



BAYERISCHE MOTOREN WERKE
AKTIENGESELLSCHAFT

Rundschreiben der Abteilung Kundendienst

Motorcycles: Group Engine No. 4/62 (198) e.

Munich, February 26, 1963.

KV-2 er/ha/wi/za

Re: Various innovations on single cylinder and twin cylinder engines

as of

<u>Frame No.</u>	<u>Type</u>	<u>Modification</u>								
378 760	R 27	<p>on cylinder head cover enlarged contact surface of flange surrounding the eyelet. This eliminates the possibility of installing the cover incorrectly and of serious oil leaks resulting therefrom.</p> <p>The part number has not been changed.</p>								
378 474	R 27	<p>The second piston ring groove of the piston now features a "minute" ring (with outer face sloped by one minute) instead of the nose ring. The new rings show a lesser tendency to burned spots.</p> <p>Part numbers:</p> <table border="0"> <tr> <td>Minute ring, normal</td> <td>00 14 577</td> </tr> <tr> <td>Minute ring + 0,5 mm.</td> <td>00 14 578</td> </tr> <tr> <td>Minute ring + 1.0 mm.</td> <td></td> </tr> </table>	Minute ring, normal	00 14 577	Minute ring + 0,5 mm.	00 14 578	Minute ring + 1.0 mm.			
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378 895	R 27	<p>In order to prolong the service life of the timing chain, the engine has been provided with a chain tightener (chain stretching device).</p> <p>This chain tightener may be installed subsequently, also on the R 26 engine. After installation of a chain tightener it is necessary to check the chain locking spring for correct position (closed end facing the forward direction).</p> <p>Part numbers:</p> <table border="0"> <tr> <td>1 chain tightener</td> <td>00 32 110</td> </tr> <tr> <td>1 leaf spring</td> <td>00 32 535</td> </tr> <tr> <td>1 spacing washer</td> <td>00 32 608</td> </tr> <tr> <td>1 retaining screws</td> <td>00 32 538</td> </tr> </table> <p>Clutch disc (00 70 700) now with slotted facings. <u>Reason:</u> The preceding non-slotted facings tear down on the slots of the steel segment. Use clutch discs with non-slotted facings for models R 24, R 25/1 and R 25/2. The part number has not been changed.</p>	1 chain tightener	00 32 110	1 leaf spring	00 32 535	1 spacing washer	00 32 608	1 retaining screws	00 32 538
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<u>as of</u> <u>Frame No.</u>	<u>Type</u>	<u>Modification</u>
632 890	R 50	The spur gears (timing gears on crankshaft and camshaft and the oil pump driving gear) now feature a new toothing with modified pressure and helix angles. This ensures an utmost silent operation. Part numbers of the spur gears with the new tooth: Gear set for crankshaft and camshaft 00 16 253 Gear, oil pump drive 00 52 155 Gear sets with the "old" toothing are not more available. Thus, when replacing timing gear sets on motorcycles with frame Nos. up to the indicated ones, it is also necessary to exchange the gear for the oil pump drive.
565 051	R 50 S	
623 481	R 60	
656 271	R 69 S	
632 890	R 50	New carburetor bodies! Reason: Simplification because thus only two different castings are required.
as of the next series	R 50 S	
624 079	R 60	Part numbers for carburetor bodies R 50 + R 60: Carburetor body, left 00 39 250 Carburetor body, right 00 39 251 For R 50 S and R 69 S: Carburetor body, left 00 39 252 Carburetor body, right 00 39 253
656 529	R 69 S	
Part Nos. of the complete carburetors:		
<u>R 50</u>		
Carburetor, complete, right		00 39 018
Carburetor, complete, left		00 39 019
<u>R 50 S</u>		
Carburetor, complete, right		00 39 020
Carburetor, complete, left		00 39 021
<u>R 60</u>		
Carburetor, complete, right		00 39 022
Carburetor, complete, left		00 39 023
<u>R 69 S</u>		
Carburetor, complete, right		00 39 016
Carburetor, complete, left		00 39 017

Yours very truly,
 BAYERISCHE MOTOREN WERKE
 Aktiengesellschaft
Herbstreit *Makowitzki*
 ppa. Herbstreit i.V. Makowitzki