

SAFETY RECALL

Mack Trucks Inc.
Greensboro, NC USA



Date	Number	Release	Page
10.2015	SC0394	01	1 (39)

Air Tank, Installation GU

SAFETY RECALL INFORMATION:

(October 2015)

Some MACK GU trucks built from 04/09/2007 through 05/11/2015 were manufactured with inadequate air tank capacity for certain air system configurations. The calculation tables used to determine air tank capacities and configurations were published with the incorrect information within. The installation of new air tanks and small modifications to the air tank configurations will correct the tank capacity inadequacies. Follow the installation instructions outlined in this Safety Recall.

MACK Trucks has received no reports of personal injury as a result of this condition. Therefore, MACK considers this as a proactive measure to protect the public and MACK's customers from the potential risk associated with this defect.

VEHICLES AFFECTED:

Certain MACK GU model trucks manufactured from 04/09/2007 through 05/11/2015.

VEHICLE IDENTIFICATION NUMBERS (VIN):

The number of vehicles affected by this recall is 87 (84 USA and 3 Canada).

REQUIRED PARTS:

To order parts call (877) 986-5862. The Vehicle Identification Number (VIN) is required for ordering parts. See the parts tables listed in each section of this safety recall for the required parts.

NOTE:

For any assistance concerning air tank installation (please include the recall # SC0394 to ensure proper support), submit an e-Service case to MACK tech support.

VIN LIST with REPAIR and PARTS LIST REFERENCE TABLE

1. Using the table below, find the VIN of the truck associated with this Safety Recall.
2. Note the repair procedure number and parts list number referenced.
3. Using the noted repair procedure number and parts list number, follow the appropriate installation procedures outlined in this Safety Recall.

VIN LIST with REPAIR and PARTS LIST REFERENCE TABLE			
Item #	VIN Number	Repair Number	Parts List Number
1	1M2AX01C0CM001554	2	2B
2	1M2AX01C0CM001585	2	2B
3	1M2AX01C0EM001881	2	2A
4	1M2AX01C1EM002053	3	3A
5	1M2AX01C2DM001797	3	3A
6	1M2AX01C4CM001623	3	3A
7	1M2AX01C4DM001798	3	3A
8	1M2AX01C6DM001799	3	3A
9	1M2AX02C0CM001570	1	1D
10	1M2AX02C0CM001603	1	1C
11	1M2AX02C1CM001593	1	1D
12	1M2AX02C2CM001571	1	1D
13	1M2AX02C2CM001635	3	3A
14	1M2AX02C3CM001594	1	1D
15	1M2AX02C4CM001572	1	1D
16	1M2AX02C4CM001636	3	3A
17	1M2AX02C5DM001792	3	3A
18	1M2AX02C6CM001573	1	1D
19	1M2AX02C6CM001587	1	1C
20	1M2AX02C6CM001637	3	3A
21	1M2AX02C8CM001607	1	1B
22	1M2AX02C8CM001638	3	3A
23	1M2AX02C8DM001754	3	3A
24	1M2AX02C8GM002276	3	3A
25	1M2AX02C9EM001814	3	3A
26	1M2AX02CXCM001639	3	3A
27	1M2AX02CXDM001755	3	3A
28	1M2AX04C0CM012467	1	1C
29	1M2AX04C0DM017105	3	3A
30	1M2AX04C1CM012459	1	1C
31	1M2AX04C1CM012462	1	1C
32	1M2AX04C1CM012493	1	1C
33	1M2AX04C28M001526	2	2A
34	1M2AX04C2BM010380	1	1B
35	1M2AX04C2CM012244	1	1C
36	1M2AX04C2CM012468	1	1C
37	1M2AX04C2DM017106	3	3A
38	1M2AX04C3CM012463	1	1C
39	1M2AX04C3CM012494	1	1C

VIN LIST with REPAIR and PARTS LIST REFERENCE TABLE (Continued)			
Item #	VIN Number	Repair Number	Parts List Number
40	1M2AX04C4BM010381	1	1B
41	1M2AX04C4CM012245	1	1C
42	1M2AX04C4CM012469	1	1C
43	1M2AX04C5CM012464	1	1C
44	1M2AX04C6BM010382	1	1B
45	1M2AX04C6CM012246	1	1C
46	1M2AX04C6CM012456	1	1C
47	1M2AX04C7CM011011	1	1B
48	1M2AX04C7CM012465	1	1C
49	1M2AX04C7DM017103	3	3A
50	1M2AX04C8BM010383	1	1B
51	1M2AX04C8CM012247	1	1C
52	1M2AX04C8CM012457	1	1C
53	1M2AX04C8CM012460	1	1C
54	1M2AX04C8CM012491	1	1C
55	1M2AX04C9CM012466	1	1C
56	1M2AX04C9DM017104	3	3A
57	1M2AX04CXCM012458	1	1C
58	1M2AX04CXCM012461	1	1C
59	1M2AX04CXCM012492	1	1C
60	1M2AX07C1CM011095	1	1F
61	1M2AX07C1CM011775	1	1F
62	1M2AX07C4CM012693	1	1F
63	1M2AX08C4CM001658	2	2A
64	1M2AX08C5EM001882	1	1E
65	1M2AX09C6BM010116	1	1A
66	1M2AX09C8BM010165	1	1B
67	1M2AX09C8BM010166	1	1B
68	1M2AX20C0GM001248	4	4B
69	1M2AX20C0GM001249	4	4B
70	1M2AX20C0GM001265	4	4B
71	1M2AX20C1FM001211	4	4B
72	1M2AX20C2FM001220	4	4B
73	1M2AX20C2GM001266	4	4B
74	1M2AX20C3FM001212	4	4B
75	1M2AX20C4GM001267	4	4B
76	1M2AX20C6FM001219	4	4B
77	1M2AX20C6FM001222	4	4B
78	1M2AX20C6FM001236	4	4A
79	1M2AX20C6GM001271	4	4B
80	1M2AX20C8GM001272	4	4B
81	1M2AX20C9GM001250	4	4B
82	1M2AX22C0BM001031	4	4C
83	1M2AX22C3EM001125	4	4A
84	1M2AX22C4GM001251	4	4A
85	1M2AX22C4GM001252	4	4A
86	1M2AX22C6FM001217	4	4A
87	1M2AX22C8FM001218	4	4A

PARTS LIST REFERENCE TABLES

1. For required installation parts and quantities, use the appropriate parts tables determined by the VIN list reference table on page 2 of this Safety Recall.

Parts List 1A			
Item #	Part Number	Description	Qty
1	21535089	600 ATANK-AL	1
2	21195800	Bracket	1
3	21195801	Bracket	1
4	22194315	Strap	2
5	20462690	Elbow, 12,7*M22*1,5	2
6	20703654	Drain Valve	1
7	25086602	Wire	1
8	25090637	Spacer	1
9	984853	Screw	1
10	992328	Flange Nut	1
11	967973	1/2" air line	AR
12	20710984	M22 Plug	4
13	25084958	1/4" NPT Plug	1

Parts List 1B			
Item #	Part Number	Description	Qty
1	21535090	600 ATANK-ST	1
2	21195800	Bracket	1
3	21195801	Bracket	1
4	22194315	Strap	2
5	20462690	Elbow, 12,7*M22*1,5	2
6	20703654	Drain Valve	1
7	25086602	Wire	1
8	25090637	Spacer	1
9	984853	Screw	1
10	992328	Flange Nut	1
11	967973	1/2" air line	AR
12	20710984	M22 Plug	4
13	25084958	1/4" NPT Plug	1

Parts List 1C			
Item #	Part Number	Description	Qty
1	21535094	500 ATANK-ST	1
2	21195800	Bracket	1
3	21195801	Bracket	1
4	22194315	Strap	2
5	20462690	Elbow, 12,7*M22*1,5	2
6	20703654	Drain Valve	1
7	25086602	Wire	1
8	25090637	Spacer	1
9	984853	Screw	1
10	992328	Flange Nut	1
11	967973	1/2" air line	AR
12	20710984	M22 Plug	4
13	25084958	1/4" NPT Plug	1

Parts List 1D			
Item #	Part Number	Description	Qty
1	21535099	350 ATANK -ST	1
2	21195800	Bracket	1
3	21195801	Bracket	1
4	22194315	Strap	2
5	20462690	Elbow, 12,7*M22*1,5	2
6	20703654	Drain Valve	1
7	25086602	Wire	1
8	25090637	Spacer	1
9	984853	Screw	1
10	992328	Flange Nut	1
11	967973	1/2" air line	AR
12	20710984	M22 Plug	4
13	25084958	1/4" NPT Plug	1

Parts List 1E			
Item #	Part Number	Description	Qty
1	21535100	350 ATANK-AL	1
2	21195800	Bracket	1
3	21195801	Bracket	1
4	22194315	Strap	2
5	20462690	Elbow, 12,7*M22*1,5	2
6	20703654	Drain Valve	1
7	25086602	Wire	1
8	25090637	Spacer	1
9	984853	Screw	1
10	992328	Flange Nut	1
11	967973	1/2" air line	AR
12	20710984	M22 Plug	4
13	25084958	1/4" NPT Plug	1

