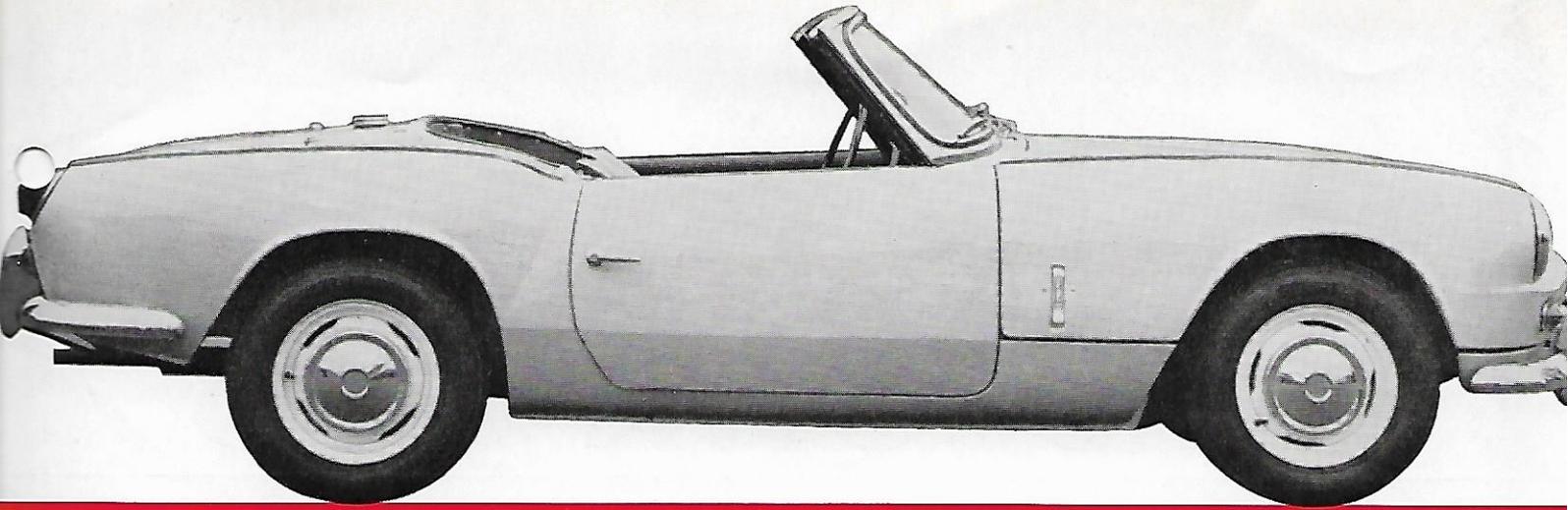




“STAGE TWO”
CONVERSION
ON YOUR
TRIUMPH
SPITFIRE 4
SPORTS CAR

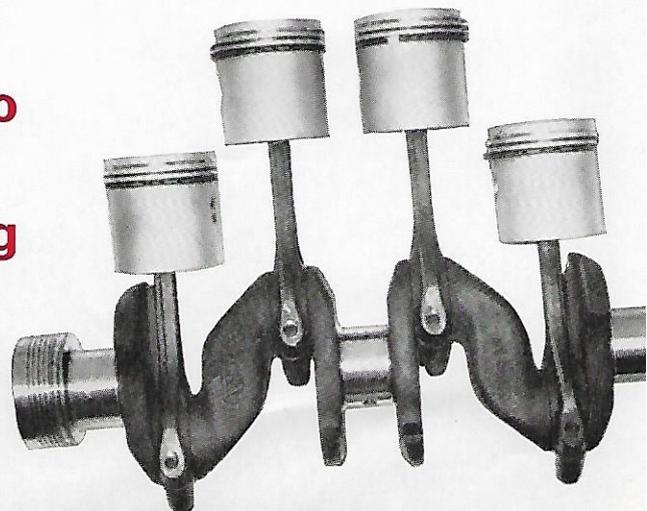
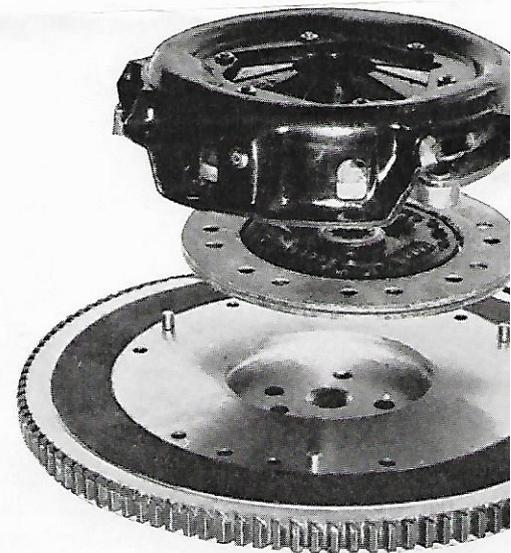
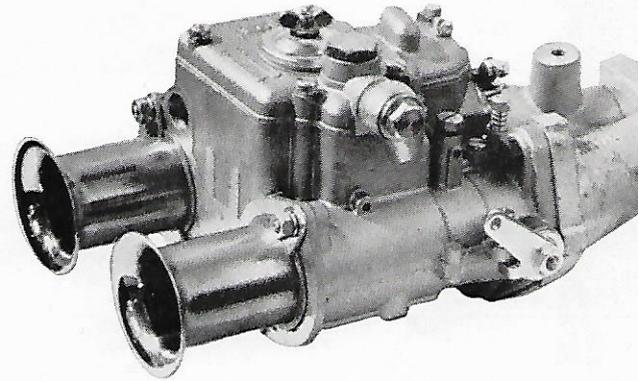
J.A.H. (ACCESSORIES) LTD., LEIGHTON BUZZARD, BEDS., PHONE 3022 & 2556
SOLE U.K. DISTRIBUTORS FOR TRIUMPH APPROVED PERFORMANCE KITS.



