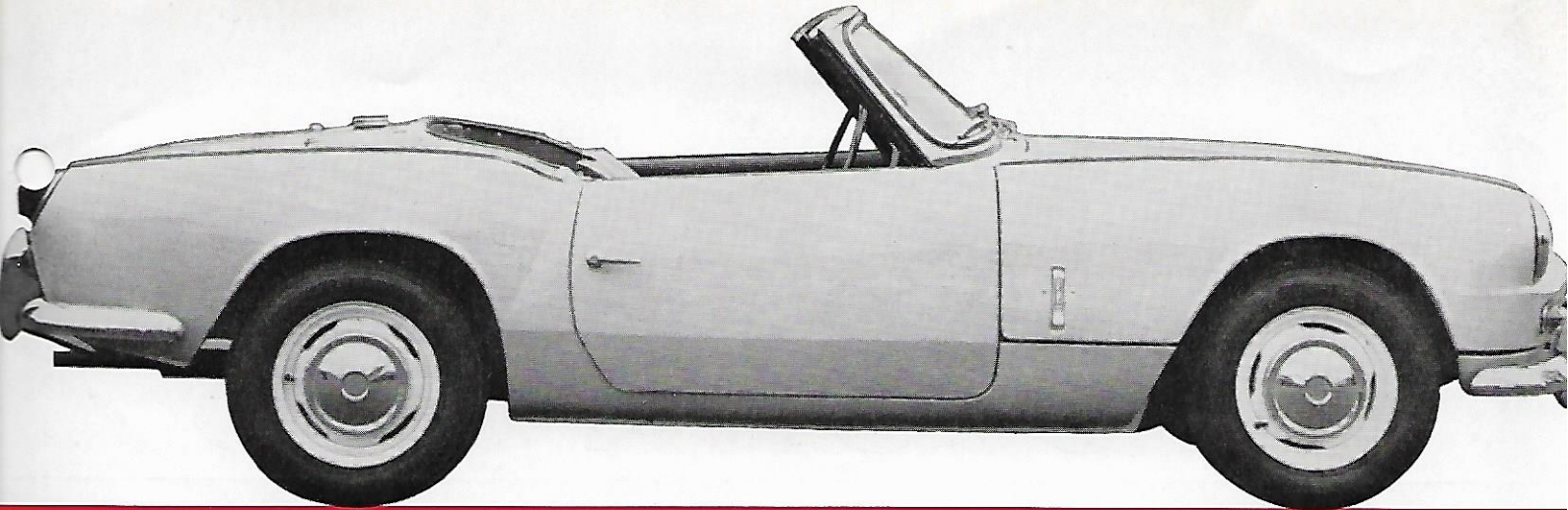




“STAGE TWO”
CONVERSION
ON YOUR
TRIUMPH
SPITFIRE 4
SPORTS CAR

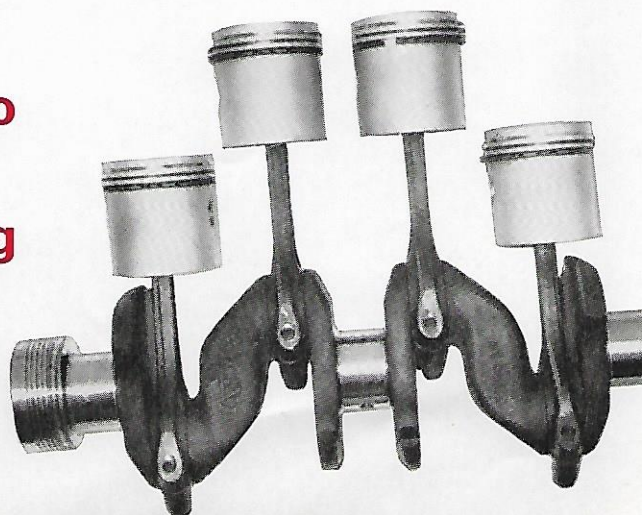
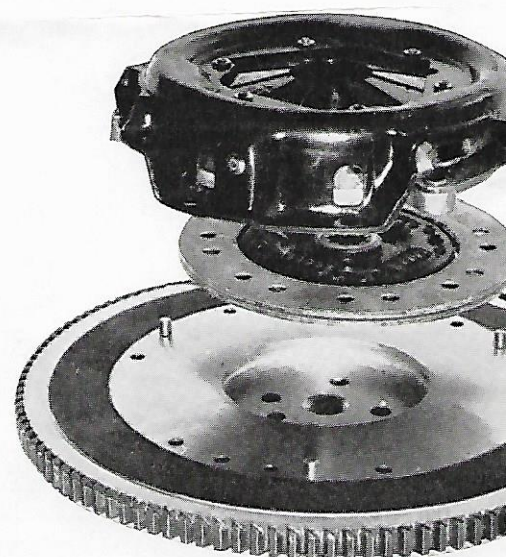
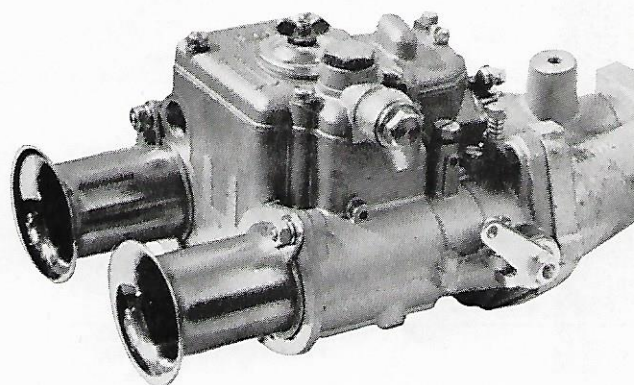
J.A.H. (ACCESSORIES) LTD., LEIGHTON BUZZARD, BEDS., PHONE 3022 & 2556
SOLE U.K. DISTRIBUTORS FOR TRIUMPH APPROVED PERFORMANCE KITS.



STAGE TWO!

More power — more speed — more performance — more sports car fun! That's the magic of the Stage Two Conversion. Now this sporting luxury has been brought well within the reach of all pockets with these 4 conversion schemes:

1. A new Spitfire, complete with Stage Two conversion available through your local Standard-Triumph Dealer.
2. A Stage Two conversion fitted to your existing Spitfire.
3. A part exchange of your existing Spitfire engine for a Stage Two converted engine.
4. The complete Stage Two conversion in kit form.



