



Labor Time Standards for Meritor's RPL Series Permalube™ Driveline

Introduction

- Labor time allowances in this document result from labor time studies performed on Meritor's RPL Series Permalube™ driveline.
- Time study procedures were performed according to industry standards and developed by an experienced, independent firm that specializes in heavy- and medium-duty trucks, automotive service publications and labor standards development.
- Labor time allowances in this bulletin can be used to address warranty issues that relate to repairs on Meritor's RPL Series Permalube™ driveline.

Procedure Timing

- Each timed step reflects the actual repair time incurred for that step.
- A technician who is familiar with a procedure can perform that procedure more quickly. In these instances, the timed steps were repeated to obtain an average time.
- Labor allowance times provided are repair time, parts cleaning time, and adjustment and inspection times required to correctly complete the repair.

Allowances

- The labor time allowances published in this bulletin are adjusted upward by 40 percent from the "actual repair time" to allow for usual variations in equipment, facilities, the technician's personal time, normal work interruptions, and parts and tool procurement time. This 40 percent allowance represents a typical allowance for the truck industry.

Tools and Work Practices

- Common air and hand tools were used to disassemble and assemble components, except in those instances where special tools are specified.
- For assembly procedures, air tools were used only in areas that did not adversely affect the integrity of components and fasteners.
- For assembly and disassembly procedures on lighter components and smaller fasteners, air ratchets or hand tools were used.
- As the final assembly step, all fasteners were tightened to the correct torque specifications.

Service Information

All labor time allowance procedures were performed according to Meritor's maintenance manual No. MM-96147, *Drivelines*. To order a copy of this publication, call Meritor's Customer Service Center at 800-535-5560. Additional information on Meritor's RPL Series Permalube™ driveline is also available by accessing Meritor's website at www.meritorauto.com.

Time Study Operation: Inspect Driveline Deflectors

Step	Operation Description
1	Block the wheels
2	Raise one dual wheel (to rotate driveshaft)
3	Cage one parking brake spring
4	Rotate interaxle driveshaft and check seals and deflectors
5	Check for looseness
6	Release caged parking brake spring
7	Lower one dual wheel and remove wheel chock

Total Time: 17.5 minutes

Time Study Operation: Removal and Replacement of Interaxle Driveshaft Plus Replace Universal Joints

Step	Operation Description
1	Block the wheels
2	Raise one dual and cage one parking brake spring (to rotate driveshaft)
3	Install temporary driveshaft support
4	Remove attaching bolts and driveshaft
5	Remove wing bushings
6	Remove snap rings and press out round bushings
7	Clean up yokes
8	Press in new bushings and install snap rings
9	Install grease plugs
10	Install driveshaft and lower one dual wheel
11	Remove temporary driveshaft supports
12	Release caged parking brake spring and remove wheel chock

Total Time: 2 hours
3 minutes

Time Study Operation: Removal and Replacement of Main Driveshaft Plus Replace Universal Joints — Section #1*

Step	Operation Description
1	Install temporary driveshaft supports
2	Remove #1 section of the driveshaft from the truck
3	Remove wing ends
4	Remove snap rings
5	Remove one universal joint
6	Install one universal joint
7	Install #1 section of the driveshaft and remove the temporary supports

Total Time: 49 minutes

Time Study Operation: Removal and Replacement of Main Driveshaft Plus Replace Universal Joints — Section #2*

Step	Operation Description
1	Install temporary driveshaft supports
2	Remove attaching bolts and driveshaft
3	Remove wing ends
4	Remove snap rings
5	Press out round bushings and universal joint
6	Clean up both yoke ends
7	Press in new round bushings and install new snap rings
8	Install grease plugs
9	Install #2 section of the driveshaft and remove temporary supports

Total Time: 86 minutes

***NOTE**

If only this section of the driveline is removed, perform the following steps:

At the beginning of the procedure

- ***Block the wheels.***
- ***Raise one dual wheel and cage one parking brake spring (to rotate the driveshaft).***

At the end of the procedure

- ***Release the caged parking brake spring and remove the wheel block.***

Total Time: 12.75 minutes



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