



TRASMISSIONI MECCANICHE

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Renault Clio Williams - RS

Mounting instructions for dog engagement gear-box Gr. N homologated (internal product code RC075).

Changes to be made to the original parts in order to have a correct mounting of the Bacci-production gear-box.

1. Face milling of the 1st – 2nd gearshift fork.

Remove, first of all, the plastic terminal you find on the 1st – 2nd original gearshift fork (see photo n°1).

After that, do the face milling of the fork, in order to have a perfect coupling with the 1st – 2nd dog ring of the Bacci-production gearbox.

The dog ring inner measure is 9 mm. Be careful to mill the original fork **in symmetrical manner** about the fork center line in order to obtain a thickness of 8,9 mm (see photo n°2).



Photo n°1 – Original 1st – 2nd gearshift fork.



Photo n°2 – The 1st – 2nd gearshift fork after the face milling required.

2. Face milling of the 3rd – 4th gearshift fork.

Do the face milling of the 3rd – 4th fork, in order to have a perfect coupling with the 3rd – 4th dog ring of the Bacci-production gearbox.

The dog ring inner measure is 7,1 mm. Be careful to mill the original fork **in symmetrical manner** about the fork center line in order to obtain a thickness of 7 mm (see photo n°3).

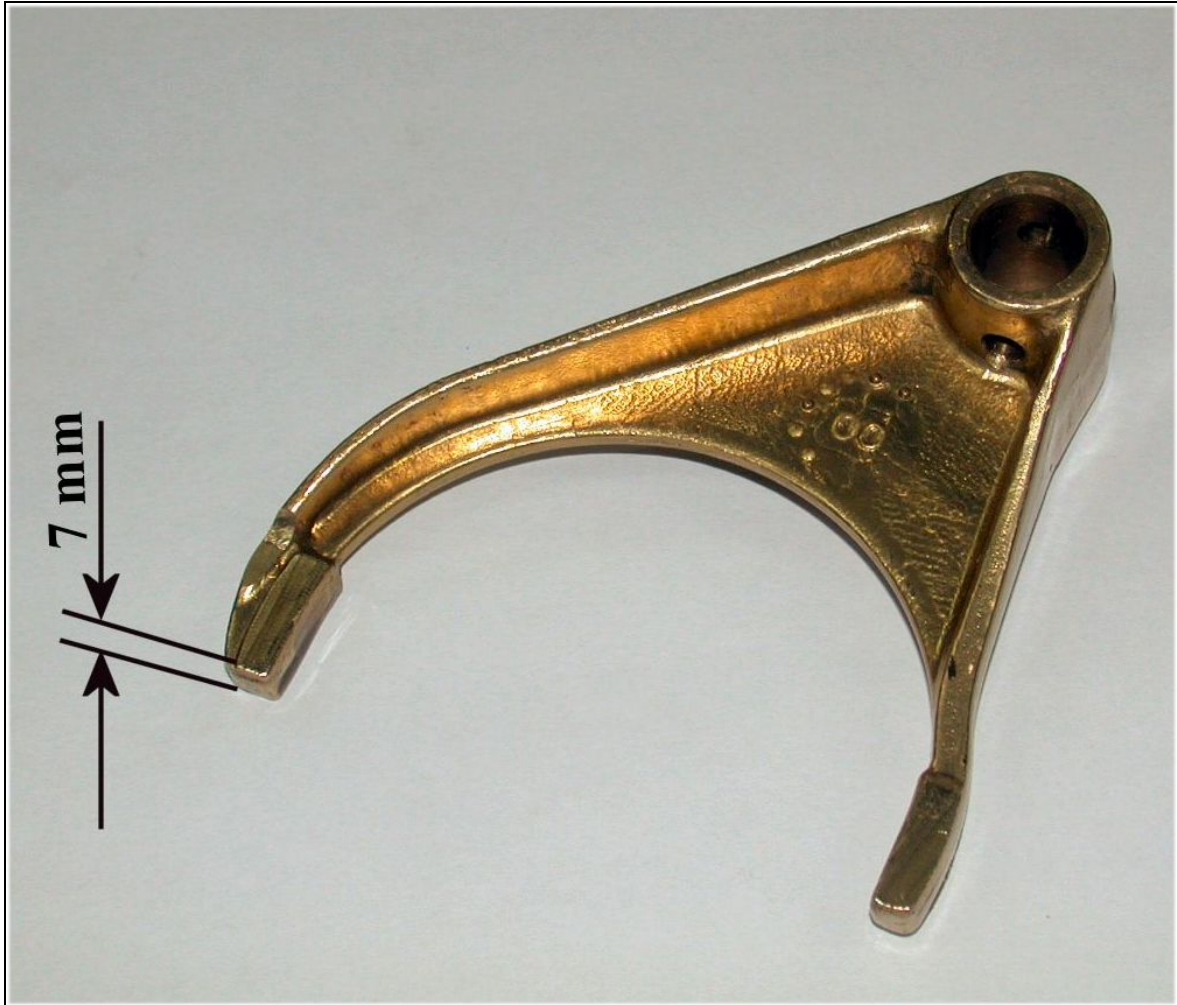


Photo n° 3 – The 3rd – 4th gearshift fork after the face milling required.

3. Installation of the supplied lock plate for the two bearings.

In the kit you can find n° 14 M5 bolts and a bearings lock plate (see photo n°4).

This plate has to be applied to the central box of the gear group (photo n°5) to make the bearings lock-system more rugged.

In order to apply this plate, a machining of the central box of the gear group has to be made.

Keep the central box and make a face milling of the shown part (photo n°5). This machining guarantees that the 2 bearings external-rings are locked from the supplied plate as well, when you reassemble the components on the central box.

You can see photo n°6, which shows the face milling measure to be made: this has to be 2.5 mm under the edge of the bearings external-rings.

In photo n°7 it is possible to see the same section with the plate connected to the central box.

