

November 2023
FL979A-F
NHTSA #23V-467
Transport Canada #2023-372
REVISED NOTICE

Subject: Freightliner eCascadia e-Axle Ring Gear

Models Affected: Specific model years 2023-2024 Freightliner eCascadia vehicles manufactured between January 19, 2023, through April 13, 2023.

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.

REVISION:The parts table has been updated with the correct parts list.

On the affected vehicles, the e-axle planetary gear set(s) may not be welded properly, which can cause the e-motor to detach from the final drive. This may result in an undetectable, sudden loss of drive power without the ability to restart the vehicle, which can increase the risk of a crash.

A Daimler Truck North America authorized service facility will replace the e-axle(s) on your vehicle. The Recall will take approximately eleven hours and will be performed free of charge.

There are approximately 95 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 FL979, 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.

Table 1 - Replacement Parts for FL979

Campaign Number	Part Description	Part Number	Qty.
FL979A	e-AXLE, REAR AXLE, 4X2 NON-DCDL	MBA 7753509214	1 ea
FL979BC	e-AXLE, REAR 1ST AXLE, 6X4 NON-DCDL	MBA 7753508914	1 ea
FL979D	e-AXLE, REAR 1ST AXLE, 6X4 DCDL	MBA A7753509014	1 ea
FL979EF	e-AXLE, REAR 2ND AXLE, 6X4 NON-DCDL	MBA 7753508814	1 ea
	FLANGE GASKET	MBA 7753530680	

Table 1

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Campaign Number	Part Description	Part Number	Qty.
FL979A-F	U-BOLT	11-23853-002	4 ea
	U-BOLT WASHER	23-09114-005	8 ea
	U-BOLT NUT	23-00461-007	8 ea
	WHEEL SEAL	CM 10045887	2 ea
	AXLE SHAFT O-RING	11-30728-000	2 ea
	CALIPER BOLTS	N210931 020001	12 ea
	CALIPER WASHER	23-09114-004	12 ea
	SPIDER PLATE BOLT - 2"	23-09445-200	16 ea
	SPIDER PLATE BOLT - 2.5"	23-09445-250	4 ea
	SPIDER PLATE WASHER	WWS 2W0264879	40 ea
	SPIDER PLATE NUT	23-13833-210	20 ea
FL979A-F	BLANK COMPLETION STICKER	WAR260	1 ea

Table 1, continued from page 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
FL979A	Remove and replace one rear electric axle	11.4	996-R218A	12-Repair Recall/Campaign
FL979B-D	Remove and replace front rear electric axle	9.9	996-R218B	12-Repair Recall/Campaign
FL979E-F	Remove and replace rear rear electric axle	9.9	996-R218C	12-Repair Recall/Campaign

Table 2

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.

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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 (**FL979-A, FL979-B, etc.**).
- In the Primary Failed Part Number field, enter **25-FL979-000**.
- 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 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: Freightliner eCascadia e-Axle Ring Gear

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, which relates to motor vehicle safety, exists in certain 2024 Freightliner eCascadia vehicles manufactured between January 31, 2023, through April 12, 2023.

On the affected vehicles, the e-axle planetary gear set(s) may not be welded properly, which can cause the e-motor to detach from the final drive. This may result in an undetectable, sudden loss of drive power without the ability to restart the vehicle, which can increase the risk of a crash.

A Daimler Truck North America authorized service facility will replace the e-axle(s) on your vehicle. The Recall will take approximately eleven hours and will be performed free of charge.

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. 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 the following 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 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 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 other concerns, you may contact the Customer Assistance Center at (800) 385-4357. If you have a safety concern relating to this Recall, you may wish to contact Transport Canada – Motor Vehicle Safety at, 80 rue Noel, Gatineau, Quebec J8Z 0A1 or phone (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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Copy of Notice to Owners

Subject: Freightliner eCascadia e-Axle Ring Gear

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

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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 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 other concerns, you may contact the Customer Assistance Center at (800) 385-4357. If your manufacturer, distributor, or dealer fails to remedy the defect or noncompliance 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>.

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: Freightliner eCascadia e-Axle Ring Gear

Models Affected: Specific model years 2023-2024 Freightliner eCascadia vehicles manufactured between January 19, 2023, through April 13, 2023.

FL979A-D — Front or Single e-Axle

See [Fig. 1](#) for the eCarrier components.

