

STUART

1½ B.H.P. MARINE ENGINES

(Types R3M, R3MC)

SPARE PARTS

When ordering spares ALWAYS quote the full Engine Number as well as the Spares Part Number and description.

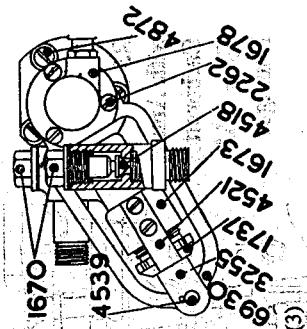
FAIRWAYS MARINE ENGINEERS
BATH PLACE WHARF, DOWNS ROAD,
MALDON, ESSEX CM9 7HU
Tel: (0621) 52866

Parts which are different in the two types of engine are marked "MC" (centrifugal clutch model), or "M" (reverse gear model)

Part No.	Description
40274	Cylinder
30228	Cylinder Head M
1777	Cylinder Head MC
4321	Cylinder Head Pipe Union (solderless)
4189 each	Cylinder Head Nuts (4)
11872F each	Cylinder Jacket Plug, M (1), MC (2)
9615	Cylinder Jacket Plug, with tapped hole M (1)
4523 each	Cylinder Jacket Disc (2)
2988	Cylinder Drain Plug and Washer
1659	Exhaust Outlet
03532 each	Exhaust Outlet Studs (2)
1760	Exhaust Cover
4321	Exhaust Cover Union
4189 each	Exhaust Cover Nuts (2)
251	Expansion Chamber Cover
4189 each	Expansion Chamber Nuts (4)
00363 each	Expansion Chamber Studs (4)
2990	Expansion Chamber Drain Plug and Washer
20531B	Piston, complete
20531/10	Piston, complete -010in. o/s
20531/20	Piston, complete -020in. o/s
20531/30	Piston, complete -0-030in. o/s
4687 or 11607 each	Piston Rings (2), see para 30
4501	Piston Pin
4502 each	Piston Pin Clips (2)
21927	Connecting Rod with Bush fitted
4503	Connecting Rod Top Bush
15520	Needle bearing
15518	Inner Race
15519	Crankpin
4506 each	Crankpin Nuts (2)
15521	Crankpin/Connecting rod assembly
20516	Crankshaft, Flywheel end
4611	Crankshaft, Driving End MC
20527	Crankshaft, Driving End M

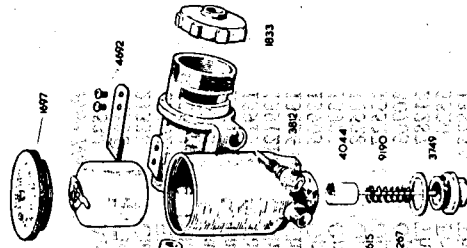
(Send Crankshaft with Connecting Rod to us for renewal of Crankshaft parts)

CIRCULATING PUMP



- Part No. 1673 Pump Body
- 1672 Pump Body Screws (3)
- 4872 Shaft
- 4516 Gear Wheel on Pump Shaft
- 00800 Gear Wheel Nut and Spring Washer
- 54030 Gear Wheel Key
- 6930 Banjo Link
- 7144 Banjo Link Bush
- 00093 Banjo Ball Bearing
- 2345 Banjo Ball Bearing Inner Washer
- 2346 Banjo Ball Bearing Screw
- 1678 Banjo Ball Bearing Grease Cap
- 2262 Banjo Ball Bearing Grease Cap Screws (3)
- 3255 Plunger
- 4539 Plunger Pin with Split Pins
- 1737 Gland Nut
- 4254/12 Gland Clipping and Screws
- 4521 Valves (2)
- 4518 Valves Caps (2)
- 1670 Water Pipe with Union Nuts (to Engine)
- 4647