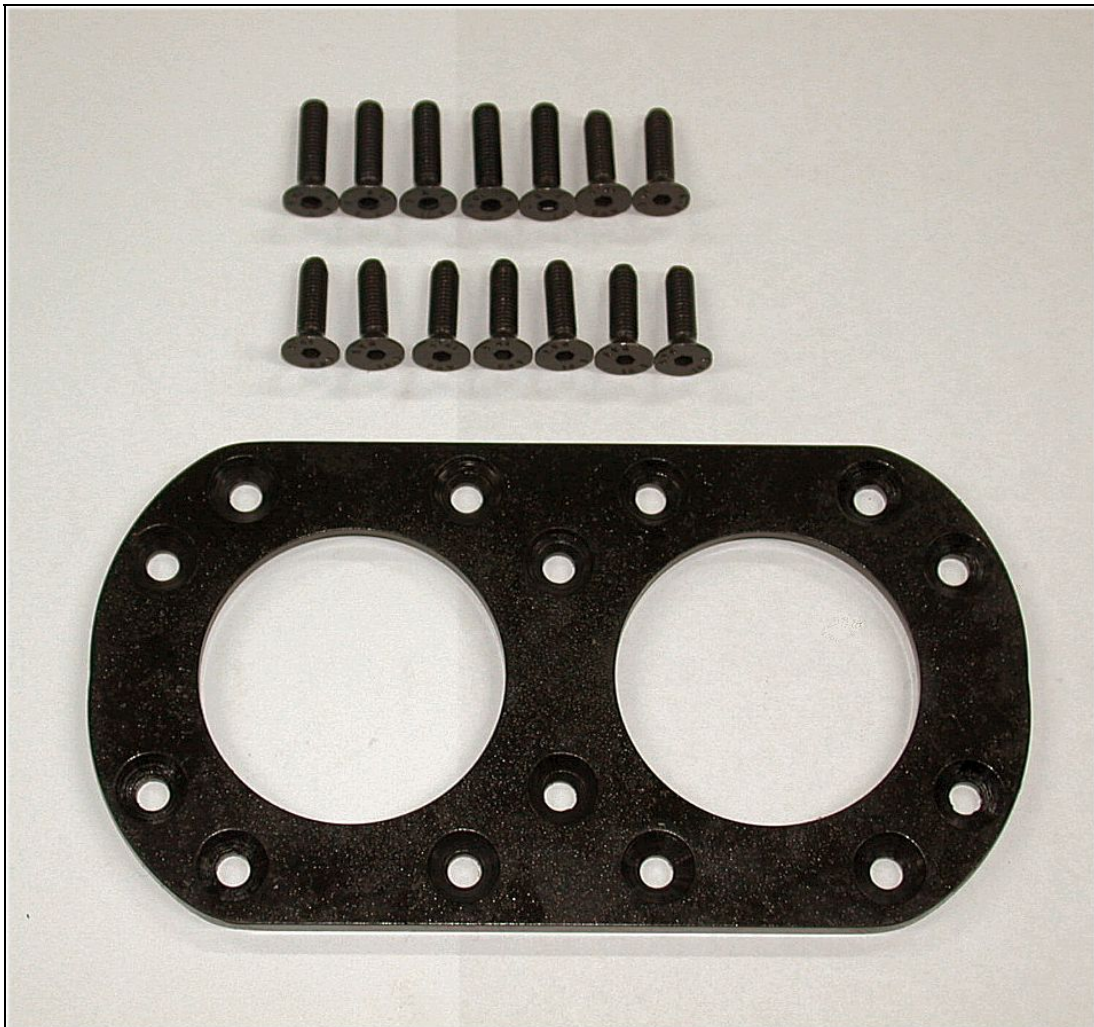


Photo n°4 – The lock plate and the bolts supplied with the kit.

