

April 2023
FL967A
NHTSA #23V-105
Transport Canada #2023-083

Subject: Drag Link Tapered Joint

Models Affected: Specific model years 2019-2021 Freightliner 108SD, 114SD, 122SD, Business Class M2, Cascadia, Columbia, and Coronado vehicles manufactured April 2, 2018, through June 25, 2020.

General Information

Daimler Truck North America LLC (DTNA), on behalf of its Freightliner Trucks Division, has decided that a defect that relates to motor vehicle safety exists on the vehicles mentioned above.

On the affected vehicles, the drag link taper joint at the steering arm may not have been tightened sufficiently and may come loose. This may result in a gradual loosening of the joint causing a loss of steering control, which increases the risk of a crash. A loose joint may be detected by pre-trip inspections, loose steering, wandering, noises, or vibration.

A Daimler Truck North America authorized service facility will inspect the taper joint, test for accurate torque, and repair as necessary.

There are approximately 74,000 vehicles involved in this campaign.

Additional Repairs

Dealers must complete all outstanding recall and field service campaigns prior to the sale or delivery of a vehicle. A dealer will be liable for any progressive damage that results from its failure to complete campaigns before sale or delivery of a vehicle.

Owners may be liable for any progressive damage that results from failure to complete campaigns within a reasonable time after receiving notification.

Work Instructions

Please refer to the attached work instructions. Prior to performing the campaign, check the vehicle for a completion sticker (Form WAR260).

Replacement Parts

Replacement parts are now available and can be obtained by ordering the kit and/or part number(s) listed below from your facing Parts Distribution Center (PDC).

If our records show your dealership has ordered any vehicle(s) involved in campaign number FL967, a list of the customers and vehicle identification numbers will be available on the DTNA Portal. Please refer to this list when ordering parts for this recall.

NOTE: See Procedure column in Table 1 below. Only choose parts based on the procedure you will be performing. Only 2% of the vehicles involved in this recall will require parts.

Table 1 - Replacement Parts for FL967

Campaign Number	Procedure	Part Description	Part Number	Qty.
FL967A	Inspect castle nut and torque	PIN-COTTER,1 3/4 X 1/8	23-00800-407	1 ea
		BLANK COMPLETION STICKER	WAR260	1 ea

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Campaign Number	Procedure	Part Description	Part Number	Qty.
FL967A Replacement Procedure (Only 2% will fall into this category)	Replace drag link and steering arm Choose appropriate drag link, PLUS Completion Sticker	LINK-STEERING, DRAGLINK-, T65, 1.04, 31.47	14-17273-000	1 ea
		DRAGLINK-STRG, THP60, M2, 10	14-17288-000	1 ea
		LINK-STEERING, DRAGLINK-, M2, THP60, 100BBC	14-17289-000	1 ea
		LINK-STEERING, DRAGLINK-, TAS85, M2, 106, 131	14-17290-000	1 ea
		LINK-STEERING, DRAGLINK-, TAS85, M2, 106, 131	14-17291-000	1 ea
		LINK-STEERING, DRAGLINK-, TAS85, M2, 106, 162	14-17293-000	1 ea
		ARM-DRAGLINK, STEERING, D2, 1400, DUAL, RHS	14-17294-000	1 ea
		ARM-DRAGLINK, STEERING, D2, 1400, DUAL, LHS	14-17295-000	1 ea
		ARM-DRAGLINK, STEERING, RCH45, SFA, 1200	14-17296-000	1 ea
		ARM-DRAGLINK, STEERING, D2, FA, 1200, THP60	14-17297-000	1 ea
		LINK-STEERING, DRAGLINK-COMMON, SFA, THP60	14-17298-000	1 ea
		ARM-DRAGLINK, STEERING, COMMON, SB, TAS85, FG	14-17299-000	1 ea
		ARM-DRAGLINK, COMMON, SFA, TAS85, FL, 1200	14-17300-000	1 ea
		ARM-DRAGLINK, STEERING, COMMON, SB, TAS85, FL	14-17301-000	1 ea
		ARM-DRAGLINK, STEERING, COMMON, SB, THP60, DB	14-17302-000	1 ea
		ARM-DRAGLINK, COMMON, SFA, T60, LWB	14-17303-000	1 ea
		ARM-DRAGLINK, STG, LC, 111, 1400, THP60	14-17310-000	1 ea
		ARM-DRAGLINK, STEERING, M2, 106, THP60, 20K	14-17311-000	1 ea
		LINK-STEERING, DRAGLINK-, COMMON, SBA, T60, 2	14-17317-000	1 ea
		LINK-STEERING, DRAGLINK-, COMMON, SBA, RCH45	14-17318-000	1 ea
		LINK-STEERING, DRAGLINK-, SBA, THP60	14-17322-000	1 ea
		ARM-DRAGLINK, 07AB SPLAY, RCH45	14-17324-000	1 ea
		ARM-DRAGLINK, 07AB SPLAY, DUAL	14-17325-000	1 ea
		ARM-DRAGLINK, 07AF, 695, THP60, SWB	14-17334-000	1 ea
		ARM-DRAGLINK, 07AB SPLY, TAS85, 14K, SWB	14-17345-000	1 ea
		ARM-DRAGLINK, 07AB SPLY, TAS85, 14K, LWB	14-17346-000	1 ea
		ARM-DRAGLINK, 07AB SPLY, TAS85, 18K, SWB	14-17347-000	1 ea
		ARM-DRAGLINK, 07AB SPLY, TAS85, 18K, LWB	14-17348-000	1 ea