Parts List 1F			
Item #	Part Number	Description	Qty
1	21535096	450 ATANK-AL	1
2	21535100	350 ATANK-AL	1
3	21195800	Bracket	1
4	21195801	Bracket	1
5	22194315	Strap	2
6	20462690	Elbow, 12,7*M22*1,5	2
7	20703654	Drain Valve	1
8	25086602	Wire	1
9	25090637	Spacer	1
10	984853	Screw	1
11	992328	Flange Nut	1
12	967973	1/2" air line	AR
13	20710984	M22 Plug	8
14	25084958	1/4" NPT Plug	2

Parts List 2A			
Item #	Part Number	Description	Qty
1	21535090	600 ST	1
2	967973	1/2" air line	AR

Parts List 2B			
Item #	Part Number	Description	Qty
1	21535099	350 ST	1
2	967973	1/2" air line	AR

Parts List 3A			
Item #	Part Number	Description	Qty
1	21356921	Tank	1
2	21292188	Bracket	2
3	21292190	Strap	2
4	990949	Lock Nut	4
5	984853	Flange Screw	4
6	994522	Lock Nut	4
7	8397701	Fitting	1
8	20462690	Fitting	1
9	3082874	PLUG	1
10	3082845	ELBOW NIPPLE, 45	1
11	20703654	DRAIN VALVE	1
12	965557	BRACKET	1
13	3082660	ATTACHING CLAMP	1
14	990950	FLANGE LOCK NUT	1
15	995463	FLANGE SCREW	1
16	967973	1/2" air line	AR

Parts List 4A			
Item #	Part Number	Description	Qty
1	21096643	Air Tank, Steel	1
2	21096664	MOUNTING STRAP	2
3	1594523	RING, RUBBER	2
4	21267944	BRACKET	1
5	3082876	PLUG	4
6	8397707	FITTING	2
7	3082874	PLUG	3
8	995466	FLANGE SCREW	2
9	990950	FLANGE NUT	2
10	995487	FLANGE SCREW	4
11	990951	FLANGE NUT	4
12	25093811	Tee Fitting	1
13	20864112	Straight Fitting	1
14	967973	1/2" air line	AR

Parts List 4B			
Item #	Part Number	Description	Qty
1	21103829	Air Tank, Aluminum	1
2	21096664	MOUNTING STRAP	2
3	1594523	RING, RUBBER	2
4	21267944	BRACKET	1
5	3082876	PLUG	4
6	8397707	FITTING	2
7	3082874	PLUG	3
8	995466	FLANGE SCREW	2
9	990950	FLANGE NUT	2
10	995487	FLANGE SCREW	4
11	990951	FLANGE NUT	4
12	25093811	Tee Fitting	1
13	20864112	Straight Fitting	1
14	967973	1/2" air line	AR

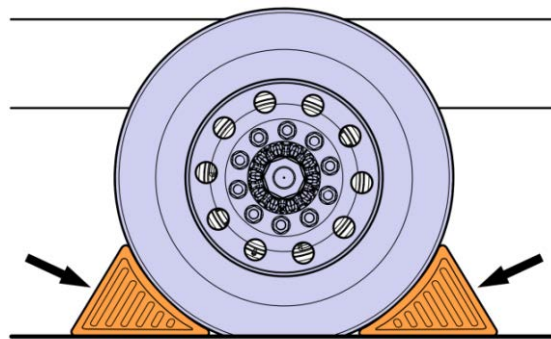
Parts List 4C			
Item #	Part Number	Description	Qty
1	21096643	Air Tank, Steel	2
2	21096664	MOUNTING STRAP	4
3	1594523	RING, RUBBER	4
4	21267944	BRACKET	2
5	3082876	PLUG	8
6	8397707	FITTING	4
7	3082874	PLUG	6
8	995466	FLANGE SCREW	4
9	990950	FLANGE NUT	4
10	995487	FLANGE SCREW	8
11	990951	FLANGE NUT	8
12	25093811	Tee Fitting	1
13	20864112	Straight Fitting	1
14	967973	1/2" air line	AR

NOTE
Due to limited space within the frame of the truck, all parts used will require the technicians to select tank installation locations that do not interfere with existing components.

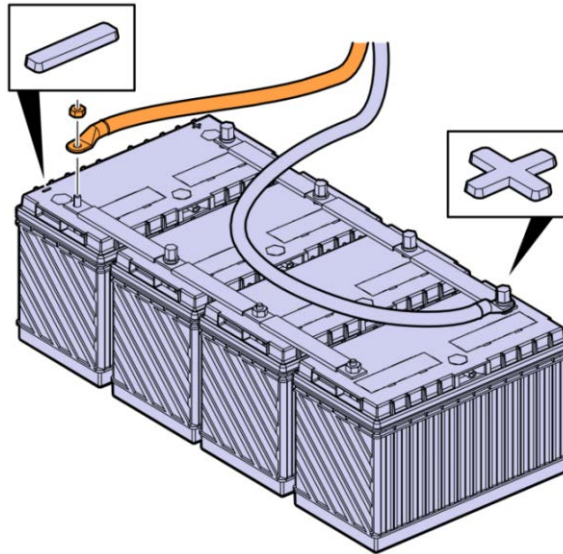
DECOMMISSIONING THE TRUCK FOR INSTALLATION:

NOTE
The Illustrations shown in this document are used for reference only and may differ slightly from the actual vehicle being serviced. However, the replacement procedure is represented as accurately as possible.

1. Secure the vehicle for service by parking on a flat and level surface, applying the parking brake, chocking the rear wheel, and placing the transmission in neutral.

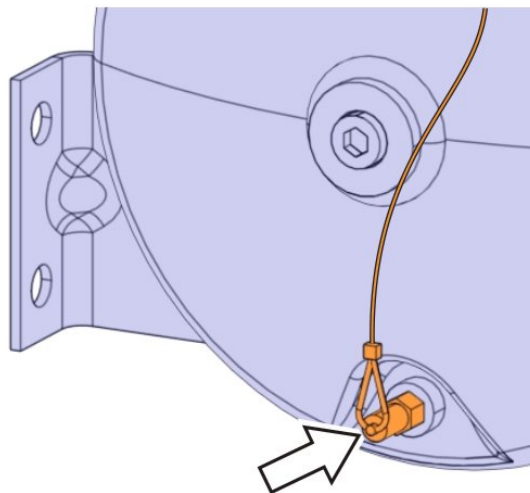


2. Disconnect the cable from the battery's negative (ground) terminal.

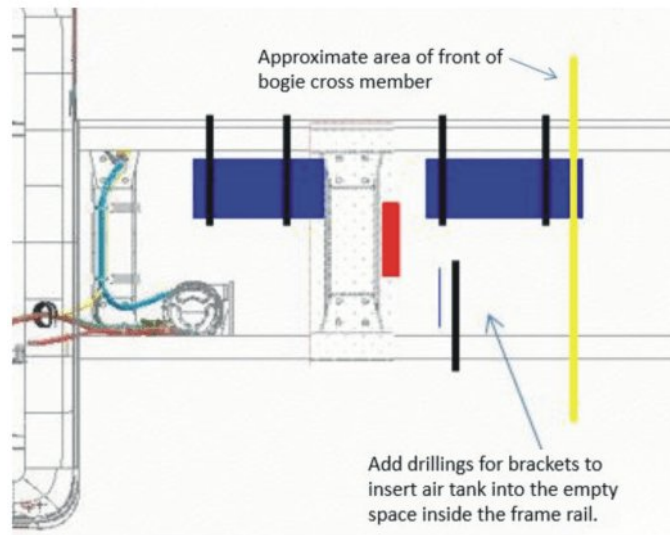


REPAIR 1, PARTS LIST 1A/1B/1C/1D/1E, AIR TANK, INSTALLATION, (ONE IN FRAME AIR TANK):

1. Drain the air system.



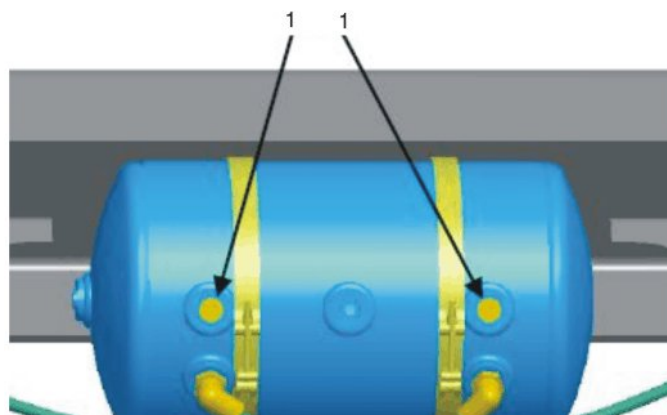
2. Identify the mounting location of the new air tank.



