SERVICE LETTER SL2014-001
Rev. 3
November 2020

From:	Soucy Track Technical Service Department
To:	Soucy Track systems operators and technical staff
Object:	Rubber Track Repair Procedure - Replace SL2011-002R1
Description:	Provide guidance and instructions on repairing rubber track damage.

INTRODUCTION:

Minor cracks are part of the normal wear of rubber tracks on a tractor. Some damage can be the results of field hazard while other cracks can be cause by stress due to repetitive cycle of sprockets tracking internal lugs as well as resistance of track on ground (lateral stress) when steering the tractor. It can also be the results of natural aging of rubber while constantly exposed to climate variations, UV and ozone exposure thus causing hardening of the rubber and eventually leading to cracks. To minimize the aging process, a good practice would be to store the tractor in a shed for long seasons of inactivity and to drive the tractor at least once a month during the storage period.

Normally small cracks or damage would not affect performance or durability of tracks; however, they can be easily repairable. The object of the repair is primarily to prevent water and debris infiltration into cavities. Refer to following instructions for repair procedure.

REQUIRED MATERIAL:

You must have on hand Permabond 268 Adhesive / Part Number: LUB-023

Contact Soucy track Parts Dept. to order.

TRACK REPAIR INSTRUCTIONS:

1. Repair must be done indoor with adequate ventilation.
2. Track must be dry and free of any contamination such as dirt, dust, grease or oil.
3. Clean and dry cavity before applying glue.
4. For damage on the outer track surface, move the tractor to get the cavity on top of the sprocket.
5. For damage on the inner track surface, move the tractor to get the cavity out of the sprocket.
6. Fill the cavity with the Permabond 268 adhesive.
7. Use a clamp to keep cavity closed for 24 hours at room temperature before using the track.

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SAFETY NOTES:

- Soucy track recommends frequently inspecting the repair zone of the track for any subsequent damage. Repeat the procedure if necessary.
- When working with the adhesive, do as follows:
- Read the Permabond 268 Material Safety Data Sheet (attached) before handling the product.
- The temperature in the work area must be at least 25 °C. The set time of the adhesive is ten seconds.
- Before opening the adhesive container, let it warm to room temperature; otherwise, water might condense into the bottle and cause hardening of the adhesive.
- Wear polyethylene gloves. Do not wear rubber gloves.

For more information:

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