STUART CARBURETTOR

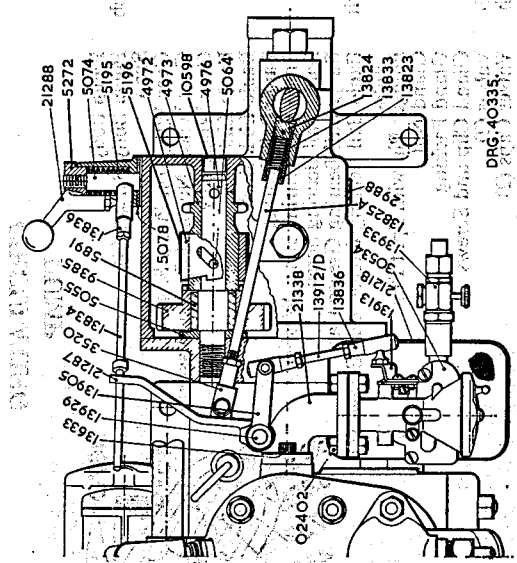


- 1679 Carburettor Body (no longer available)
- 4530 Throttle (no longer available)
- 4692 Air Cap Clip and Screws
- 2716 Float (no longer available)
- 1697 Float Chamber Cover
- 3812 Float Needle
- 3749 Jet (give the number stamped on jet)
- 2994 Filter Chamber
- 4044 Filter Gauze
- 9902 Filter Gauze Holder
- 9190 Filter Spring
- 3267 Filter Fibre Joint
- 4546 Throttle Collar and Screw MC
- 5080 Throttle Adjusting Collar M
- 5084 Throttle Adjusting Collar Spindle M
- 5108 Throttle Adjusting Collar Locknut M
- 3989 Throttle Adjusting Collar Spindle Collar M
- 4547 Throttle Adjusting Collar Spindle Spring M
- 1849 Throttle Operating Die
- 4802 Throttle Lever MC
- 4663 Throttle Lever Handle and Locknut MC
- 4800A Throttle Lever Friction Disc MC
- 4805 Throttle Lever Pillar and Pin MC
- 20553 Throttle Lever Pillar Spring MC
- 4800A Throttle Lever M
- 5077 Throttle Lever Pillar and Pin M
- 9691 Throttle Lever Pillar Spring M
- 32300 Drip Tray
- 32300 Drip Tray Drain Plug and Washer

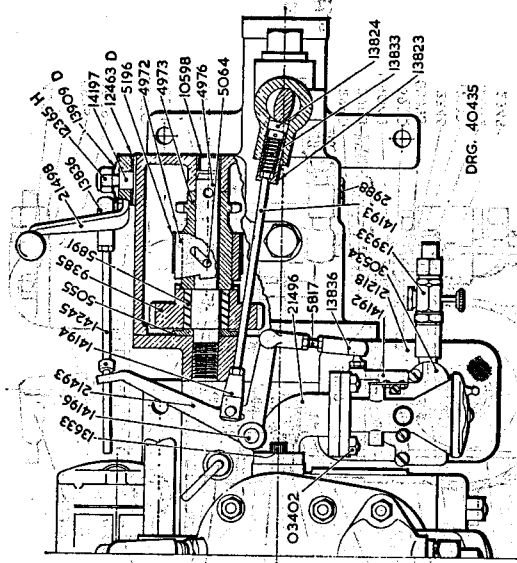


- Part No. 00106 each Ball Bearings (2)
- 00105 Ball Bearings MC
- 00097 Ball Bearings M
- 15053 each Compression Oil Seal (2)
- 15023B Compression Sleeve, driving end
- 15023D Compression Sleeve, flywheel end
- 4513 each Crankshaft Nut M (1), MC (2)
- 4515 Spiral Gear on Crankshaft
- 54080 Spiral Gear Key
- 4549A Crankshaft Sleeve M
- 3223 Sprocket (Magneto Drive)
- 11574 Sprocket Distance Washer
- 4703 Sprocket Dowel
- 11950 Washer (thin, thick)
- 12583B Oil Thrower, drive end MC
- 12583D Oil Thrower, flywheel end MC
- 4522A Oil Thrower M
- 20515 Flywheel
- 54080 Flywheel Key
- 8763 Flywheel Nut
- 40008A Crankcase, complete
- 4524 set Crankcase Cylinder Studs (4)
- 03514A set Crankcase Studs and Nuts (3), Sockets Screw (1)
- 2988 Crankcase Gauze Plugs (2)
- 2988 Crankcase Drain Plug (in the foot)
- 21115 Chaincase Filler and Oil Level Plugs
- 4540 Drive End Cover MC
- 02401 Drive End Dipstick MC
- 02400 each Drive End Drain Plug and Washer MC
- 7195 Oil Seal MC
- 13264 Crankshaft Sleeve, Long MC
- 11770 Crankshaft Sleeve, Short MC
- A1835HZ Magneto
- 2999 Magneto H.T. Lead
- 10608 Spark Plug
- 12317 B Spark Plug Cover and Suppressor
- 7364 each Magneto Fixing Set-screws (3)
- 11659 Magneto Chain
- 30206 Magneto Chaincase Cover
- 11605 Magneto Chaincase Cover Disc
- 02400 each Magneto Chaincase Cover Set-screws (7)
- 9761 Magneto Chaincase Cover Oil Seal
- 2568A Magneto Sprocket and Nut
- 13410 Felt Washer
- 00156 Coil H.T.
- 00174 Contact Set
- 00162 Condenser
- 00190 Cover - Distributor
- 00189 Cover - Coil
- 00376 Terminal Screw Cap
- 00378 Terminal H.T. Lead
- 002653 Exchange Magneto
- 00169 Contact Set
- 00161 Condenser
- 00187 Cover - Distributor

