

**RETROFIT CASSETTE SEAL KITS FOR THE THROUGH DRIVE
DIFFERENTIAL CARRIERS**

Improved cassette seals for the input/output flange sealing in the heavy through drive tandem & tridem differential carriers are available now also as retrofit kits for converting the earlier sealing to the new design which has been introduced in the new axles in production. Because of the new cassette seal also the seal housings and input/output flanges are new. When doing the conversion a seal kit and an associated input/output flange are both needed (except output flange for differential carrier assembly FP-330 in FRFP-13/16 & FSFP-14 axles which remains same as earlier). The cassette seals in the seal kits are factory installed into the seal housings so the conversion work is mainly changing the seal housings and the input/output flanges. Please see the maintenance manuals for differential carrier assemblies MP-330 (for FRMP-13/16 & FSMP-14 axles) and FP-330 (for FRFP-13/16 & FSFP-14 axles).

Cassette Seal Kits are available for the following differential carrier assemblies:

Diff. Carrier Assy	Application
MP-330	FRMP-13/16 & FSMP-14 Axles
FP-330	FRFP-13/16 & FSFP-14 Axles

Available kits are the following

Kit part No.	Description
544-300-0011	Input Seal Kit for MP-330 & FP-330 Differential Carriers
544-300-0021	Output Seal Kit for MP-330 & FP-330 Differential Carriers

Items Included in Input Seal Kit 544-300-0011:

Description	Part No.	Qty
Adjusting Nut/Seal housing	543-226-1400	1
Cassette Seal	591122-08507	1
O-ring	91101-39530	1

Items Included in Output Seal Kit 544-300-0021:

Description	Part No.	Qty
Seal Housing	544-321-0500	1
Hex Screw	90303-10303	8
Cassette Seal	591122-08507	1

Input/Output Flanges in MP-330 & FP-330 Differential Carrier Assemblies:

Description	New Part No.	Old Item
MP330 Input HS1700/1800	538-918-1610	138-918-0400
MP330 Input ISO T180	538-918-1611	138-918-0401
MP330 Input Yoke 1710	538-967-0600	538-967-0100
MP330 Output HS1700/1800	538-917-2510	138-917-2410
MP330 Output ISO T180	538-917-2511	538-917-2411
MP330 Output Yoke 1710	538-967-0610	538-967-0110
FP330 Input HS1700/1800	538-918-0900	538-918-0700
FP330 Input ISO T180	538-918-0511	538-918-0500
FP330 Output HS1700/1800	No new flange needed	538-918-0710
FP330 Output ISO T180	No new flange needed	538-918-0510
FP330 Output Yoke 1710	No new flange needed	538-967-0310

Date of change: In axle production installing of the new input flange seal has started gradually by axle type from August 2004 (Mainly in the new model year 2005 axles). Axles assembled before this can be modified for the new cassette seals by using these retrofit kits.

INSTALLING INSTRUCTIONS

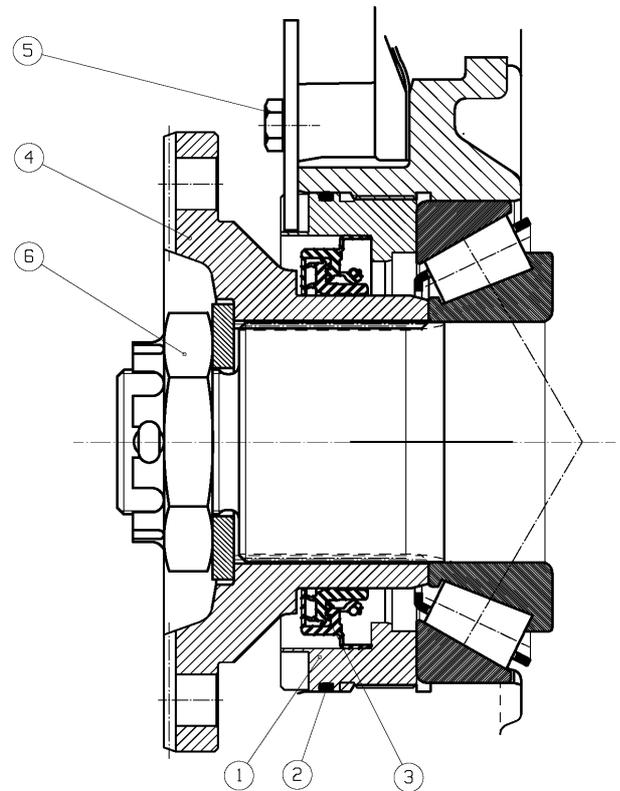
Installing instructions for the input flange cassette seal kit 544-300-0011:

(Please see maintenance manual also)

1. Remove the input drive flange and the bearing adjusting nut/seal housing.
2. Apply grease to the thread and o-ring groove of the new adjusting nut and Install the new o-ring to the groove and apply grease also to the outer surface of the o-ring.
3. Install the new adjusting nut/seal housing with the pre-installed seal. Tighten the adjusting nut until there is no clearance in the input axle bearings. Then tighten the nut still approx. one locking position more and then lock the nut to the nearest locking position with the lock plate. Apply thread locking compound to the lock plate cap screws and tighten to 21 Nm (15 lb-ft) torque.
4. When installing the new input flange it's sealing surface has to be wiped with blend of alcohol and water (1:1) to prevent installing friction between the input flange and the cassette seal. Also Klüberplus S 06-100 assembly gel can be used.

