



**RECEIVED**  
By Recall Mgt Div. at 12:23 pm, May 11, 2010

Timothy J. Nalepka  
Senior Vice President & General Counsel

Direct Line: (847) 285-2085  
Facsimile: (502) 318-8085

May 10, 2010

**BY EMAIL AND**  
**BY CERTIFIED MAIL**

Associate Administrator for Enforcement  
National Highway Traffic Safety Administration  
Attention: Recall Management Division (NVS – 215)  
1200 New Jersey Avenue, SE.  
Washington, DC 20590

**Re: PART 573 NOTICE RE ARVINMERITOR ADAPTER PLATE BOLT TORQUE**  
**(10E-014)**

Dear Sir or Madam:

I have enclosed Motor Coach Industries, Inc.'s ("MCI") Part 573 Defect and Noncompliance Report.

Please confirm receipt of this notice and provide NHTSA's reference number. MCI's proposed customer notification letter, draft Service Bulletins 345 and 346, and sample envelope and mailing label will be sent under separate cover.

Thanks for your assistance with this matter.

Sincerely,  
MOTOR COACH INDUSTRIES, INC.

By: Timothy J. Nalepka  
Senior Vice President &  
General Counsel

Enclosure

c: Sonny Murianka (by email, w/ encl.)

Safety Defect and Noncompliance Report Guide for Vehicles  
**PART 573 Defect and Noncompliance Report**

On May 4, 2010, Motor Coach Industries, Inc. decided that a defect which relates to motor vehicle safety exists in the motor vehicles listed below, and is furnishing notification to the National Highway Traffic Safety Administration in accordance with 49 CFR Part 573 **Defect and Noncompliance Reports.**

Date this report was prepared: **May 10, 2010**

Furnish the manufacturer's identification code for this recall (if applicable):

**MCI Service Bulletins 345 and 346**

1. Identify the full corporate name of the fabricating manufacturer of the vehicle being recalled. If the recalled vehicle is imported, provide the name and mailing address of the designated agent as prescribed by 49 U.S.C. §30164.

**Motor Coach Industries, Inc.  
1700 E. Golf Road  
Suite 300  
Schaumburg, IL 60173**

Identify the corporate official, by name and title, whom the agency should contact with respect to this recall.

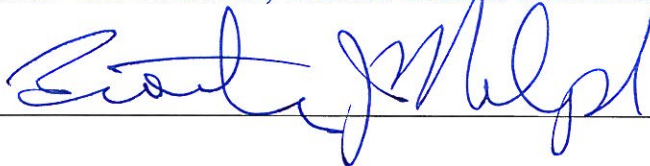
**Bryan Couch, Vice President & General Manager of Operations**

Telephone Number: **(204) 287-4447** Fax No.: **(204) 478-2867**

Name and Title of Person who prepared this report.

**Timothy J. Nalepka  
Senior Vice President, General Counsel & Secretary**

Signed: \_\_\_\_\_



**I. Identify the Vehicle Models Involved in the Recall**

**2. Identify the Vehicles Involved in the Recall, for each make and model or applicable vehicle line (provide illustrations or photographs as necessary to describe the vehicle), provide:**

All MCI D, E, and J series coaches equipped with an ArvinMeritor Unitized Wheel End (UWE) steer or trailing (tag) axle identified by ArvinMeritor as potentially containing the safety-related defect. See the attached ArvinMeritor Defect Information Report dated April 30, 2010, and ArvinMeritor customer notification letter dated May 7, 2010, for further information.