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.**



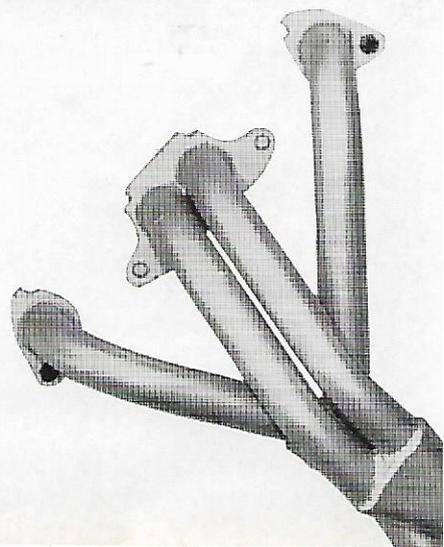
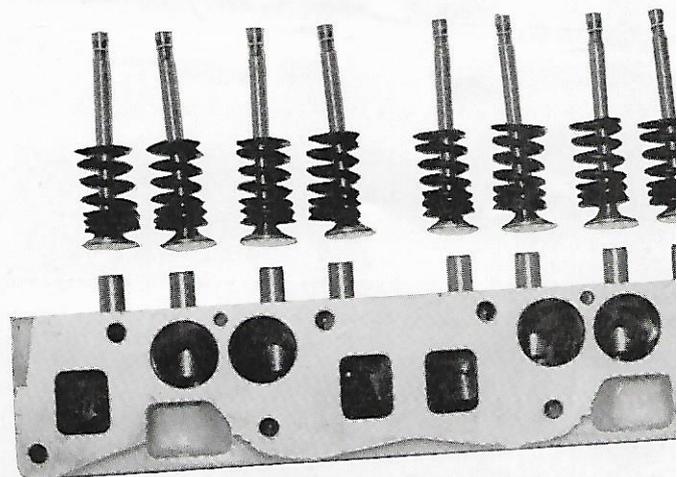
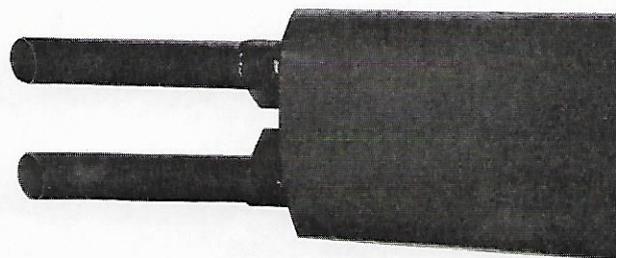
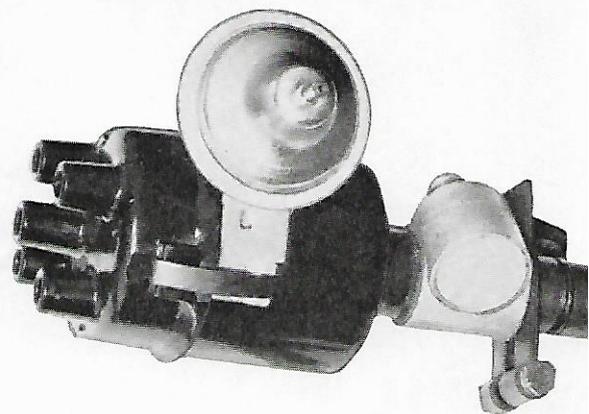
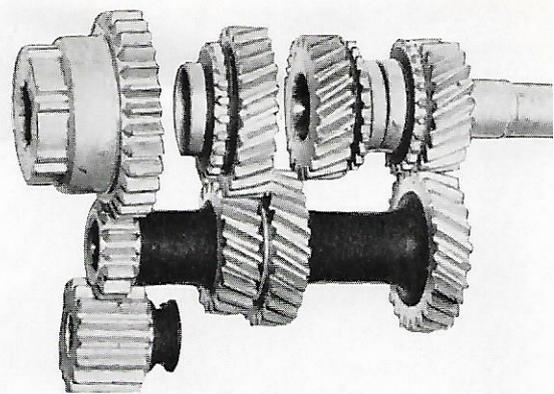
Whilst the full list of Stage Two parts is shown overleaf, the major changes for conversion comprise, 2 DCOE Weber Carburettors with special manifolds; 4 port cylinder head (10.5 to 1 compression ratio); stronger crankshaft, connecting rods and pistons; competition valves and valve springs; "racing" 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.

