"	Clearance of 0.004" to 0.006" is specified and obtained by selective assembly of Thrust washers.
Intermediate Bearing Cap Width (Plus Thickness of two Thrust Washers)	1.7450"– 1.7390"		
Main Bearing Cap Width	1.5050"– 1.4950"		

Undersize bearings are available in the following sizes: –010" –020" –030" –040"

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Big End:</u>			
Crank Pin Diameter	2.0866”– 2.0860”		
		0.0016” to 0.0035”	
Bearing Internal Diameter	2.0895”– 2.0882”		
Internal Diameter of Bearing Housing	2.2335”– 2.2327”		
Bearing Width	0.9670”– 0.9650”		
<u>Big End Float:</u>			
Crankpin Width	1.1915”– 1.1865”		
		0.007” to 0.014”	
Connecting Rod Width	1.1795”– 1.1775”		

Undersize bearings are available in the following sizes: –010” –020” –030” –040”

<u>Small End:</u>			
Bore for Bush	1.0000”– 0.9950”	Press fit in	
Bush External Diameter	1.0005”– 0.9950”	Connecting Rod	

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Small End (Cont.):</u>			
Internal Diameter of Bush	0.8752"– 0.8748"		
		0.0002" at 68° F	
Gudgeon Pin Diameter	0.87510"– 0.87485"		
<u>Piston Rings:</u>			
Compression Ring Width	0.062"– 0.061"		
		0.0015" to 0.0035"	
Groove Width	0.0645"– 0.0635"		
Scraper Ring Width	0.156"– 0.0155"		
		0.001" to 0.003"	
Groove Width	0.158"– 0.157"		
Ring Gap in Cylinder Liners		0.003" to 0.016"	

Piston rings are obtainable in the following oversizes: +010" +020" +030" +040"

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Part and Description	Grade "F"	Grade "G"	Grade "H"
<u>Piston and Cylinder Sleeves:</u>			
Bore Diameter	3.2676"—3.2673	3.2680"—3.2677	3.2684"—3.2681
Top Dia. of Piston Skirt	3.2626"—3.2622	3.2630"—3.2626	3.2634"—3.2630
Bot. Dia. of Piston Skirt	3.2641"—3.2639	3.2645"—3.2641	3.2649"—3.2645
Top—Skirt Clearance (All Grades)	0.0057"—0.0054"		
Bot.—Skirt Clearance (All Grades)	0.0039"—0.0032"		
Height of Cyl. Sleeves above Cylinder Block Face (All Grades)	0.0055"—0.003"		

Piston are obtainable in the following oversizes: +020" +030" +040"

Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Camshaft:</u>			
Front Journal Diameter	1.8720"—1.8710"		
		0.0028"—0.0047"	
Front Journal Bearing Bore	1.8757"—1.8748"		

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Camshaft (Cont.):</u>			
External Diameter of Front Bearing	2.2498”– 2.2493”	Push fit in Cylinder Block	
Bore in Block for Front Bearing	2.2507”– 2.2493”		
Diameter of 2nd, 3rd and Rear Camshaft Journals	1.7157”– 1.7152”		
		0.0026” to 0.0046”	
Bore in Cylinder Block for 2nd, 3rd and Rear Journals	1.7198”– 1.7183”		
End Float		0.004” to 0.012”	
<u>Valves and Valve Guides:</u>			
Inlet Stem Diameter	0.3110”– 0.3100”		
		0.001” to 0.003”	
Inlet Guide ID	0.3130”– 0.3120”		

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Valves and Valve Guides</u> (Cont.):			
Exhaust Stem Diameter	0.3715"– 0.3705"		
		0.003" to 0.005"	
Exhaust Guide ID	0.3755"– 0.3745"		
Included Angle of Valve Faces	90°		
Inlet Valve Head Diameter	1.5620"– 1.5530"		
Width of Inlet Valve Seating	0.0469" (approx.)		
Exhaust Valve Head Diameter	1.3030"– 1.2990"		
Width of Exhaust Valve Seating	0.0469" (approx.)		

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Oil Pump:</u>			
Outer Rotor Outside Diameter	1.5975"– 1.5965"		
		0.0055" to 0.0075"	
Housing Internal Diameter	1.6040"– 1.6030"		
Depth of Rotor	1.4995"– 1.4985"		
		0.0005" to 0.0025"	
Housing Depth	1.5010"– 1.5000"		
Bush in Cylinder Block	0.5010"– 0.5005"		
		0.0015" to 0.0030"	
Distributor Driving Shaft	0.4990"– 0.4980"		
<u>Oil Pump Inner Rotor:</u>			
Major Diameter	1.1720"– 1.1710"		
Minor Diameter	0.7310"– 0.7290"		

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Oil Pump Inner Rotor (Cont.):</u>			
Rotor Depth	1.4995”– 1.4985”		
		0.0005” to 0.0025”	
Housing Depth	1.5010”– 1.5000”		
Clearance on Rotors		0.0005”–0.0025” Min. 0.001”–0.004” Max.	
<u>Valve Springs:</u>			
Outer Springs (Inlet & Exhaust), Fitted Length	1.560”		
Outer Springs (Inlet & Exhaust), Fitted Load	38 lbs.		
Outer Springs (Inlet & Exhaust), Free Length	1.980” (approx.)		
Inlet Inner Spring, Fitted Length	1.560”		
Inlet Inner Spring, Fitted Load	33 lbs.		
Exhaust Inner Spring, Fitted Length	1.450”		
Exhaust Inner Spring, Fitted Load	36.5 lbs.		

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Part and Description	Dimensions – New	Clearance – New	Remarks
<u>Valve Springs (Cont.):</u>			
Inner Inlet Spring, Free Length	2.080” (approx.)		
Inner Exhaust Spring, Free Length	2.080” (approx.)		
Auxiliary Inner Exhaust Spring, Fitted Length	1.140”		
Auxiliary Inner Exhaust Spring, Fitted Load	10 lbs.		
Auxiliary Inner Exhaust Spring, Free Length	1.540”		

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