DAIMLERCHRYSLER

DaimlerChrysler
India Private Limited

Pune, September 23, 2004

All Workshop Incharge
DC India dealerships / ASC

Service Measure – Seal off internal suction damper (ISD) hole with adhesive.

Model 168, 208, 210, 215, 220.

Dear All,

On the above cited models a leak in the internal suction damper for the ASR/ESP hydraulic unit can occur during light brake operation. This can in extreme cases a small amount of brake fluid to be expelled through the internal membrane of the integral suction damper. In order to avoid this situation right from the start, the ISD hole on these models is to be sealed off.

The affected vehicle list and work instructions are enclosed herewith.

Parts

Quantity	Designation	Part No.
01	Dispensing gun (for all vehicles)	W 220 589 03 63 00
01	Adhesive cartridge (check expiration date)	A 008 989 97 71
01	Repair set	W 220 589 04 63 00

Operation text and flat rates:

Operation text: Seal off internal suction damper (ISD) hole with bonding material

Operation No. -02-4334 Flat rates -0.6 h

Damage code - 043910267

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Cost Settlement:

A warranty / goodwill claim for the cost of labour and material can be submitted through the usual warranty process channel quoting **accounting no. 4391026**.

Completion Deadline:

This Service Measure actvity is to be completed as soon as the vehicle reports to workshop for any work. Please note that if the vehicle visits the workshop for some warranty repairs then the activities of relevant campaigns must be done immediately otherwise the warranty claims for the other repairs will not be processed. **This Service Measure should be completed by 31st December 2005.**

Kindly explain the above instructions to your concerned staff and also provide your personal attention to complete this campaign as soon as possible.

Please acknowledge receipt of this letter and in case of any queries, please feel free to contact us.

Thanking you,

With best regards,
DaimlerChrysler India Private Limited

A. Faria
General Manager
Aftersales

D. Thakur
Sr. Manager
Customer Service

Copies to – DCIPL Service Representatives } for close follow up with the workshops.

Encl. – As above

ork description for service measure:

Inject adhesive into bore of internal suction damper (ISD)
Various models

Requirements:

- For injecting adhesive into the ISD, the hydraulic units must not be hotter than 80 °C but must be at a temperature of at least 20 °C.
- The service brake of the vehicle to be treated must not be operated for at least 2 hours after injecting the adhesive.
- Otherwise, it is not guaranteed that the adhesive has cured and that reliable adhesion has been provided. Therefore, before starting the operation, park the vehicle at a location at which it may stay for this period.

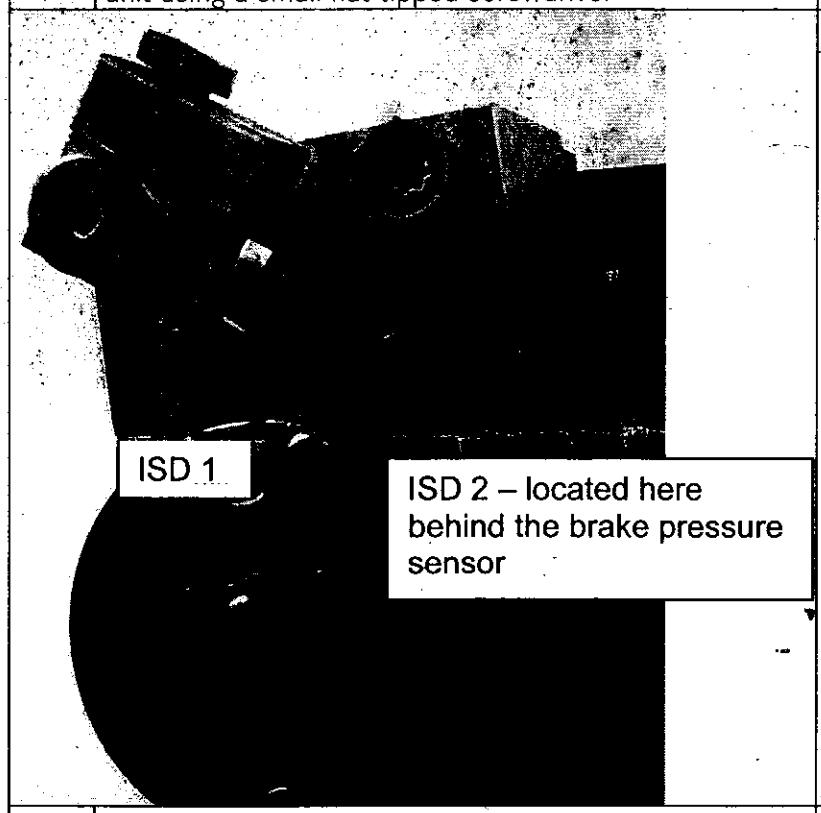
Shelf life of adhesive:

