

**INSTRUCTIONS FOR CHANGING THE AXLE BREATHER POSITION
IN SISU FRMP-10/11 AXLES**

The axle breather can be moved from the differential carrier housing to the axle housing if necessary. When making the connection thread for the breather, care has to be taken that no machining chips will remain inside the axle housing.

If the differential carrier assembly is removed the machining chips should be removed before installing the differential carrier assembly.

The thread for the breather can be made also without removing the differential carrier assembly according to the instructions below (the dimensions in the drawing are in millimeters only):

- With a drill approx. $\varnothing 6$ mm (1/4 inch) drill a bore almost through the axle housing. Note the thickness of the material, which is 12 mm (0.47 inch).
- Then with nearly flat pointed $\varnothing 14.8$ mm (0.58 inch) drill widen the bore also almost through the material. When estimating the depth of the bore, the previous smaller bore can be used for help.
- Tap R 3/8" thread to the bore and clean the bore.
- With a suitable centre punch and a hammer break through the bottom of the bore. The hole must be at least as big as the as the inner diameter of the breather hose.