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Campaign Number	Procedure	Part Description	Part Number	Qty.
FL967A Replacement Procedure (Only 2% will fall into this category)	Replace drag link and steering arm Choose appropriate drag link, PLUS Completion Sticker	LINK-STEERING, DRAGLINK-, T65, 1.04, 31.47 ARM-DRAGLINK, 07AB SPLY, THP60, SWB	14-17349-000	1 ea
		LINK-STEERING, DRAGLINK-07MD, AWD, THP60	14-17350-000	1 ea
		LINK-STEERING, DRAGLINK-, X2, MERITOR AXLE	14-17643-000	1 ea
		LINK-STEERING, DRAGLINK-, X2, TAS85, 16-18K	14-17645-000	1 ea
		ARM-DRAGLINK, 07AF, 695, THP60, LWB	14-17648-000	1 ea
		DRAGLINK, 10AF, 695, T85, 18K TAPER	14-17865-000	1 ea
		DRAGLINK, 10AF, 695, T85, 18K FLAT	14-17866-000	1 ea
		DRAGLINK, 10AF, 695, T85, 14K	14-17876-000	1 ea
		DRAGLINK-M2-SFA-DC, RCH45	14-18299-000	1 ea
		DRAGLINK-M2-SFA-DC, DUAL	14-18300-000	1 ea
		DRAGLINK, CMN, 645 SFA	14-18472-000	1 ea
		DRAGLINK, T60, LWB, 645 SFA	14-18473-000	1 ea
		DRAGLINK, T85, SWB, 645 SFA	14-18486-000	1 ea
		DRAGLINK, T85, SWB, 645 SFA	14-18487-000	1 ea
		DRAGLINK, T85, SWB, 645 SFA	14-18488-000	1 ea
		DRAGLINK, T60, LWB ,645 SFA	14-18491-000	1 ea
		DRAGLINK-AB BO, SWB, THP60	14-18527-000	1 ea
		DRAGLINK-AB BO, LWB, THP60	14-18528-000	1 ea
		DRAGLINK-STEERING, THP45, FC1	14-18789-000	1 ea
		DRAGLINK-STEERING, SD-SFA-SPLAY, DUAL	14-18901-000	1 ea
DRAGLINK-STEERING, SD-SFA-SPLAY, RCH45	14-18902-000	1 ea		
SEE NOTE DRAGLINK-STRG, TRW, NGC, LWB	14-19428-000	1 ea		
DRAGLINK-STRG, TRW, NGC, SWB	14-19429-000	1 ea		
DRAGLINK-TAS85, NGC, 14.6K	14-19512-000	1 ea		
DRAGLINK-TAS85, NGC, 16K	14-19513-000	1 ea		
DRAGLINK-SFA-SPLAY, RCH60	14-19533-000	1 ea		
FL967A Replacement Procedure (Only 2% will fall into this category)	Replace drag link and steering arm Vehicles with Hendrickson steering arms, choose appropriate steering arm, PLUS hardware	STEERING ARM AY-LH	HDR 60903 435	1 ea
		STEERING ARM AY-LH	HDR 60903 436	1 ea
		STEERING ARM AY-LH	HDR 60903 438	1 ea
		STEERING ARM AY	HDR 60903 439	1 ea
		STEERING ARM ASSEMBLY LH	HDR 60903 473	1 ea
		5/8-11 SOCKET CAP	HDR 60236 001	2 ea
		PIN-COTTER,1 3/4 X 1/8	23-00800-407	2 ea