**Make(s):** MCI

**Model Years and Models Involved:**

1. 2010 D4000
2. 2010 D4005
3. 2010 D4500
4. 2010 D4505
5. 2010 E4500
6. 2010 J4500

**Production Dates:**

1. 2010 D4000	<b>Beginning:</b> October 2009	<b>Ending:</b> March 2010
2. 2010 D4005	<b>Beginning:</b> January 2010	<b>Ending:</b> March 2010
3. 2010 D4500	<b>Beginning:</b> September 2009	<b>Ending:</b> April 2010
4. 2010 D4505	<b>Beginning:</b> September 2009	<b>Ending:</b> April 2010
5. 2010 E4500	<b>Beginning:</b> November 2009	<b>Ending:</b> December 2009
6. 2010 J4500	<b>Beginning:</b> September 2009	<b>Ending:</b> May 2010

**VIN Range:**

1. 2010 D4000	<b>Beginning:</b> 59234	<b>Ending:</b> 59369
2. 2010 D4005	<b>Beginning:</b> 59308	<b>Ending:</b> 59376
3. 2010 D4500	<b>Beginning:</b> 59197	<b>Ending:</b> 59419

- |               |                  |               |
|---------------|------------------|---------------|
| 4. 2010 D4505 | Beginning: 59196 | Ending: 59415 |
| 5. 2010 E4500 | Beginning: 65501 | Ending: 65519 |
| 6. 2010 J4500 | Beginning: 65487 | Ending: 65597 |

59196 – 59419	65487 – 65597
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Descriptive information which characterizes /distinguishes the recalled vehicles from those model vehicles not included in the recall:

The recalled vehicles are the MCI motor coaches that are equipped with an ArvinMeritor UWE steer or tag axle identified by ArvinMeritor by axle serial number. See the attached ArvinMeritor Defect Information Report dated April 30, 2010, and ArvinMeritor customer notification letter dated May 7, 2010, for further information.

Identify the approximate percentage of the production of all the recalled models manufactured by your company between the inclusive dates of manufacture provided above, that the recalled model population represents. For example, if the recall involved Widgets equipped with certain items of equipment from January 1, 1996 through April 1, 1997, then what was the percentage of the recalled Widgets of all Widgets manufactured during that time period.

The recall population is 100% of the D, E, and J series coaches manufactured during the time periods referenced above.

## II. Identify the Recall Population

3. Furnish the total number of vehicles recalled potentially containing the defect or noncompliance.

<u>MODELS</u>	<u>MODEL YEARS</u>	<u>NUMBER OF VEHICLES INVOLVED</u>
D4000	2010	22
D4005	2010	3
D4500	2010	121
D4505	2010	78
E4500	2010	8
J4500	2010	103

Total Number Potentially Affected by the Recall: 335

4. Furnish the approximate percentage of the total number of vehicles estimated to actually contain the defect or noncompliance:

100%

Identify and describe how the recall population was determined--in particular how the recalled models were selected and the basis for the beginning and final dates of manufacture of the recalled vehicles:

MCI used the list of affected axles furnished by ArvinMeritor to identify the MCI vehicles into which the affected axles were installed.

### III. Describe the Defect or Noncompliance

5. Describe the defect or noncompliance. The description should address the nature and physical location of the defect or noncompliance. Illustrations should be provided as appropriate.

ArvinMeritor reports that the suspect UWE steer and tag axles may have had improper amount of torque applied to the hub/rotor/wheel adapter bolts during the assembly process. See the attached ArvinMeritor Defect Information Report dated April 30, 2010, and ArvinMeritor customer notification letter dated May 7, 2010, for further information.

Describe the cause(s) of the defect or noncompliance condition.

See the attached ArvinMeritor Defect Information Report dated April 30, 2010, and ArvinMeritor customer notification letter dated May 7, 2010, for further information.

Describe the consequence(s) of the defect or noncompliance condition.

ArvinMeritor reports that a reduced bolt torque potentially reduces the clamp force which, in turn, could lead to a vibration loosening concern. ArvinMeritor further reports that complete loss of clamp load could result in a wheel off condition, and that there is also a concern that the operational loads could be greater than the bolt clamping forces, which can lead to possible bolt fatigue issues. See the attached ArvinMeritor Defect Information Report dated April 30, 2010, and ArvinMeritor customer notification letter dated May 7, 2010, for further information.