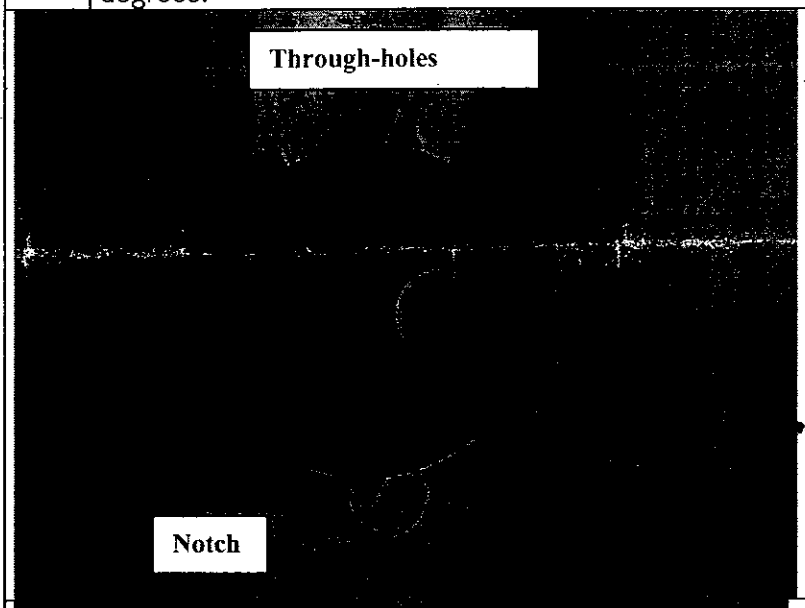
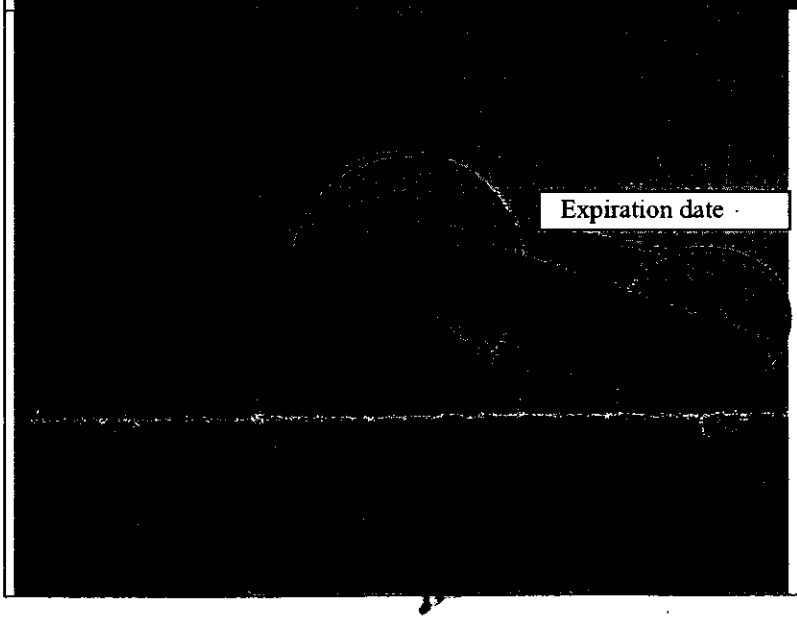
- A new adhesive cartridge in the original aluminum packaging will keep at room temperatures of approx. 23 °C until the expiration date. The expiration date of the adhesive is provided on the aluminum packaging and on the orange-colored label (see Figure 3) on the adhesive cartridge.
- The adhesive cartridge with the earliest expiration date should always be used.