Note! If installed dry the cassette seal may damage.

5. Install the washer and tighten the flange nut to 600 Nm (442 lb-ft) torque and secure with a cotter pin.



Picture 1. Input flange cassette sealing

1. Adjusting Nut/Seal housing
2. O-ring
3. Cassette Seal
4. Input Flange
5. Lock plate screws (2 pcs)
6. Flange Nut

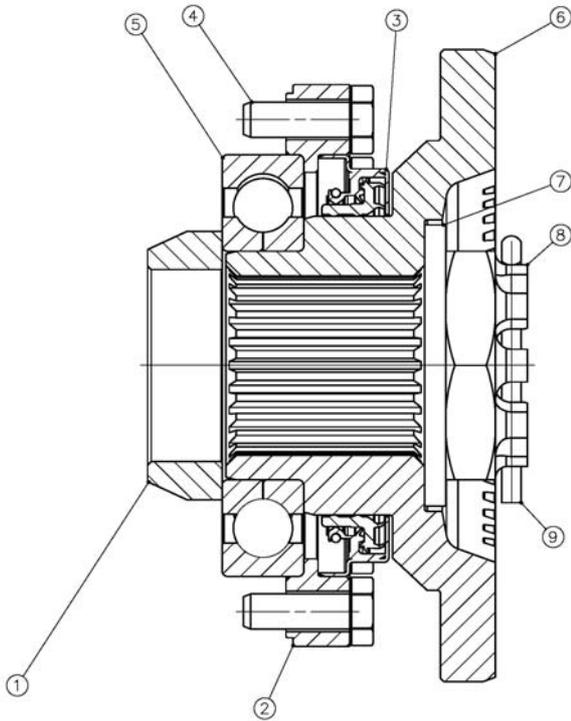
Installing instructions for the output flange cassette seal kit 544-300-0021:

(Please see maintenance manual also)

1. Remove the output drive flange and the seal housing.
2. Clean the seal housing mounting surface of the axle housing and apply RTV silicone rubber to the surface for sealing.
3. Install the new seal housing with the pre-installed cassette seal.
4. Apply locking compound (medium) to the threads of the eight fixing screws and tighten to 41 Nm (30 lb-ft).
5. When installing the new output flange it's sealing surface has to be wiped with blend of alcohol and water (1:1) to prevent installing friction between the output flange and the cassette seal. Also Klüberplus S 06-100 assembly gel can be used.

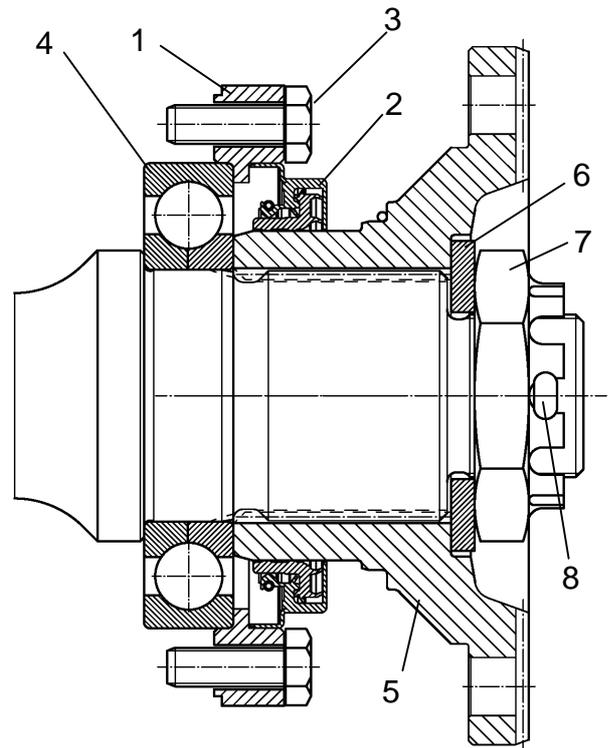
Note! If installed dry the cassette seal may damage.

6. Install the washer and tighten the flange nut to 600 Nm (442 lb-ft) torque and secure with a cotter pin.



Picture 2. Output flange cassette sealing in tandem MP-330 Differential Carrier

- 1. Spacer ring
- 2. Seal housing
- 3. Cassette Seal
- 4. Fixing screws
- 5. Ball bearing
- 6. Input Flange
- 7. Washer
- 8. Flange Nut
- 9. Cotter pin



Picture 3. Output flange cassette sealing in tridem FP-330 Differential Carrier

- 1. Seal housing
- 2. Cassette Seal
- 3. Fixing screws
- 4. Ball bearing
- 5. Output Flange
- 6. Washer
- 7. Flange Nut
- 8. Cotter pin

Note! Instructions for changing the cassette seals in the axles with the new sealing design are described in Product Change Note P14003.

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