



Service Parts Instructions

Replacing the Inter-Axle Differential (IAD) Shift Cylinder O-Ring on Meritor's R-611 Series Forward Rear Axle

Removal and Installation

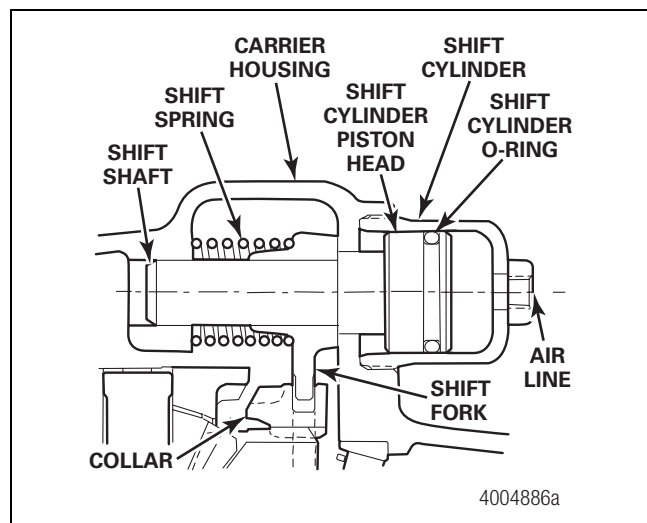
Shift Cylinder O-Ring

WARNING

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury and damage to components can result.

1. Wear safe eye protection.
2. Park the vehicle on a level surface. Set the parking brake. Block the wheels to prevent the vehicle from moving.
3. Disconnect the air line from the shift cylinder.
4. Remove the shift cylinder from the carrier.




5. Remove the black O-ring from the piston head.
6. Lightly lubricate the O-ring and the shift cylinder bore with the same lubricant used in the axle housing.

7. Install the O-ring into the groove on the shift cylinder piston head.
8. Slide the shift cylinder back into the carrier.

WARNING

When you apply some silicone gasket materials, a small amount of acid vapor is present. To prevent serious personal injury, ensure that the work area is well-ventilated. Read the manufacturer's instructions before using a silicone gasket material, then carefully follow the instructions. If a silicone gasket material gets into your eyes, follow the manufacturer's emergency procedures. Have your eyes checked by a physician as soon as possible.

Take care when you use Loctite[®] adhesive to avoid serious personal injury. Read the manufacturer's instructions before using this product. Follow the instructions carefully to prevent irritation to the eyes and skin.

9. Clean the shift cylinder threads. Coat the threads with Loctite[®] 518 Gasket Eliminator.
10. Install the shift cylinder into the carrier. Tighten the cylinder to 80-100 lb-ft (109-136 N·m). 
11. Connect the air line to the shift cylinder.

ArvinMeritor™

Meritor Heavy Vehicle Systems, LLC
2135 West Maple Road
Troy, MI 48084 USA
800-535-5560
arvinmeritor.com



Information contained in this publication was in effect at the time the publication was approved for printing and is subject to change without notice or liability. Meritor Heavy Vehicle Systems, LLC, reserves the right to revise the information presented or discontinue the production of parts described at any time.

Copyright 2004
ArvinMeritor, Inc.
All Rights Reserved

Printed in the USA

TP-0449
Issued 03-04
(16579/24240)