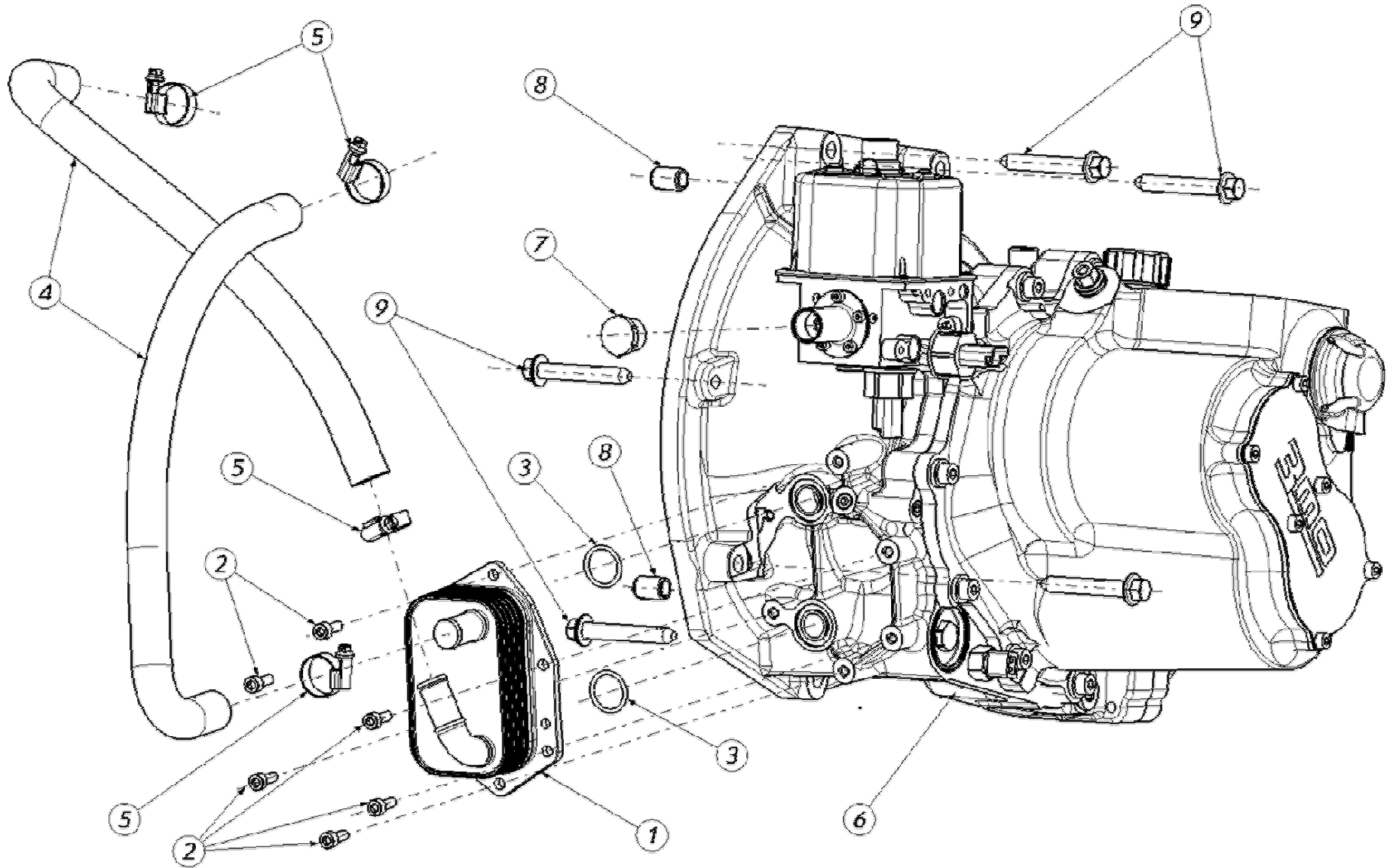
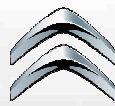