Identify any warning which can (a) precede or (b) occur.

MCI is not currently aware of any such warning prior to the occurrence of an incident.

If the defect or noncompliance is in a component or assembly purchased from a supplier, identify the supplier by corporate name and address.

ArvinMeritor, Inc.  
2135 W. Maple Road  
Troy, Michigan 48084-7186

Identify the name and title of the chief executive officer or knowledgeable representative of the supplier:

Nirav Parikh  
Regional Quality Manager & Project Manager  
Product Safety and Compliance  
ArvinMeritor, Inc.  
2135 W. Maple Road  
Troy, Michigan 48084-7186

#### IV. Provide the Chronology in Determining the Defect/Noncompliance

*If the recall is for a defect, complete item 6, otherwise item 7.*

6. With respect to a defect, furnish a chronological summary (including dates) of all the principal events that were the basis for the determination of the defect. The summary should include, but not be limited to, the number of reports, accidents, injuries, fatalities, and warranty claims.

On April 7, 2010, MCI became aware of an incident involving MCI coach VIN 65581 in which a bolt had backed out of the wheel end adapter / rotor / hub bearing joint on the ArvinMeritor-supplied tag axle serial # NWK00223516. The bolt was discovered in the hub cap after completing an initial shakedown test run of the coach.

MCI reported the incident to ArvinMeritor on April 7, 2010. ArvinMeritor subsequently reported to MCI that after review of its assembly process, ArvinMeritor had determined that its assembly plant was not properly controlling the torque applied to the hub/rotor/wheel adapter bolts in the assembly process. ArvinMeritor further advised that it had immediately implemented containment action to verify all torques on all axles then being assembled in order to eliminate the torque issue on those axles.

MCI inspected a number of axles and found that the torques on the hub bolts were lower than the ArvinMeritor-specified torque limits. ArvinMeritor further advised MCI that it had also inspected axles at its facilities and determined the same result.

On April 30, 2010, ArvinMeritor advised MCI that ArvinMeritor had submitted information that day to NHTSA relating to the bolt torque issue. On May 7, 2010, ArvinMeritor provided MCI with the customer notification letter attached hereto.

7. With respect to a noncompliance, identify and provide the test results or other data (in chronological order and including dates) on which the noncompliance was determined.

N/A

#### V. Identify the Remedy

8. Furnish a description of the manufacturer's remedy for the defect or noncompliance. Clearly describe the differences between the recall condition and the remedy.

ArvinMeritor has advised that affected axles should be inspected and any loose bolts replaced in accordance with the attached ArvinMeritor Technical Bulletin TP-10110, at ArvinMeritor's expense.

Clearly describe the distinguishing characteristics of the remedy component/assembly versus the recalled component/assembly.

No discernible difference will be observed.

Identify and describe how and when the recall condition was corrected in production. If the production remedy was identical to the recall remedy in the field, so state. If the product was discontinued, so state.

ArvinMeritor advises that it undertook containment action at its factory on April 8, 2010, and that all axles ArvinMeritor shipped after April 8, 2010 had verified bolt torques.

#### VI. Identify the Recall Schedule

9. Furnish a schedule or agenda (with specific dates) for notification to other manufacturers, dealers/retailers, and purchasers. Please identify any foreseeable problems with implementing the recall.

MCI anticipates sending notifications to customers within one week after receiving approval by NHTSA of MCI's draft customer notification.

#### VII. Furnish Recall Communications

10. Furnish a final copy of all notices, bulletins, and other communications that relate directly to the defect or noncompliance and which are sent to more than one manufacturer, distributor, or purchaser. This includes all communications (including both original and follow-up) concerning this recall from the time your company determines the defect or noncompliance condition on, not just the initial notification. *A DRAFT copy of the notification documents should be submitted to this office by Fax (202-366-7882) for review prior to mailing.*

MCI's proposed customer notification letter and Service Bulletins 345 and 346 will be sent under separate cover.