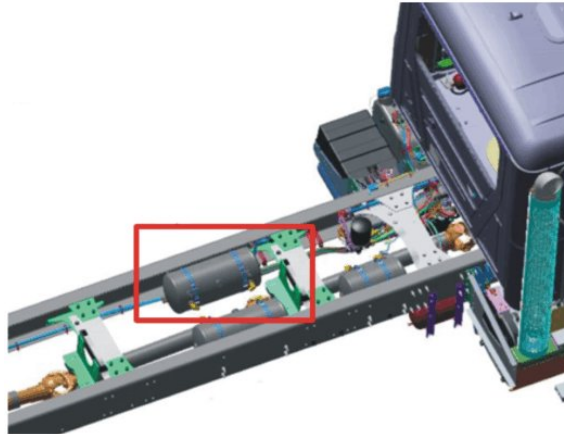
3. Loosely position the air tank mounting straps (part number 22194315) 150 mm (5.9 in) from the ends of the air tank and measure the strap centerline distance to determine bracket spacing.

NOTE

To determine air tank mounting bracket spacing, measure the distance between the bungs on the air tank, ensure the spacing between the brackets/straps are as close as possible to the inside of the air tank bungs (1).



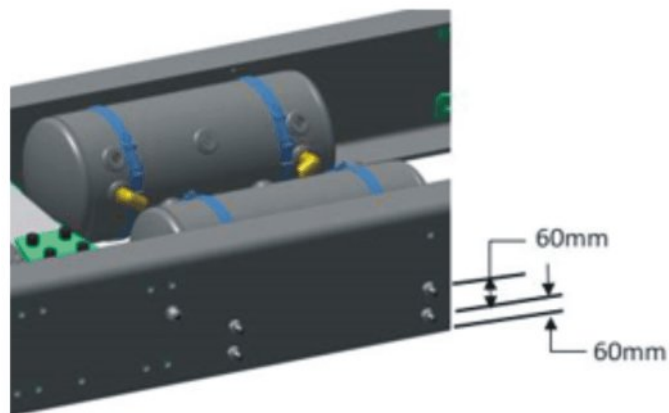
4. Locate, measure, and mark the appropriate location of the air tank brackets and mounting holes inside the frame.



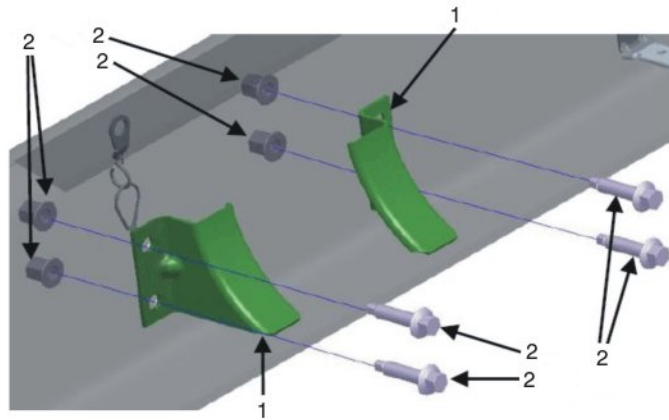
5. Drill the frame, 4 holes X 10 mm (0.39 in).

 **CAUTION**

Check the frame for Air lines, wire harnesses, or other components before drilling.



6. Install the air tank mounting brackets (1) and fasteners (2).
7. Tighten the fasteners to 140 ± 25 Nm (130 ± 18 ft-lb).

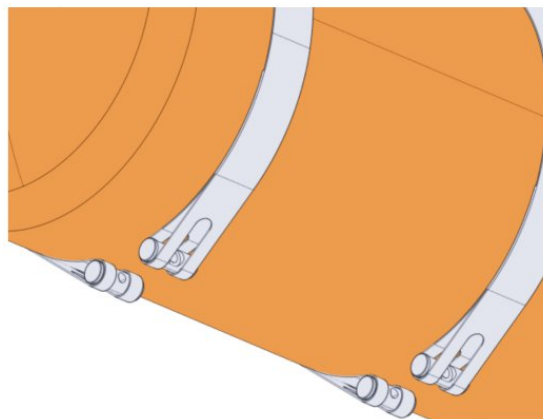


8. Install the air tank fittings and plugs.

NOTE
Pipe fittings require an application of thread sealant during installation. Use thread sealant on pipe fittings only.

NOTE
O-ring fittings do not require an application thread sealant during installation.

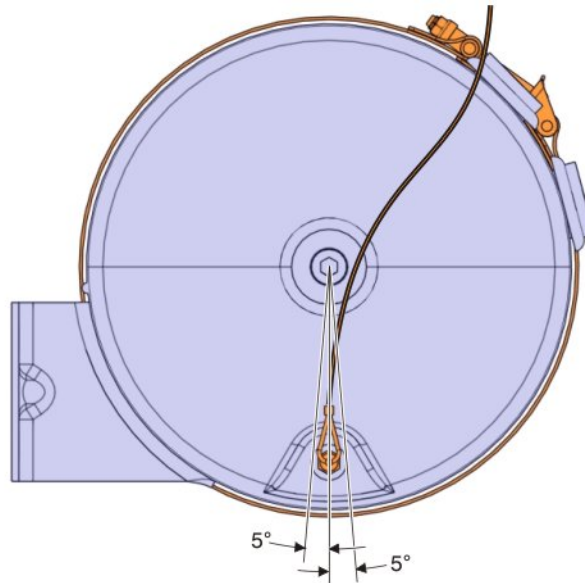
9. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).
10. Position the air tank and straps on the mounting brackets.



11. Using hand tools, hand tighten the strap bolts.

NOTE

The tank drain should be within ± 5 degrees of the vertical position.



12. Using a torque wrench, tighten the air tank strap bolts to 25 ± 5 Nm (18 ± 4 ft-lb).

13. Install fitting (part number 20462690) in the left side of the air tank to the rear.

NOTE

O-ring fittings do not require an application thread sealant during installation.

NOTE

Fitting (part number 20462690) will connect the new air tank to the existing air system.

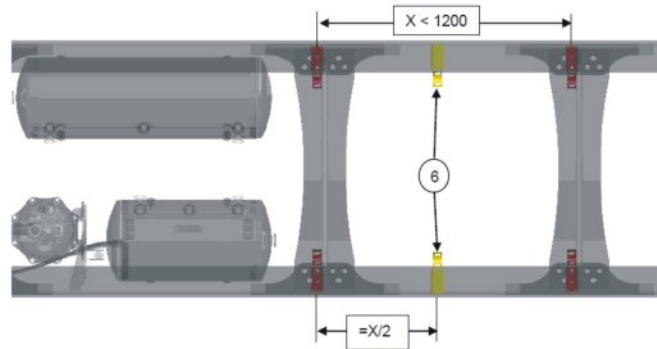
14. Position and connect the air lines.

15. Using cable ties, secure the air lines.

NOTE

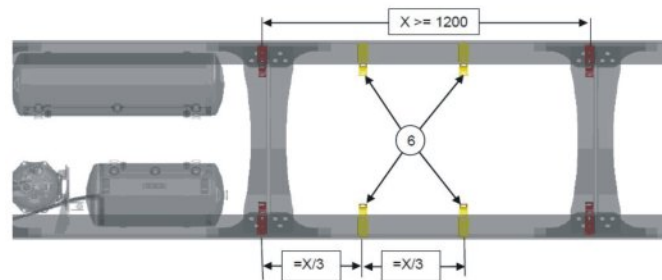
Ensure the air lines do not contact any moving parts or components.

3.5.2 X-Member Spacing less than 1200 mm



3.5 Routing and clipping through empty sections

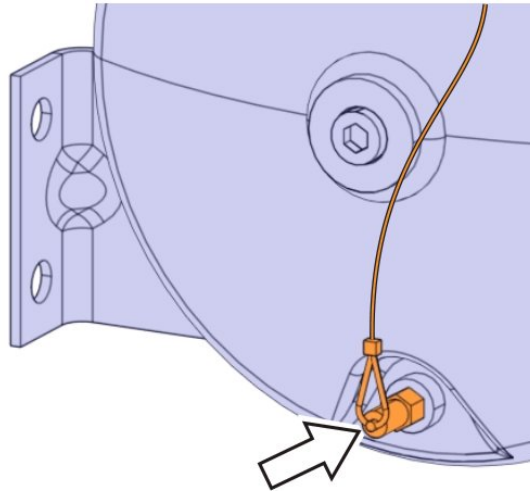
3.5.1 X-Member spacing greater than 1200 mm



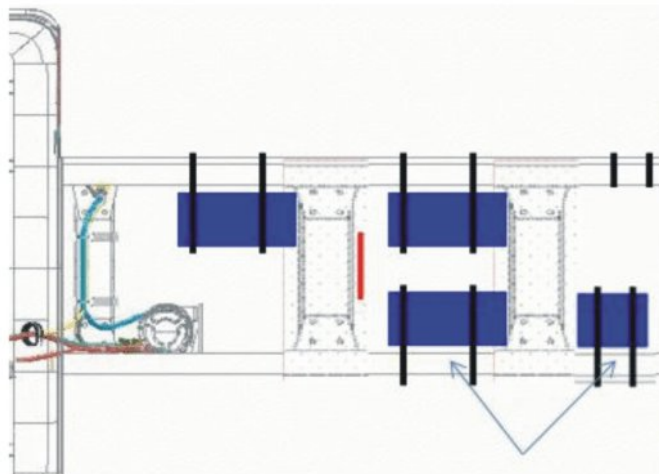
16. Proceed to **Commissioning the Truck for Operation** section.