**CITROËN**  
RACING

**DS3 R3**

**C23**  
**BOITE DE VITESSES**  
**GEARBOX**

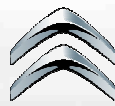




REP	REFERENCE	QTE	DESIGNATION
1	9683194380	1	<b>Echangeur Eau/Huile BV</b> <i>Gearbox Water/Oil Intercooler</i>
2	BCSP691306	6	<b>Vis M6 L16</b> <b>Screw M6 L16</b>
3	BCSP5271G9	2	<b>Joint Torique</b> <i>O-Ring</i>
4	0B1363703A	2	<b>Tuyau eau refroidissement BV</b> <i>Gearbox Cooling Water Hose</i>
5	BCSP6981H7	4	<b>Collier Métal D16-27</b> <i>Metal Collar D16-27</i>
6	1C2363969C	1	<b>Boite de Vitesses</b> <i>Gearbox</i>
7	1C2964351A	1	<b>Bouchon Plastique M20</b> <i>Plastic Cap M20</i>
8	BCSP696836	2	<b>Goupille</b> <i>Pin</i>
9	BCSP6925V0	5	<b>Vis à Embase</b> <i>Collar Screw</i>
10	1E2420457A	1	<b>Rondelle Convexe</b> <i>Convex Washer</i>
11	1E2420458A	1	<b>Rondelle Concave</b> <i>Concave Washer</i>
12			
13			
14			
15			

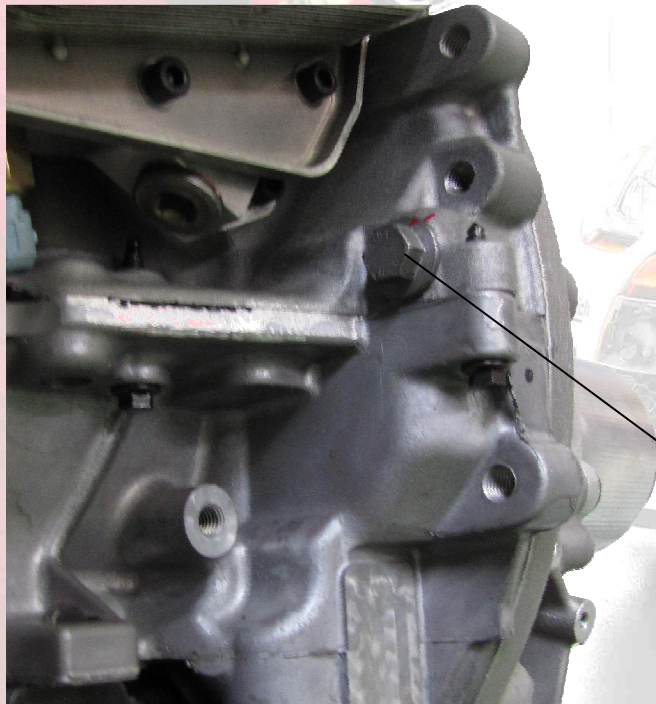






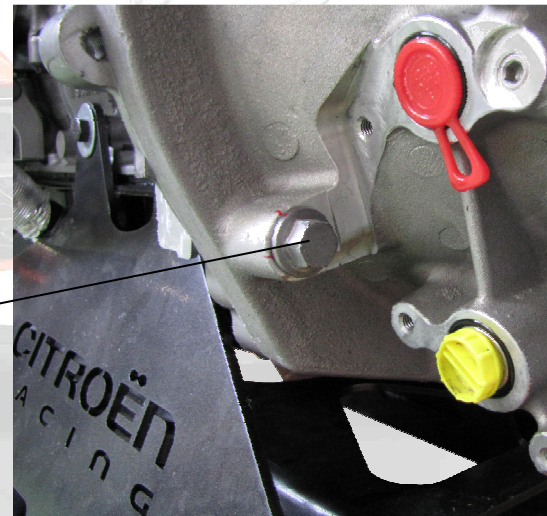
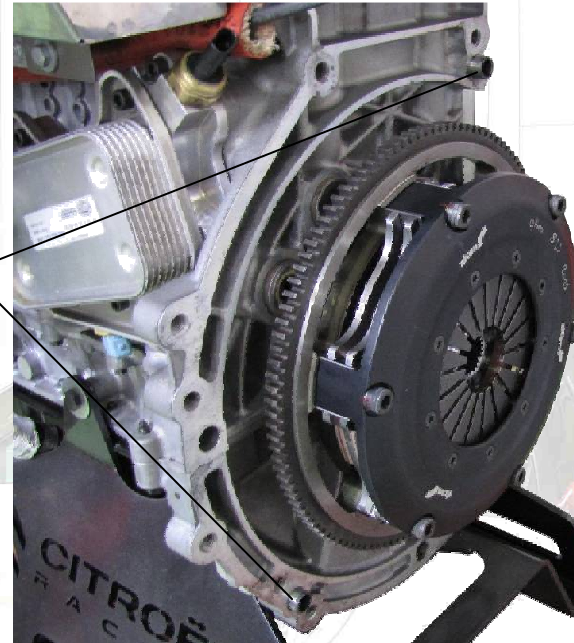
Assembler la boîte de vitesse sur le bloc moteur à l'aide des goupilles (rep. 8) et des vis (rep. 9).