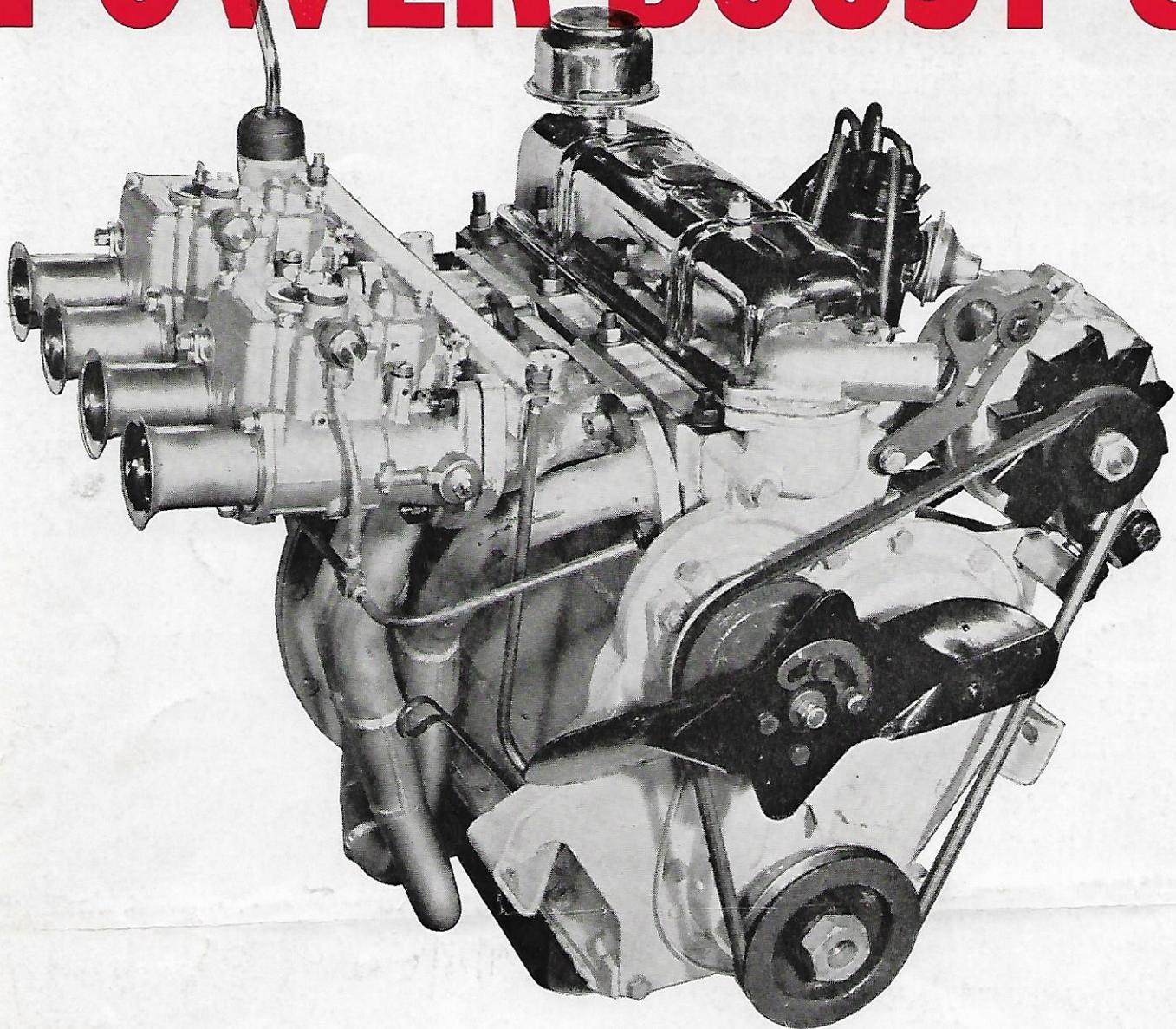
Acceleration: 0-30 m.p.h. 3.7 secs. 0-40 m.p.h. 5.5 secs. 0-50 m.p.h. 7.9 secs. 0-60 m.p.h. 10.3 secs. 0-70 m.p.h. 14.1 secs. 0-80 m.p.h. 18.9 secs. 0-90 m.p.h. 27.2 secs.