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Campaign Number	Procedure	Part Description	Part Number	Qty.
FL967A Replacement Procedure (Only 2% will fall into this category)	Replace drag link and steering arm Vehicles with Detroit steering arms, choose appropriate steering arm and capscrew, PLUS cotter pin	STEERING ARM	MBA 6803382101	1 ea
		STEERING ARM	MBA 6803380201	1 ea
		ARM-STEERING	MBA 6803382501	1 ea
		STEERING ARM	MBA 6803380401	1 ea
		STEERING ARM	MBA 6803380901	1 ea
		STEERING ARM	MBA 6803381601	1 ea
		STEERING ARM (14.7K GAWR)	MBA 6803384401	1 ea
		ARM, L. H. STEERING	MBA 6803382203	1 ea
		ARM, L. H. STEERING	MBA 6803382603	1 ea
		STEERING ARM LH LARGE TAPER UP IN KM	MBA 6803382303	1 ea
		STEERING ARM, LH	MBA 6803382403	1 ea
		ARM, R. H. STEERING	MBA 6803383203	1 ea
		ARM, R. H. STEERING	MBA 6803383603	1 ea
		R.H. STEERING ARM	MBA 6803381402	1 ea
		STRG ARM, RH	MBA 6803383403	1 ea
		STEERING ARM, M2	MBA 6813380001	1 ea
		STEERING ARM, M2	MBA 6803381801	1 ea
		STEERING ARM, M2	MBA 6813380201	1 ea
		STEERING ARM, M2	MBA 6803382001	1 ea
		ARM, STEERING M3	MBA 6803382301	1 ea
		STEERING ARM, M3	MBA 6813380901	1 ea
		STEERING ARM, M3	MBA 6803382701	1 ea
		STEERING ARM, 14.7K	MBA 6803382901	1 ea
		STEERING ARM RH	MBA 6803380502	1 ea
		STEERING ARM LH	MBA 6803384503	1 ea
		STEERING ARM LH	MBA 6803384403	1 ea
		STEERING ARM RH	MBA 6803380402	1 ea
		STEERING ARM	MBA 6813381001	1 ea
		STEERING ARM 430 RH NGC	MBA 6803385603	1 ea
		STEERING ARM 390 RH	MBA 6813381101	1 ea
SCREW,M20X1.5X80-10.9	MBA 308676020025	2 ea		
SCREW M24X2X90	MBA 308676024001	2 ea		
SCREW M24X2X90	MBA 308676024003	2 ea		
PIN-COTTER,1 3/4 X 1/8	23-00800-407	2 ea		

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Campaign Number	Procedure	Part Description	Part Number	Qty.
SF660A Replacement Procedure (Only 2% will fall into this category)	Replace drag link and steering arm Vehicles with Meritor steering arms, choose appropriate steering arm, PLUS hardware	ARM & KEYS	TDA 3133Z7696K	1 ea
		ARM AND KEYS	TDA 3133N7736K	1 ea
		ARM-TIE ROD ARM-STEERING	TDA 3133S8963	1 ea
		ARM-STRG	TDA 3133S8963F	1 ea
		ARM-STEERING	TDA 3133W8967	1 ea
		ARM-STEERING	TDA 3133E8403	1 ea
		ARM-STRG	TDA 3133S8417F	1 ea
		STRG ARM LH	TDA 3133E8403F	1 ea
		ARM-STEERING, LH	TDA 3133E7779	1 ea
		ARM-STEERING LH	TDA 3133B8582	1 ea
		ARM-STEERING, RH	TDA 3133C8609	1 ea
		ARM-STEERING	TDA 3133E8611	1 ea
		ARM-STEERING	TDA 3133G8743	1 ea
		ARM-STEERING, LH	TDA 3133L8618	1 ea
		STEERING ARM	TDA 3133U8679	1 ea
		ARM STEERING ASSEMBLY, RIGHT HAND	TDA 3133V8680	1 ea
		ARM STEERING LH	TDA 3133E8455F	1 ea
		ARM-STEERING	TDA 3133G8457F	1 ea
		ARM STEERING LH	TDA 3133D8454F	1 ea
		ARM-STEERING,FRONT AXLE, RH	TDA 3133E9287	1 ea
		ARM-STEERING,FRONT AXLE, LH	TDA 3133F9288	1 ea
		ARM-STEERING, LH	TDA 3133D9286	1 ea
		ARM-STEERING, LH	TDA 3133C9285	1 ea
		ARM-STEERING, LH	TDA 3133F9470	1 ea
		ARM-STEERING, LH	TDA 3133H9472	1 ea
		ARM-STEERING, LH	TDA 3133Q9403	1 ea
PIN-COTTER	TDA K2618	1 ea		
NUT-STEERING ARM	TDA 1227Y1715	1 ea		
PIN-COTTER,1 3/4 X 1/8	23-00800-407	2 ea		