Wipac Magneto Spares
Exchange Wipac Magneto
Lucas SR Magneto Spares



**R3 M
with Amal
Carburettor
Type 'A'
Linkage**

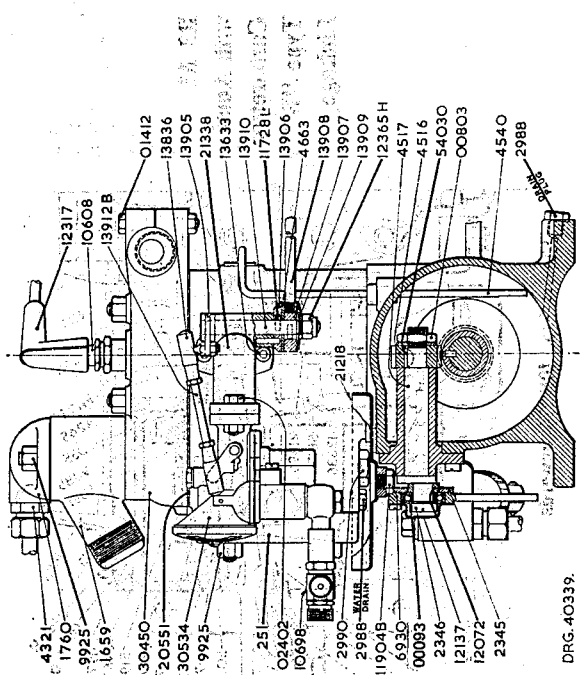


**R3 M
with Amal
Carburettor
Type 'B'
Linkage**

Engine No. 40R976 upwards

- Part No.**
- 30534 Amal Carburettor, 396 (no longer available)
 - 14136 Float Chamber Joint (no longer available)
 - 21338 Carburettor Elbow
 - 03402 each Elbow Screw and Nut (2)
 - 13633 each Elbow Socket Screw (2)
 - 13933 Carburettor Petrol Tap and Banjo
 - 21218 Carburettor Drip Tray
 - 13913 Throttle Arm
 - 13912D Throttle Link Rod Ball Joint (2)
 - 13836 each Operating Lever
 - 13905 Operating Lever Spindle and Pin
 - 13929 Operating Lever Spindle Spring
 - 13527 Operating Lever Spindle Nut
 - 30703 Operating Lever Spindle Locknut
 - 21287 Throttle Lever
 - 3520 Fork End and Pin
 - 13825A Throttle Tappet Rod and Collar
 - 13823 Throttle Tappet
 - 13833 Throttle Tappet Spring
 - 13824 Throttle Tappet Plug and Pin
 - 13834 Throttle Hand Control Rod and Collar
 - 13836 Throttle Hand Control Ball Joint
 - 21288 Throttle Hand Lever
 - 5272 Throttle Hand Lever Sleeve Nut
 - 5074 Throttle Hand Lever Spindle
 - 5195 Throttle Hand Lever Spring
 - 5078 Throttle Hand Lever Friction Disc

- Part No.**
- 30534 Amal Carburettor, 396 (no longer available)
 - 14136 Float Chamber Joint (no longer available)
 - 21496 Carburettor Elbow
 - 13633 each Elbow Socket Screw (2)
 - 02400 each Carburettor Fixing Screw (2)
 - 13933 Carburettor Petrol Tap and Banjo
 - 21218 Carburettor Drip Tray
 - 14192A Throttle Arm
 - 13836 each Ball Joint (2)
 - 5817 Throttle Link Rod Ball Joint (2)
 - 14196 Throttle Lever Spindle
 - 21493 Throttle Control Crank
 - 5291 Spring
 - 21498 Throttle Hand Lever
 - 14197 Throttle Lever Spindle
 - 12463D Friction Disc
 - 13909D Friction Disc Spring
 - 12365H Spindle Nut, Self-Locking
 - 11728Q Stop Pin
 - 14245A Hand Control Rod with Collar
 - 14193A Rod, Auto Control, with Nuts
 - 13824 Tappet, Auto Control
 - 13833 Spring
 - 14194A Fork End with Pin



**R3 MC
with Amal
Carburettor**

DRG. 40339.