REPAIR 1, PARTS LIST 1F, AIR TANK, INSTALLATION, (TWO AIR TANKS):

1. Drain the air system.



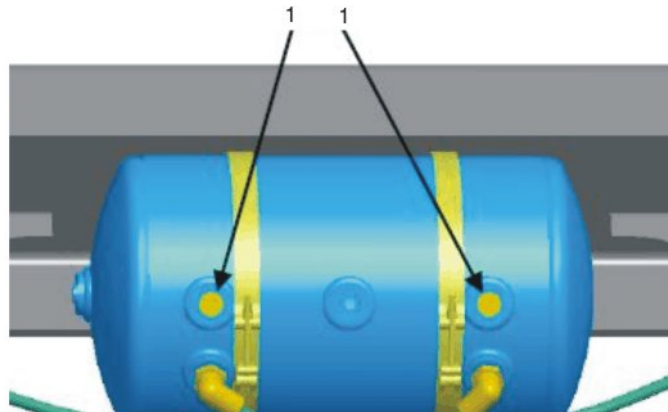
2. Identify the mounting location of the new air tank.



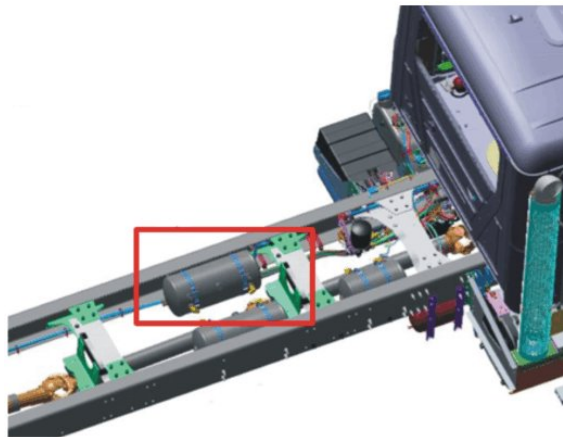
- Loosely position the air tank mounting straps (part number 22194315) 150 mm (5.9 in) from the ends of the air tank and measure the strap centerline distance to determine bracket spacing.

NOTE

To determine air tank mounting bracket spacing, measure the distance between the bungs on the air tank, ensure the spacing between the brackets/straps are as close as possible to the inside of the air tank bungs (1).



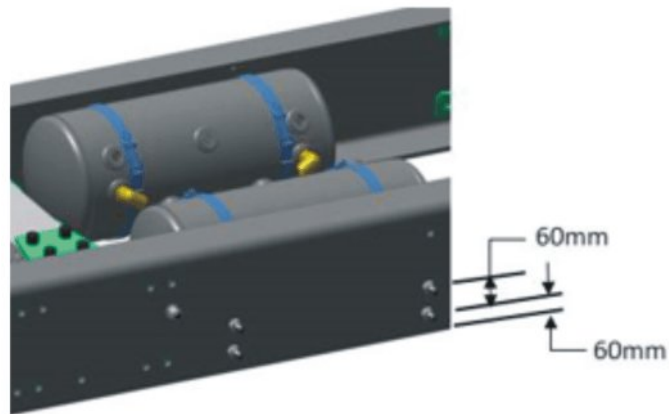
- Locate, measure, and mark the appropriate location of the air tank brackets and mounting holes inside the frame.



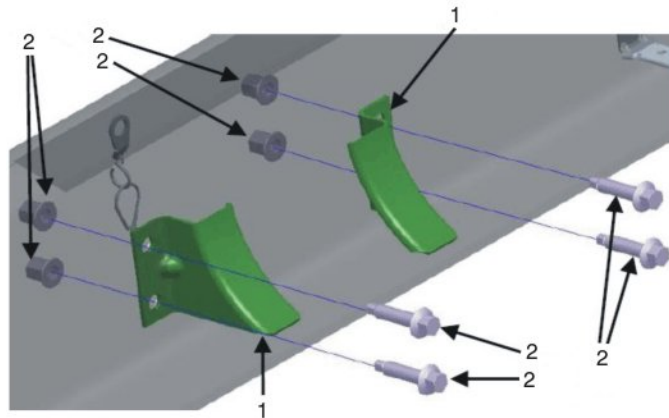
5. Drill the frame, 4 holes X 10 mm (0.39 in).



Check the frame for Air lines, wire harnesses, or other components before drilling.



6. Install the air tank mounting brackets (1) and fasteners (2).
7. Tighten the fasteners to 140 ± 25 Nm (130 ± 18 ft-lb).



8. Install the air tank fittings and plugs.

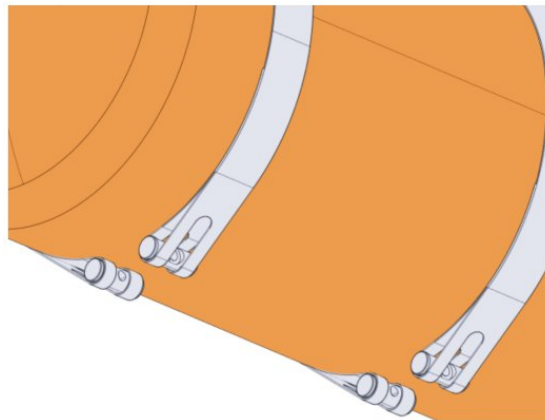
NOTE

Pipe fittings require an application of thread sealant during installation. Use thread sealant on pipe fittings only.

NOTE

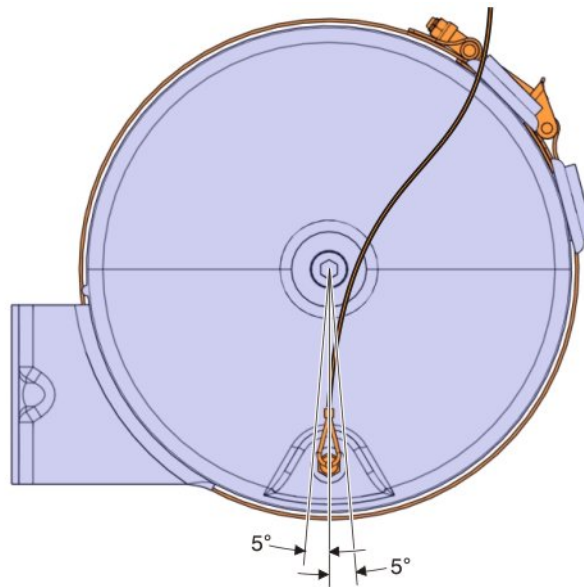
O-ring fittings do not require an application thread sealant during installation.

9. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).
10. Position the air tanks and straps (part number 22194315) on the mounting brackets.



11. Using hand tools, hand tighten the strap bolts.

NOTE
The tank drain should be within ± 5 degrees of the vertical position.



12. Using a torque wrench, tighten the air tank strap bolts to 25 ± 5 Nm (18 ± 4 ft-lb).

13. Repeat steps 1-12 for installation of the second air tank.

14. Install fitting (part number 20462690) in the left side (Secondary Air Tank) of the air tank to the rear.

16. Tighten the air tank fitting to 40 ± 5 Nm (30 ± 4 ft-lb).

NOTE
O-ring fittings do not require an application thread sealant during installation.

NOTE
Fitting (part number 20462690) will connect the new air tank to the existing air system.

15. Install fitting (part number 20462690) in the right side (Primary Air Tank) of the air tank.

16. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).

NOTE
O-ring fittings do not require an application thread sealant during installation.

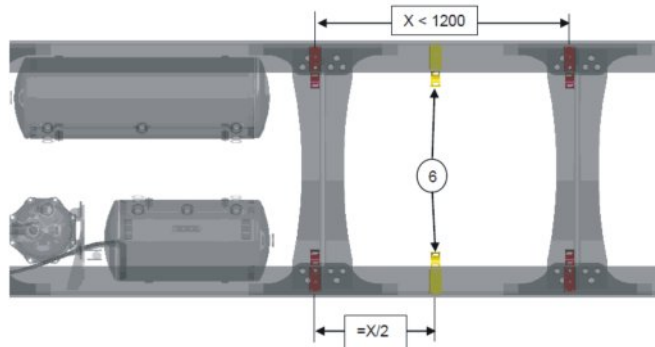
NOTE
Fitting (part number 20462690) will connect the new air tank to the existing air system.

17. Position and connect the air lines from the new air tanks to vehicle air system.

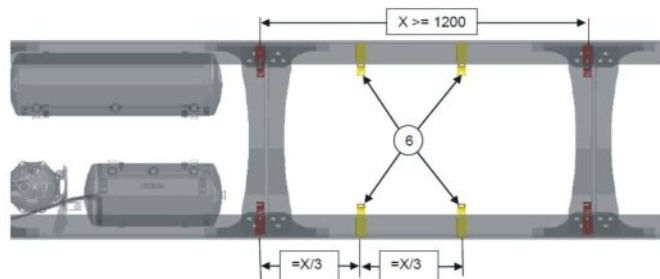
18. Using cable ties, secure the air lines.

NOTE
Ensure the air lines do not contact any moving parts or components.

