

## Making a clip for Lucas MDB1 mag-dyno on a 1928 Triumph NSD.

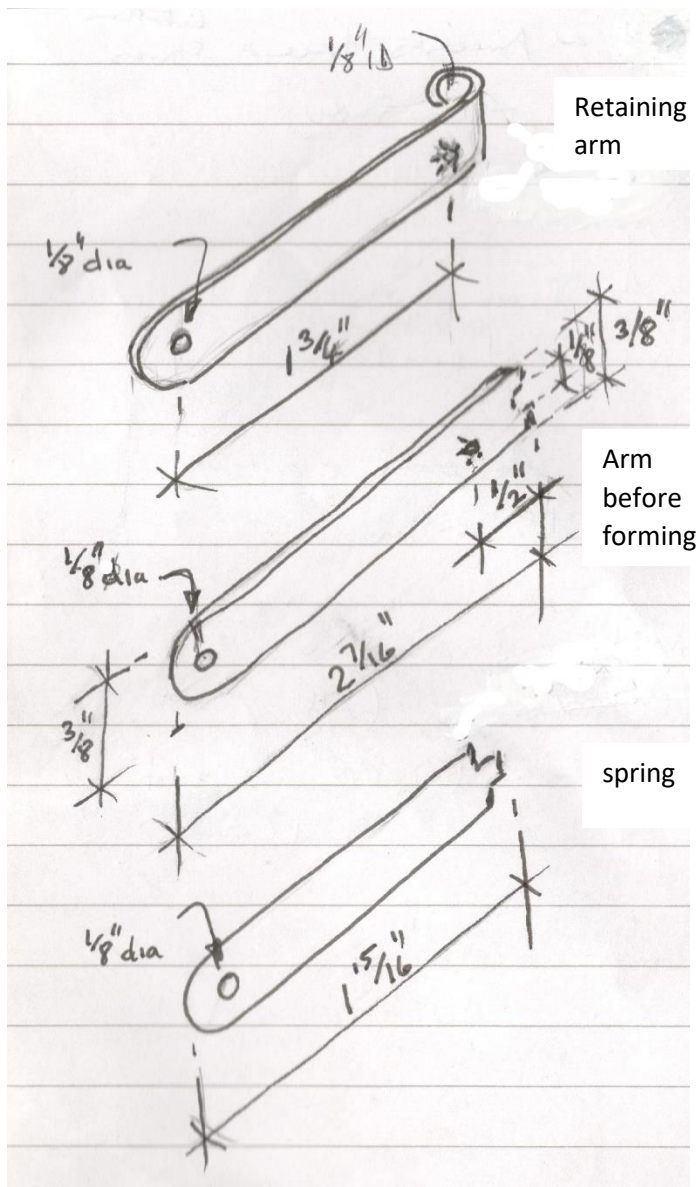
You cannot always find these old parts and it can be interesting to make your own. I made this clip for the point cover using mostly reclaimed materials.



This is the clip fitted to the bike. The spring arm is too short and the stub on the spring arm fails to reach the dimple in the centre of the cover.

The thread on the peg is 2BA, as is the hexagon.

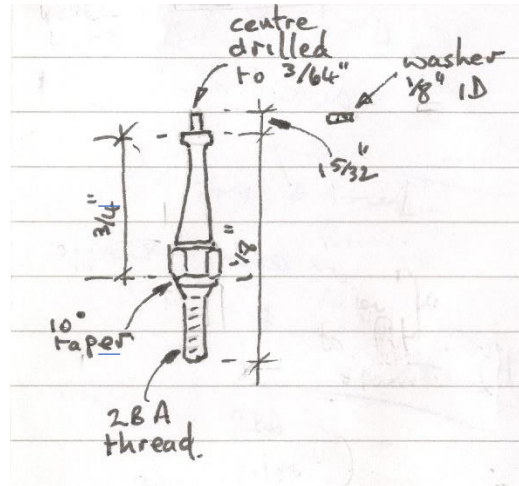
A 2BA nut is 0.324" across flats (8.23mm). The thread is 3/16" OD.



For the retaining arm, I cut a piece from a sheet of 1mm (approximately 20 gauge) thick mild steel. I shaped and drilled it, copying the original but making this one 1 3/4" between the centre of the peg and the stub that locates in the centre of the magneto points cover. I used a centre punch ground to a spherical end to form the stub.

For the spring, I cannibalised an old bow saw blade. This is high carbon steel with the teeth hardened but the back of the blade is quite workable so I could cut and file it to size after grinding off the teeth. After shaping and drilling, I put a set in it so it would be loaded against the cover when in place, then polished and hardened it by heating to cherry red (700 to 800C) and quenching in engine oil. This was followed by re-polishing and tempering by heating to dark blue (300C) and allowing to cool slowly between a couple of refractory bricks.

I felt 8mm was close enough to the 2BA nut (8.23mm), especially if I want to have it plated. I used an old 8mm Allen key which I annealed to make it machinable. I did this by heating to dull red and allowing it to cool between a couple of refractory bricks. I machined this on my Myford lathe, copying the original item. I left enough material (at 1/8" dia.) on the spring end of the peg to allow it to be peened to secure the spring. To aid this, I used a centre drill to drill a depth of 3/64".



The finished clip in place. It fits nicely with a nice, positive feel when the stub engages with the dimple in the points cover.

