

## Mercedes OM606 > BMW GS6-53DZ Gearbox Adapter Plate

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Have Fun :) Ben

- Notes:**
- For the avoidance of doubt X and Y coordinates are reference origin of 0,0 taken from the centre of the workpiece.
  - Adapter plate ring fabricated from 25mm S275(43A), water jet/ plasma cut and plough ground both faces
  - The 11mm dowels @ 190mm PDC were used to provide a simple way to retain the origin centred to the ring when flipping over for machining of each side (you may have a better technique or more sophisticated machining facilities available, use your judgement :-)

### GS6-53 Gearbox

Item #	X	Y	Instruction	Notes
1	-124.699	119.284	Drill and Tap to 20mm, M12x1.75 (for M12 Stud),	Loctite 270 to secure
3	134.21	140.66	Drill and Tap to 20mm, M12x1.75 (for M12 Stud)	"
4	161.57	65.861	Drill and Tap to 20mm, M12x1.75 (for M12 Stud)	"
2	6.955	193.881	Drill and Tap to 20mm, M8x1.25 (for M8 Stud)	"
6	-30.452	-173.099	Drill and Tap to 20mm, M8x1.25 (for M8 Stud)	"
7	-130.753	-114.753	Drill and Tap to 20mm, M8x1.25 (for M8 Stud)	"
8	-171.812	-26.126	Drill and Tap to 20mm, M8x1.25 (for M8 Stud)	"
5	136.437	-106.971	Drill and Tap to 20mm, M10x1.5 (for M10 Stud), Counterbore 14.56 to 6mm (for locating ring-dowels)	"
9	-169.938	33.058	Drill and Tap to 20mm, M10x1.5 (for M10 Stud), Counterbore 14.56 to 6mm (for locating ring-dowels)	"

### OM606 Engine

Item #	X	Y	Instruction	Notes
1	-168.775	-11.228	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	Counterbore could probably be a little smaller?
2	-148.042	81.822	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
3	-104.179	163.614	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
4	7.749	193.628	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
5	76.63	152.813	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
9	117.946	-119.525	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
10	-42.515	-162.617	Drill through @ 10.5mm, Counterbore reverse 18mm to 10mm depth (for M10 socket cap screw)	"
6	109.157	134.915	Drill blind @ 9.5mm, ream to 9.975 to 15mm depth (for interference fit 10mm hardened steel dowel)	
12	-161.132	-50.864	Drill blind @ 9.5mm, ream to 9.975 to 15mm depth (for interference fit 10mm hardened steel dowel)	
11	-141.697	-92.566	Drill through @ 10.5mm, Counterbore reverse 18mm to 20mm depth (for M10 Low socket cap screw)	
7	137.396	101.368	Drill through @ 12.5mm, Counterbore reverse 20mm to 12mm depth (for M12 socket cap screw)	Starter motor bolts
8	170.856	2.026	Drill through @ 12.5mm, Counterbore reverse 20mm to 12mm depth (for M12 socket cap screw)	"