3.5.2 X-Member Spacing less than 1200 mm



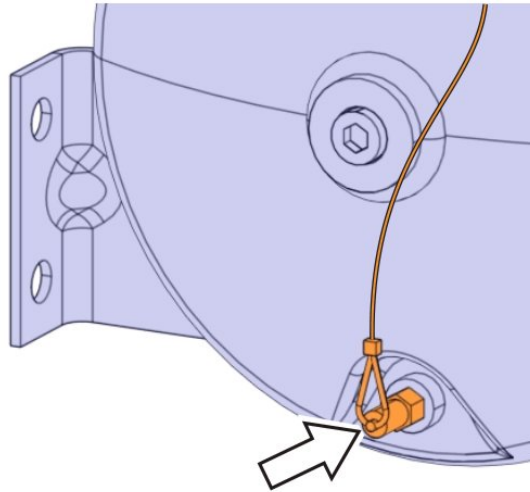
3.5 Routing and clipping through empty sections
3.5.1 X-Member spacing greater than 1200 mm



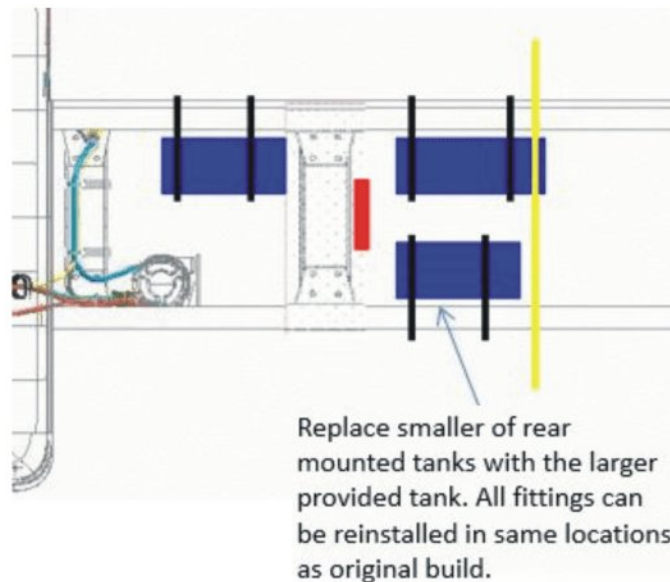
19. Proceed to **Commissioning the Truck for Operation** section.

**REPAIR 2, AIR TANK, INSTALLATION, (ONE LARGER VOLUME AIR TANK) WITH
or WITHOUT MOUNTING BRACKET MOVED:**

1. Drain the air system.



2. Identify the air tank to be replaced. See the figure below.



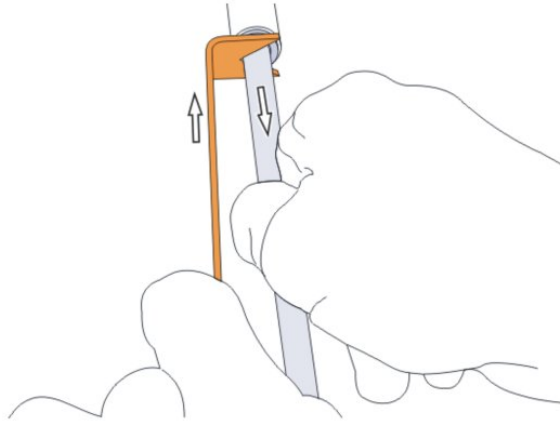
Replace smaller of rear mounted tanks with the larger provided tank. All fittings can be reinstalled in same locations as original build.

3. Verify the replacement tank will fit in the location of the present air tank.

- Using air line release tool (part number 88870019, disconnect the air lines from the existing air tank.

NOTE

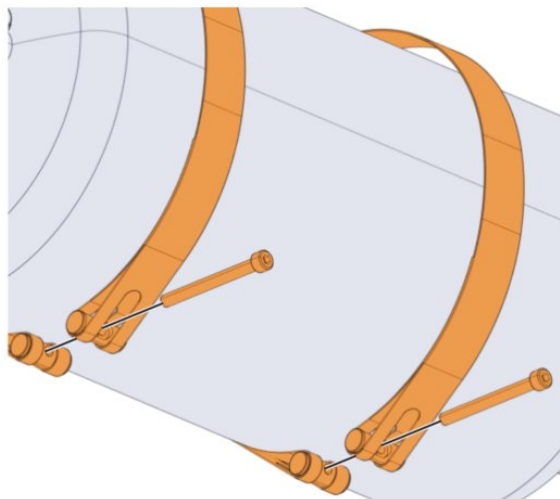
Note the orientation of the air lines for re-installation purposes.



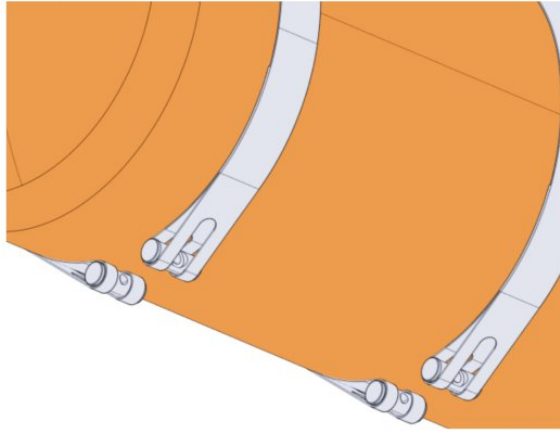
- With assistance, remove the bolts from the air tank straps.

⚠ CAUTION

The air tank may fall when the bolts are removed from the air tank straps.



6. With assistance remove the air tank from the mounting brackets.



7. Transfer the air tank fittings and plugs to the replacement tank.
8. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).

NOTE

Pipe fittings require an application of thread sealant during installation. Use thread sealant on pipe fittings only.

NOTE

O-ring fittings do not require an application thread sealant during installation.

9. In some instances the rear mounting bracket may require relocation for installation of the larger volume air tank. Verify if the replacement air tank can be installed with or without moving the rear mounting bracket.

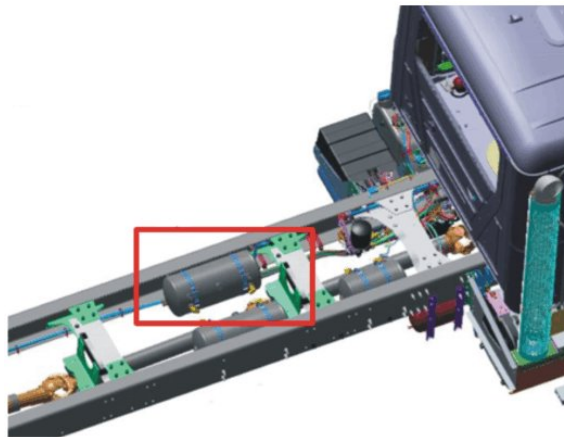
NOTE

If the replacement air tank will fit in the location of the present tank, skip to step 12.

NOTE

If the replacement air tank does not fit in the location of the present tank, proceed to step 10.

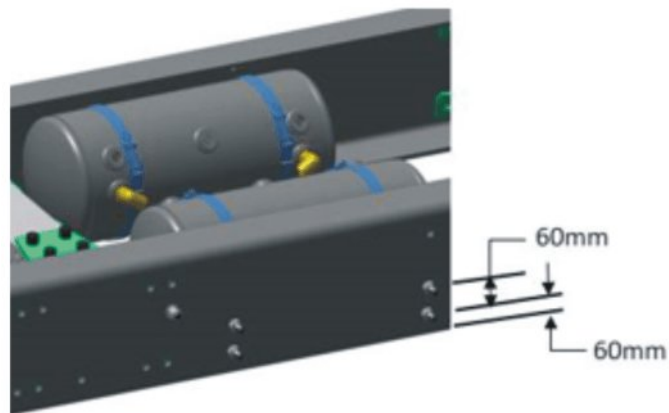
10. Locate, measure, and mark the appropriate location of the relocated air tank mounting bracket and mounting holes inside the frame.



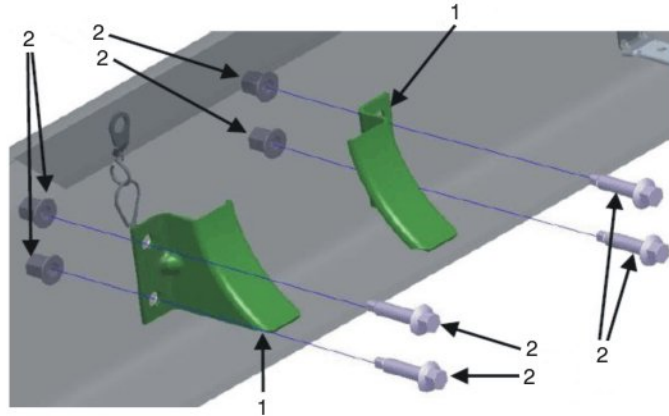
11. Drill the frame, 2 holes X 10 mm (0.39 in).

