

Rockwell

TECHNICAL BULLETIN

MAINTENANCE MANUAL UPDATE*

Application of Three Bond 1216 or Equivalent Silicone Gasket Material

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

MM #	Title	Date
5B	Tandem Axle Forward Rear Drive Units	9-88
5J	Single Reduction Hypoid Unit	8-79
5L	Tandem Axle Forward Rear Drive Units	8-91
5P	Tandem Axle Forward Rear Drive Units	3-91
6C	Double Reduction Carriers	8-84
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12	Front Driving Axles	3-91

WARNING

Small amounts of methylethylketoxime acid vapor is present when applying silicone gasket material. To prevent possible serious personal injury, make sure there is good ventilation in the work area. If the silicone gasket material gets in your eyes, flush your eyes with water for 15 minutes. Have your eyes checked by a doctor.

NOTE

The following silicone gasket products or equivalent are available in 3 oz (85 gram) tubes and can be used for Rockwell components:

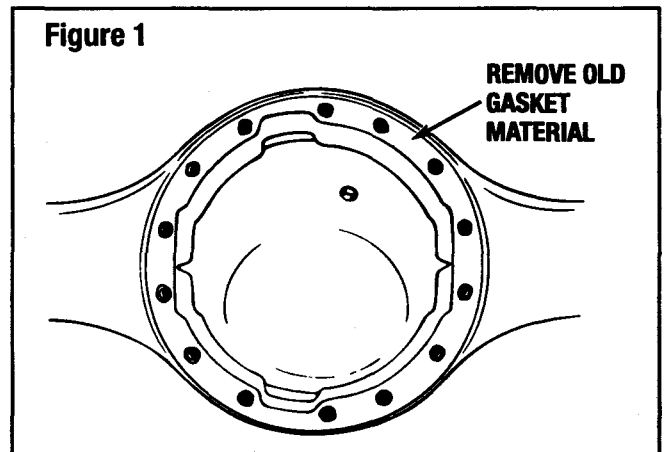
- *Three Bond Liquid Gasket No. TB 1216 — (Grey) Rockwell Part Number 2297-Z-7098*
- *Loctite® Ultra Grey Flange Sealant No. 5699 — Rockwell Part Number 2297-A-7021*

Also available in 120 oz (3.4 kg) cartridges:

- *Three Bond RTV1216 (Grey) Rockwell Part Number 2297-A-7051*

1. Remove all old gasket material from both surfaces. **Figure 1.**
2. Clean the surfaces where silicone gasket material will be applied. Remove all oil, grease, dirt and moisture. **Figure 1.**

Figure 1



3. Dry both surfaces.

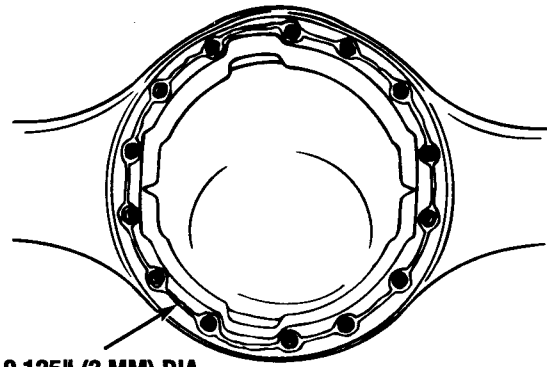
CAUTION

The amount of silicone gasket material applied must not exceed 0.125 inch (3 mm) diameter bead. Too much gasket material can block lubrication passages and result in damage to the components.

4. Apply 0.125 inch (3 mm) diameter continuous bead of the silicone gasket material around one surface. Also apply the gasket material around the edge of all fastener holes on that surface.
Figure 2.

5. Assemble the components immediately to permit the silicone gasket material to compress evenly between the parts. Tighten fasteners to the required torque value for that size fastener.
6. Wait 20 minutes before filling the assembly with lubricant.

Figure 2



**0.125" (3 MM) DIA.
SILICONE GASKET BEAD**



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Printed in the U.S.A.

TP-96105
Revised 2/97
16579/24240