



SERVICE INFORMATION

Nr. 02_05

Type: ASTRONIC
CC list SSO: all
CC list OEM: all
CC list customer: --

Model: 1327,1328,1329,1337,1339
1348,1353,4231,4232,4240,4241
Subassembly: Heat exchanger

Date: 2005-01-20
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New Housing Seals in ASTRONIC 2 Transmissions

In the past, the housing seals used on ASTRONIC 2 transmissions have involved a liquid gasketing agent. Solid seals (metal gaskets) are to be used instead in the future. The thicknesses of the metal gaskets must be taken into account in the housing assembly. New housings 2 with a reduced total length have been introduced for this purpose. There are two versions of housing 2, with different lengths.

The new components, housings and metal gaskets are being launched into volume production through parts list changes.

Measures:

The new housings are being introduced in two steps:

- 1st step: Introduction of housing with reduced total length, (raw part as before, see Figure 2).
- 2nd step: Introduction of housing with reduced total length with optimized raw part (new pressure die cast part, see Fig. 3).

The following **MUST** be noted during repairs:

Old housings must be fitted with **liquid gaskets**,
New housings must be fitted with **solid seals (2 metal gaskets)**.

Non-compliance with this procedure will result in transmission failure!

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Components affected:

- Housing 2 (1st step)

	OLD	NEW	
Designation	Item number	Item number	Remark
Housing	1328 301 060	1328 301 069	Housing 2, long version
Housing	1327 301 023	1327 301 026	Housing 2, short version

- Seals

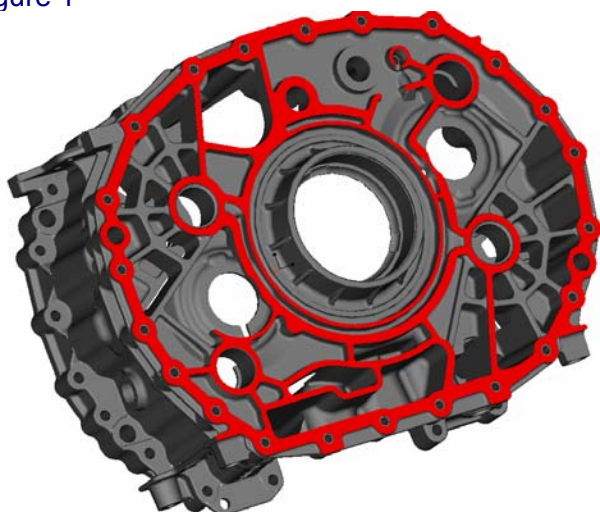
	Designation	Item number	Remark
OLD	Sealing compound	0666 791 001	Replacement part, 22 g tube
	Gasket	0666 790 040	Replacement part, 7 g tube
NEW	Seal	0501 321 442	Metal gasket, Clutch housing - housing 2
	Seal	0501 321 443	Metal gasket, Housing 2 - GP housing

Diagram of sealing face/GP thrust surface of housing 2:

- **OLD** Assembly with liquid gasket

Housing sealing face and thrust surface of GP plate at the same height

Figure 1



- **NEW, volume production introduction of 1st step**

Assembly with solid seal

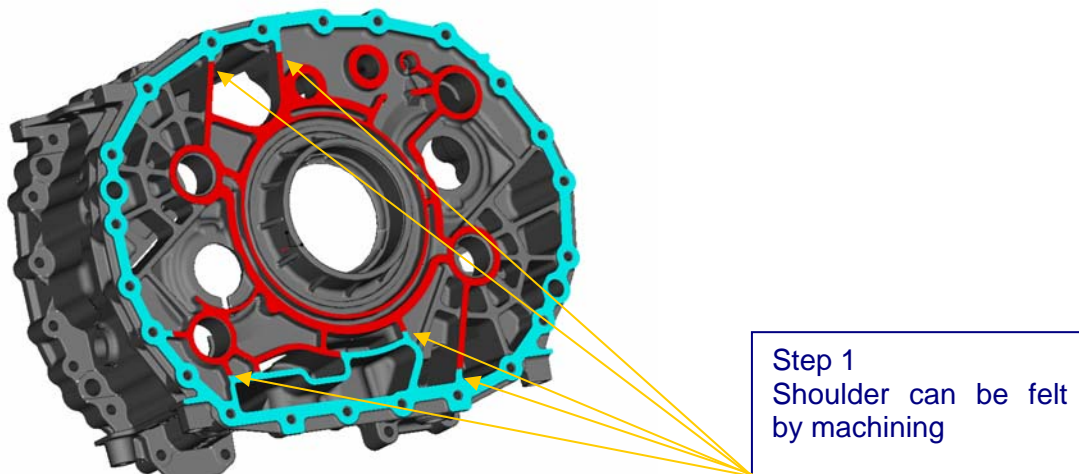
Shoulder can be felt when machining between housing's sealing face and thrust surface of GP plate.

