



**Rockwell**

## TECHNICAL BULLETIN

# MAINTENANCE MANUAL UPDATE\*

**Installing Fasteners with  
Pre-applied Adhesive,  
Rockwell Liquid Adhesive  
2297-C-7049, Loctite® 680  
Liquid Adhesive or Equivalent**

\* The information in this Technical Bulletin updates the following Maintenance Manuals:

MM #	Title	Date
5B	Tandem Axle Forward Rear Drive Units	9-88
5L	Tandem Axle Forward Rear Drive Units	8-91
5J	Single Reduction Hypoid Unit	8-79
5P	Tandem Axle Forward Rear Drive Units	3-91
6B	Tandem Axle Forward Rear Drive Units	5-75
6C	Double Reduction Differential Carriers	8-84
7A	Two-Speed Differential Carriers	8-90



### **WARNING**

*To prevent serious eye injury, always wear safe eye protection when doing maintenance or service.*

1. Clean the oil and dirt from threaded holes. There is no special cleaning required.



### **CAUTION**

*Do not apply adhesives or sealants on new fasteners with pre-applied adhesive patches or in the threaded holes. If other adhesives or sealants are used, the new adhesive will not function correctly.*

2. Assemble parts using the new pre-applied adhesive fasteners.

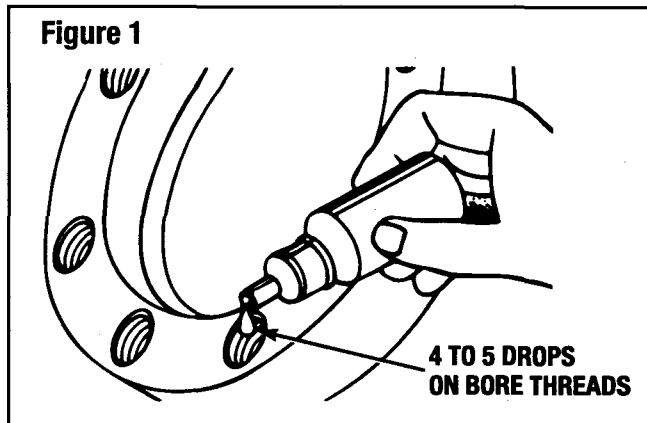
### **NOTE**

*There is no drying time required for fasteners with pre-applied adhesive.*

3. Tighten the fasteners to the required torque value for that size fastener.

## Installing Original or Used Fasteners Using Rockwell Liquid Adhesive 2297-C-7049 or Loctite® 680 or Equivalent

1. Clean the oil, dirt and old adhesive from all threads and threaded holes.
2. Apply four or five drops of Rockwell Liquid Adhesive, Loctite® 680 or equivalent to each threaded hole or bore ONLY. Make sure the adhesive is applied to the threads. **Figure 1.**



### **CAUTION**

*Do not apply adhesive to the fastener threads. Air pressure in the hole will push the adhesive out as the fastener is installed.*

3. Tighten the fasteners to the required torque value for that size fastener.

### **NOTE**

*There is no drying time required for Rockwell Liquid Adhesive 2297-C-7049, Loctite® 680 or equivalent.*



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