



Service Letter

**Service Letter No. 413
October, 1994**

SUBJECT: Retightening Loose Pipe Plugs and Plenum Plugs

MODELS AFFECTED: 349A

Loose pipe plugs or plenum plugs encountered in service can be easily corrected without replacing the engine brake housing. To do this, the loose plug should be completely removed from the housing. Clean the thread area of the plug with a solvent or threadlocker primer (Loctite® 755 or equivalent) to remove all oil and old sealant.

Once the threads are clean and dry, apply an appropriate threadlocker (Loctite® 271 or equivalent) and reinstall the plug.

Tighten the plug to the appropriate torque values as follows:

Plenum End Caps	65 lbft. (88 N•m)
3/8" Pipe Plugs	35 lbft. (47 N•m)
1/16" Pipe Plugs	95 lbin. (10.7 N•m)

Allow the threadlocker to cure per the manufacturer's instructions.