Table 1

Removed Parts

U.S. and Canadian Dealers, please follow Warranty Failed Parts Tracking shipping instructions for the disposition of all removed parts. Export distributors, please destroy removed parts unless otherwise advised.

Labor Allowance

Table 2 - Labor Allowance

Campaign Number	Procedure	Time Allowed (hours)	SRT Code	Corrective Action
FL967A	Inspect drag link and torque	0.4	996-R189A	06-Inspect
	Inspect drag link and torque; replace drag link and steering arm	2.1	996-R189B	12-Repair Recall/Campaign
	Inspect drag link and torque, both sides; replace drag link and steering arm	4.1	996-R189C	12-Repair Recall/Campaign

Table 2

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IMPORTANT: When the recall has been completed, locate the base completion label in the appropriate location on the vehicle, and attach the red completion sticker provided in the recall kit (Form WAR260). If the vehicle does not have a base completion label, clean a spot on the appropriate location of the vehicle and first attach the base completion label (Form WAR259). If a recall kit is not required or there is no completion sticker in the kit, write the recall number on a blank sticker and attach it to the base completion label.

Claims for Credit

You will be reimbursed for your parts, labor, and handling (landed cost for Export Distributors) by submitting your claim through the warranty system within 30 days of completing this campaign. Please reference the following information in OWL:

- Claim type is **Recall Campaign**.
- In the Campaign field, enter the campaign number and appropriate condition code (**FL967-A**).
- In the Primary Failed Part Number field, enter **25-FL967-000**.
- In the Parts field, enter the appropriate kit or part number(s) as shown in the Replacement Parts table.
- In the Labor field, first enter the appropriate SRT from the Labor Allowance table. Administrative time will be included automatically as SRT 939-6010A for 0.3 hours.
- The VMRS Component Code is **F99-999-005** and the Cause Code is **A1 - Campaign**.
- **U.S. and Canada -- Reimbursement for Prior Repairs.** When a customer asks about reimbursement, please do the following:
 - Accept the documentation of the previous repair.
 - Make a brief check of the customer's paperwork to see if the repair may be eligible for reimbursement. (See the "Copy of Owner Letter" section of this bulletin for reimbursement guidelines.)
 - Submit an OWL Recall Pre-Approval request for a decision.
 - Include the approved amount on your claim in the Other Charges section.
 - Attach the documentation to the pre-approval request.
 - If approved, submit a based-on claim for the pre-approval.
 - Reimburse the customer the appropriate amount.

IMPORTANT: OWL must be viewed prior to performing the recall to ensure the vehicle is involved and the campaign has not been previously completed. Also, check for a completion sticker prior to beginning work.

U.S. and Canadian dealers, if you need additional information, contact the Warranty Campaigns Department using the WSC (Warranty Support Center) app on the DTNA Portal. Export distributors, submit a WSC ticket or contact your International Service Manager.

U.S. and Canadian Dealers: To return excess kit inventory related to this campaign, U.S. dealers must submit a Parts Authorization Return (PAR) to the Memphis PDC. Canadian dealers must submit a PAR to their facing PDC. All kits must be in resalable condition. PAR requests must include the original purchase invoice number. Export Distributors: Excess inventory is not returnable.

The letter notifying U.S. and Canadian vehicle owners is included for your reference.

Please note that the National Traffic and Motor Vehicle Safety Act, as amended (Title 49, United States Code, Chapter 301), requires the owner's vehicle(s) be corrected within a reasonable time after parts are available to you. The Act states that failure to repair a vehicle within 60 days after tender for repair shall be prima facie evidence of an unreasonable time. However, circumstances of a particular situation may reduce the 60 day period. Failure to repair a vehicle within a reasonable time can result in either the obligation to (a) replace the vehicle with an identical or reasonably equivalent vehicle, without charge, or (b) refund the purchase price in full, less a reasonable allowance for depreciation. The Act further prohibits dealers from selling a vehicle unless

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all outstanding recalls are performed. Any lessor is required to send a copy of the recall notification to the lessee within 10 days. Any subsequent stage manufacturer is required to forward this notice to its distributors and retail outlets within five working days.