Note that these documents are to be submitted separately from those provided in accordance with Part 573.8 requirements.



2135 W. Maple Rd  
arvinmeritoinc.com  
Troy, MI 48084

10E-014  
(3 pages)

April 30, 2010

Administrator of Enforcement  
Office of Defects Investigation  
National Highway Traffic Safety Administration  
400 Seventh Street S.W.  
Washington, D.C. 20590

Fax: 202-366-7882

Re: Defect Information Report, in accordance with 49 CFR §573.6, concerning certain front and tag axles shipped to ArvinMeritor customers between August 10, 2009 and April 6, 2010.

ArvinMeritor File: C10AA

NHTSA File: Unassigned

Dear Sir /Madam:

ArvinMeritor, Inc. submits this Defect Information Report in accordance with 49 CFR §573.6. The information is presented to correspond to the sub-paragraphs of section §573.6(c).

Information Requested under §573.6(c)(1)

This report is submitted by:  
ArvinMeritor, Inc.  
2135 West Maple Road  
Troy, Michigan 48084-7186

Information Requested under §573.6(c)(2):

The affected motor vehicle equipment are front and tag axles assembled at ArvinMeritor Newark, Ohio facility located at 444 Hebron Road, Heath, Ohio 43055, and shipped to ArvinMeritor customers between August 10, 2009 and April 6, 2010. A list of affected customers and quantities is contained in Appendix A of this notice.

The population of potential affected axles was determined by shipment records maintained by ArvinMeritor's Heath facility.

Information Requested under §573.6(c)(3):

ArvinMeritor has determined that approximately 685 axles were shipped during the suspect period. The axles may have had incorrect torque applied to the wheel adapter during the assembly process

Information Requested under §573.6(c)(4):

ArvinMeritor has determined that approximately 100% of the above mentioned population of axles may exhibit the conditions described in the paragraphs immediately below.

Information Requested under §§573.6(c)(5):



The suspect axles may have had improper amount of torque applied to the wheel adapter during the assembly process. A reduced bolt torque potentially reduces the clamp force which, in turn, could lead to a vibration loosening concern. Complete loss of clamp load could result in a wheel off condition. There is also a concern that the operational loads could be greater than the bolt clamping forces, which can lead to possible bolt fatigue issues

Information Requested under §§573.6(c)(6):

- April 8, 2010 – MCI reported an incident where one bolt backed out of wheel adapter / rotor / hub bearing joint. This incident happened on a new vehicle completing an initial shakedown test run.
- April 8, 2010 – Containment started at ArM assembly plant to verify torque on all axles
- April 9, 2010 – MCI and Newark bolt torque verification checks revealed that other new production axles have bolts that were measured lower than the torque specification.

Information Requested under §573.6(c)(7):

There is no impact of this issue towards non-compliance with a motor vehicle standard.

Information Requested under §573.6(c)(8):

ArvinMeritor is in process of developing the Defect Information Notice to its customers and will submit that information to NHTSA as soon as available. The following is an approximate schedule for the program:

5/30/10 Complete notification to affected customers.

In addition, ArvinMeritor has determined that none of the suspect axles have been remedied prior to this notification and, therefore, that no general pre-notification reimbursement remedy program is required.

We trust that the information provided in this document is fully responsive to the requirements of 49 CFR §573.5. All additions or modifications to any of the information given will be reported promptly to NHTSA. Any questions with respect to the information provided should be directed to the undersigned.

Respectfully Submitted,

Nirav Parikh  
Regional Quality Manager &  
Project Manger - Product Safety and Compliance  
ArvinMeritor

Enclosures



Appendix A: Summary of affected customer.