- Part No.
 - 30534 Amal Carburettor, 396 (no longer available)
 - 14136 Float Chamber Joint (no longer available)
 - 21338 Carburettor Elbow
 - 02402 each Elbow Screw and Nut (2)
 - 13633 each Elbow Socket Screw (2)
 - 13912B Throttle Link Rod
 - 13836 each Throttle Link Rod Ball Joint (2)
 - 13905 Operating Lever
 - 13910 Operating Lever Spindle
 - 11728L each Operating Lever Spindle Dowel (2)
 - 13906 Friction Plate
 - 14663 Throttle Disc
 - 13908 Throttle Hand Lever
 - 13907 Throttle Hand Lever Boss
 - 13909 Operating Lever Spindle Cone Washer
 - 12365H Operating Lever Spindle Cone Washer Nut
 - 10698A Carburettor Petrol Tap and Banjo
 - 21218 Drip Tray
 - 11904B Drip Tray Drain Plug
- PATENT CENTRIFUGAL CLUTCH—MC**
- 21114 Body
 - 21878 Body (for engines 46R312 upwards)
 - 11770 Body Collar
 - 54080 Body Key
 - 13078 each Driving Pins (3)
 - 21036 each Shoe (3)
 - 4526 each Shoe Springs (3)
 - 4529 each Shoe Springs Pins (6)
 - 30293F Drum, complete with lining (no longer available)*
 - 30758 Drum, complete with lining (for engines 46R312 upwards)
 - 9616 Drum Lining and Rivets (8)
 - 00900 Drum Nut
 - 00094 Drum Ball Bearing
 - 00105 Drum Ball Bearing Retaining Washer
 - 13252 Drum Coupling Studs and Nuts (3)
 - 03504 each Drum Coupling Studs and Nuts (3)
- * To replace Drum 30293F, parts 21878, 00105 & Thrust Washer 15387 are required in addition to 30758

- Part No.
- 15387 Thrust Collar and Screws
- 2271 Coupling Flexible Disc
- 1252 Coupling Propeller Shaft
- 9301 Coupling Propeller Shaft Grub Screw
- 4253 Coupling Greaser
- 02504 each Coupling Bolts and Washer (3)

REVERSE GEAR—M

- 117/119 Gear Box with centre Bearing Case
- 2990 Gear Box Oil Filler Plug
- 2988 Gear Box Drain Plug
- 00095 Gear Box Ball Bearing
- 9383 Front Wheel 16T
- 9479 Front Wheel Nut
- 9384 Rear Wheel 18T
- 00700 Rear Wheel Nut
- 54080 each Keys (2) for Ball Bearing
- 4976 Idler Shaft
- 5055 Idler Shaft Washer $\frac{1}{16}$ in. bore
- 4973 Idler Sprocket
- 9385 Idler Wheel, 38T
- 4972 Starting Claw
- 5064 Starting Claw Pin
- 5196 Starting Claw Brake
- 5197 Starting Claw Brake Screw
- 4942 Clutch Shaft
- 00803 Clutch Shaft Nut
- 00104 Clutch Shaft Front Ball Bearing
- 00098 . each Clutch Shaft Rear Ball Bearing (2)
- 5051 Clutch Shaft Distance Tube between Ball Races
- 5054 Clutch Shaft Washer, $\frac{1}{16}$ in. bore
- 5055 Clutch Shaft Washer, $\frac{1}{16}$ in. bore
- 5053 each Clutch Shaft Washer, $\frac{1}{16}$ in. bore (2)
- 4703 each Clutch Shaft Washer Driving Pins (2)
- 9381 Clutch Cone and Front Wheel, 24T
- 9382 Clutch Cone and Rear Wheel, 27T
- 9389F each Spiral-Roller Bearings (3)
- 9477 Clutch with Thrust Race
- 125 Clutch Retaining Segment
- 5594 each Clutch Retaining Segment Screws (2)
- 5050 Operating Sleeve
- 3492 set Operating Sleeve Springs (12)
- 10589 Operating Sleeve Inner Washer (1 notch)
- 10590 Operating Sleeve Outer Washer (2 notches)
- 5085H Operating Sleeve Locating Screw
- 7196 Oil Seal
- 213 Coupling (on engine)
- 5201 Coupling Key
- 10670 Coupling Centre Screw
- 9311 Coupling Copper Seating Washer
- 5109 Coupling Centre Screw Washer
- 212 Coupling on Propeller Shaft
- 9872 each Coupling Screws (3)
- 9301 each Coupling Grub Screws (2)
- 13545 Control Column Extension
- 6084 Control Column Cover
- 21178 Control Shaft
- 5065 Control Shaft Stop Screw
- 9677 Control Shaft Lock Body
- 9678 Control Shaft Lock Tappet
- 9679 Control Shaft Lock Tappet
- 6394A Control Handle, complete
- 5288 Control Handle Ball Bearing
- 5289 Control Handle Ball Screw