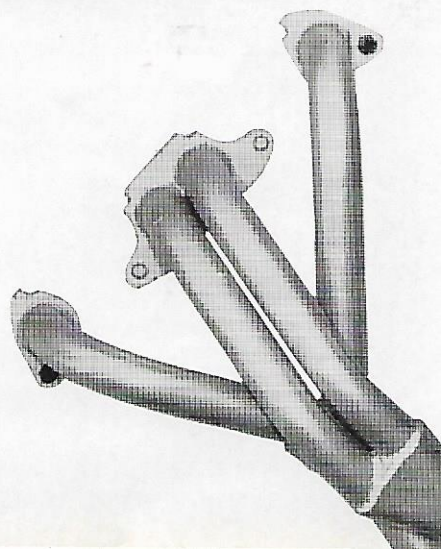
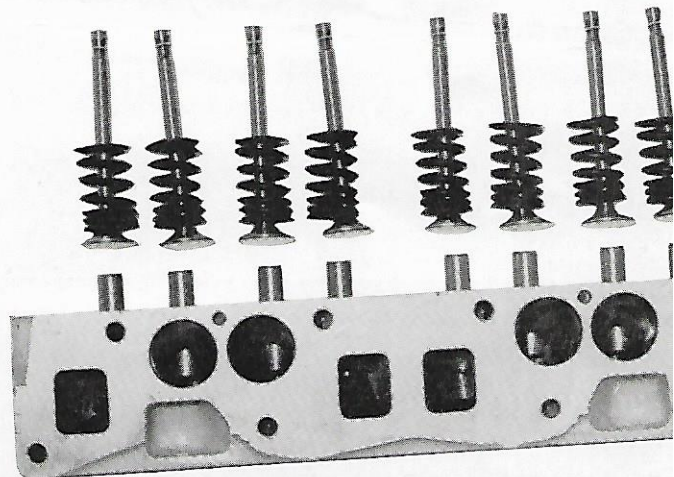
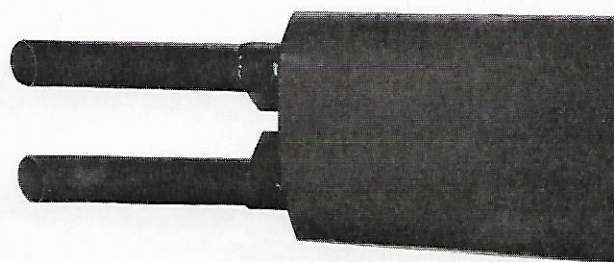
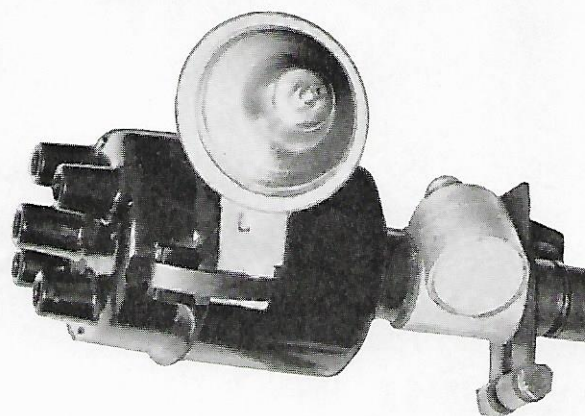
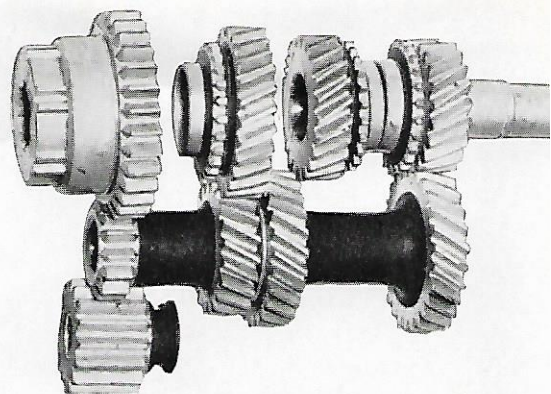
Whilst the full list of Stage Two parts is shown overleaf, the major changes for conversion comprise, 2 DCOE Weber Carburettors with special manifolds; 4 port cylinder head (10.5 to 1 compression ratio); stronger crankshaft, connecting rods and pistons; competition valves and valve springs; "racing" camshaft; special distributor; diaphragm clutch; special close ratio gears; 4 branch extractor type exhaust manifold; twin tail pipe silencer.

The following performance figures were attained by the "Motor" during a road test in April 1964.

