



BAYERISCHE MOTOREN WERKE
AKTIENGESELLSCHAFT

Rundschreiben der Kundendienst-Abteilung
Circular-Letter of the Service Department
Motorcycles: Gear Box Group No. 1/54

Munich, 20/10/54
KVK Ba/Wi/Se

Dear Sirs,

Subject: Removal of layshaft coupling flange on R 25/3,
R 51/3, R 67/2 and R 68. Sealing the hub of
coupling flange on 25/3.

In case of a gear box leaking on the layshaft coupling flang fit a new

felt ring retaining cup 224 1 31 010 04 with
felt washer 224 1 31 011 04

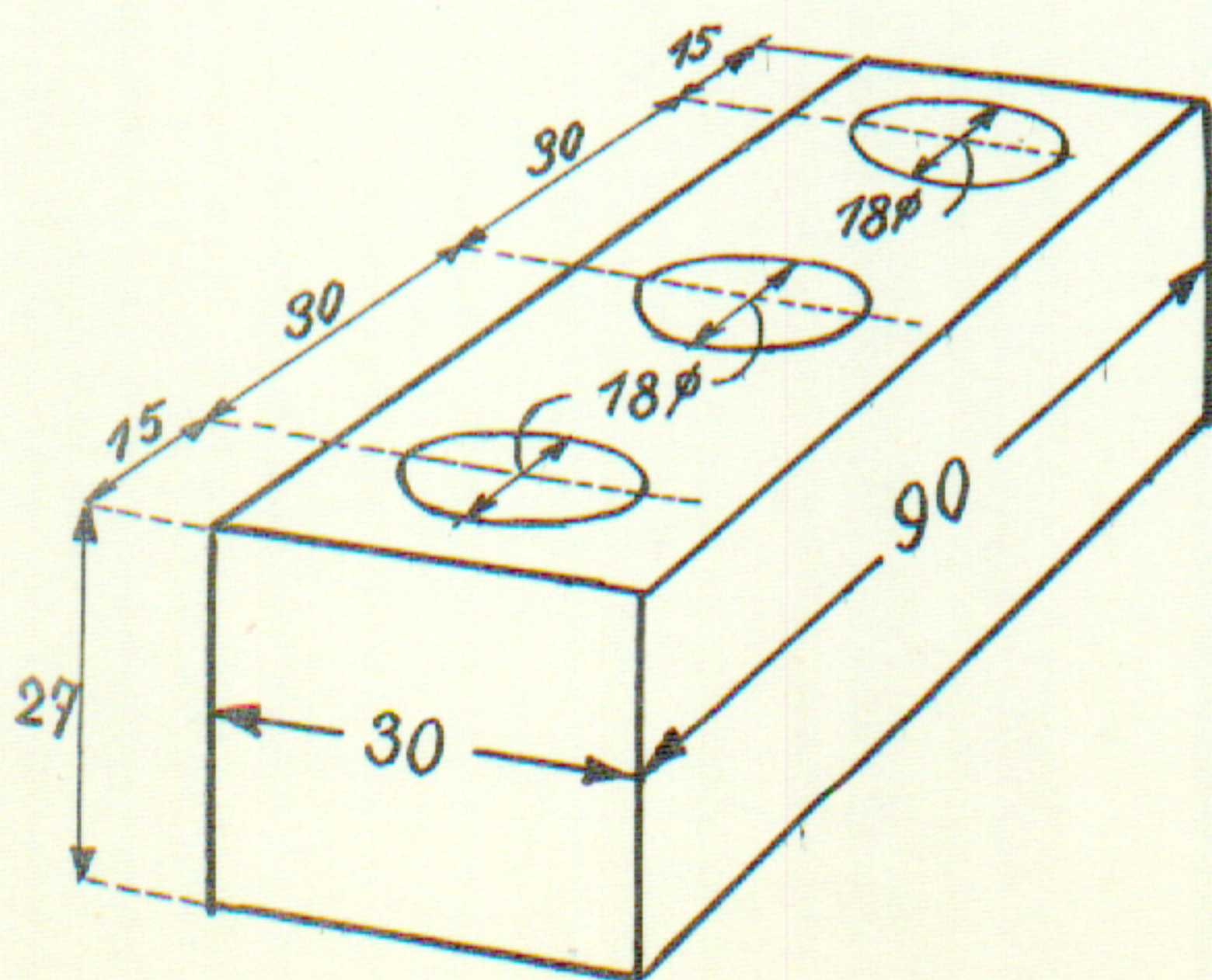
by means of adaptor tool SKK 12 612.4 as per drawing on reverse side.

Check the new felt ring retaining cup for freedom from burrs and for equal diameters on the sealing edges.

If the bearing bore on the gearbox housing shows signs of impact notches applied on earlier installations, these spots must be equalized carefully.

In order to ensure tightness the felt ring retaining cup outer side should be given a smear with "Cunil" prior to fitting.

To prevent flange distortion when withdrawing the coupling flange from layshaft, for the parallelism of the two coupling pegs it is necessary to fit upon them a distance piece of steel with 3 drilling holes 18 mm ϕ as per sketch below. Then bring puller Matra 422 A in action, so that it applies underneath the two coupling pegs. Having tightened the puller spindle apply a hammer blow upon the spindle head in order to loosen the coupling flange without applying undue spindle pressure.



Yours truly,

BAYERISCHE MOTOREN WERKE
Aktiengesellschaft

Drawing SKK 12 612.4 on reverse side: