

Fill only the cylinder and head jackets with water and start the pump. The water pump is best left disconnected from the cylinders for the present.
Run the engine slowly until the water in the cylinders begins to boil and then stop the engine and go over all the cylinder head nuts, tightening any that require it. Let the water in the pump to the cylinder cooling and when the water has cooled down fill the radiator to the correct level.



FIG. 13. REMOVAL OF FRAME FROM ENGINE AND TRANSMISSION UNIT

REMOVAL OF FRAME FROM POWER AND TRANSMISSION UNIT. (Figs. 13, 14, & 15).

In order to do any work on internal parts of the engine, starter mechanism, clutch or gearbox the main frame must be removed from the unit leaving the assembly for attention.

The manner in which this is done differs slightly from that employed on earlier models and is easier and quicker than before, as there is no necessity to take the front fork and wheel assembly out of the steering head. The unit can in fact be free for any work to be done to it in from fifteen to twenty minutes by one man with occasional assistance. Proceed as follows:—

Drain out the water through the cylinder head drain holes. Detach the hot pipe at the carburettor, unscrew the mixing chamber top and pull out the choke valve.

Remove the battery and, working under the edge of the frame, unscrew the speedometer for cable drive from the housing in the gearbox front cover and pull the drive cleat. Unhook the clutch cable nipple from the transmission in the handlebar lever. This is made easier by removing the lower pivot pin first. Pull the clutch cable assembly down into the frame and let it hang clear.

FIG. 14. REMOVAL OF BOLT FROM FRAME UNDER THE PLATE
(Always to check that clear)

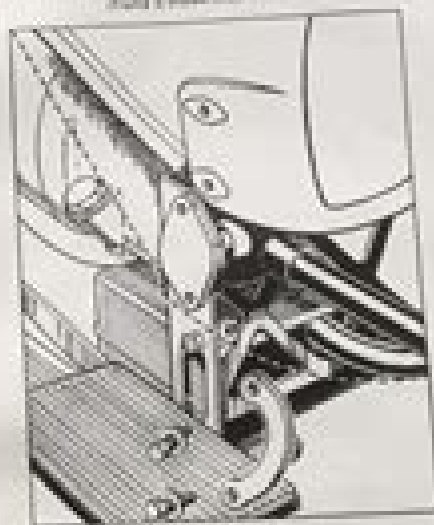
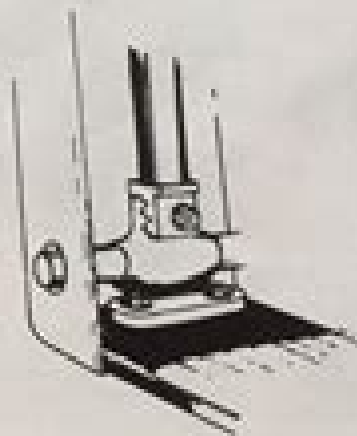


FIG. 15. BOTTOM END OF TUBULAR FRAME ASSEMBLY



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A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the Causey Enterprises, LLC text.

