

**No.: 12 TS-19**  
September 17, 2012

TO: Service Locations

FROM: Service Operations

SUBJECT: **Detroit Axle Model 4 FRT Thru-Shaft Snorkel Seal Leak**

## ISSUE

Inspection is necessary on customer complaint of Model 4 FRT thru-shaft snorkel seal leak; this may be caused by an exposed seam in the weld area. If this is the case, follow procedure listed for repair. If no exposed seam is observed, only seal replacement is required.

## REQUIRED ACTION

### Supplies needed:

- 1/16" drill bit
- Abrasive pad or emery cloth
- Loctite 5900
- Loctite #97473 Fixmaster Superior Metal

1. Clean surrounding leak area, then sand with abrasive pad, emery cloth, wire wheel, etc. DO NOT GRIND!



2. Pilot punch ends of crack to prepare for drilling.



3. Use a 1/16" bit drill at both ends of the crack.  
Note: bit should have a slightly larger diameter than the width of the crack.



4. Post drilling image.



5. Mix Loctite #97473 Fixmaster Superior Metal epoxy per enclosed instructions contained in the kit.



6. Apply epoxy to effected area, smooth in. Let cure OVERNIGHT, then lightly sand with emery cloth or abrasive pad. DO NOT GRIND. Sand until there is a smooth uniform layer across the flange



7. Apply Loctite 5900 sealant to snorkel seal MBA0139976746 where the flange and outside diameter of the seal meet.



8. Install Seal MBA 0139976746, Note: Image is for demonstration only; actual repair will be performed with the thru-shaft installed.



9. After seal installation, add an additional bead of sealant to outer edge of the seal.



10. Repair completed.



## CONTACT INFORMATION

Please contact the Detroit™ Customer Support Center at 855-253-0427 or email [csc@daimler.com](mailto:csc@daimler.com) if you have any questions.