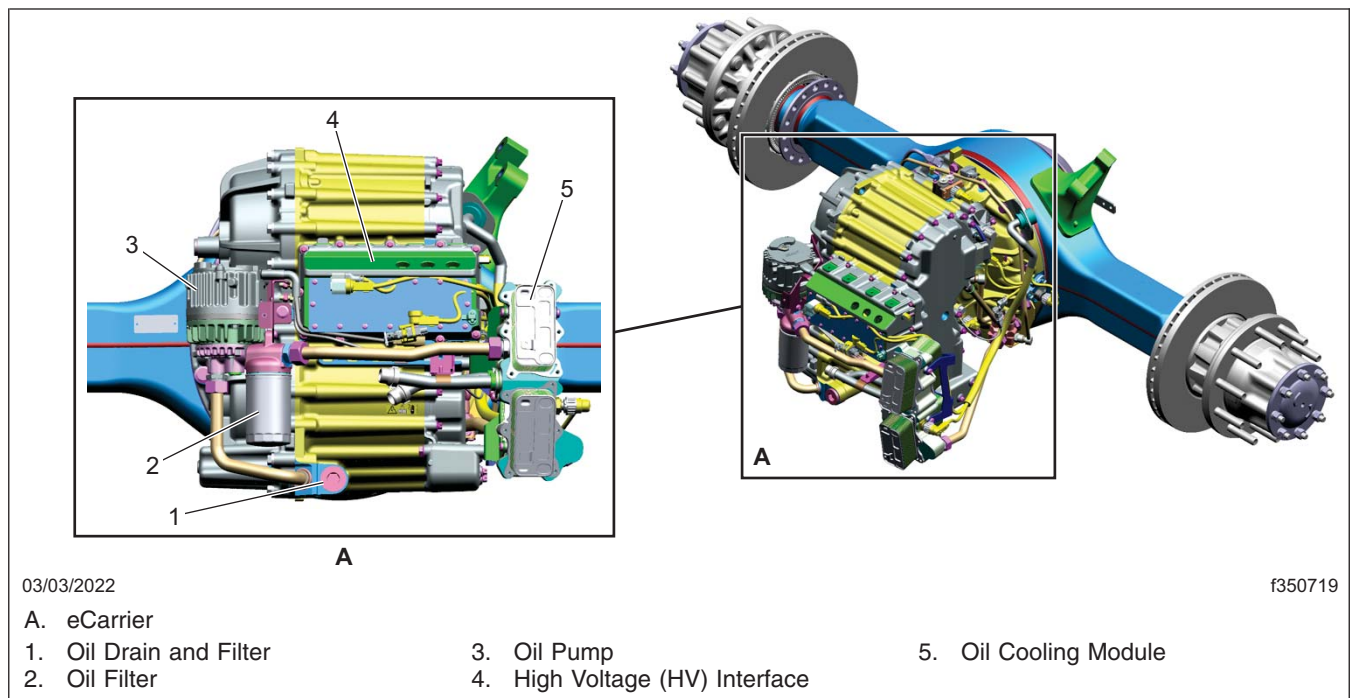


Fig. 1, eCarrier Components

1. Check the base label (Form WAR259) for a completion sticker for FL979 (Form WAR260) indicating this work has been done. The base label is usually located on the passenger-side door, about 12 inches (30 cm) below the door latch. If a recall completion 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. Turn the keyswitch to the OFF position, place the vehicle in neutral, and set the park brake. Chock the tires.
3. Drain the air from the vehicle's air system.
4. Decommission the vehicle and verify the high voltage system is shut down. For instructions, see **Section 08.08** of the *eCascadia Workshop Manual*.
5. Remove the drive wheel fairings. For instructions, see **Section 31.04** of the *eCascadia Workshop Manual*.
6. Take the mobile wheel lift column and position it at each corner of the vehicle.

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- Lift the vehicle. Remove all the tires on the axle being replaced, then lower the vehicle to the ground. For instructions to raise and lower the vehicle, see **Section 00.05** of the *eCascadia Workshop Manual*.
- Disconnect the low voltage (LV) chassis harness from the e-Axle. See **Fig. 2**.

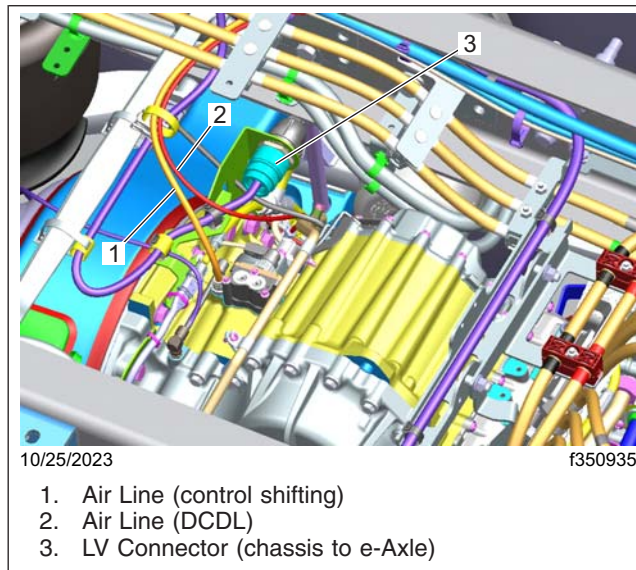


Fig. 2, Location of the LV Connector

- Disconnect the flat grounding cables straps from the e-Axle. See **Fig. 3**.

