

MERITOR®

Technical Bulletin

Installing Carriers with Tapered Dowels to Axle Housings

All Meritor RP-164 and RD-164 Series Forward Axle Carriers, and RR-164 Series Rear Axle Carriers

How to Obtain Additional Maintenance and Service Information

Refer to Maintenance Manual 5L, Single-Reduction Forward and Rear Differential Carriers on Tandem and Tridem Axles; and Maintenance Manual 5A, Single-Reduction Differential Carriers. To obtain these publications, call ArvinMeritor's Customer Service Center at 800-535-5560, or visit Literature on Demand at meritorhvs.com.

Cleaning Procedure

1. Use a rotary tool with a scour pad to clean all silicone residue from the housing and carrier faces. Figure 1. Surfaces must be clean, dry and free of foreign matter. The surfaces must not be oily to the touch.



Figure 1

2. Remove metal filings from the magnets inside the housing.

⚠ WARNING

Solvent cleaners can be flammable, poisonous and cause burns. Examples of solvent cleaners are carbon tetrachloride, and emulsion-type and petroleum-base cleaners. Read the manufacturer's instructions before using a solvent cleaner, then carefully follow the instructions. Also follow the procedures below.

- Wear safe eye protection.
- Wear clothing that protects your skin.
- Work in a well-ventilated area.
- Do not use gasoline or solvents that contain gasoline. Gasoline can explode.
- You must use hot solution tanks or alkaline solutions correctly. Read the manufacturer's instructions before using hot solution tanks and alkaline solutions. Then carefully follow the instructions.

3. Use solvent to clean the inside of the housing.
4. Use Loctite® ODC Free cleaner or brake cleaner to clean the housing and carrier faces.
5. Dry the housing and carrier faces.
6. Use a tap to clean the internal threads in the housing.

Installation Procedure

⚠ 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 or fall over. Serious personal injury and damage to components can result.

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.

CAUTION

Only apply Loctite® 5699 silicone gasket material, Meritor part number 2297-A-7021, to the housing face. Do not apply ThreeBond 1216E silicone products. Damage to components can result.

1. Apply a 0.25-inch (6 mm) bead of Loctite® 5699 silicone gasket material, Meritor part number 2297-A-7021, to the housing face. Do not apply ThreeBond 1216E silicone products. Damage to components can result. Only use the specified amount of gasket material; otherwise, it can break off, plug lubrication passages and damage components. Figure 2.

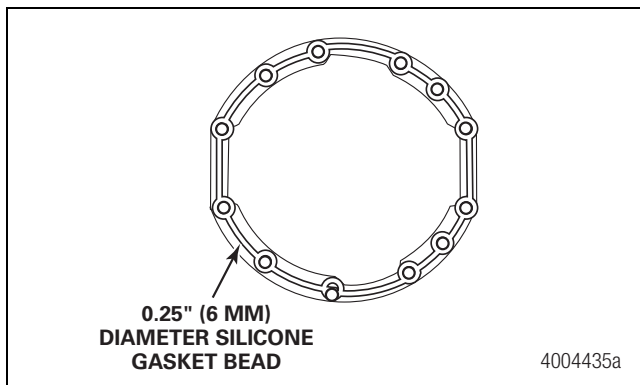


Figure 2

2. Install the carrier into the housing. Refer to Maintenance Manual 5A and 5L.
3. Install new capscrews with blue Dri-Loc® STS threadlocker. Tighten the capscrews and stud nuts in the following order.
 - A. For RP-164 and RD-164 Series forward axles, install four 2-inch capscrews and two 3.5-inch capscrews to secure the tapered dowels. Figure 3. Tighten the capscrews in a crisscross pattern to 80-100 lb-ft (109-136 N•m). **ⓘ**
For RR-164 Series rear axles, install three 2-inch capscrews and one 4-inch capscrew to secure the tapered dowels. Figure 4. Tighten the capscrews in a crisscross pattern to 80-100 lb-ft (109-136 N•m). **ⓘ**
 - B. Install the remaining capscrews. Tighten the capscrews in a crisscross pattern to 80-100 lb-ft (109-136 N•m). **ⓘ**

- C. Tighten all the capscrews in a crisscross pattern to 225 lb-ft (306 N•m). **ⓘ**

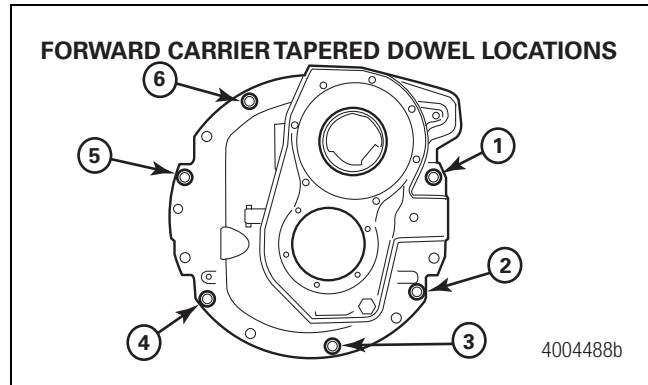


Figure 3

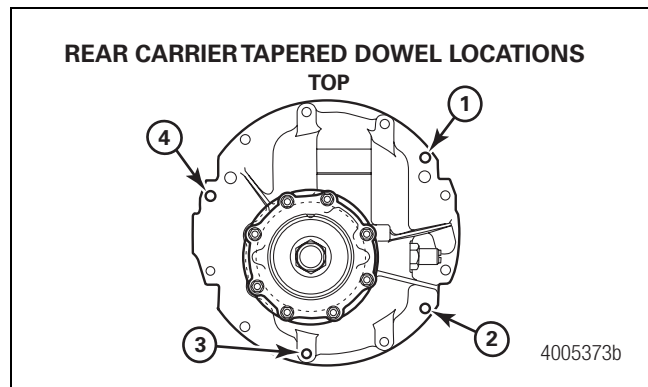


Figure 4

WARNING

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. If Loctite® adhesive material gets into your eyes, follow the manufacturer's emergency procedures. Have your eyes checked by a physician as soon as possible.

- D. Apply Loctite® 242 threadlocker on the stud threads to secure the stud nuts.
 - E. Within five to 10 minutes after applying Loctite® 242 threadlocker, tighten the stud nuts to 225 lb-ft (306 N•m). If you wait longer than 10 minutes to tighten the stud nuts, the threadlocker can set, which can affect clamp load. Damage to components can result. **ⓘ**
4. Wait a minimum of 60 minutes before filling the assembly with lubricant.



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Printed in USA

TP-0450
Revised 07-07
(16579/22882)