Motor Coach Industries  
1475 Clarence Avenue  
Winnipeg, MB R3T 1T5 Canada



2135 W. Maple Rd  
Troy, MI 48084

arvinmeritor.com

May 7, 2010

Antoinette McKee  
Sourcing Manager  
Motor Coach Industries  
1700 East Golf Road  
Schaumburg, IL 60173

**NOTICE:** Defect Information Report, in accordance with 49 CFR §573.6, concerning certain front and tag axles shipped to ArvinMeritor customers between August 10, 2009 and April 6, 2010.

ArvinMeritor File: C10AA

NHTSA File: 10E-014

Dear Sir /Madam

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act.

ArvinMeritor has determined that a defect which relates to motor vehicle safety exists in certain of its FH 941 and FH946 Front Non-Drive Steer Axles, and MC14 and MC16 Series Tag Axles axles. The affected motor vehicle equipment are front steer and rear tag axles assembled at ArvinMeritor Heath, Ohio facility located at 444 Hebron Road, Heath, Ohio 43055, and shipped to ArvinMeritor customers between August 10, 2009 and April 6, 2010. A list of affected axle and serial numbers is contained in Appendix A of this notice.

The population of potential affected axles was determined by shipment records maintained by ArvinMeritor's Heath facility.

### **Description of Defect**

The suspect axles may have had improper amount of torque applied to the hub/rotor/wheel adapter bolts during the assembly process. A reduced bolt torque potentially reduces the clamp force which, in turn, could lead to a vibration loosening concern. Complete loss of clamp load could result in a wheel off condition. There is also a concern that the operational loads could be greater than the bolt clamping forces, which can lead to possible bolt fatigue issues.

### **NHTSA Notification & Safety Recall Obligations**

According to our records, affected units were shipped to your company. If those units were installed as original equipment on vehicles manufactured at your facility, and you agree that they contain a safety defect, your company must notify the National Highway Traffic Safety Administration (NHTSA) within 5 business days and conduct a safety recall of those vehicles. It is critical that the NHTSA guidelines are followed in a timely manner and that your customers are notified to conduct the remedy described below.

**IMPORTANT:** Some of the affected vehicles may still be in your inventory. Federal law requires you to complete the recall service on these vehicles before delivery. ArvinMeritor will provide replacement or repair for these units prior to delivery to your customers.



You must also submit your draft version of your dealer and customer notices to NHTSA for approval at least 5 days prior to mailing such notification to dealers and owners of potentially affected wheel ends. You may contact NHTSA with questions by sending an email to [rmd.odi@dot.gov](mailto:rmd.odi@dot.gov).

**IMPORTANT:** Dealer notification by Certified Mail is required by Federal law for all safety recalls. Responsible dealership personnel should be instructed to sign for this Certified Mail without hesitation as it contains urgent safety recall information. Notifications to owners of potentially affected vehicles are by first class mail. Please be advised that the outside of each envelope containing an owner notification letter must be marked "SAFETY RECALL NOTICE" all in capital letters, either in boldface or underlined, and in type that is larger than that used in the address section. A sample of the envelope must be submitted to NHTSA for approval at least 5 business days before mailing to owners.

### **Recommended Action**

ArvinMeritor recommends that owners of vehicles originally equipped with ArvinMeritor axle assemblies containing the suspect axles use the inspection procedure provided in ArvinMeritor Technical Publication TP-10110. The repair procedure within this technical bulletin can be used to inspect torque and replace bolts that have had an improper amount of torque applied.

**NOTE:** Not all bolts will need to be replaced. Only replace bolts that are identified as having a torque value of less than 150 ft-lbs in the procedure outlined within the TP-10110.

The affected vehicles should be inspected and repaired as soon as feasible by a vehicle manufacturers' authorized repair facility or end-user. This inspection program will be managed by ArvinMeritor, and will be at no expense to vehicle owners.

### **Identification of Affected Parts**

The suspect population information containing the suspect axle serial numbers is attached with this notification.

