

# Service-Information

Group 36 Wheels and Tires	August 1983	Bulletin No.: 36 019 83 (2084)
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- For U.S.A. and Canada Only -

RE: PAINT CRACKS ON THE SEAM OF BMW COMPOSITE WHEELS  
R65LS

Dear Dealer:

In the composite cast wheel process of the R65LS, the spoke and hub section is made of an aluminum alloy which is injected into a rim made of a highly resistant and flexible aluminum extrusion design. The composite cast wheel seam looks like two ball joints from a cross section view. With this process of securing the spoke to the rim, the strength of the joint is also increased. (Re: Dealer Bulletin, Vol. II, No. 26.)

Because no intermetallic bond exists between both sections of the wheel, movement in the seam area is possible during operation. This may cause the paint surface to crack. Then, due to the seams movement, water may seep into the micro-crevice and come out during riding, from the centrifugal forces. Oxidation products and dirt will mix in the water making it blackish in color.

To remedy the cosmetic appearance caused by the cracking paint, we offer the following adhesive strips in rolls to be used to cover the seam:

Part No.	51 14 2 302 295	Silver
	51 14 2 302 296	White
	51 14 2 302 297	Reflecting White

One roll contains 10 meters of adhesive strip, which is sufficient for two motorcycles.

To install, use the following directions:

In cases where a large area of paint is cracking, first paint the wheel.

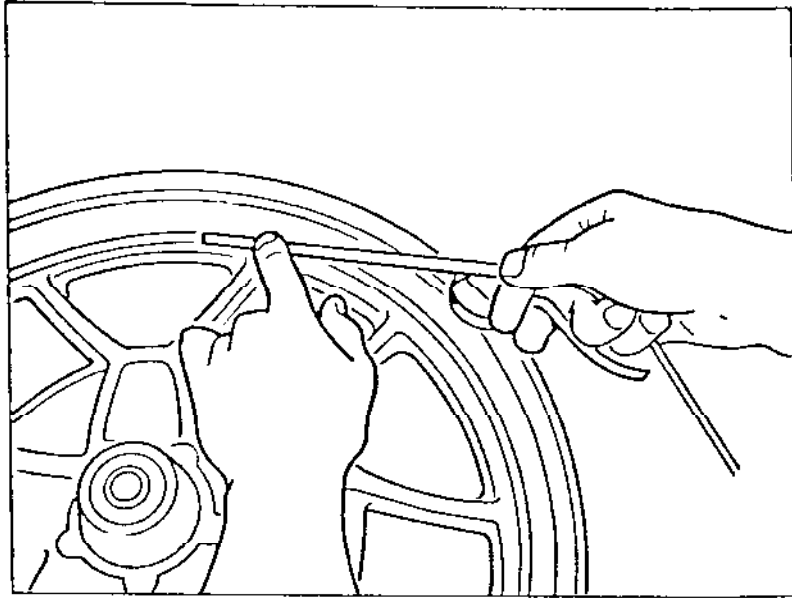
Carefully clean the seam area of dirt and grease.

Strip approximately 10 cm of adhesive protection and press the beginning of the roll in the center over the seam.

Please route and initial before filing.

Service Manager	Parts Manager	Service Writer	Technicians				

Carefully guide the adhesive strip along the seam, while stripping the adhesive protection. At the same time with your hand, press the strip exactly over the casting seam. Maintain a uniform distance to the inside edge of the rim.



Cut off a short piece from the start of the roll (because your fingers touched the adhesive it will not hold).

Allow the end of the roll to overlap about 1 cm before cutting off.

Press once again the adhesive strip especially hard on the edge to make sure that moisture or dirt will not undermine the strip.

The full adhesive effect will set in after 24 hours - until then use no cleansers.

If needed, paint can be ordered under the following part numbers:

Silver	51 91 1 240 868	spray
	51 91 1 240 867	250 ml can
White	51 91 1 876 666	spray
	51 91 1 876 649	250 ml can

Installation of adhesive strips for motorcycles which are under warranty, please claim under defect code 33 31 06 68 00 for 6 FR for each wheel.

If painting is required, you must claim actual (WT) work time.

Sincerely,

BMW OF NORTH AMERICA, INC.



Richard Dampf  
National Technical Manager

RD/cs