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Velocette Singles Owners Workshop Manual Jeff Clew, 1975-01-01 WALNECK'S CLASSIC CYCLE TRADER, NOVEMBER 1988 Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, ISSUE #33** Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, ISSUE #32** Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, FEBRUARY 1988** Causey Enterprises, LLC, WALNECK'S CLASSIC CYCLE TRADER, JANUARY 1988 Causey Enterprises, LLC, WALNECK'S CLASSIC CYCLE TRADER, MARCH 1988 Causey Enterprises, LLC, SERVICE AND MAINTENANCE MANUAL VELOCETTE MOTORCYCLES UP TO 1962 FERRERS. LEIGH, 2009 *Velocette - Mov - Mac - Mss 1933-1952 Rigid Frame Workshop Manual & Illustrated Parts Manual* Floyd Clymer, Velocepress, 2023-04-13 196 pages and more than 83 illustrations and charts size 8 25 x 10 75 inches This publication is a reproduction of two original Velocette Factory Manuals the October 1955 service manual part number F50 7R and the March 1958 illustrated parts manual part number F132 11R The parts manual is invaluable as it details changes in construction by engine number and or model year The original 118 page factory service manual covers the 1933 1952 range of 250cc 350cc and 500cc rigid frame models and both the Iron Cylinder Head and Aluminum Head machines It includes the 1933 1948 MOV and the 1935 1948 MSS with Webb Girder Forks and the 1934 1952 MAC The MAC models covered are the 1934 1948 with Webb Girder Forks the 1948 1950 with Dowty Oleomatic Forks and the 1951 1952 models with Veloce Telescopic Forks In addition a reproduction of the factory Service and Maintenance manual for Dowty forks is included The original 68 page illustrated parts manual covers both the MOV and MAC models listed above It also includes diagrams and parts listings for the Webb Dowty and Velocette forks The 350cc MAC is possibly the most popular Velocette model ever built It evolved from the 250cc MOV by lengthening the stroke of the MOV crankshaft from 68 25 to 96 mm From 1933 1939 the MAC was constructed with a rigid frame fitted with Webb girder forks From 1940 1941 a version of the MAC was the basis for the company's World War II military motorcycles The Military models were MDD and MAF Factory Dispatch Records state 1320 were produced In 1946 after the war MAC civilian production restarted and in 1948 the MAC's Webb girder forks were replaced with innovative air sprung oil dampened Dowty Oleomatic forks In 1951 the Dowty forks were replaced by Veloce telescopic forks with coil springs and oil damping In June of that same year the engine was upgraded to an aluminum barrel and head with wider fins to improve cooling For 1953 the MAC was updated with fully adjustable rear swinging arm suspension and a tube frame Production of the rigid frame MAC ended in 1952 swing arm production ended in 1960 Based on the factory part numbers there were approximately 20 service and parts manuals published during the 20 year production run of the rigid frame machines However the print quality of the later factory manuals was not the best as the same pages or sections from earlier publications were re printed multiple times as the newer manuals were published Unfortunately this created problems in print quality and print density in those later manuals resulting in both light and heavy print on the same page While we have

done our best to correct as many of those imperfections as possible there are some occurrences that just could not be corrected Therefore we request your indulgence in tolerating any variations that still exist and accept that the intention in reproducing these manuals was to provide the reader with information that would assist in the renovation and maintenance of these classic Velocette motorcycles *WALNECK'S CLASSIC CYCLE TRADER, OCTOBER 1985* Causey Enterprises, LLC, ClassicCycle Trader Causey Enterprises, LLC, *VELOCETTE MAC 350cc SPRING FRAME 1953-1960 WORKSHOP MANUAL AND ILLUSTRATED PARTS LIST* Floyd Clymer, 2024-09-25 128 pages with 56 illustrations and diagrams size 8 25 x 10 75 inches This manual is a compilation of two Velocette factory publications for the 1953 through 1960 MAC 350cc Spring Frame model It includes 1 a reproduction of the original January 1960 factory Service Manual part number F 469 3R 2M and 2 a reproduction of the original May 1953 illustrated Spare Parts List part number F 473 The total number of pages in this manual is 128 However both the Service Manual and the illustrated Parts List have their own individual index and page numbers Consequently the Parts List begins immediately after page 88 of the Service Manual We encourage you to exercise caution when purchasing technical publications for your Velocette as many of the reprints found on internet websites are from bedroom sellers at enticingly low prices by individuals that really have no idea what they are selling Many are nothing more than poor quality comb bound photocopies that are scanned and printed complete with greasy pages and thumbprints and as such are deceptively described as pre owned used or even refurbished In addition they are often advertised for the incorrect series and or model years However VelocePress com has been publishing reprints of motorcycle and automobile manuals since 2003 and our publications have earned excellent reviews worldwide so you can be assured you are purchasing a quality product *WALNECK'S CLASSIC CYCLE TRADER, APRIL 1998* Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, SEPTEMBER 2003** Dominion Enterprises, All Rights Reserved, WALNECK'S CLASSIC CYCLE TRADER, OCTOBER 2004 Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, MAY 2001** Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, MARCH 1999** Causey Enterprises, LLC, **WALNECK'S CLASSIC CYCLE TRADER, MARCH 2003** Causey Enterprises, LLC, *WALNECK'S CLASSIC CYCLE TRADER, MAY 1985* Causey Enterprises, LLC, WALNECK'S CLASSIC CYCLE TRADER, OCTOBER 2009 Causey Enterprises, LLC,

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