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Copy of Notice to Owners

Subject: Drag Link Tapered Joint

For the Notice to U.S. Customers: This notice is sent to you in accordance with the National Traffic and Motor Vehicle Safety Act. **For the Notice to Canadian Customers:** This notice is sent to you in accordance with the requirements of the Motor Vehicle Safety Act. This is to inform you that your vehicle may contain a defect that could affect the safety of a person.

Daimler Truck North America LLC (DTNA), on behalf of its Freightliner Trucks Division, has decided that a defect that relates to motor vehicle safety exists on specific model years 2019-2021 Freightliner 108SD, 114SD, 122SD, Business Class M2, Cascadia, Columbia, and Coronado vehicles manufactured April 2, 2018, through June 25, 2020.

On the affected vehicles, the drag link taper joint at the steering arm may not have been tightened sufficiently and may come loose. This may result in a gradual loosening of the joint causing a loss of steering control, which increases the risk of a crash. A loose joint may be detected by pre-trip inspections, loose steering, wandering, noises or vibration.

A Daimler Truck North America authorized service facility will inspect the taper joint, test for accurate torque and repair as necessary.

Please contact an authorized Daimler Truck North America dealer to arrange to have the recall performed and to ensure that parts are available at the dealership. The recall will take approximately four hours and will be **performed free of charge**. To locate an authorized dealer, search online at <https://northamerica.daimlertruck.com/contact-us/>. Scroll down to "Locate a Dealer," and select the appropriate brand. You may also confirm your vehicle's involvement in this recall at this URL: <https://dtna-dlrinfo.prd.freightliner.com:48518/VinLookup/vin-module/getVinLookupPage>.

You may be liable for any progressive damage that results from your failure to complete the recall within a reasonable time after receiving notification.

If you do not own the vehicle that corresponds to the identification number(s) which appears on the recall notification, please return the notification to the Warranty Campaigns Department in the postage-paid envelope with any information you can furnish that will assist us in locating the present owner. If you have leased this vehicle, federal law requires that you forward this notice to the lessee within 10 days. If you are a subsequent stage manufacturer, federal law requires that you forward this notice to your distributors and retail outlets within five working days. If you have paid to have this recall condition corrected prior to this notice, you may be eligible to receive reimbursement. Please see the reverse side of this notice for details.

If you have questions about this recall, please contact the Warranty Campaigns Department at (800) 547-0712, 7:00 a.m. to 4:00 p.m. Pacific Time, Monday through Friday, e-mail address dtna.warranty.campaigns@daimlertruck.com. **For the Notice to U.S. Customers:** If you are not able to have the defect remedied without charge and within a reasonable time, you may wish to submit a complaint to the Administrator, National Highway Traffic Safety Administration, 1200 New Jersey Avenue, SE., Washington, DC 20590; or call the Vehicle Safety Hotline at (888) 327-4236 (TTY: 800-424-9153); or go to <http://www.nhtsa.gov>. **For the Notice to Canadian Customers:** If you wish to submit a complaint about this recall, you can contact Transport Canada - Road Safety, 80 Rue Noel, Gatineau, Quebec J8Z 0A1, or call (800) 333-0510.

We regret any inconvenience this action may cause but feel certain you understand our interest in motor vehicle safety.

WARRANTY CAMPAIGNS DEPARTMENT

Enclosure

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Reimbursement to Customers for Repairs Performed Prior to Recall

If you have already **paid** to have this recall condition corrected you may be eligible to receive reimbursement.

Requests for reimbursement may include parts and labor. Reimbursement may be limited to the amount the repair would have cost if completed by an authorized Daimler Truck North America LLC dealer. The following documentation must be presented to your dealer for consideration for reimbursement.

Please provide original or clear copies of all receipts, invoices, and repair orders that show:

- The name and address of the person who paid for the repair
- The Vehicle Identification Number (VIN) of the vehicle that was repaired
- What problem occurred, what repair was done, when the repair was done
- Who repaired the vehicle
- The total cost of the repair expense that is being claimed
- Proof of payment for the repair (such as the front and back of a cancelled check or a credit card receipt)

Reimbursement will be made by check from your Daimler Truck North America LLC dealer.

