

SERVICE INFORMATION



STANDARD AND TRIUMPH VEHICLES

(NOT FOR PUBLICATION)

No.	SPORTS/3/A	NUT TIGHTENING TORQUES	Date	JULY 1954
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It is intended to incorporate this information in the Service Manual with any additional information in this connection which may be available at the time of publication.

The nut tightening torques attached are recommended for the units as stated.

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

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Date JULY 1954

TRIUMPH SPORTS T.R.2

NUT TIGHTENING TORQUES

ENGINE

Operation	Description	Detail No.	Specified Torques	Remarks
Cylinder Head	1/2" UNF & UNC Stud	106960 106959	100 – 105	Tighten nut with engine cold.
Connecting Rod Caps	7/16" UNF Bolt	105312	55 – 60	
Main Bearing Caps	1/2" x 13 NC Setscrew	57121	85 – 90	
Flywheel Attachment to Crankshaft	3/8" x 24 NF Setscrew	102065	42 – 46	
Timing Chain Wheel to Camshaft	5/16" x 18 NC Setscrew	56370	24 – 26	
Manifold Attachment	3/8" NC Stud	58688 102475 107055	22 – 44	
Oil Pump Attachments	5/16" x 24 UNF Stud	HN.2008	12 – 14	
Rear Oil Seal Attachment	1/4" x 20 UNC Setscrew	UN.0755	8 – 10	
Clutch Attachment	5/16" x 18 UNC Setscrew	HU.0856	20	
Attachment of End Plates	5/16" x 18 UNC Bolt	HU.0856	14 – 16	Tapped into Aluminium.

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Operation	Description	Detail No.	Specified Torques	Remarks
Attachment of Oil Filters	5/16" x 18x24 UNC Bolts Cap Nut Bolt	HB.0874 HB.0882 DN.3408 HB.0856	18 – 20	
Timing Cover	5/16" x 18 x 24 NC Setscrew	HU.0805 HU.0857	16 – 18	
Sump Attachment	5/16" x 18 NC Setscrew	100749	16 – 18	
Pulley to Water Pump Spindle	5/16" x 24 UNF Simmonds Nyloc Nut	TN.3208	16 – 18	
Dynamo Bracket to Block	5/16" x 18 UNC Setscrew	HU.0856	16 – 18	
Dynamo to Bracket and Pedestal	5/16" x 24 UNF Setscrew and Bolt	59115 HU.0808	16 – 18	
Rocker Pedestal	3/8" NF & NC Stud	108205	24 – 26	
Oil Gallery Plugs	7/16" x 14 UNC 3/8" x 16 UNC	102785 HU.0954	32 – 36 24 – 26	Tighten onto copper washer.
Attachment of Starter Motor	3/8" x 24 NF Bolt	HB.0915	25 – 28	

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GEARBOX

Operation	Description	Detail No.	Specified Torque	Remarks
Front Cover to Gearbox	5/16" x 18 NC Setscrew	55771	14 - 16	
Extension to Gearbox	5/16" x 18 UNC Bolt	HB.0866 HB.0858	14 - 16	
Top Cover to Gearbox	3/8" x 18 Bolts and Setscrews	HU.0851 HB.0871 HB.0873	14 - 16	
Attachment of Engine to Gearbox	5/16" x 18 NC & NF Bolt and Stud	HB.0858 125C056	14 - 16	
Rear Mounting to Gearbox Extension	1/2" x 20 UNF Bolt	HB.1112	50 - 55	
Shock Absorber to Frame Bracket	3/8" x 24 UNF Setscrew 3/8" x 24 Nyloc Nut	HU.0908 TN.3209	26 - 28	

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FRONT SUSPENSION

Operation	Description	Detail No.	Specified Torque	Remarks
Back Plate and Tie Rod Levers to Vertical Link	3/8" x 24 UNF Bolts and Set-screws	HB.0925 HB.0922 HB.0905	24 - 26	
Wheel Studs and Nuts	7/16" NF	100869	45 - 55	
Ball Pin to Vertical Link	1/2" x 20 UNF Nut - Slotted	2211 LN	55 - 65	To suit pin hole.
Top Wishbone to Fulcrum Pin	7/16" x 20 UNF Nut - Slotted	2211 LN	26 - 40	To suit pin hole.
Spring Pan to Wishbone	3/8" x 24 UNF Stud 3/8" x 24 UNF Bolt	107350 107351	26 - 28	
Tie Rod to Idler Lever and Drop Arm	3/8" x 24 UNF Simmonds Nyloc Nut	TN.3209	26 - 28	
Top Inner Fulcrum Pin to Chassis	3/8" x 24 UNF Bolt 3/8" x 24 UNF Set-screw	HB.0913 HU.0908	26 - 28	
Lower Fulcrum Bracket to Chassis	5/16" x 24 UNF Bolt	HB.0805	16 - 18	

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Operation	Description	Detail No.	Specified Torque	Remarks
Lower Wishbone to Fulcrum Pin	7/16" x 20 UNF Nyloc Nut	TN.3210	26 – 28	
Front Hub to Stub Axle	1/2" x 20 UNF Nut – Slotted	LN.2211	Tighten up & unscrew one flat.	

REAR AXLE

Operation	Description	Detail No.	Specified Torques	Remarks
Bearing Caps to Housing	3/8" x 24 UNF Setscrew	100878	34 – 36	
Hypoid Pinion Flange	5/8" x 18 UNF	100892	85 – 100	To suit split pin holes.
Crown Wheel to Differential Case	5/16" x 24 UNF 3/8" x 24 UNF	107880 109735	22 – 24 35 – 40	Orig. equipment. Current equipment
Rear Cover Attachment	5/16 x 24 UNF Setscrew	HU.0805	16 – 18	
Backing Plate Attachment	3/8" x 24 UNF Setscrew	HU.0908	26 – 28	
Hub to Axle Shaft	5.8" x 18 UNF Nut – Slotted	100812	110–125	

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REAR SUSPENSION

Operation	Description	Detail No.	Specified Torque	Remarks
Spring Front End to Frame	1/2" x 20 UNF Bolt	106251	28 - 30	
Spring Shackle (Nut to Pin)	3/8" x 24 UNF Nut Shackle Pin	HN.2009 104953	26 - 28	
Road Spring to Rear Axle	Clip Nyloc Nut 3/8" x 24 UNF	107688 YN.2909	28 - 30	
Shock Absorber to Frame Bracket	3/8" x 24 UNF Setscrew 3/8" x 24 Nyloc Nut	HU.0908 TN.3209	26 - 28	

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