

BAYERISCHE MOTOREN WERKE
AKTIENGESELLSCHAFT

Rundschreiben der Abteilung Kundendienst und Teile

Motorcycles: Group Frame No. 3/61 (181) e.

Munich, November 2, 1961
KV2F ke/wi/ha

Re:

Reinforcement of kickstand supports for R 27 motorcycle

Though the dimensions of the kickstand supports on the above mentioned motorcycle are sufficient, we have been informed that these supports have undergone deformation on several motorcycles.

The new motorcycles leaving the assembly line therefore come now equipped with reinforced kickstand supports and for the already delivered R 27 motorcycles covering plates have been designed for subsequent installation.

With these plates

a) the undamaged kickstand supports should be reinforced as follows:

Necessary parts

2 covering plates 40 00 155

From the kickstand support front face remove the finish, position the covering plate so that it touches the frame tube and weld it as per the enclosed drawing on the seating edges.

Caution! Do not weld it onto the frame tube.

Whenever possible, use the electric arc welding method, for which we recommend the

electrode Fincord D (Ti VIII s) 2 mm.
40 - 60 amps.

Motorcycles (181) engl.

In the case of using the autogenous welding method, the frame tubes and all parts adjacent to the welding spot should with sheet metal pieces or wet asbestos plates be shielded against the welding flame in order to avoid unnecessary damaging of the finish.

After the welding seam has cooled down, clean the welding scales from the repair spot and retouch the finish.

b) Distorted kickstand supports should be repaired and reinforced as follows:

Necessary parts

2 covering plates 40 00 155

Dress the kickstand supports, eventually carefully heated up, observing the dimensions (in millimeters) indicated on the enclosed drawing, and weld on the covering plates as already described.

In cases of complaints within the warranty period we exceptionally reimburse, against presentation of a warranty claim with frame number quoted on,

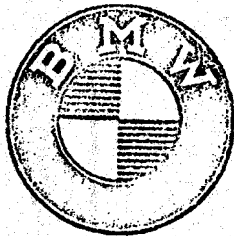
30 minutes of working time for the jobs listed under a)
50 minutes of working time for the jobs listed under b) and the covering plates required for each case.

**BAYERISCHE MOTOREN WERKE
Aktiengesellschaft**


i.V. Mecer


i.A. Schäfer

Drawing



NOV. 1962

CENTERSTAND SUPPORT FOR R-27