Please speak with your Daimler Truck North America LLC authorized dealer concerning this matter.

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Work Instructions

Subject: Drag Link Tapered Joint

Models Affected: Specific model years 2019-2021 Freightliner 108SD, 114SD, 122SD, Business Class M2, Cascadia, Columbia, and Coronado vehicles manufactured April 2, 2018, through June 25, 2020.

Castle Nut Inspection and Tightening

NOTE: This procedure will require two people—one in the cab to turn the steering wheel, and one to observe the drag link steering arm joint as the steering wheel is turned.

1. Check the base label (Form WAR259) for a completion sticker for FL967 (Form WAR260) indicating this work has been done. The base label is usually located on the passenger door about 12 inches (30 cm) below the door latch. If a sticker is present, no work is needed. If there is no sticker, proceed with the next step.
2. Park the vehicle on a level surface, shut down the engine, and set the parking brake. Chock the rear tires.
3. Open the hood.
4. Observe the behavior of the drag link steering arm joint. See [Fig. 1](#).

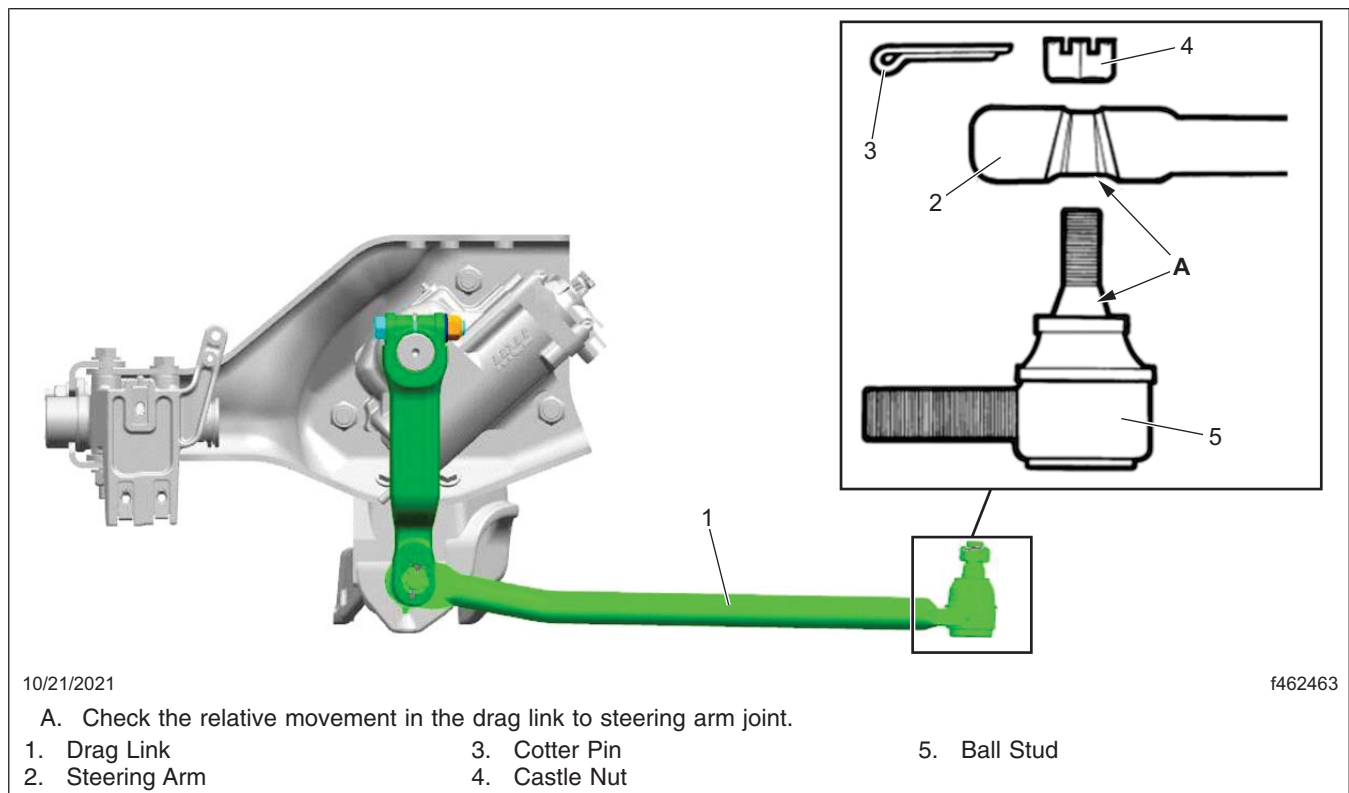


Fig. 1, Drag Link to Steering Arm Joint

- 4.1 With the engine running at idle, and the parking brake still engaged, have an assistant turn the steering wheel in small increments from left-to-right and back several times.