Assemble the gearbox on the engine block using the pins (rep. 8) and the screws (rep. 9).



9

8

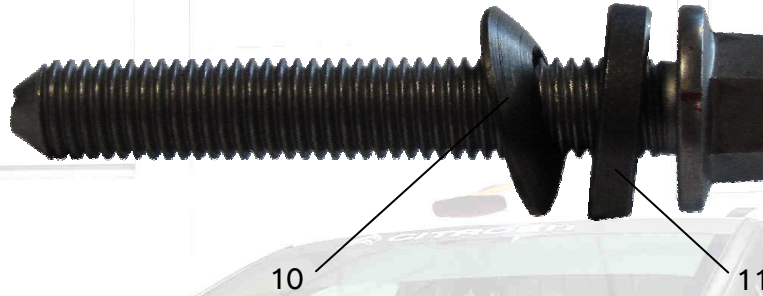


65 N.m



Monter les rondelles convexe (*rep. 10*) et concave (*rep. 11*) sur la vis de fixation BV positionnée sous le capteur Smot dans l'ordre indiqué sur la photo ci-contre en recouvrant la partie bombée des rondelles de graisse cuivre.

*Fit the convex (*rep. 10*) and concave (*rep. 11*) washers on the gearbox assembling screw located just under the engine speed sensor in the order shown on the picture opposite, coating the curved part of the washers with copper grease.*



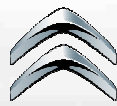
**Graisse cuivre**  
Copper grease

Monter l'ensemble sur le bloc moteur en prenant soin de centrer au maximum les rondelles sous la tête de vis et serrer au couple.

*Assemble it on the engine block, taking care to centre the washer under the screw head and torque it.*