 CAUTION

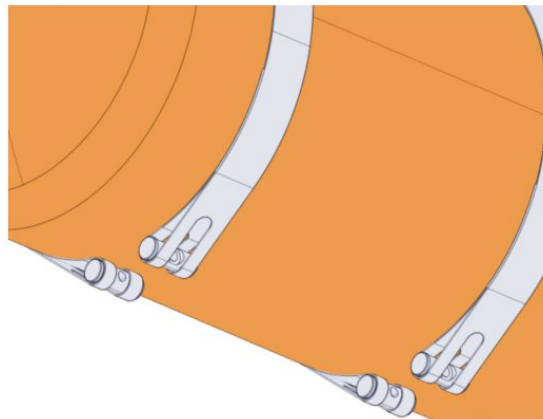
Check the frame for Air lines, wire harnesses, or other components before drilling.



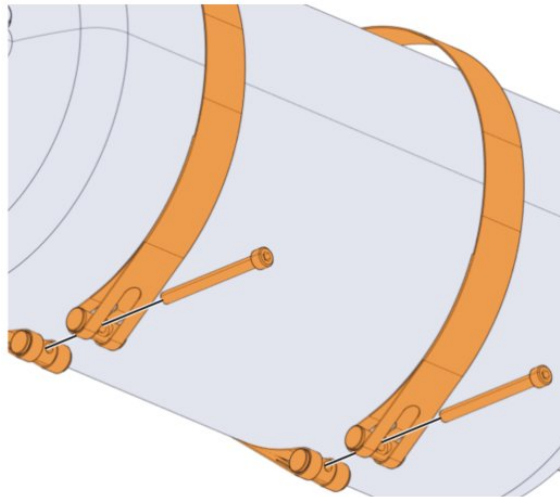
12. Position the relocated air tank mounting brackets (1) and install fasteners (2).
13. Place two M14 bolts in the unused holes of the frame after relocating the mounting bracket.
14. Tighten the fasteners to 140 ± 25 Nm (130 ± 18 ft-lb).



15. With assistance, position the replacement air tank inside the tank straps.



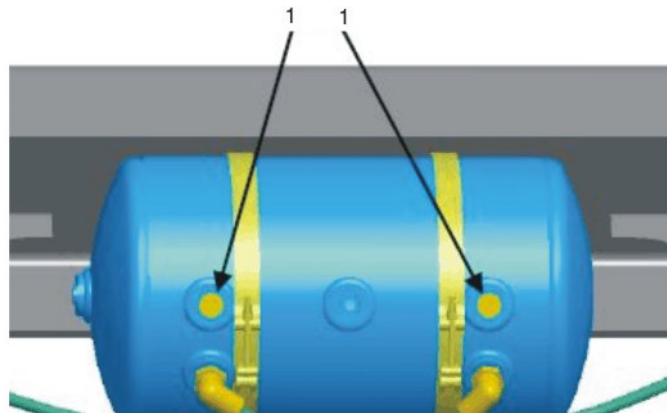
16. With assistance, install the tank strap bolts. Do not tighten at this time.



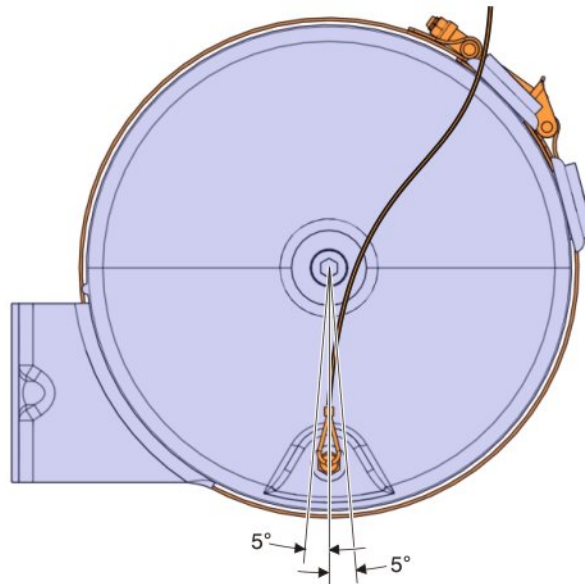
17. Loosely position the air tank mounting straps 150 mm (5.9 in) from the ends of the air tank and measure the strap centerline distance to determine bracket spacing.

NOTE

To determine air tank mounting bracket spacing, measure the distance between the bungs on the air tank, ensure the spacing between the brackets/straps are as close as possible to the inside of the air tank bungs (1).



18. Using hand tools, hand tighten the strap bolts.



19. Using a torque wrench, tighten the air tank strap bolts to 25 ± 5 Nm (18 ± 4 ft-lb).

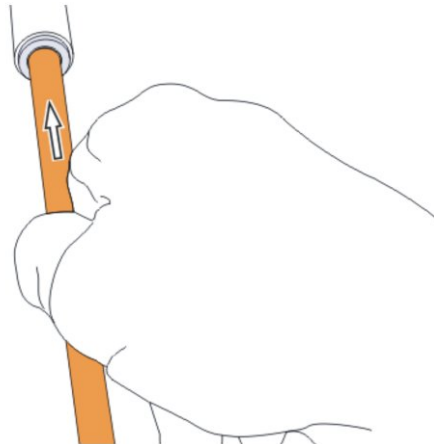
20. Position and connect the air lines.

NOTE

If the air lines are not long enough to connect to the replacement tank, add the needed length using the appropriate type air line and splice.

NOTE

One splice per air-line is permitted.



21. Using cable ties, secure the air lines.

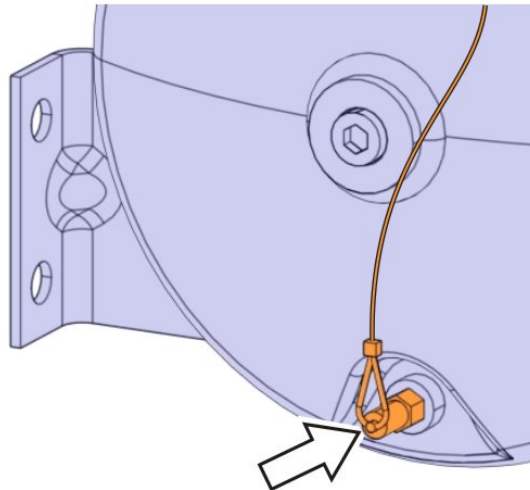
NOTE

Ensure the air lines do not contact any moving parts or components.

22. Proceed to **Commissioning the Truck for Operation** section.

REPAIR 3, AIR TANK, INSTALLATION, (ONE UNDER-FRAME AIR TANK):

1. Drain the air system.



2. Using one air tank (part number 21356921), install the air tank fittings and plugs.

NOTE

Pipe fittings require an application of thread sealant during installation. Use thread sealant on pipe fittings only.
--

NOTE

O-ring fittings do not require an application thread sealant during installation.

3. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).




4. Loosely assemble the air tank mounting brackets and fasteners.
5. Using hand tools, hand tighten the fasteners.
6. Identify the mounting location of the new under frame mounted air tank.

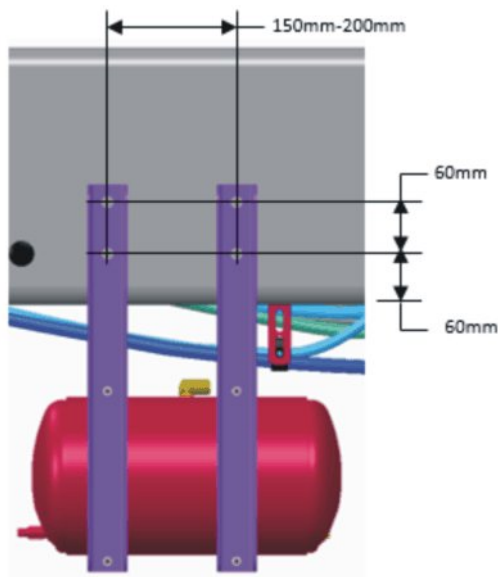
NOTE
Ensure the air tank and under-frame mounting brackets are not too close to the ground or interfere with any of the vehicle's components.



7. Locate, measure, and mark the appropriate location of the air tank brackets and mounting holes in the frame.
8. Drill the frame, 4 holes X 10 mm (0.39 in).

 CAUTION
Check the frame for Air lines, wire harnesses, or other components before drilling.

9. Position the air tank and mounting brackets under frame.
10. Using four bolts (part number 984853) and four nuts (part number 994522), secure the air tank and mounting brackets to under frame.
11. Tighten the fasteners to 140 ± 25 Nm (130 ± 18 ft-lb).

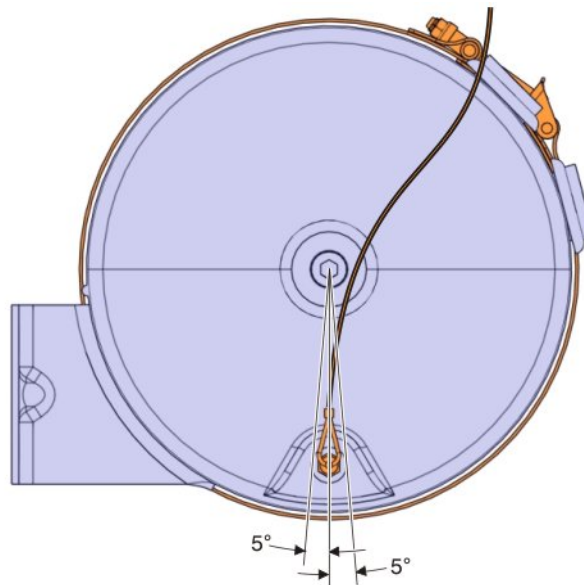


12. Position the air tank in the mounting brackets.

13. Using a torque wrench, tighten the air tank clamps to 10 ± 5 Nm (88 ± 13 in-lb).

NOTE

The tank drain should be within ± 5 degrees of the vertical position.