Blue = Housing's sealing face

Red = Thrust surface of GP plate

Date for introduction as of approx. January /February 2005

Figure 2



- **NEW, volume production introduction of 2nd step**

Assembly with solid seal

Interruption of webbing, visual division of housing's sealing face from thrust surface of GP plate.

Conversion into new pressure die cast shape.

Date of introduction approx. 3rd quarter of 2005

Figure 3

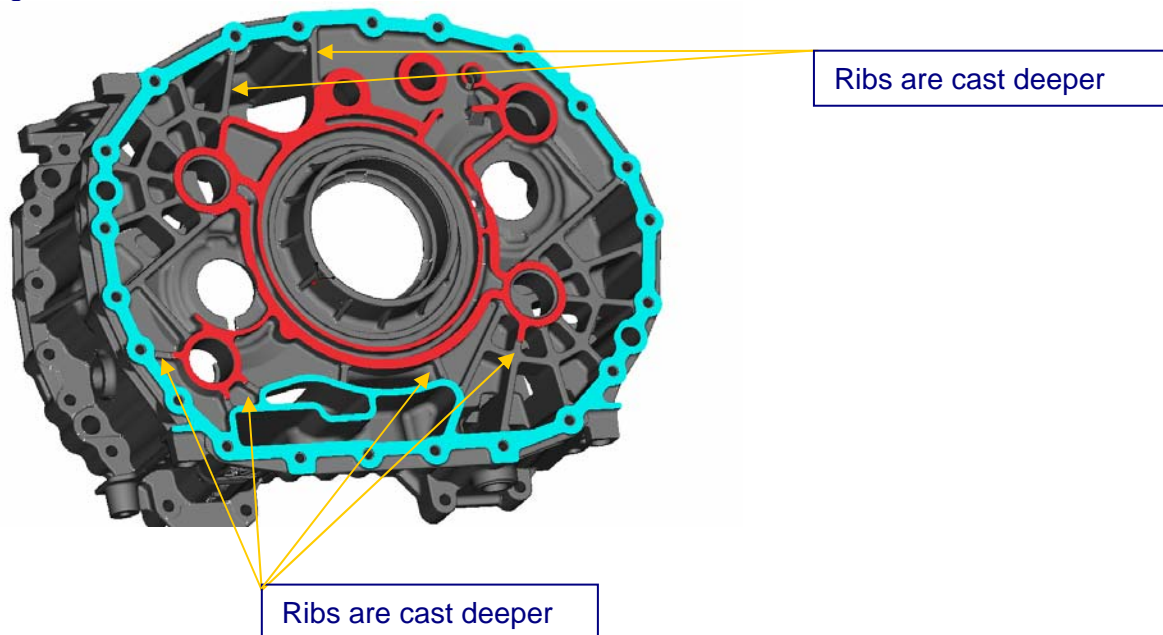
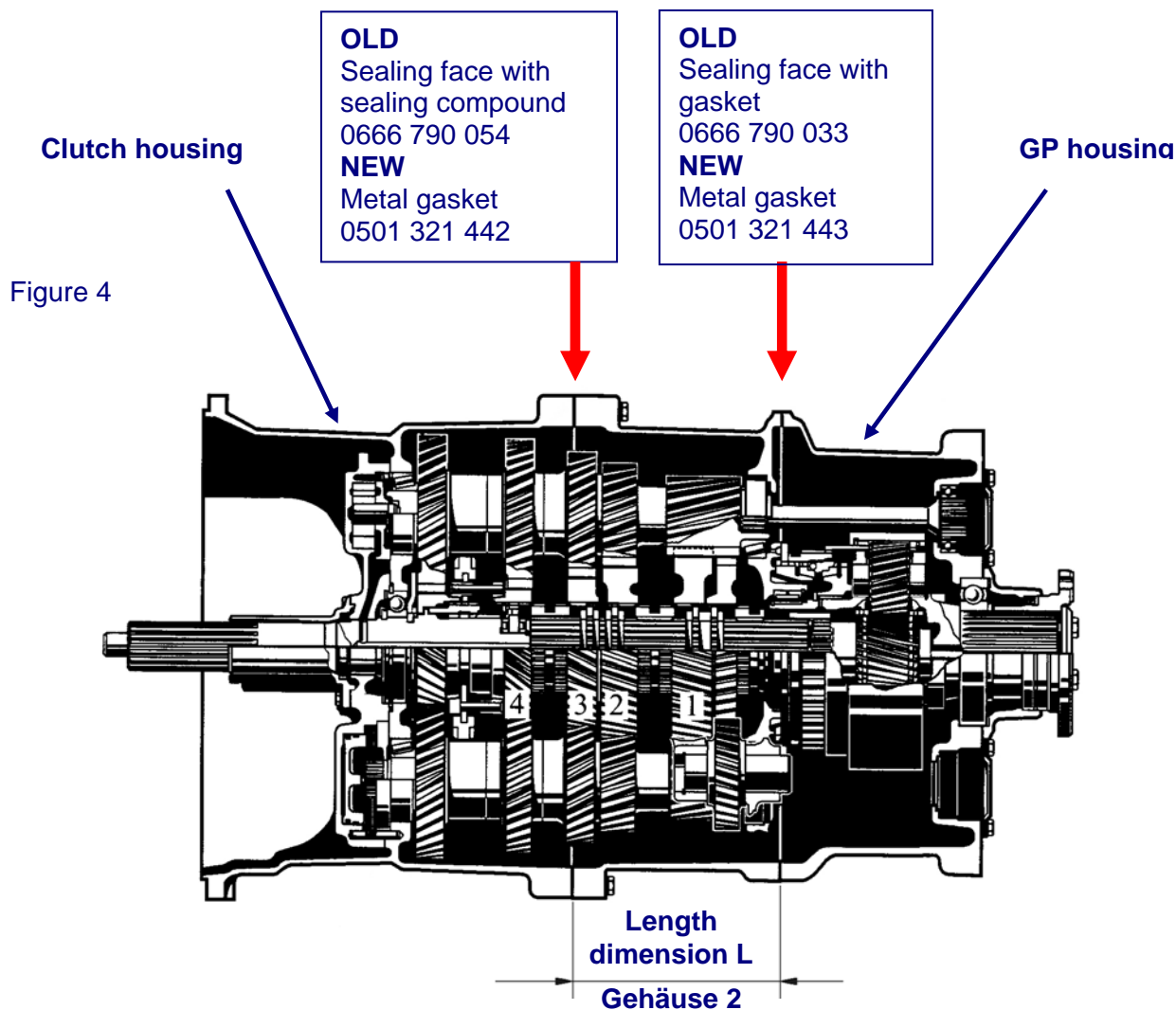