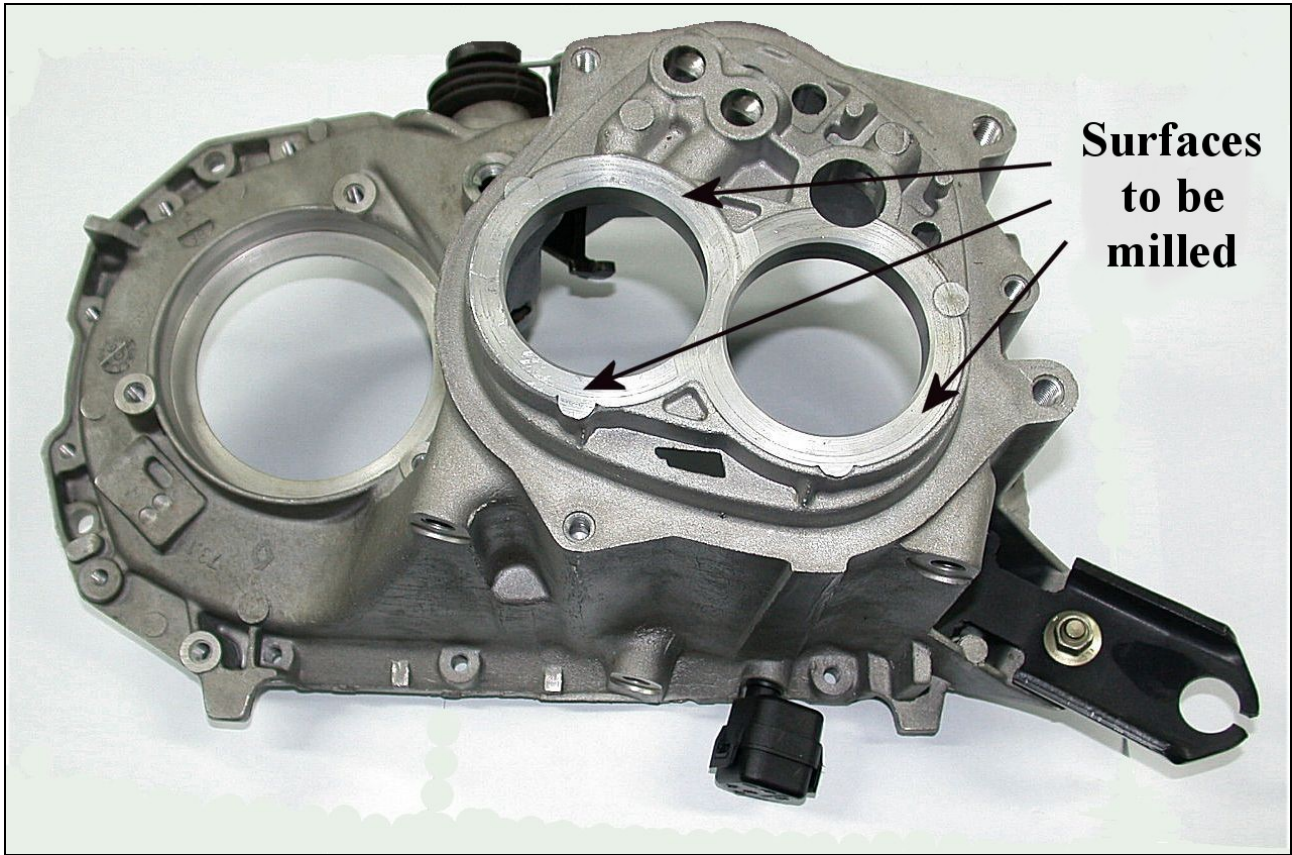


Photo n°5 – Global view of the central box with the surfaces to be milled.