14. Install fitting (part number 20462690) in the left side of the air tank to the rear.

15. Tighten the fitting to 40 ± 5 Nm (30 ± 4 ft-lb).

NOTE

O-ring fittings do not require an application thread sealant during installation.

NOTE

Fitting (part number 20462690) will connect the new air tank to the existing air system.

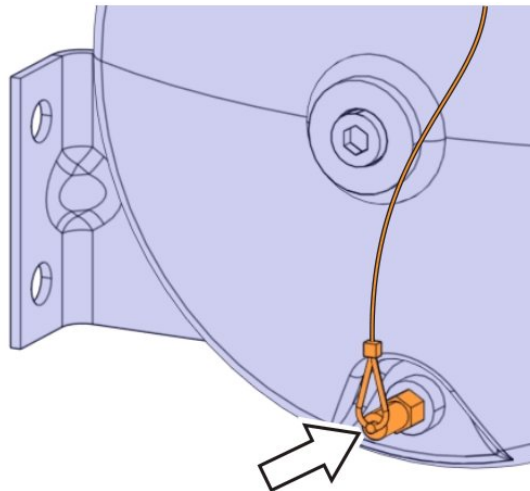
16. Position and connect the air lines.
17. Attach one clamp (part number 3082660), one flange screw (part number 995463), and one lock nut (part number 990950) to the tank under-frame mounted air tank bracket.
18. Using a cable tie, secure the air line to the clamp.

NOTE
Ensure the air lines do not contact any moving parts or components.

19. Proceed to **Commissioning the Truck for Operation** section.

REPAIR 4, AIR TANK, INSTALLATION, (TRI-DRIVE CROSS MEMBER MOUNTED AIR TANK):

1. Drain the air system.



2. Identify the mounting location of the new air tank.

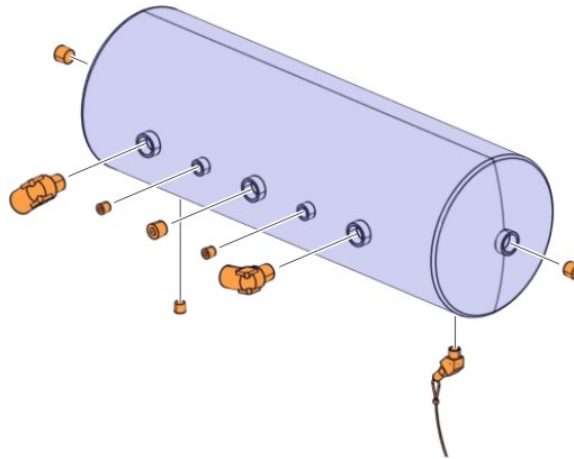
3. Install the air tank fittings and plugs.

NOTE

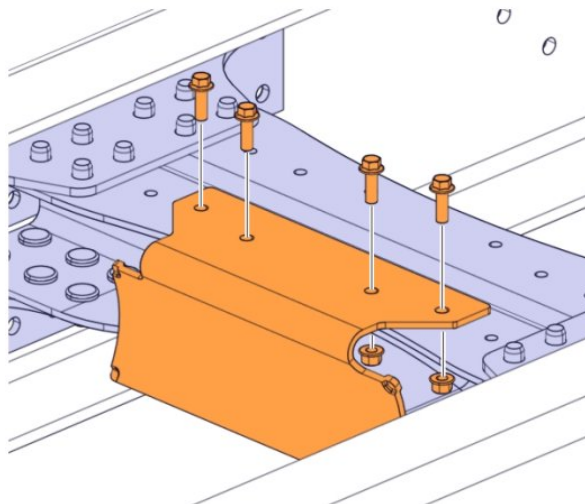
Pipe fittings require an application of thread sealant during installation. Use thread sealant on pipe fittings only.

NOTE

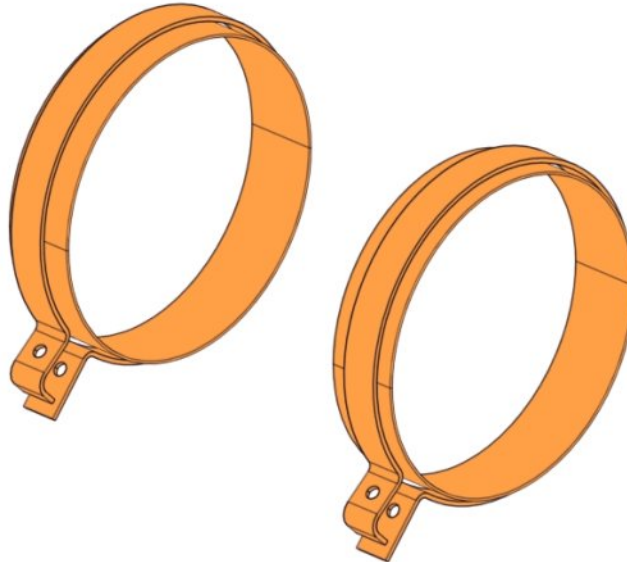
O-ring fittings do not require an application thread sealant during installation.



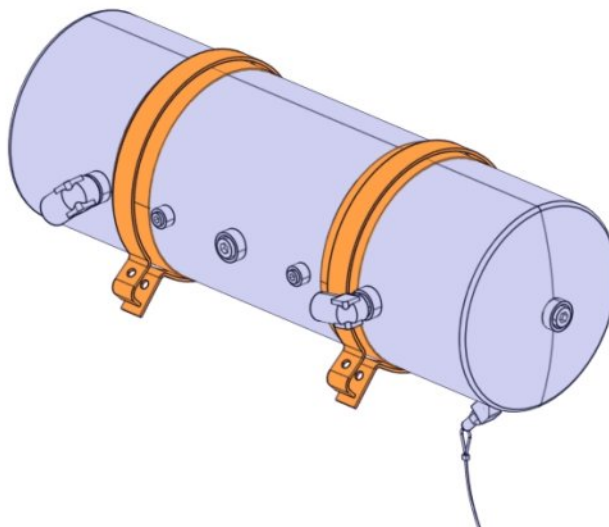
4. Tighten the air tank fittings to 40 ± 5 Nm (30 ± 4 ft-lb).
5. Install tank mounting bracket and fasteners on the cross member.



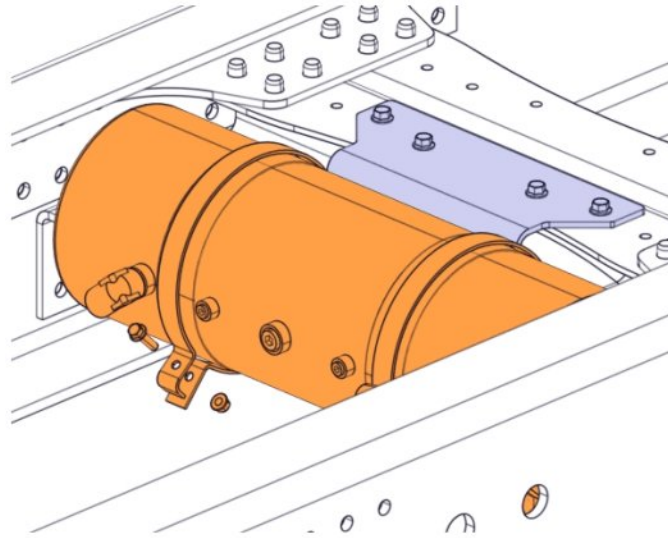
6. Tighten the fasteners to 48 ± 8 Nm (35 ± 6 ft-lb).
7. Install two rubber rings (part number 1594523) on the two mounting straps (part number 21096664).



8. Loosely position the air tank mounting straps over the ends of the air tank.



9. Position the air tank and straps on the mounting brackets, and install the air tank strap fasteners.

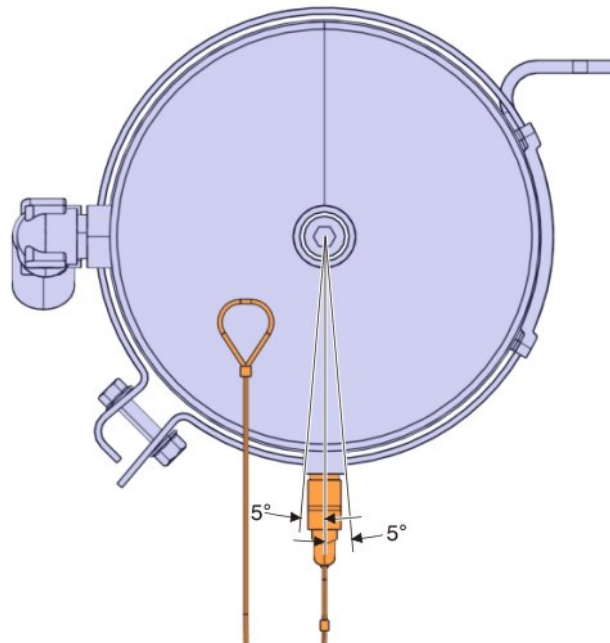


10. Using hand tools, hand tighten the strap bolts.

NOTE

The tank drain should be within ± 5 degrees of the vertical position.