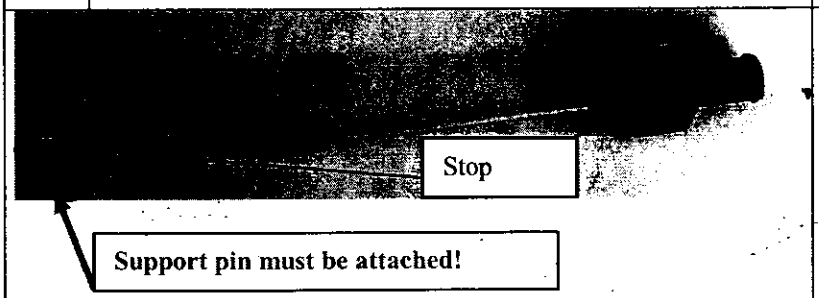
Note:

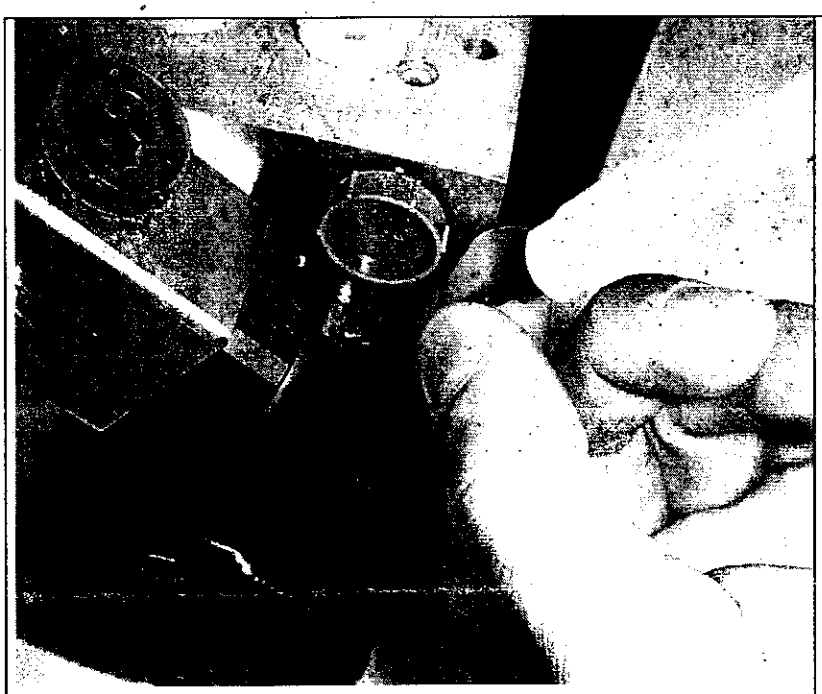
- If the hydraulic unit has a leak in the area of the ISD, this hydraulic unit must be replaced.

! The described procedure must be followed !

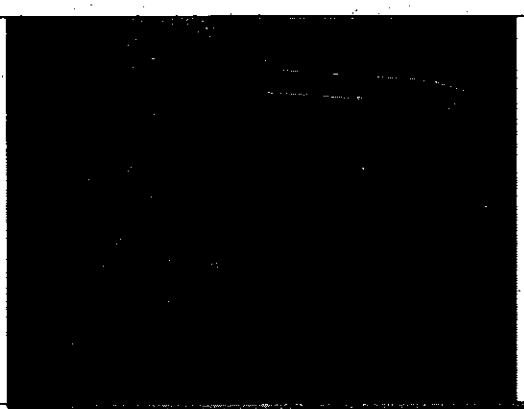
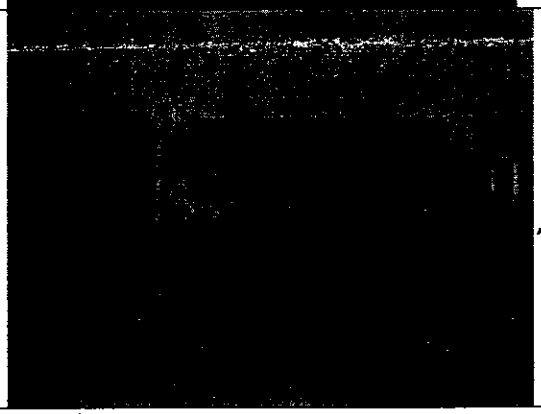
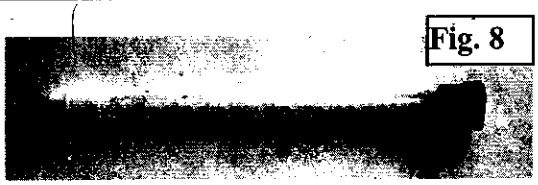
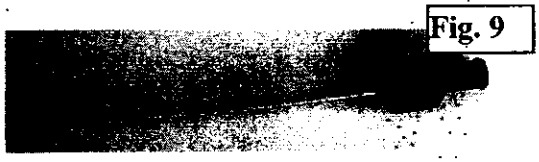
1.	Pry off black cap(s) (see Figure 1) from the hydraulic unit using a small flat-tipped screwdriver	
		Figure 1: Position of the ISD at which the caps must be pried off.
2.	Using the cleaner swabs provided in the repair kit, clean the ISD bores. Insert a clean cleaner swab into the first bore as far as possible, then turn it 180° and pull it out. Now similarly push in the other end completely, turn it 180° and pull it out. Repeat this on the second ISD bore using the second swab.	
3.	Assemble the dispensing gun. Insert adhesive cartridge (see Figure 7) into the dispensing gun (see Figure 6) and lock dispensing gun.	