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 **WARNING**

Maintain a safe distance from the front tire and the moving steering linkage while observing.

Failure to maintain a safe distance could result in severe personal injury or death.

4.2 While the steering wheel is being turned, check the behavior of the drag link to steering arm joint.

5. Are any of the following conditions observed?

- The castle nut appears to be loose.
- The cotter pin is not in place.
- There is relative movement in the drag link to steering arm joint when the steering wheel is moved back and forth.
- If the vehicle is equipped with dual steering gears, follow the steps for both sides.

YES → Go to the **Drag Link and Steering Arm Replacement** procedure, on the next page.

NO → Go to the next step.

IMPORTANT: Do not back off the castle nut to align its slots to the cotter pin hole on the ball stud. Further turn the castle nut a maximum of one-sixth of a turn to align it.

6. Remove and discard the cotter pin from the castle nut at the drag link to steering arm joint, then tighten the castle nut to the torque value shown in **Table 3**. See **Fig. 2**.

Castle Nut Torque Values	
Size	Torque: lbf-ft (N·m)
3/4-16	117-143 (159-194)
7/8-14	207-253 (281-343)

Table 3, Castle Nut Torque Values

7. Install and lock a new cotter pin on the drag link to steering arm joint.
8. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for FL967 (Form WAR260), indicating this work has been completed.

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Drag Link and Steering Arm Replacement

IMPORTANT: For vehicles equipped with dual steering gears, the inspection procedure and the necessary repairs must be performed on both sides.

1. At both ends of the drag link, remove the cotter pins, then remove the castle nuts. See **Fig. 2**. Discard the cotter pins and castle nuts.
2. Using a ball stud removal tool, remove the ball studs from the pitman arm and the steering arm.
3. Remove the drag link from the vehicle, and discard it.
4. **For Detroit® steering arm:**
 - 4.1 Remove the capscrews that attach the steering arm to the knuckle, then remove the steering arm from the vehicle. Discard the steering arm and capscrews.
 - 4.2 Position a new steering arm on the knuckle. Apply Loctite® 277 on the threads of the new steering arm capscrews, then install the capscrews.
 - If M20 capscrews are used, tighten them 425 lbf-ft (576 N-m).
 - If M24 capscrews are used, tighten them 664 lbf-ft (900 N-m).