Vehicle manufacturers are requested to provide VIN information and Vehicle In-Service Dates for the corresponding suspect axle serial numbers for traceability and reporting purposes. The requested information is to be forwarded to:

Anthony Seppey  
Anthony.Seppey@ArvinMeritor.com  
Specialty Service Manager – Troy, MI  
Ph 248.435.0896 Fax 248-435-1208

Inspection of the adaptor plate bolt torque, will determine if bolt replacement is required during the torque validation of the bolts. Additional details for inspection and replacement values are described in the ArvinMeritor Technical Publication TP-10110, attached to this notice.



## **Availability of Replacement Parts and Service Instructions**

Replacement part 10-X-1711 is currently available at ArvinMeritor's aftermarket distribution center in Florence, KY.

## **Parts, Labor and Handling Allowance**

The following are the details of allowances relating to parts, labor and handling available to vehicle manufacturers' (OEM):

- Parts and labor cost will be reimbursed through standard warranty.
- ArvinMeritor will reimburse as the standard repair time (SRT) of 1/4 hour per wheel end for inspection and an additional 1/10<sup>th</sup> hour per 1-2 bolts for replacement.
- ArvinMeritor will reimburse as the standard repair time (SRT) of 1/2 hour per wheel end if hub end-play will require adjustment.

## **Removed Material Disposition**

Repair facilities should change identified suspect bolts that have had improper amount of torque applied to the wheel adapter only on an identified vehicle axle. Removed bolts should not be reused. The removed fasteners should be destroyed and discarded.

## **Claims for Credit**

ArvinMeritor will accept warranty claims for inspecting bolt torque and replacing a bolt that has had an improper amount of torque applied to the wheel adapter associated with this notice directly from the vehicle manufacturers (OEM). To obtain credit for the claim; the repair facility should file with their OEM and the OEM will reimburse the repair facility for the work. ArvinMeritor will reimburse the OEM through its standard warranty process.

In order to receive proper credit, such warranty claims must contain the following information at the time of submission:

- Reference to ArvinMeritor Campaign ID Number: C10AA
- Reference to NHTSA Campaign ID Number: 10E-014
- Reference to the vehicle manufacturer's campaign number (optional)
- 17-digit vehicle identification number (VIN)
- Axle serial number
- Vehicle owner's name, address, and telephone number
- Vehicle in-service date
- Vehicle repair date
- Vehicle mileage at the time of repair
- Dealer work order number
- Repairing facility name, address, and telephone number
- Total labor hours required performing the work, not to exceed agreed formula
- Repair facilities hourly rate
- Filled out data sheet within TP-10110
- Tracking number for shipment of returned suspect studs.

Failure to provide complete information will delay processing of the warranty claim.



**Communication**

If you conclude that ArvinMeritor has not enabled you to remedy this condition in a reasonable time, you may submit a complaint to the:

Administrator  
National Highway Traffic Safety Administration  
1200 New Jersey, S.E.  
Washington, D.C. 20590

- or -

Call the toll free Vehicle Safety Hotline: 1-888-327-4236; (TTY: 800-424-9153  
or go to <http://www.safercar.gov>

We regret any inconvenience that this situation may cause. ArvinMeritor wants to assure you that we are concerned for customer safety and your continued satisfaction with our products.

Sincerely,

ArvinMeritor

A handwritten signature in cursive script, appearing to read "Frank Cookson".

Frank Cookson  
Manager of Customer Service

Attachments:

**MERITOR**<sup>®</sup>

an **ArvinMeritor** brand

## Technical Bulletin

### Inspect for Under-Tightened Hub/Rotor/Adapter Plate Bolts on Meritor Front Non-Drive Steer Axles and Tag Axles Equipped with Unitized Wheel Ends Installed on Motor Coach Industries (MCI) Coaches

All Meritor FH941 and FH946 Front Non-Drive Steer Axles, and MC14 and MC16 Series Tag Axles

## Hazard Alert Messages

Read and observe all Warning and Caution hazard alert messages in this publication. They provide information that can help prevent serious personal injury, damage to components, or both.