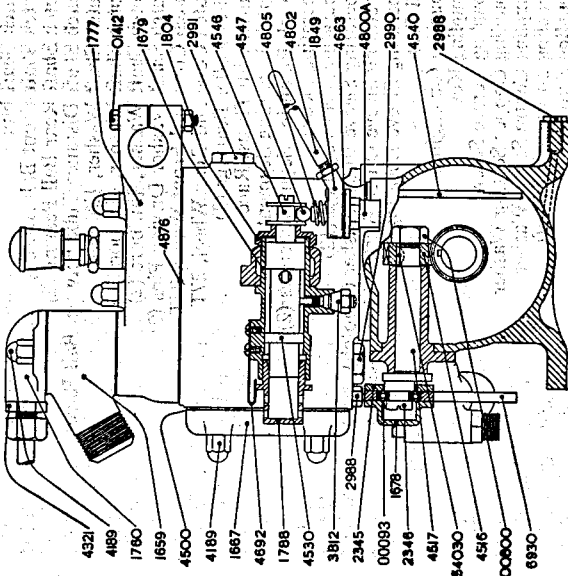
Part No.

- 1955 Throttle Hand Lever
- 5195 Throttle Hand Lever Spring
- 5272 Throttle Hand Lever Retaining Nut
- 5074 Throttle Hand Lever Spindle
- 5840 Throttle Hand Lever Ball Joint
- 5078 Throttle Hand Lever Friction Disc
- 11642 Throttle Rod
- 5067 Tappet Rod (Automatic Control)
- 5068 Tappet Rod Spring
- 5265

OVERHEAD STARTING GEAR—MC

Engines, No. 30000 to 36700 and 38400 upwards. Having the starting gear on the cylinder head—not on the cylinder

- 20983D Handle
- 13222 Shaft (diam. $\frac{1}{2}$ in.)
- 13223 Shaft Tube with Bushes fitted
- 01412 each Shaft Tube Fixing Bolt and Nut (2)
- 13225 Shaft Collar and Pin
- 4198 Chain, 55 Links
- 5591 Chain Coupling Link
- 13956 Chain Wheel
- 4640A Lower Sprocket
- 13269 Lower Sprocket Retaining Ring
- 13268 each Pawls (2)
- 14393 each Pawl Springs (2)
- 14392 each Pawl Pillars (2)



OVERHEAD STARTING GEAR—M

- 9032 Handle
- 5079 Shaft
- 1989 Shaft Bearing on Cylinder
- 5047 Shaft Sprocket
- 5593 Chain
- 5592 Chain Coupling-Link
- 1888A Chain Case
- 01408 each Chain Case Clamping Bolts and Nuts (3)

OVERHEAD STARTING GEAR—MC

With starting shaft supported by the cylinder and a bracket on the crankcase, as on R3M Engines, Nos. 36701 to 38399

- Part No.
- 9032 Handle
- 20548 Shaft (diam. $\frac{1}{2}$ in.)
- 1989 Shaft Bearing on Cylinder
- 4123 Shaft Collar and Pin
- 11623 Shaft Eccentric Bearing (no longer available)
- 20549 Bracket (no longer available)
- 11639 Chain (50 links)
- 5591 Chain Coupling Link
- 11624A Chain Wheel
- 4640 Lower Sprocket
- 4807 Lower Sprocket Retaining Ring
- 3541 each Pawls (2)
- 13420 each Pawl Springs (2)
- 4642 each Pawl Pillars (2)