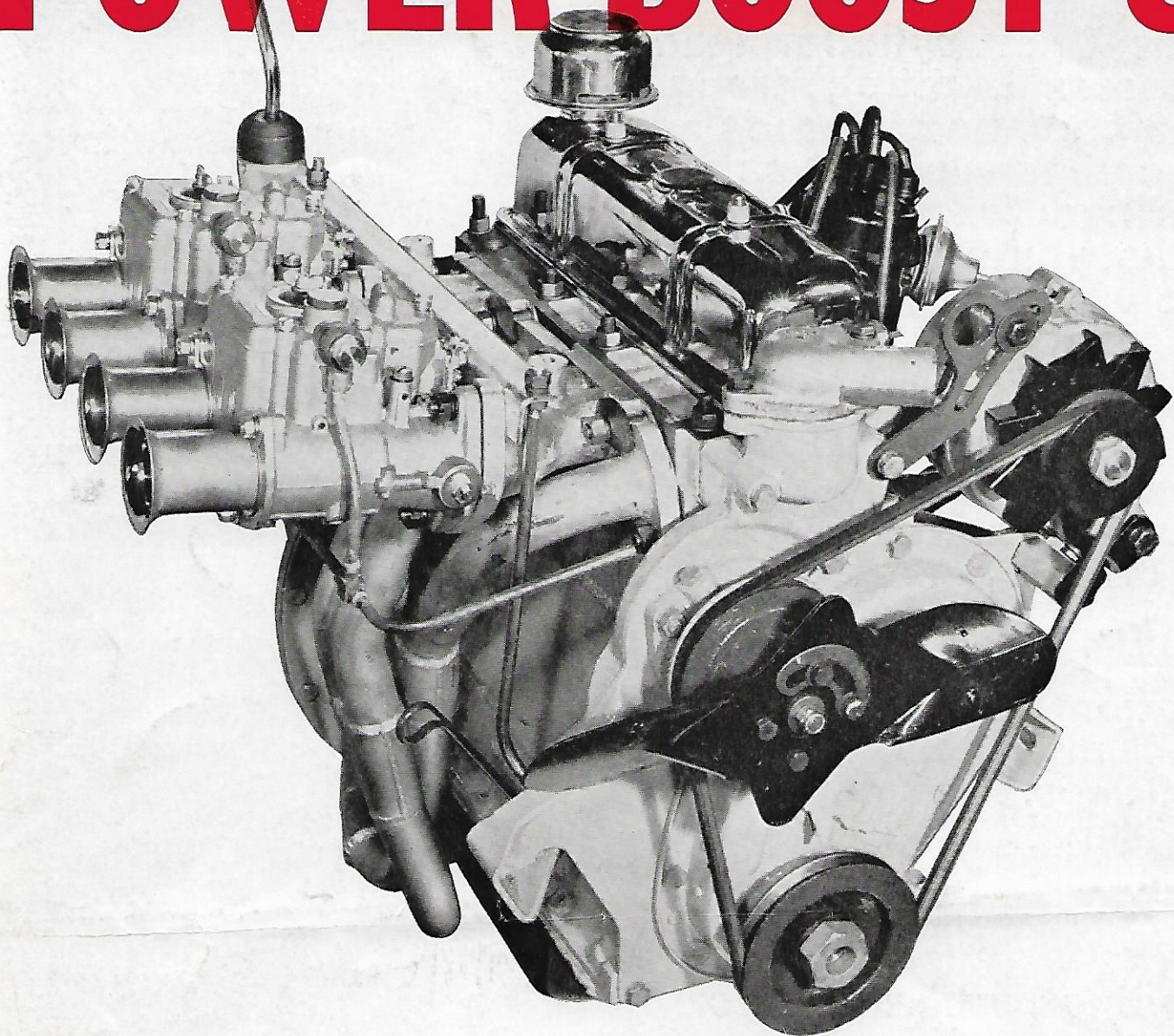
Acceleration: 0-30 m.p.h. 3.7 secs. 0-40 m.p.h. 5.5 secs. 0-50 m.p.h. 7.9 secs. 0-60 m.p.h. 10.3 secs. 0-70 m.p.h. 14.1 secs. 0-80 m.p.h. 18.9 secs. 0-90 m.p.h. 27.2 secs.

The standing $\frac{1}{4}$ mile 18.0 secs.
Maximum speed 106 m.p.h.

As well as the Stage Two (standard) conversion mentioned, which develops approximately 90 B.H.P., there is available an "interim" stage of tuning which produces approximately 70 B.H.P. and consists of modified manifolds, Solex compound carburettor and compression ratio raised to 9.75:1. Further details and prices of Stage Two interim conversion or individual requirements are available through your local Standard-Triumph Dealer, or from S.A.H. direct.