### **WARNING**

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle only supported by jacks. Jacks can slip or fall over. Serious personal injury and damage to components can result.

### **CAUTION**

A unitized wheel end is sealed and greased for life and does not require lubrication. If you disassemble, or attempt to repair or lubricate a unitized wheel end assembly, the Meritor warranty will be void, and damage to components can result.

A unitized wheel end is not adjustable. Do not attempt to set or adjust end play. Damage to components can result.

## How to Obtain Additional Maintenance and Service Information

Refer to Maintenance Manual MM-0409, Wheel-End Components; Maintenance Manual 23, Bus and Coach Front Axles; and Maintenance Manual MM-0467, DiscPlus™ EX225 Air Disc Brake. To obtain these publications, visit Literature on Demand at [arvinmeritor.com](http://arvinmeritor.com).

## How to Obtain Hub/Rotor/Adapter Plate Bolts (ArvinMeritor Part Number 10X1711)

Contact the original equipment manufacturer (OEM) or the ArvinMeritor OnTrac™ Performance Plus Call Center (phone: 866-668-7221/Fax: 248-435-5580/Email [ontrac@arvinmeritor.com](mailto:ontrac@arvinmeritor.com)).


## Inspection and Service Procedures

### Check Hub/Rotor/Adapter Plate Bolt Torque on the Unitized Wheel Ends

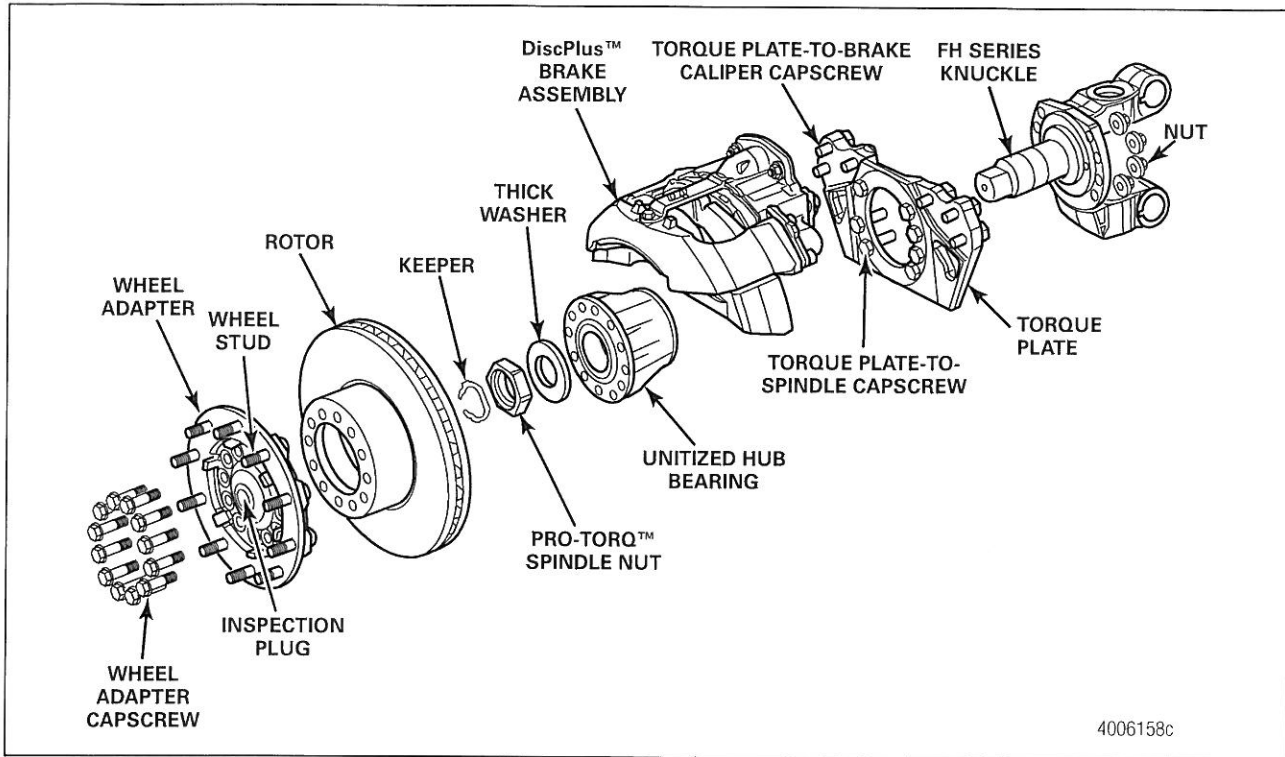
1. Wear safe eye protection.
2. Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving.