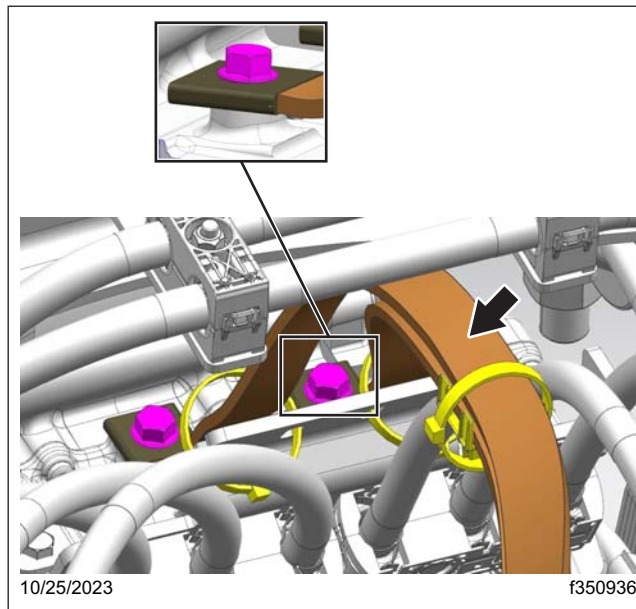


Fig. 3, Flat Grounding Cables Straps

- Remove the two rear deck plates that protect the inverters by removing the fasteners on each plate.

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11. Remove the high voltage (HV) cable clamps and the mounting fasteners from the HV cable support brackets. Then, remove the support brackets. See [Fig. 4](#).

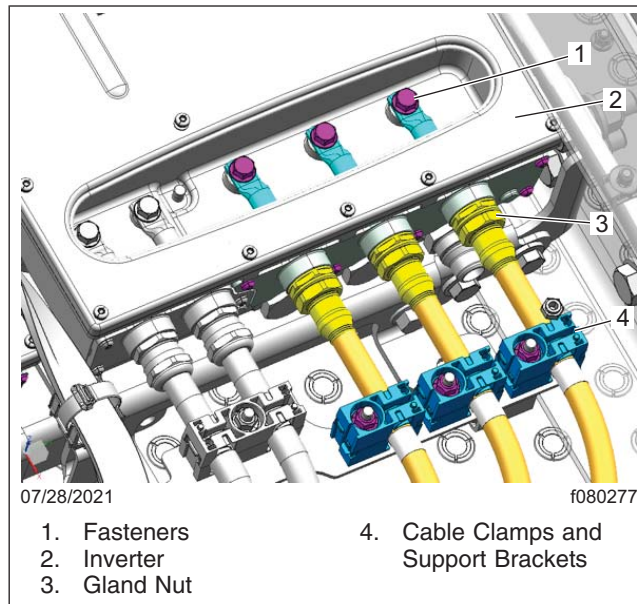


Fig. 4, Inverter Side High Voltage Cables

IMPORTANT: Clean any dirt or debris from high voltage connectors before removing them. Failure to do so could increase the chance of dirt getting into the connector during installation.

12. Remove the inverter access cover.

13. Remove the delayed access cover. See [Fig. 5](#).

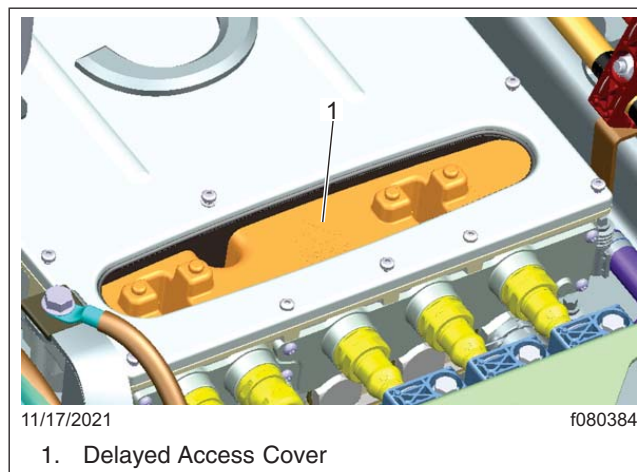


Fig. 5, Delayed Access Cover Removal

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14. Remove the fasteners that secure the HV cables from the e-Axle to the rear side of the inverter. See [Fig. 6](#) and [Fig. 4](#).

