



BAYERISCHE MOTOREN WERKE
AKTIENGESELLSCHAFT

Rundschreiben der Kundendienst-Abteilung

Circular-Letter of the Service Department
Motorcycles: Engine Group No. M1e/53

Munich, 8/6/53
KVE Ba/Wi/eb

Subject: R 67/2 Pistons and Piston Rings

Dear Sirs,

As of engine No. 613 675, the R 67/2 motorcycles have new pistons 267 2 03 610 23, the 3 cornered high-tension compression rings 267 2 03 014 04/14 with a width of 3.2 mm instead of the former 2.9 mm value.

These cornered high-tension compression rings must on no account be fitted on the R 67 pistons, part No. 267 1 03 610 33/43 nor on the R 67/2 pistons, part No. 267 2 03 610 03, pertaining to machines supplied before and on engine No. 613 674, for owing to the shallow piston ring grooves they would jam on the cylinder wall.

It has happened in some cases that a cornered high-tension compression ring fitted in the piston top groove fluttered (producing noise in this way) therefore the piston rings on machines supplied as of engine No. 614 041 are fitted as follows:

Top groove	compression ring	268 1 03 014 04/14
2nd and 3rd groove	cornered high-tension compression ring	267 2 03 014 04/14
4th and 5th groove	scraper ring	267 2 03 015 04/14.

In case a piston noise becomes audible on an engine as of No. 613 675 to 614 040, which might be due to a fluttering cornered top ring, we also recommend to replace the cornered top ring by a compression ring 268 1 03 014 04/14.

When replacing piston rings, all of them should be fitted with the stamped-in mark "Top" on the upper side.

Very truly yours,

BAYERISCHE MOTOREN WERKE
Aktiengesellschaft