



Spicer® Drive Axles

P/N: SHAIS167

Repair Instructions for S110 Wheel Seal Leaks on Ford Trucks

Affected Models:

Dana S110 drive axles built for Ford Motor Company between February 1, 2004 and February 28, 2005.

Dana recommends that both wheel ends be repaired even if there are no signs of a leak on the opposing side. Repair kits have been created with the material need to insure a proper repair. Repair kit P/N 513981 contains a special installation tool that must be used during this repair. If additional installation tools are **not** needed, order repair kit P/N 513982. This kit contains the same material minus the installation tool.

This repair is limited to product built between the dates listed above. The axle carrier assembly contains a tag with it's own unique serial number. Serial numbers between HN01297868 and HN01775113 are the only axles included in this repair.

Installation Instructions:

1. Block the wheels of the steer axle front and rear.
2. Remove both wheels, hub assemblies and inner bearing cones.
3. Remove and discard old wheel seals.
4. Clean any oil or contamination from the seal-mounting surface of the hubs and the axle spindles.
5. Apply a line of Loctite 680 to the spindle at the seal journal. It is important that the Loctite is applied around the entire circumference of the seal journal.



Seal Journal Location



Apply Loctite 680

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- Place the Speedi-Sleeve into the installation tool with the rolled lip facing outward as shown below.



Rolled Lip Should Face Outward

- Place the sleeve/tool over the housing spindle. Ensure that the sleeve is aligned to the spindle and that the tool is not cocked.
- Using a dead-blow hammer, install the sleeve on to the spindle. The tool will bottom out on the spindle end when the sleeve is in the correct position.



Install sleeve with Driver



Bottom Out Installation Tool

- Install new wheel seals utilizing the appropriate seal driver.
Important note: Not using the appropriate CR Seal driver may result in improper seal installation.
- Reinstall the hub assembly, bearings and wheel end nut system.
- Set wheel endplay .001" to .005".

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For spec'ing or service assistance, call 1-800-621-8084 24 hours a day, 7 days a week.
Or visit our web site at: <http://www.spicerparts.com>

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