



BSA

SPEED & SPORTS PARTS



from **BSA** Incorporated Service Dept.

Speed Bulletin #2

April 17, 1964

HOW TO IMPROVE C15-S ENGINE PERFORMANCE

The engine performance can be improved on 1960-61-62 C15 Starfires by installing oversize valves, racing valve springs, alloy valve collars, induction spacer and oversize carburetor as listed below:

<u>QUANTITY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>LIST PRICE</u>
1	389/8	1-1/8" Monobloc Carb.	\$ 34.50 A
1	66-9251	Spacer - 1-3/4" Carb. to Cyl. Head	3.60 A
2	40-622	Studs	ea. .12 A
2	2-49	Nuts	ea. .06 A
2	24-8784	Washers	ea. .03 A
3	65-1417	Gaskets	ea. .02 A
1	65-1419	Fiber Spacer	.48 A
1	68-156	Inlet Valve - Oversize	4.32 A
1	68-157	Exhaust Valve - Oversize	6.12 A
2 pr.	B-613	Racing Valve Springs	ea. 2.55 B
2	67-1349	Alloy Valve Collars	ea. 1.92 A
2 pr.	65-1848	Valve Collar Keepers	ea. 1.92 A

It will be necessary to modify the cylinder head as follows:

1. Increase the inside diameter of the inlet valve port to 1-3/8".
2. Increase the intake port at the carb. mounting flange to 1-1/8" straight through maximum.
3. Increase the inside diameter of the exhaust valve port to 1-3/16".
4. Blend in the diameters and streamline the inlet and exhaust ports with a burring tool.
5. Polish both ports and the combustion chamber to a mirror finish.
6. Bore out and polish the induction spacer to match up with cylinder head and carburetor.
7. The inlet valve seat should be 1/16" wide and the exhaust 3/32" wide.
8. Grind the valves in with fine grinding compound.
9. Shim the valve springs to a height of 1-5/16".
10. Cut away the pockets in the pistons to provide clearance for the larger valves.

Walter Brown
Walter Brown
Service Manager

PRICES SHOWN ARE SUBJECT TO CHANGE WITHOUT NOTICE

~~Speed~~ Bulletin amends Speed Bulletin #2 dated March 5, 1963.