11. Using a torque wrench, tighten the air tank strap bolts to 25 ± 5 Nm (18 ± 4 ft-lb).



12. Install fitting (part number 20462690) in the left side of the (Secondary) air tank to the rear.

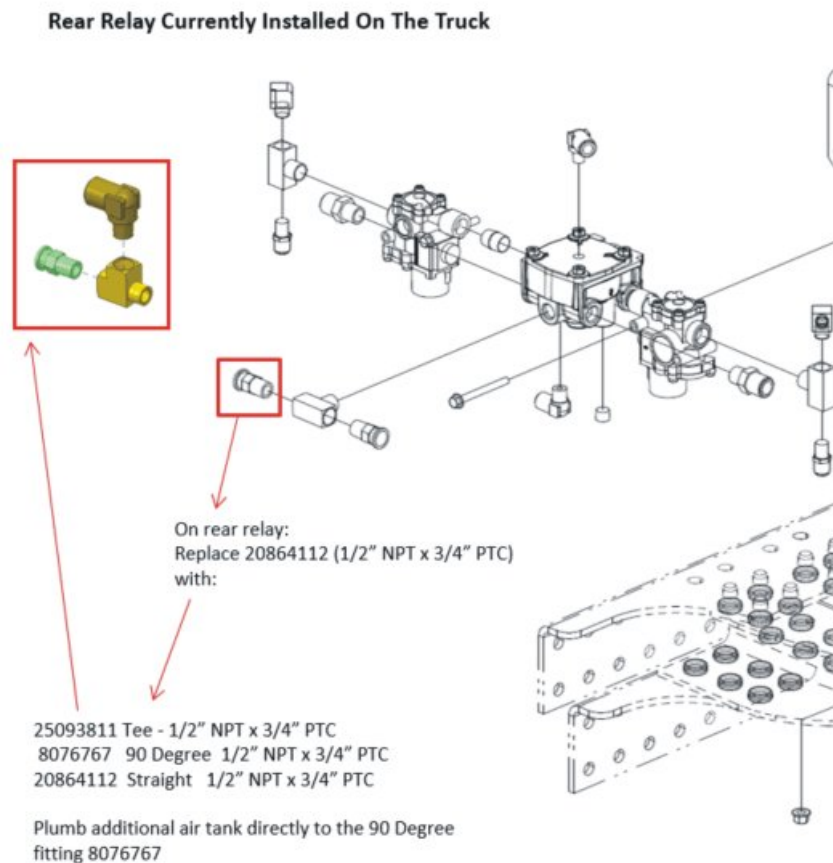
NOTE
O-ring fittings do not require an application thread sealant during installation.

NOTE
Fitting (part number 20462690) will connect the new air tank to the existing air system.

13. Tighten the fitting to 40 ± 5 Nm (30 ± 4 ft-lb).

14. Remove the air line fitting from the relay as shown in the figure below.

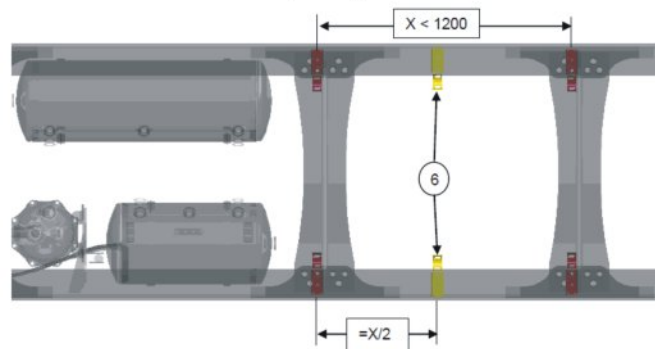
15. Install the tee fitting, elbow, and straight fitting listed in the parts table for this repair.



16. Position and connect the air lines from the new air tank to the vehicle air system.
17. Using cable ties, secure the air lines.

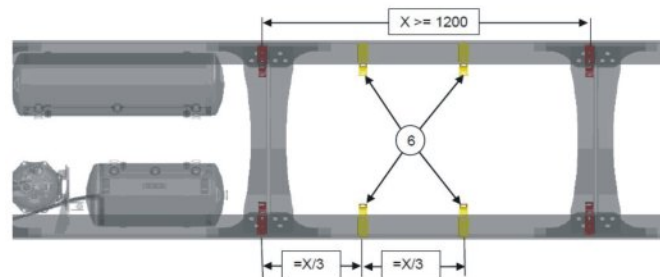
NOTE
Ensure the air lines do not contact any moving parts or components.

3.5.2 X-Member Spacing less than 1200 mm



3.5 Routing and clipping through empty sections

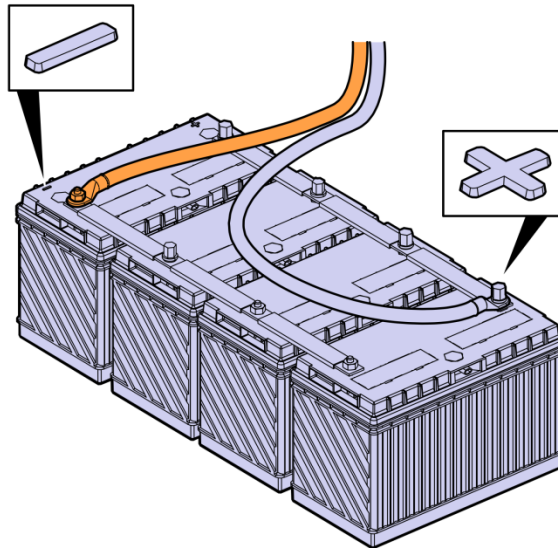
3.5.1 X-Member spacing greater than 1200 mm



18. Proceed to **Commissioning the Truck for Operation** section.

COMMISSIONING THE TRUCK FOR OPERATION:

1. Connect the battery cable to the negative (ground) terminal.

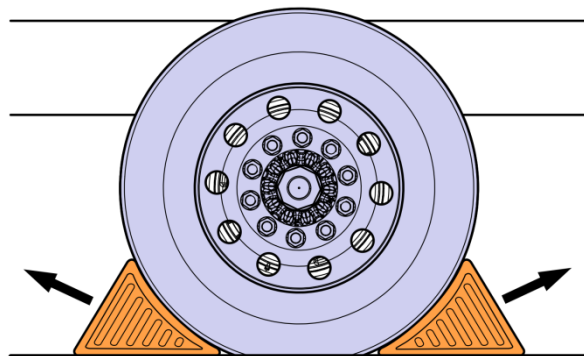


2. Start the truck, check the operation of the air brakes and check for air leaks.

NOTE

Run the engine until the correct pressure for the air brake system is obtained.

3. Remove the wheel chocks.



REIMBURSEMENT:

This repair is covered by an authorized Safety Recall campaign. Reimbursement is obtained through the normal claim handling process.		
	UCHP Reimbursement	eWarranty Reimbursement
Claim Type (Used when uploading from the Dealer business System)	40	40
Recall Status		
Vehicle repaired per instructions		1-Modified per instructions
Labor Code		
Primary Labor Code (Air Tank, Installation Parts List Inspection),	5621-02-09-06 0.3 hrs	5322G-01-95 0.3 hrs
Labor Code (Air Tank, Installation), One In-Frame Air Tank, Repair 1, Parts List 1A, 1B, 1C, 1D,1E	5621-02-09-02 2.4 hrs	5322H-01-95 2.4 hrs
Labor Code (Air Tank, Installation), Two In-Frame Air Tanks, Repair 1, Parts List 1F	5621-02-09-03 3.8 hrs	5322J-01-95 3.8 hrs
Labor Code (Air Tank, Replacement), One Larger Volume Air Tank (Without Mounting Bracket Moved), Repair 2	5621-03-09-05 0.9 hrs	5322K-01-95 0.9 hrs
Labor Code (Air Tank, Replacement), One Larger Volume Air Tank (With Mounting Bracket Moved), Repair 2	5621-03-09-06 1.3 hrs	5322M-01-95 1.3 hrs
Labor Code (Air Tank, Installation), One Under-Frame Air Tank, Repair 3	5621-02-09-04 2.3 hrs	5322N-01-95 2.3 hrs
Labor Code (Air Tank, Installation), Tri-Drive Cross Member Mounted Air Tank, Repair 4	5621-02-09-05 1.6 hrs	5322P-01-95 1.6 hrs
Time to take charge of vehicle and determine campaign status	1700-16-01-01 0.3 hrs	101AA-0A-00 0.3 hrs
Causal Part	21535094	21535094
Authorization Number	C6563	SC0394

Take-charge time is not included in the labor code for this operation. Take charge may be eligible, but can only be used once per vehicle repair visit. If the vehicle is having other warranty repairs performed, take-charge should be charged to the warranty repair, otherwise take-charge can be charged to this Safety Recall campaign.