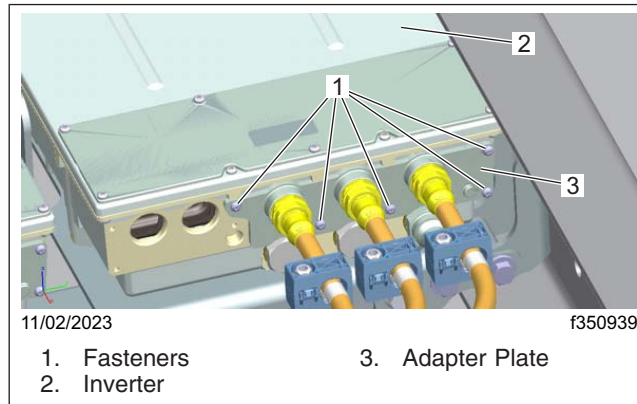


Fig. 6, Fasteners on the Rear Side of the Inverter

15. Remove the high voltage cable lug fasteners located inside the inverters 1 and 2. See [Fig. 7](#).

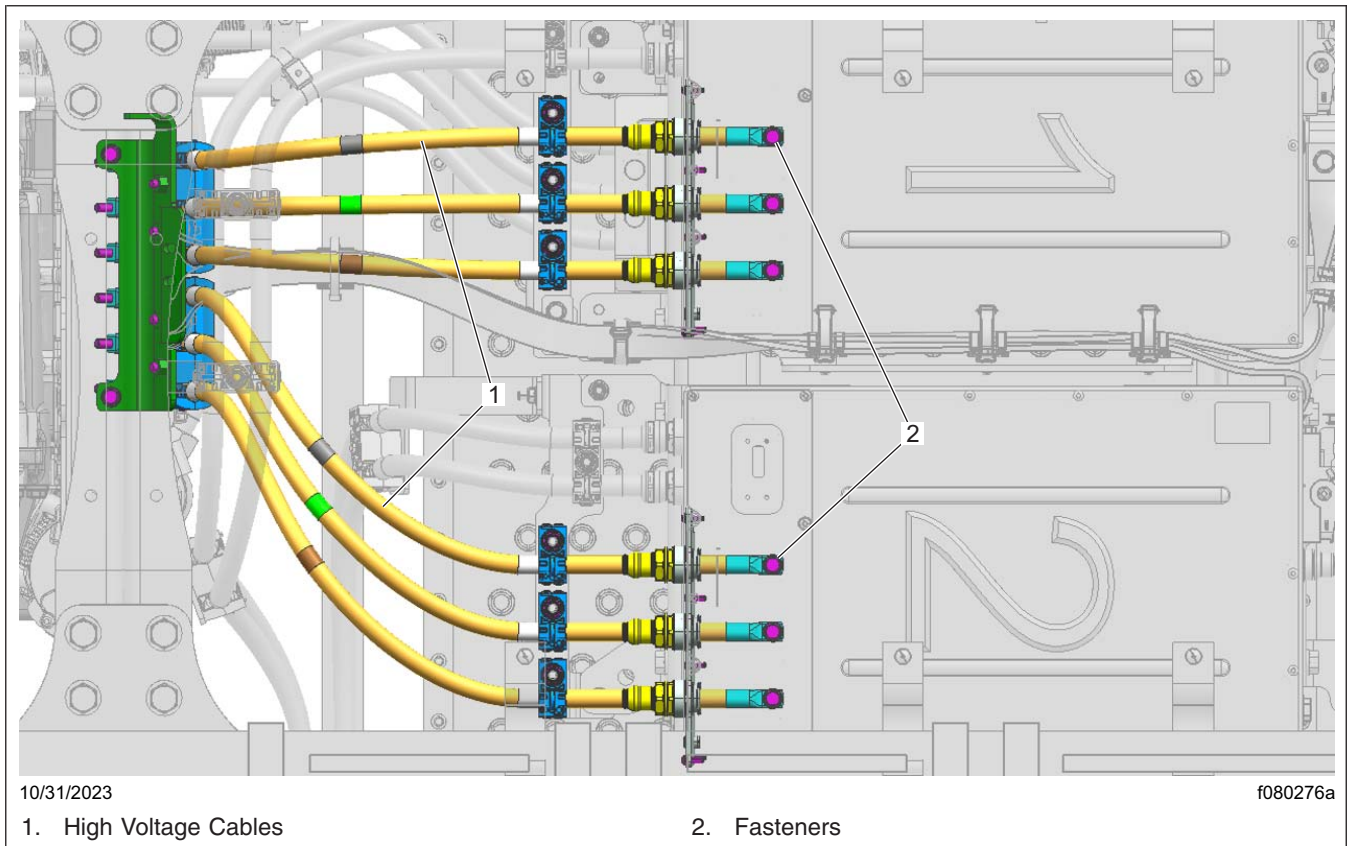


Fig. 7, High Voltage Cables Connecting Inverter and Forward Rear Axle

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16. Pull the cables out from the rear of the inverters. See [Fig. 8](#).
17. Disconnect the air lines from the eCarrier. See [Fig. 2](#).
18. Lift the vehicle to the desired working height.
19. Cut the zip ties on the coolant hoses.
20. Disconnect the coolant lines from the e-Axle, and let the fluid drain out. See [Fig. 9](#).