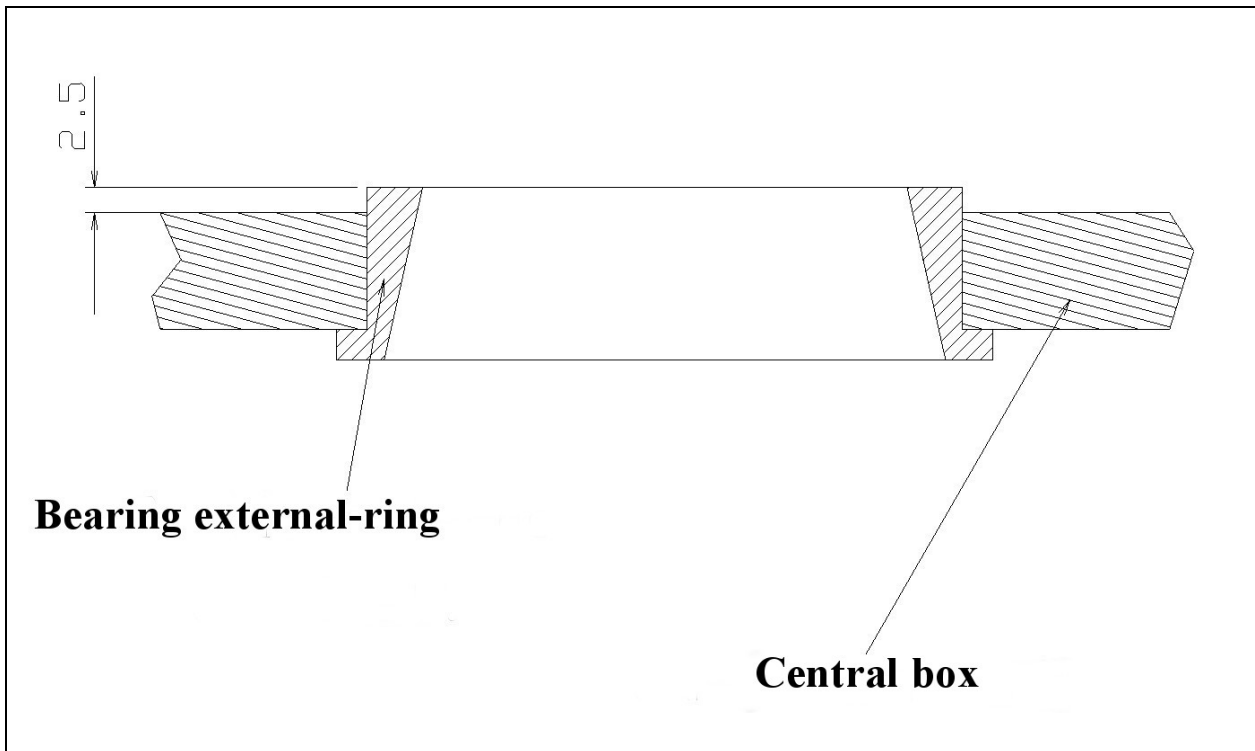


Photo n°6 – The face milling has to be 2.5 mm under the bearing external-ring.