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	Qty.	Part No.	Description	Qty.	Part No.	Description
ENGINE			ENGINE—cont.			GEARBOX		
1	513964	Cylinder Head, 10.5 to 1 Ratio	1	140697	Petrol Pipe Assembly	1	138502	Cover, Front End, Gearbox
4	131179	Valve, Exhaust	1	140575	Breather Pipe Assembly	1	DP0205	Dowel
4	136487	Spring, Valve	1	140580	Extension—Breather	1	141758	Oil Seal
4	126893	Valve, Inlet	1	211461	Distributor Assembly	1	132293	Reverse Idler Gear Assembly
8	140562	Spring, Valve—Outer	1	141675	Flywheel Assembly	1	119889	Countershaft
1	207930	Gasket, Cylinder Head	2	DP0410	Dowel	1	208788	Gear Cluster, Countershaft
2	129677	Stud, Cylinder Head attachment	1	212037	Clutch Cover Assembly	3	119891	Retaining Ring
1	306716	Manifold, Exhaust	1	139665	Driven Plate	1	119892	Retaining Ring
1	139242	Gasket, Exhaust Manifold	1	211030	Camshaft	1	119893	Needle Rollers
1	211039	Inlet Manifold—Front	8	141686	Stud (Drilled)—Carburettor Att'ment	1	132446	1st and 2nd Gear & Sleeve Assem
1	211040	Inlet Manifold—Rear	1	142685	Angle Bracket	1	132296	2nd Gear
8	141605	Stud, Carbs. to Manifold	2	129677	Stud, 3/8" UNFX 1.63", Cyl. Head Att.	1	132097	3rd Gear
1	141602	Steady Plate	1	611524	Badge, "S2", Trunk Lid	1	104466	Washer—3rd Speed Gear
4	WL0208	Washer } Steady plate to Manifold	4	610623	Clip—Badge Attachment	1	211000	Shaft, Constant Pinion
4	HN2008	Nut } Steady plate to Manifold	1	131530	Water Rail	1	118507	Bearing—Needle Roller
1	141603	Steady Rod—Front	1	306549	Crankshaft	1	129839	Circlip, Constant Pinion Shaft
1	141604	Steady Rod—Rear	6	140111	Main Bearing Shells	1	139563	Sleeve, Ball Throwout
4	JN2108	Nut, 3/8" UNF. Steady Rod attachment	2	141207	Thrust Washer	1	139572	Ball Bearing
2	137845	Clamp } Manifold attachment	4	139267	Piston Assembly (Selected F, G or H)			
6	WL0209	Washer } Manifold attachment	4	138549	Connecting Rod Assembly			
6	100498	Nut, 3/8" UNF.—Manifold attachment	8	138211	Bearing Shells—Connecting Rod			
1	306947	Carburettor—Front \ Weber Type	8	138438	Tappet			
1	306948	Carburettor—Rear \ (40 DCOE 2)	1	137809	Rocker Shaft			
1	140734	Throttle Lever Assembly	1	137642	Rocker Pedestal, No. 1			
4	139718	'O' Ring	1	137643	Rocker Pedestal, No. 4			
8	WD0158	Washer } Carbs. to	2	128424	Rocker Pedestal, Nos. 2 and 3			
8	LN2208	Nut, 3/8" UNF. slotted } Manifold	4	104834	Rocker, No. 1			
8	PC0008	Pin, Cotter } Manifold	4	104836	Rocker, No. 2			
1	140935	Lever Assembly, ACC. Operating	2	137811	Plug—Rocker Shaft			
1	140936	Throttle Rod, adjustable	2	PC0010	Pin—Cotter			
1	139760	Spring } "HI-LIFT"	1	27378	Core Plug			
1	139873	Ident Plate } Fuel Pump	1	211635	Rev. Counter (8,000 r.p.m.)			
						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