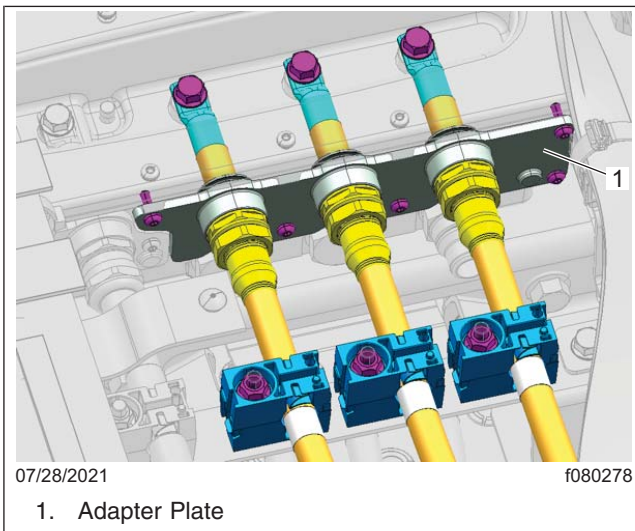


Fig. 8, Location of the Adapter Plate

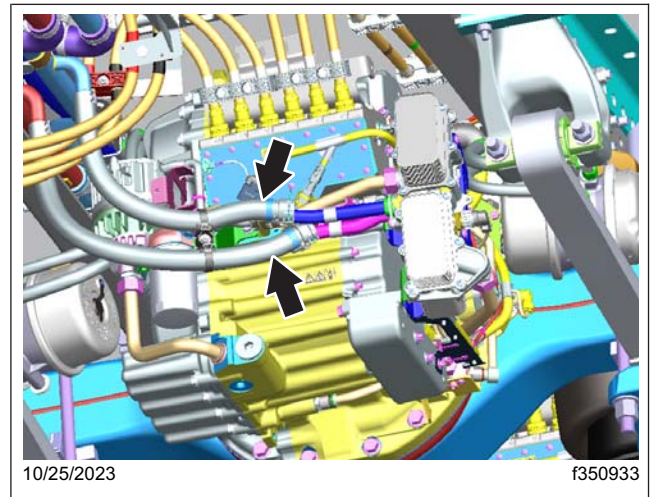


Fig. 9, Location of the Coolant Lines

21. Place the e-Axle cart under the vehicle and rest the e-Axle on it.
22. Remove the fasteners that hold the control rod to the e-Axle tower.
23. Remove the upper shock bolts.
24. Remove the fasteners that secure the lower air bag.
25. Cage the rear brake chambers on both sides of the e-Axle. For instructions, see **Section 42.14, Subject 110** of the *eCascadia Workshop Manual*.

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26. Remove the antilock braking system (ABS) sensor wiring from the mounting locations on driver-side of the vehicle.
 27. Remove the ABS sensor from the spider plate on the driver-side of the vehicle.
 28. Disconnect all the brake chamber air lines at the caliper side on both sides of the e-Axle.
 29. Remove the ABS sensor wiring from the mounting locations on the passenger-side of the vehicle.
 30. Remove the ABS sensor from the spider plate, on the passenger-side of the vehicle.
 31. Remove the front suspension fasteners.
 32. Raise the vehicle off the e-Axle.
 33. Remove the spider plate. For instructions, see **Group 42** of the *eCascadia Workshop Manual*.
 34. Remove the four U-bolt nuts, then remove the U-bolts and the clamp group from the both sides of the e-Axle.
 35. Raise the vehicle, and lower it close to the new e-Axle.
 36. Install the airliner suspension springs on the new e-Axle housing. Then, install the U-bolts and the clamp group on the both sides of the e-Axle.
 37. Install the front suspension fasteners.
 38. Install the fasteners that secure the lower air bag.
 39. Install the fasteners that hold the control rod to the e-Axle tower.
 40. Install the upper shock bolts.
 41. Tighten the front suspension fasteners 190 to 210 lbf-ft (258 to 285 N·m).
 42. Tighten the upper shock bolts 162 lbf-ft (220 N·m).
 43. Tighten the control rod fasteners 136 lbf-ft (184 N·m).
 44. Tighten the air bag fasteners 55 lbf-ft (75 N·m).
 45. Tighten the U-bolt nuts in two stages. Start with 200 lbf-ft (271 N·m), and then finish by tightening them to 400 lbf-ft (542 N·m).
 46. Install the spider plate. For instructions, see **Group 42** of the *eCascadia Workshop Manual*.
 47. Install all the air brake chamber lines at the caliper side.
 48. Install both the ABS sensors.
 49. Connect the air lines to the eCarrier. See **Fig. 2**.
 50. Connect the LV chassis harness to the e-Axle. See **Fig. 2**.
- NOTE: Use McMaster-Carr's Chemical-Resistant Seal and O-Ring Grease or equivalent on the O-rings.
51. Grease the O-rings that are located on the adapter plate of the new cables.
 52. Install the high voltage cables to the inverter.
 53. Install the lug fasteners inside the inverters.
 54. Install the fasteners that secure the adapter plate on the inverter.
 55. Tighten the adapter plate fasteners 4 lbf-ft (6 N·m). For instructions of the tightening sequence, see **Section 08.02, Subject 050** of the *eCascadia Workshop Manual*.
 56. Tighten the lug fasteners 17 lbf-ft (23 N·m).