POWER BOOST UP



THE FULL LIST OF PARTS FOR THE STAGE TWO (STANDARD) CONVERSION COMPRISES:-

Qty.	Part No.	Description
ENGINE		
1	513964	Cylinder Head, 10.5 to 1 Ratio
4	131179	Valve, Exhaust
4	136487	Spring, Valve
4	126893	Valve, Inlet
8	140562	Spring, Valve—Outer
1	207930	Gasket, Cylinder Head
2	129677	Stud, Cylinder Head attachment
1	306716	Manifold, Exhaust
1	139242	Gasket, Exhaust Manifold
1	211039	Inlet Manifold—Front
1	211040	Inlet Manifold—Rear
8	141605	Stud, Carbs. to Manifold
1	141602	Steady Plate
4	WL0208	Washer } Steady plate to Manifold
4	HN2008	Nut }
1	141603	Steady Rod—Front
1	141604	Steady Rod—Rear
4	JN2108	Nut, $\frac{3}{8}$ " UNF. Steady Rod attachment
2	137845	Clamp } Manifold attachment
6	WL0209	Washer }
6	100498	Nut, $\frac{3}{8}$ " UNF.—Manifold attachment
1	306947	Carburettor—Front \ Weber Type
1	306948	Carburettor—Rear / (40 DCOE 2)
1	140734	Throttle Lever Assembly
4	139718	'O' Ring
8	WD0158	Washer } Carbs. to
8	LN2208	Nut, $\frac{3}{8}$ " UNF. slotted } Manifold
8	PC0008	Pin, Cotter
1	140935	Lever Assembly, ACC. Operating
1	140936	Throttle Rod, adjustable
1	139760	Spring } "HI-LIFT"
1	139873	Ident Plate } Fuel Pump

Qty.	Part No.	Description
ENGINE—cont.		
1	140697	Petrol Pipe Assembly
1	140575	Breather Pipe Assembly
1	140580	Extension—Breather
1	211461	Distributor Assembly
1	141675	Flywheel Assembly
2	DP0410	Dowel
1	212037	Clutch Cover Assembly
1	139665	Driven Plate
1	211030	Camshaft
8	141686	Stud (Drilled)—Carburettor Att'ment
1	142685	Angle Bracket
2	129677	Stud, $\frac{3}{8}$ " UNFX 1.63", Cyl. Head Att.
1	611524	Badge, "S2", Trunk Lid
4	610623	Clip—Badge Attachment
1	131530	Water Rail
1	306549	Crankshaft
6	140111	Main Bearing Shells
2	141207	Thrust Washer
4	139267	Piston Assembly (Selected F, G or H)
4	138549	Connecting Rod Assembly
8	138211	Bearing Shells—Connecting Rod
8	138438	Tappet
1	137809	Rocker Shaft
1	137642	Rocker Pedestal, No. 1
1	137643	Rocker Pedestal, No. 4
2	128424	Rocker Pedestal, Nos. 2 and 3
4	104834	Rocker, No. 1
4	104836	Rocker, No. 2
2	137811	Plug—Rocker Shaft
2	PC0010	Pin—Cotter
1	27378	Core Plug
1	211635	Rev. Counter (8,000 r.p.m.)

Qty.	Part No.	Description
GEARBOX		
1	138502	Cover, Front End, Gearbox
1	DP0205	Dowel
1	141758	Oil Seal
1	132293	Reverse Idler Gear Assembly
1	119889	Countershaft
1	208788	Gear Cluster, Countershaft
3	119891	Retaining Ring
1	119892	Retaining Ring
50	119893	Needle Rollers
1	132446	1st and 2nd Gear & Sleeve Assem
1	132296	2nd Gear
1	132097	3rd Gear
1	104466	Washer—3rd Speed Gear
1	211000	Shaft, Constant Pinion
1	118507	Bearing—Needle Roller
1	129839	Circlip, Constant Pinion Shaft
1	139563	Sleeve, Ball Throwout
1	139572	Ball Bearing
EXHAUST		
1	211922	Exhaust Pipe—Intermediate
2	55801	Clip, Pipe to Manifold
1	212070	Silencer
1	138807	Clip, Silencer to Pipe
2	HB0820	Bolt
1	HB0822	Bolt
3	WP0107	Washer
3	WL0208	Washer