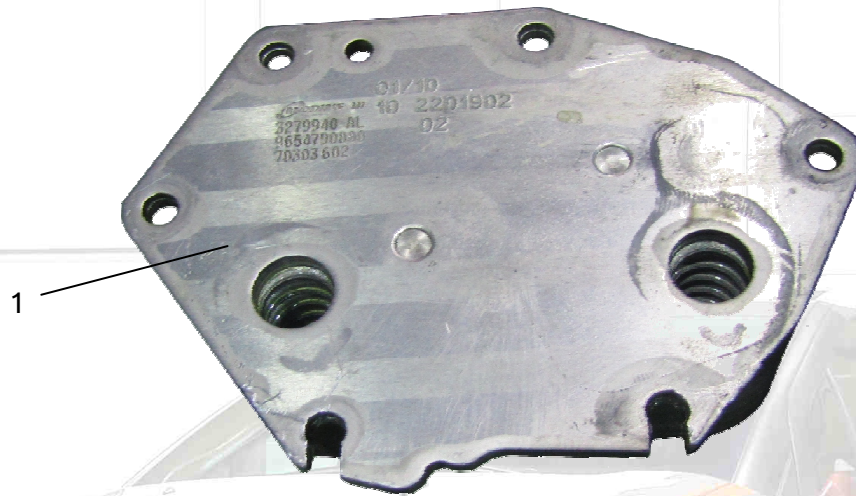


**65 N.m**



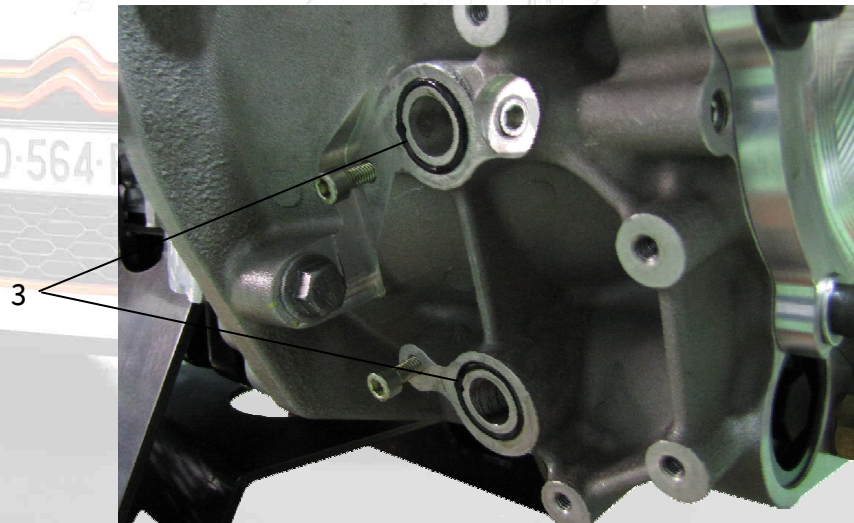
Modifier l'échangeur eau/huile BV (**rep. 1**) comme indiqué sur la photo ci-contre.

Modify the gearbox water/oil intercooler (**rep. 1**) as indicated on the picture opposite.

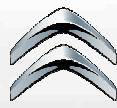


Monter les joints toriques (**rep. 3**) sur la boîte de vitesse (**rep. 6**) comme indiqué sur la photo ci-contre.

Fit the O-rings (**rep. 3**) on the gearbox (**rep. 6**) as indicated on the picture opposite.

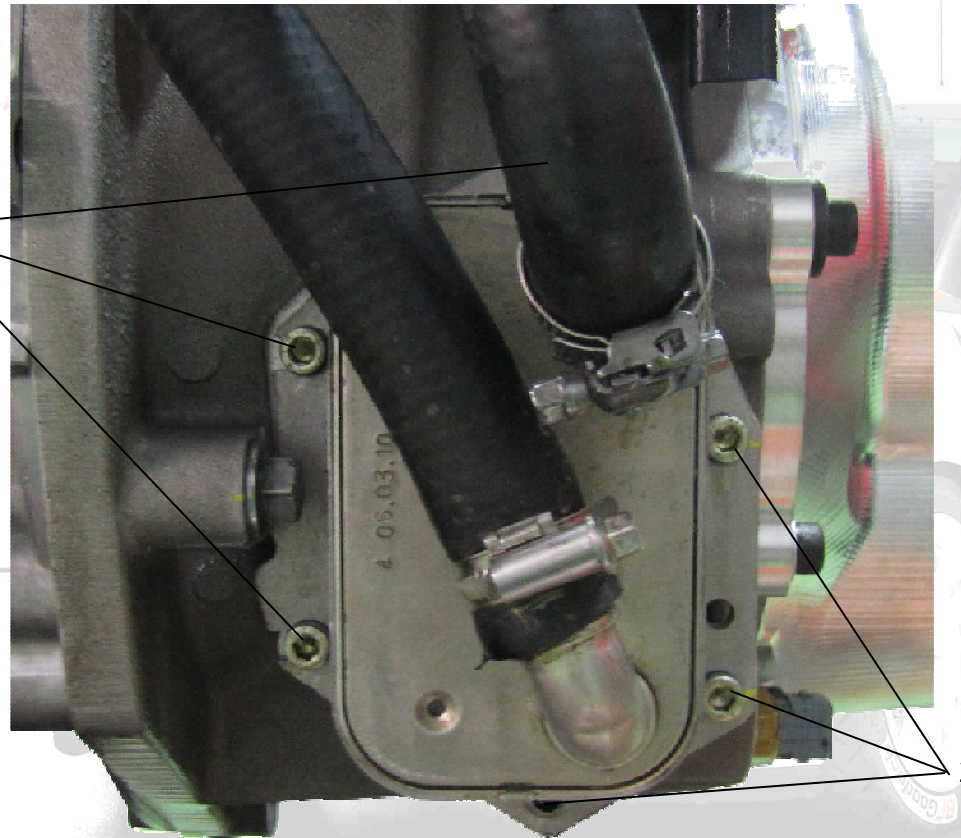






Assembler l'échangeur eau/huile sur la boîte de vitesse à l'aide des vis (rep. 2).

Assemble the water/oil intercooler on the gearbox using the screws (rep. 2).