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57. Install the delayed access cover. See [Fig. 5](#).

NOTE: Use McMaster-Carr's Chemical-Resistant Seal and O-Ring Grease or equivalent on the O-rings.

58. Install the inverter access cover and tighten all fasteners 44 lbf-in (497 N-cm) in the sequence shown in [Fig. 10](#). See [Section 08.02, Subject 050](#) of the *eCascadia Workshop Manual* for detailed instructions.



Fig. 10, Inverter Access Cover Tightening Sequence

59. Install the HV cable support bracket and the HV cable clamps. Then, tighten 11 lbf-ft (15 N-m).

60. Connect the flat ground cable straps to the e-Axle. See [Fig. 3](#).

61. Install the zip ties on the flat ground cable straps.

62. Tighten the flat ground cable straps 18 lbf-ft (24 N-m).

63. Install the two rear deck plates and tighten the fasteners 11 to 15 lbf-ft (15 to 20 N-m).

64. Install the height control rod.

65. Install the wheel and tire. For instructions, see [Group 40](#) of the *eCascadia Workshop Manual*.

66. Remove the e-Axle cart.

67. Connect the coolant lines to the e-Axle. See [Fig. 9](#).

68. Install the drive wheel fairings. For instructions, see [Section 31.04](#) of the *eCascadia Workshop Manual*.

69. Fill the eCarrier and housing with fluid until the oil level reaches the fill plug threads. For instructions, see [Section 35.03](#) of the *eCascadia Maintenance Manual*.

70. Commission the vehicle (Gen 2). For instructions, see [Section 08.08, Subject 100](#) of the *eCascadia Workshop Manual*.

71. Run DiagnosticLink® for the resolver relearn function on the inverters 1 and 2.

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72. Fill and bleed the vehicle cooling system for circuit 1. For instructions, see **Section 20.01, Subject 160** of the *eCascadia Workshop Manual*.
73. Return the seal remover and the seal driver.
74. Complete the vehicle alignment and the calibration of the steering angle sensor.
75. Test drive the vehicle.
76. Clean a spot on the base label (Form WAR259), and attach a recall completion sticker for FL979 (Form WAR260), indicating this work has been completed.

FL979E-F — Rear e-Axle in a Tandem Set

1. Check the base label (Form WAR259) for a completion sticker for FL979 (Form WAR260) indicating this work has been done. The base label is usually located on the passenger-side door, about 12 inches (30 cm) below the door latch. If a recall completion 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. Turn the keyswitch to the OFF position, place the vehicle in neutral, and set the park brake. Chock the tires.
3. Drain the air from the vehicle's air system.
4. Decommission the vehicle and verify the high voltage system is shut down. For instructions, see **Section 08.08** of the *eCascadia Workshop Manual*.
5. Remove the drive wheel fairings. For instructions, see **Section 31.04** of the *eCascadia Workshop Manual*.
6. Take the mobile wheel lift column and position it at each corner of the vehicle.
7. Lift the vehicle. Remove all the tires on the axle being replaced, then lower the vehicle to the ground. For instructions to raise and lower the vehicle, see **Section 00.05** of the *eCascadia Workshop Manual*.
8. Disconnect the low voltage (LV) chassis harness from the e-Axle. See **Fig. 11**.

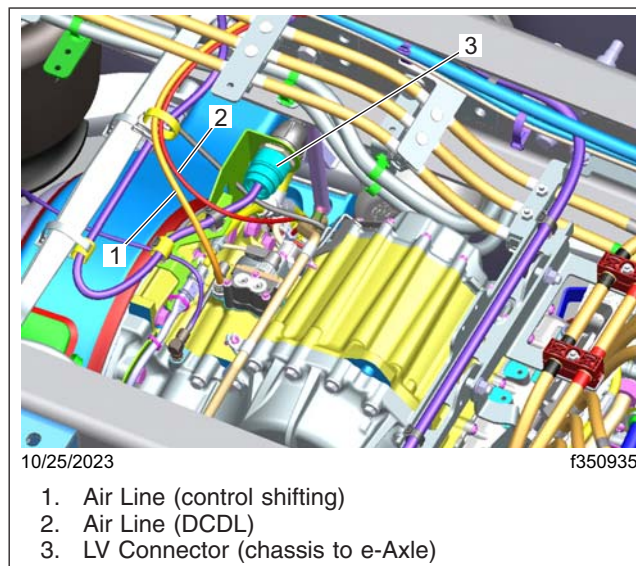


Fig. 11, Location of the LV Connector

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9. Disconnect the flat grounding cables straps from the e-Axle. See [Fig. 12](#).