4.	Remove cap on adhesive cartridge, attach mixing nozzle. When attaching the mixing nozzle, ensure that the two round through-holes are at right angles to the notch of the bayonet lock (see Figure 2). To insert the mixing nozzle, the notches on the bayonet lock must be aligned with those on the adhesive cartridge. Then secure the joint by turning the bayonet lock 90 degrees.	
		Figure 2: Through-holes in mixing nozzle at right angles to the notch on the bayonet lock
		Figure 3: Mixing nozzle attached

5.	Only perform for new mixing nozzle: Operate dispensing gun until the adhesive completely fills the mixing nozzle. The dispensing gun must be held at a steep upward angle so that any residual air in the mixing nozzle is able to escape. Then fully press the lever of the dispensing gun once and dispose of the adhesive that emerges.	! This is necessary to achieve even mixing of the 2-component adhesive when using a new mixing nozzle. ! The mixed adhesive starts to cure after 6 min.
6.	Hand-tighten the filler unit (see Figure 4) clockwise onto the tip of the mixing nozzle.	
7.	Check whether the support pin at the end of the filler unit is attached (see Figure 4). If the support pin is missing, use a new repair kit.	! Support pin must be attached to the filler unit, otherwise there is the danger that the adhesive will penetrate into the hydraulic unit.
		Figure 4: Support pin attached to filler unit
8.	Bend filler unit and carefully insert it into the ISD bore as far as the stop (shoulder on hose) (see Figures 4 + 5). The filler unit must be bent, but must not be pinched or kinked anywhere, otherwise the hose will be unable to escape to the rear when squirting.	! Caution: !!! A pinched or kinked hose may burst in extreme cases!

		Figure 5: Insert filler unit into the ISD bore as far as the stop (see Figure 4)
9.	Now squeeze the dispensing gun slowly and evenly using moderate force of the hand and hold for approx.10 s. The filler unit will then slowly be pushed out until it emerges from the ISD bore.	Information: If the filler unit does not slide out of the ISD bore on its own, check whether it is caught anywhere. ! Caution: Do NOT pull the filler unit out of the bore by hand under any circumstances. When injecting adhesive, do not apply to much force to the dispensing gun and mixing nozzle.
10.	Unscrew the filler unit from the mixing nozzle and throw away.	
11.	Inject adhesive into second ISD bore. ! On vehicles with ESP, two ISD bores must be injected with adhesive. ! On vehicles with ASR, there is only one ISD bore and this needs to be filled.	
12.	After injecting adhesive into the second ISD bore, dispose of the adhesive cartridge, mixing nozzle and filler unit.	
13.	Attach black cap(s) (see Figure 1) to the hydraulic unit	

Tools/aids:

Designation	Picture	Part no.
"Dispensing gun" (Fig. 6) ***Delo model 904 (DS53)***		W 220 589 03 63 00
Adhesive cartridge (Fig. 7) with 2-component adhesive		A 008 989 97 71
Repair kit comprising *3x stop caps (not illustrated)* *1x mixing nozzle (Fig. 8)* *2x filler units (Fig. 9)* *2x cleaner swabs (not illustrated)*	 Fig. 8  Fig. 9	W 220 589 04 63 00

Operation text and flat rate

Operation no.	Operation text	Flat rate
02-4334	Inject adhesive into bores of internal suction damper (ISD)	0.6 hrs.