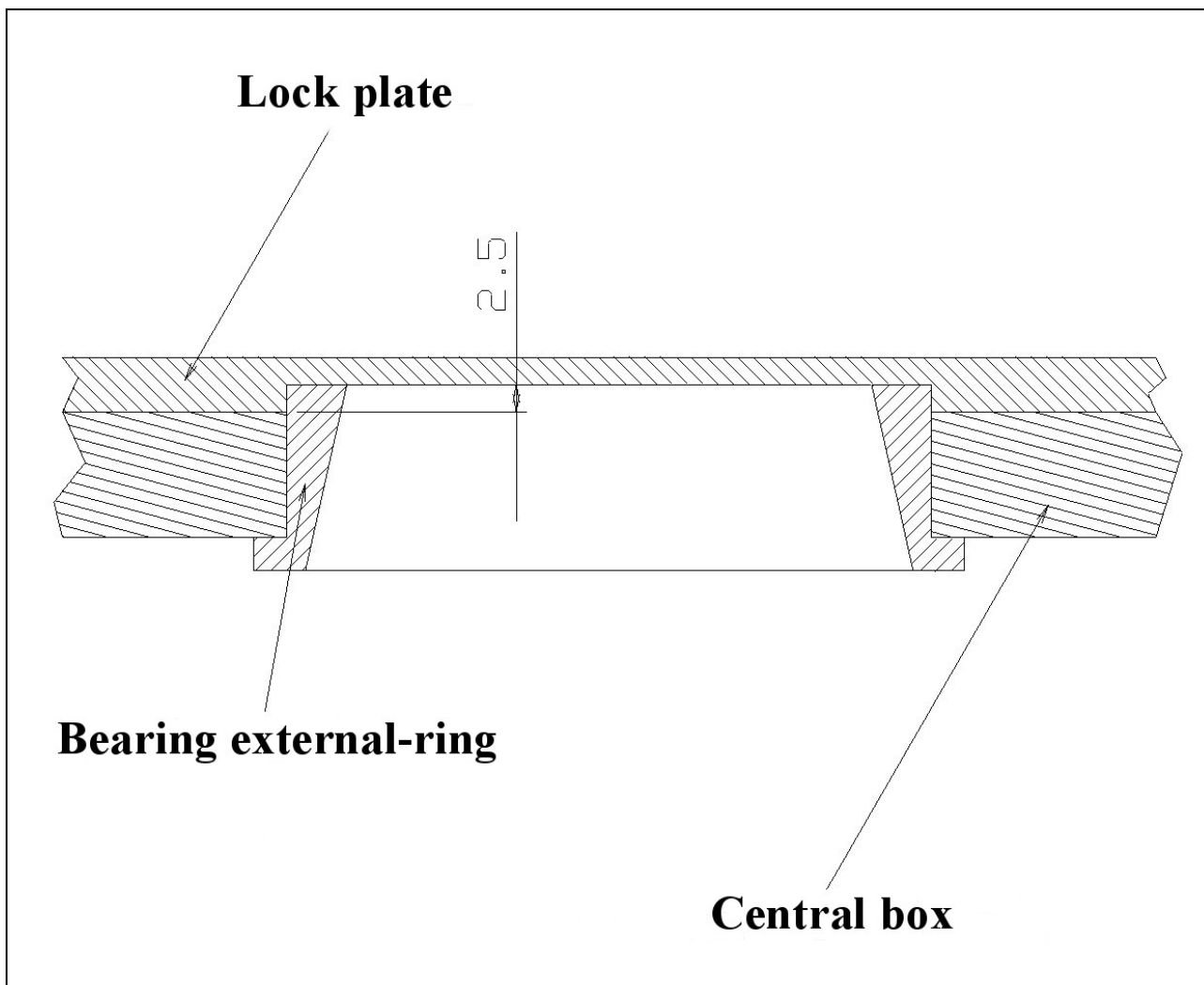


Photo n°7 – Section view of the lock plate applied to the central box.

After you have checked that the bearings external-rings are correctly mounted, following the previous instructions, drill the central box coaxially with the holes you find on the lock plate. After that, thread with M5 each hole in order to apply the bolts supplied with the kit.