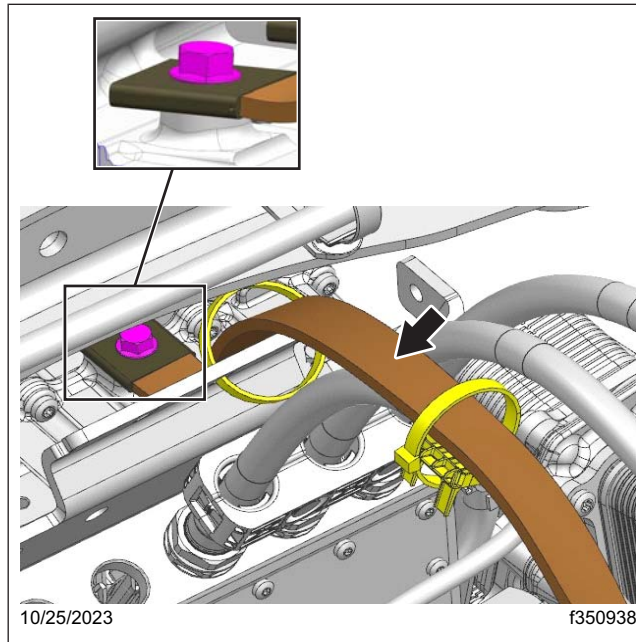


Fig. 12, Flat Grounding Cables Straps

10. Remove the fasteners from the high voltage (HV) cable clamps that are connected just above the e-Axle gland nuts.

11. Disconnect the high voltage interlock (HVIL) and the LV harness from the HV cover. See [Fig. 13](#).

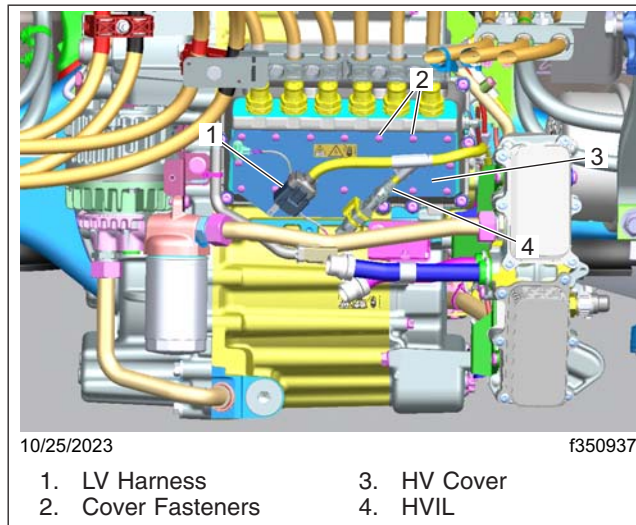


Fig. 13, Location of the HVIL

12. Remove the HV cover fasteners and remove the HV cover. See [Fig. 13](#).

13. Remove the high voltage cable lug fasteners located inside the e-Axle HV interface.

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14. Remove the HV cable support bracket and the mounting fasteners that are mounted to the eCarrier. See [Fig. 14](#) and [Fig. 15](#).

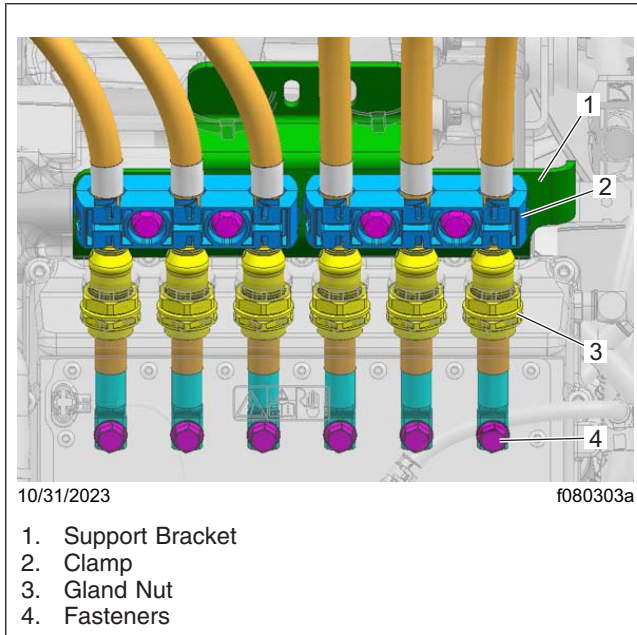


Fig. 14, Axle Side High Voltage Cable Removal

15. Disconnect the cable gland connections.
16. Remove the cables from the e-Axle.
17. Disconnect the air lines from the eCarrier. See [Fig. 11](#).
18. Lift the vehicle to the desired working height.
19. Cut the zip ties on the coolant hoses.
20. Disconnect the coolant lines from the e-Axle, and let the fluid drain out. See [Fig. 16](#).