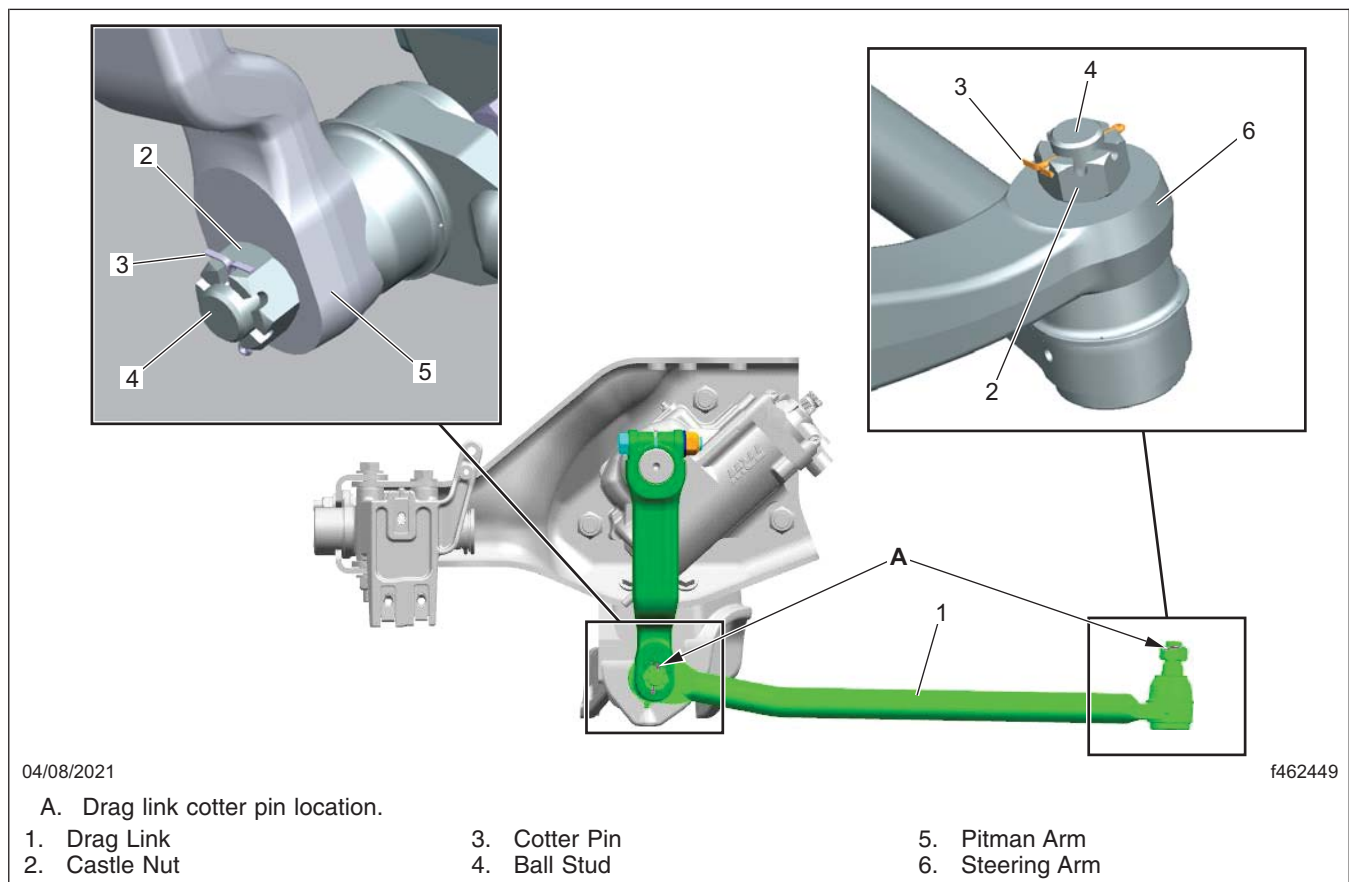


Fig. 2, Drag Link Cotter Pin Location

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5. For Meritor steering arm:

- 5.1 For non-drive front axles, remove the cotter pin and castle nut that attach the steering arm to the knuckle, then remove the steering arm from the vehicle. Discard the steering arm, castle nut and cotter pin.
- 5.2 Press the key into the slot in the arm, then install the new steering arm on the knuckle.

IMPORTANT: Do not back off the castle nut to align its slots to the cotter pin hole on the ball stud. Further turn the castle nut a maximum of one-sixth of a turn to align it.

- 5.3 Install a new castle nut TDA 1227Y1715. Tighten the nut 775 to 1450 lbf·ft (1051 to 1966 N·m). Install and lock a new cotter pin TDA K2618 on the castle nut.
- 5.4 For front drive axles, see Meritor MX-120/MX-120EVO Service Manual.
- 5.5 Remove the capscrews that attach the steering arm to the knuckle, then remove the steering arm from the vehicle. Discard the steering arm and capscrews.
- 5.6 Position a new steering arm on the knuckle, then install the new capscrews. Tighten the capscrews 500 to 650 lbf·ft (678 to 881 N·m).

6. For Hendrickson steering arm:

- 6.1 Remove the capscrews that attach the steering arm to the knuckle, then remove the steering arm from the vehicle. Discard the steering arm and capscrews.
 - 6.2 Position a new steering arm on the knuckle, then install the new capscrews HDR 60236-001. Tighten the capscrews 176 to 200 lbf·ft (239 to 271 N·m).
7. Insert the steering arm ball stud of the new drag link assembly through the bottom of the steering arm, then install a new castle nut, and hand-tighten it.
 8. Turn the steering wheel as needed to align the hole in the lower end of the pitman arm with the forward ball stud. Insert the ball stud in the pitman arm from the inboard side. Install a new castle nut, and hand-tighten it.

IMPORTANT: Do not back off the castle nut to align its slots to the cotter pin hole on the ball stud. Further turn the castle nut a maximum of one-sixth of a turn to align it.

9. Tighten the castle nuts to the torque value shown in [Table 3, on page 11](#).
10. Install and lock a new cotter pin on the castle nuts at both ends of the drag link. See [Fig. 2, on page 12](#).
11. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for FL967 (Form WAR260), indicating this work has been completed.