4. Modification of the reverse gear.

Modify the reverse gear tacking away the outlined parts, as shown in photo n°8.

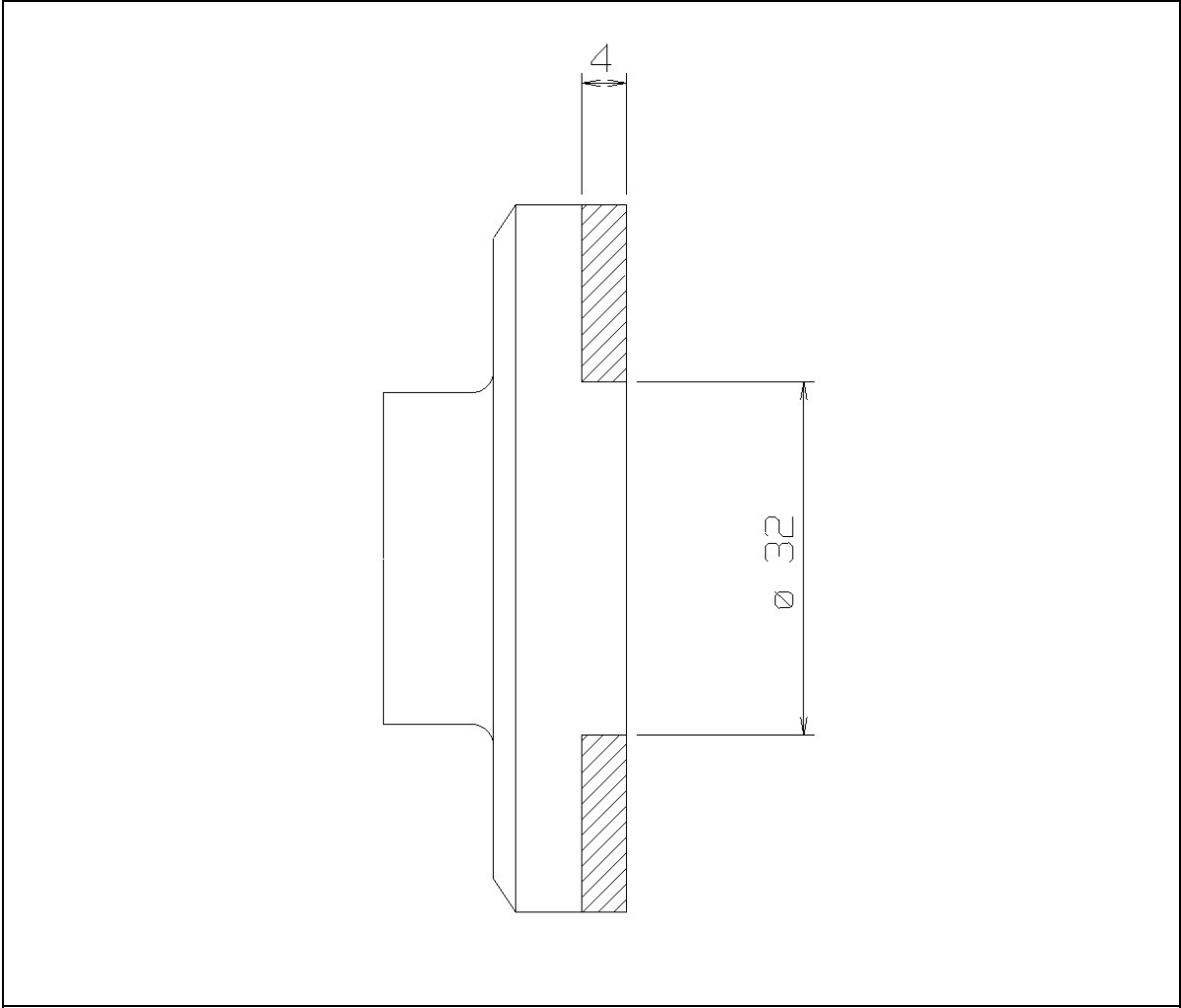


Photo n°8 – The modification of the reverse gear.