

Service-Information Motorcycle



BMW NA
Service Department

Group: 11
Engine

June 1991
11 048 91
(2463)

For USA Only

Oversize Valves for BMW R80 and R100 Engines from 1985 >

Information: If the valve guides are worn out, the possibility exists of reaming out the existing valve guide bores and fitting oversize valves with a stem diameter of 8.3 mm.

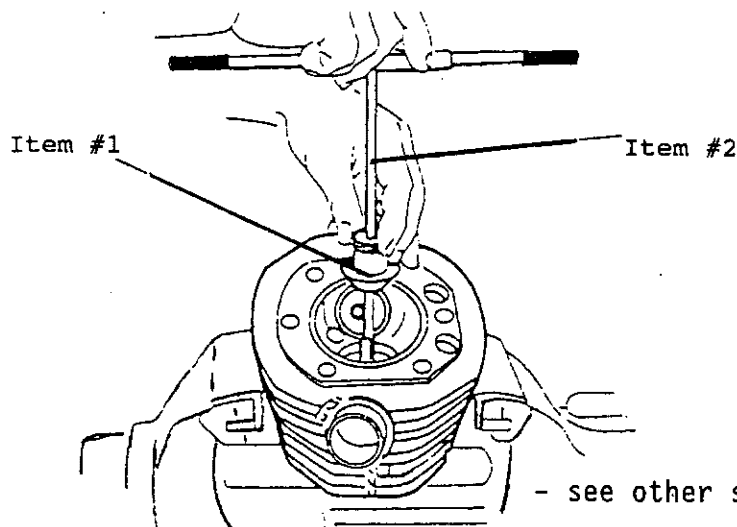
For the 800cc and 1000cc boxer engines, the following valves with a stem diameter of 8.3 mm are available:

Part No.	Valve Type & Size	Seat Angle
11 34 1 338 660	Inlet 42 mm	45
11 34 1 338 661	Exhaust 40 mm	30
11 34 1 338 665	Exhaust 38 mm	45

The following tool set must be used to fit the oversize valves:

Part No. 88 88 6 004 600 - consists of the following:

- 88 88 6 004 601 - Rough Cut Reamer
Hunger 8.2 H7
- 88 88 6 004 602 - Finish Reamer
Hunger 8.3 H7
- 88 88 6 004 603 - Guide Block



Please initial and route to the following before filing

Service	Parts	Sales	Warranty	Technicians
---------	-------	-------	----------	-------------

**Repair
Procedure:**

- Secure the cylinder head with the combustion chamber upright in a vise with protective jaw coverings. The valve guide to be reamed should be positioned vertically.
- Insert the top (tap wrench end) of the reamer into the guide block, then insert reamer into valve guide (reamer cut diameter is larger than guide block pilot hole, which is ground to match reamer shaft size).
- Place the guide block, item #1, on the valve seat. This block guides the reamer. When reaming, press the guide block into the valve seat with two fingers.
- Turn reamer with a tap wrench . . never use an electric drill! Powering the reamer with a drill will dull the reamer and create a larger hole than intended.

Note:

Start the reaming operation using reamer #004 601 (8.2 mm), item #2. Lubricate with thread-cutting oil only.

- Turn reamer clockwise, never counterclockwise.
- Clean reamer at frequent intervals, turning in cutting direction only.
- When reaming is complete, remove the reamer downwards through the guide.
- Complete the reaming operation using the finish reamer - part #004 602 (8.3 mm).
- After the valve guide has been finish-reamed, resurface the valve seat.

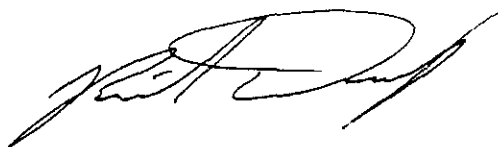
Tool Note: 8.3 mm solid pilots for Neway valve seat cutting equipment can be purchased from The Carlson Company by calling 1-800-222-6199.

Very truly yours,

BMW of North America, Inc.



Frank Stevens
National Service Manager



Richard Dampf
National Technical Manager

FS:jel/41.1