

**BAYERISCHE MOTOREN WERKE**  
AKTIENGESELLSCHAFT

Rundschreiben der Abteilung

Kundendienst und Teile

- Limousine BMW 600 - Group "General Hints" No. 17/59 (71)
- Motocoupé BMW Isetta - Group "General Hints" No. 12/59 (142)
- BMW Motor-cycles - Group "General Hints" No. 12/59 (166)

Munich, November 19th, 1959  
KV2F ke/gr/ha

With the issuing of this service bulletin the following are canceled:

- Limousine BMW 600 - Group "General Hints" No. 15/59
- Motocoupé BMW Isetta - Group "General Hints" No. 10/59
- BMW Motor-cycles - Group "General Hints" No. 10/59

**Subject:** New spring container cups ( top ), valve cottens and valve guides on cylinderhead R26, R50, R60, R69, Motocoupé Isetta and BMW 600.

For the above mentioned models we have adopted new valve cotters, upper spring retainer cups and valve guides as standard equipment.

The innovation will concern the following models:

Limousine BMW 600	From chassis No. 145 924
Motocoupé BMW Isetta 250 ccm	From chassis No. 453 630
Motocoupé BMW Isetta 300 ccm	From chassis No. 585 009
Motocoupé BMW Isetta Three wheel	From chassis No. 604 061
BMW Motor-cycle R26	From chassis No. 364 872
BMW Motor-cycle R50	From chassis No. 560 556
BMW Motor-cycle R60	From chassis No. 620 181

For all above mentioned models the following parts will be necessary:

Per cylinderhead:

- Two pairs of valve locks Ordering No. 00 26 824 ←
- Two spring retainer cups Ordering No. 00 26 832 ←

In addition the following for the models Limousine BMW 600 and Isetta:

- One Valve guide (inlet) Ordering No. 00 21 804 ←  
(normal)
- or size 0.1 mm Ordering No. 00 21 806 ←
- 0.2 mm Ordering No. 00 21 807 ←
- 0.3 mm Ordering No. 00 21 808 ←

Also:

- One valve guide (exhaust) Ordering No. 00 21 814  
(normal)
- or size 0.1 mm Ordering No. 00 21 816
- 0.2 mm Ordering No. 00 21 817
- 0.3 mm Ordering No. 00 21 818

Limousine BMW 600 - Group "General Hints" No. 17/59 (71)  
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For the motor-cycles (except R69) there is only one Valve Guide, which is the same for inlet and exhaust; Ordering No. 00 21 804, with additional sizes as already given for Valve Guide (inlet).

Whenever adjusting valves attention should be given to the valve stem upper edges, which must exceed the valve cotters (2 parts). If this is not the case the spring retainer cup and the valve cotter pair must be replaced.

Valve Guide bushings found to be excessively worn must also be replaced on this occasion.

Whenever replacing the mentioned parts make absolutely certain that either parts of the old pattern only or those of the new type only are installed throughout the same engine.

Whenever it becomes necessary to remove old valve guide bushings, it is advisable to proceed as follows:

Grind the valve guide bushings with a spot facer down to the retainer ring. Remove the retainer ring, heat the cylinderhead to 356° F. and remove the valve guide bushings inwards by driving or pressing it with a suitable arbour out of the cylinderhead. Coat outside of new valve guide bushing with talcum, mount the retainer ring and install the valve guide bushing from outside inwards into the heated cylinder.

In case the valve guide bushing of the old pattern are not replaced because they are not worn as yet beyond the specified limits, they must under all circumstances be approx. two mm (0.08") be shortened from 15.9 to 0.4 mm as per sketch, when installing valves and valve retainer cups of the new type. To grind down or to shorten the valve guide bushing best use the

Spot facer ( Senker ) AV 1 - 14 mm  $\emptyset$   
Normal holder with cyl. shank 8 mm  $\emptyset$  H 1  
Sliding pilot pin 669 mm  $\emptyset$  GZ 1

of the firm

Firma  
Hermann B i l z  
Zell - Esslingen a.N.

The Valve guide bushings are available with three different oversize outer diameters.

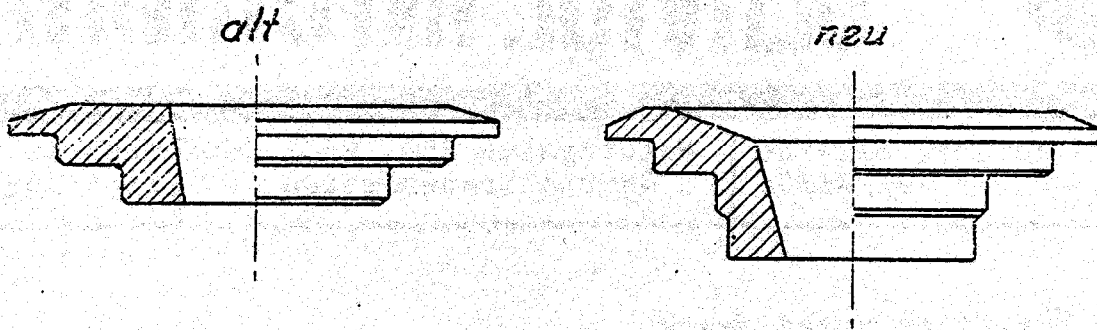
The existing stock of valve locks, spring retainer cups and valve guide bushings of the old pattern may be used up.

1 enclosure

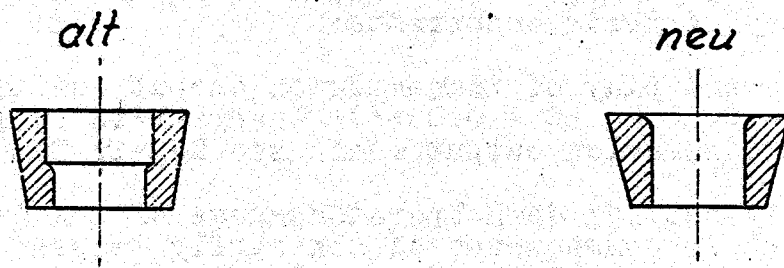
BAYERISCHE MOTOREN WERKE  
Aktiengesellschaft



Federteller  
(Maßst. 2:1)



Keilkegel  
(Maßst. 2:1)



Ventilführung  
(M 1:1)

Einlaß - BMW600  
Einlaß - Isetta  
sowie  
Einlaß u. Auslaß - Motorrad

Auslaß - BMW600  
Auslaß - Isetta