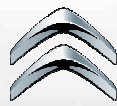


12 N.m



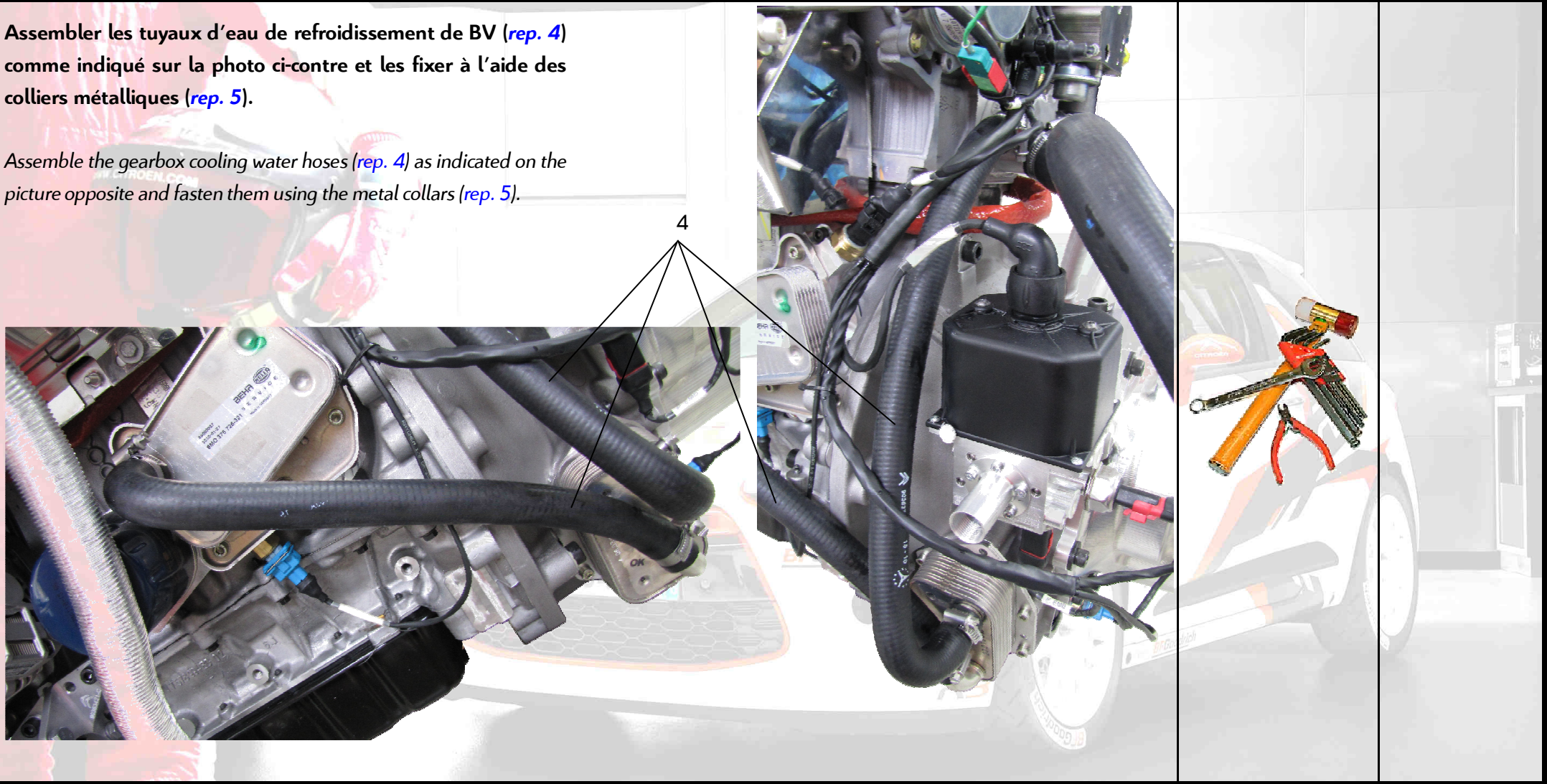
242

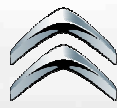




Assembler les tuyaux d'eau de refroidissement de BV (rep. 4) comme indiqué sur la photo ci-contre et les fixer à l'aide des colliers métalliques (rep. 5).

Assemble the gearbox cooling water hoses (rep. 4) as indicated on the picture opposite and fasten them using the metal collars (rep. 5).





Assembler le bouchon plastique M20 (rep. 7) sur le bloc hydraulique de commande.

Assemble the plastic cap M20 (rep. 7) on the hydraulic control unit.