### **WARNING**

When you install new hub/rotor/adapter plate bolts (ArvinMeritor part number 10X1711) as instructed in this technical bulletin, discard the old bolts. Do not reuse the bolts. A reused bolt will not tighten correctly, which can cause the wheel to loosen and separate from the vehicle. Serious personal injury and damage to components can result.

3. Use a torque wrench with a dial indicator to check hub/rotor/adapter plate bolt torque on all 12 bolts on each unitized wheel end. The bolt torque must not be less than 150 lb-ft (203 N•m). Record the torque on the Inspection Sheet included in this bulletin. 
  - If hub/rotor/adapter plate bolt torque on any one of the 12 bolts on each unitized wheel end is less than 150 lb-ft (203 N•m): Replace the bolt using ArvinMeritor part number 10X1711. Discard the bolts that were removed. Do not reuse old bolts. Record the bolt replacement on the Inspection Sheet included in this bulletin.

- If any two or more bolts in the same bolt circle on a wheel end are less than 150 lb-ft (203 N•m): Replace all 12 bolts on the untized wheel end using ArvinMeritor part number 10X1711. Remove, replace and tighten each bolt one at a time to maintain the correct clamp load on the wheel end. Discard the bolts that were removed. Do not reuse old bolts. Record the bolt replacement and torque in the Inspection Sheet included in this bulletin.



4. Use a click torque wrench to tighten all remaining bolts and any replacement bolts in a star pattern to  $275 \pm 25$  lb-ft ( $373 \pm 34$  N•m). Record the torque on the Inspection Sheet included in this bulletin. When you have tightened all of the bolts, recheck the torque of all 12 bolts in a star pattern. **ⓘ**
5. Mark a stripe on all of the tightened bolts. Use a different color than the color already used.

# MCI Coach — UWE Bolt Torque — Inspection Chart

<b>VIN:</b>	<b>In-Service Date:</b>	<b>Repair Date:</b>	<b>Mileage:</b>
<b>Torque Wrench Dial Indicator – Calibration #</b> <b>Torque Click Wrench – Calibration #</b>		<b>Inspect By:</b>	
<b>Right Front Non-Drive Steer Wheel End</b> <b>Axle Serial Number:</b>		<b>Left Front Non-Drive Steer Wheel End</b>	
<b>Bolt #</b>	<b>Original Torque</b>	<b>Bolt Replaced (Yes/No)</b>	<b>New Torque</b>
1			<b>Original Torque</b>
2			<b>Bolt Replaced (Yes/No)</b>
3			<b>New Torque</b>
4			
5			
6			
7			
8			
9			
10			
11			
12			
<b>Comments:</b>		<b>Comments:</b>	

Bolt #	Right Tag Wheel End Axle Serial Number:				Left Tag Axle Wheel End			
	Original Torque	Bolt Replaced (Yes/No)	New Torque		Original Torque	Bolt Replaced (Yes/No)	New Torque	
1								
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12								
	Comments:				Comments:			

**ArvinMeritor™**

**Meritor Heavy Vehicle Systems, LLC**  
2135 West Maple Road  
Troy, MI 48084 USA  
800-535-5560  
arvinmeritor.com

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