STERN GEAR

- 4668 Propeller Nut and Split Pin
- 3835 Inboard Bearing Lock Nut
- 9789 Inboard Bearing Gland Nut
- 12589B Inboard Bearing Ring
- 15055/15 Inboard Bearing Packing
- 3927 Inboard Bearing Greaser
- 7163 Outboard Bearing Rubber Liner only
- 7576 each Bearing Screws (4)

For Propellers, Shaft, Stern Tubes, Seacocks, Tanks—See Publication 265

SPECIAL TOOLS FOR COMPLETE OVERHAUL:—

- 8858 Complete Kit, comprising:—
- 7791 Pliers, for removing Circlips (see para 30)
- 6863A Crankpin Extractor with Bolt, 2 $\frac{1}{2}$ in. long
- 8654 Extractor Sleeve, $\frac{1}{2}$ in. long MC
- 9617 Extractor Sleeve, 4 in. long M
- 4918 Crankpin Assembly Nut
- 6871A Tool for removing and fitting Piston Pin and Small End Bush



- 20758 Petrol Funnel with waterproof gauze filter
- 7409 Oil Measure
- 00285 Stuart Green Enamel-Tin (approx. 125 ml.)

INSTALLATION EQUIPMENT

Part No.	
8362	Exhaust Silencer, 12in. x 4in.
4165	Exhaust 1in. Pipe to Silencer (2ft. 6in.) with Nuts
1495 each	Exhaust 1in. Pipe Union Nuts (2)
5571	Exhaust 3/4in. Tail Pipe (2ft. 6in.), with Nuts
5572 each	Exhaust 3/4in. Tail Pipe Union Nuts (2)
5573	Exhaust Skinfitting Washer
5574	Exhaust Skinfitting Locknut
30273	Seacock and Strainer with Scoop
11787	Seacock Strainer only, length 2 1/2in.
11874	Seacock Cap only
11793	Seacock Scoop only
4319 each	Seacock Pipe Union Nuts (2)
4320 each	Seacock Pipe Olive, only (2)
14992D	Water Outlet Pipe
4040	Water Outlet Skinfitting Washer
4052	Water Outlet Skinfitting Locknut
20595	Blige Pumping Strainer
12659	Hose
12342D each	Hose Clips (2)
10819	Hose Union on Seacock
00288	Petrol Pipe 5/16" o/dia. Per ft.
5384	Petrol Tank, 1-gall., 15in. x 6 1/2in. x 3 1/2in.
4783	Petrol Tank Filler Cap and Chain
00203	Tap and Filter (complete)
2988	Tank Drain Plug
10698	Tap on Carburettor (Stuart)
20892	Engine Tray MC
30393	Engine Tray M
4171	Ignition Switch
4894	Ignition Switch Wire (4ft.)
7574 each	Coach Screw, 2 1/2in. (3MC, 5M) (no longer available)
11672	Coach Screw, 1 1/2in. (no longer available)

JOINTS

5575	Complete Set M	
4893	Complete Set MC	
Cylinder Head (20551),	Cylinder Base (4875),	Expansion Chamber (4877),
Exhaust Outlet, bottom (4 holes) (4825),	Exhaust Outlet, top (2 holes) (7001),	Central Bearing
Crankcase (4878),	Magneto Chaincase Cover (11584),	Starting Chaincase Base
Case to Gearbox (M) (9496),	Pump Body (4879),	Elbow Amal Carburettor
(M) (5083),	Filter Chamber (Stuart Carburettor (3267),	Filter Chamber (Stuart Carburettor Type
(13638),	Amal Carburettor (13911),	72) (15328),

TOOLS

All bolts are B.S.F. Standard. The heads take Whitworth Standard Spanners of one size smaller. That is 1/8in. B.S.F. and 1/4in. Whitworth are the same

Supplied with Engine:

Part No.	
2280	Spanner, 1/2in. x 5/8in. B.S.F.
2284	Spanner, 3/4in. x 1 1/8in. B.S.F.
9343	Grub Screw Key
13953	Water Pump Valve Cap Spanner