Diagram of ASTRONIC 2 transmission



	Item number	Dimension L, housing 2	Remark
OLD	1328 301 060	227.5 -0.1	Housing 2, long version
	1327 301 023	184.5 -0.1	Housing 2, short version
NEW	1328 301 069	226.75 -0.13	Housing 2, long version
	1327 301 026	183.75 -0.13	Housing 2, short version

Start data:

Parts list modification for 1st step

Parts list change notification	Launch date	Remark
9723D	15.06.2005	Housing 2, long new + 2 metal gaskets
1019E	15.06.2005	Housing 2, short new + 2 metal gaskets

**Spare parts:**

Liquid gaskets are still available for repairs. The metal gaskets are included in the current sealing kit 1327 298 001. Old housings 2 will be used up and replaced by kits (each containing one housing 2 and two metal gaskets). Any old housings 2 still available can be used.

Kits available

- New ▶ • Housing 1327 298 002** consisting of:

Quantity	Designation	Order number	Remark
1	Housing	1327 301 026	Short version
1	Seal	0501 321 442	Clutch housing - housing 2
1	Seal	0501 321 443	Housing 2 - GP housing

- New ▶ • Housing 1328 298.003** consisting of:

Quantity	Designation	Order number	Remark
1	Housing	1328 301 069	Long version
1	Seal	0501 321 442	Clutch housing - housing 2
1	Seal	0501 321 443	Housing 2 - GP housing

- **Sealing kit 1327 298 001** consisting of:

Quantity	Designation	Order number	Remark	
4	Sealing ring	0730 008 637	A 24x29	
2	Sealing ring	0730 009 515	A 22x27	
1	Sealing ring	0634 801 013	A 10x14	
1	Seal	0501 316 322		
1	Shaft seal	0750 111 348	OTK 55x70x8	
2	Shaft seal	0734 309 397		
1	Shaft seal	0734 319 459	105x125x12/9.5	
1	O-ring	0634 313 805	82x4	
4	O-ring	0634 313 523	13x2	
1	Grooved ring	0501 318 282	71.7x6.5	
1	Compression spring	0732 040 385		
2	Gasket	0666 790 040	7 g tube	
1	Sealing compound	0666 791 001	22 g tube	
1	Seal	1238 308 201		
2	Sealing ring	0634 801 308	A20x24	
New ▶	1	Seal	0501 321 442	Metal gasket
New ▶	1	Seal	0501 321 443	Metal gasket