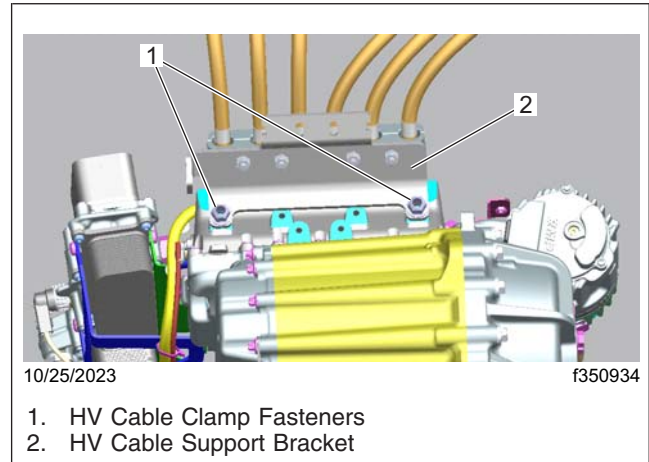


Fig. 15, HV Cable Support Bracket

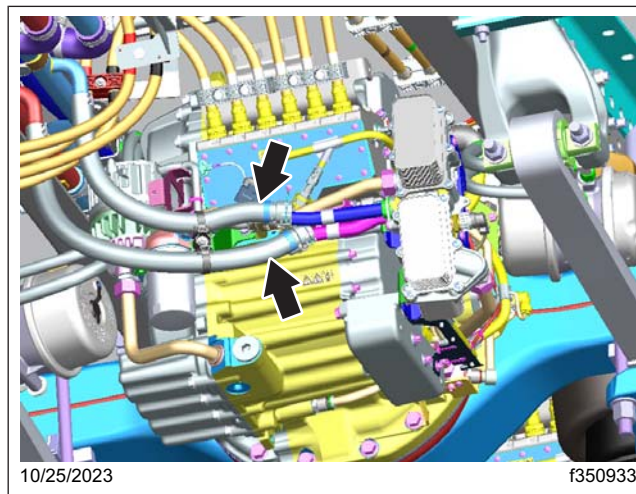


Fig. 16, Location of the Coolant Lines

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21. Place the e-Axle cart under the vehicle and rest the e-Axle on it.
22. Remove the fasteners that hold the control rod to the e-Axle tower.
23. Remove the upper shock bolts.
24. Remove the fasteners that secure the lower air bag.
25. Cage the rear brake chambers on both sides of the e-Axle. For instructions, see **Section 42.14, Subject 110** of the *eCascadia Workshop Manual*.
26. Remove the antilock braking system (ABS) sensor wiring from the mounting locations on driver-side of the vehicle.
27. Remove the ABS sensor from the spider plate on the driver-side of the vehicle.
28. Disconnect all the brake chamber air lines at the caliper side on both sides of the e-Axle.
29. Remove the ABS sensor wiring from the mounting locations on the passenger-side of the vehicle.
30. Remove the ABS sensor from the spider plate, on the passenger-side of the vehicle.
31. Remove the front suspension fasteners.
32. Raise the vehicle off the e-Axle.
33. Remove the spider plate. For instructions, see **Group 42** of the *eCascadia Workshop Manual*.
34. Remove the four U-bolt nuts, then remove the U-bolts and the clamp group from the both sides of the e-Axle.
35. Raise the vehicle, and lower it close to the new e-Axle.
36. Install the airliner suspension springs on the new e-Axle housing. Then, install the U-bolts and the clamp group on the both sides of the e-Axle.
37. Install the front suspension fasteners.
38. Install the fasteners that secure the lower air bag.
39. Install the fasteners that hold the control rod to the e-Axle tower.
40. Install the upper shock bolts.
41. Tighten the front suspension fasteners 190 to 210 lbf·ft (258 to 285 N·m).
42. Tighten the upper shock bolts 162 lbf·ft (220 N·m).
43. Tighten the control rod fasteners 136 lbf·ft (184 N·m).
44. Tighten the air bag fasteners 55 lbf·ft (75 N·m).
45. Tighten the U-bolt nuts in two stages. Start with 200 lbf·ft (271 N·m), and then finish by tightening them to 400 lbf·ft (542 N·m).
46. Install the spider plate. For instructions, see **Group 42** of the *eCascadia Workshop Manual*.
47. Install all the air brake chamber lines at the caliper side.
48. Install both the ABS sensors.
49. Connect the air lines to the eCarrier. See **Fig. 11**.
50. Connect the LV chassis harness to the e-Axle. See **Fig. 11**.
51. Install the HV cables to the eAxle HV interface.
52. Connect the cable glands to the eCarrier.
53. Install the high voltage cable lug fasteners inside the eAxle HV interface.

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54. Install and tighten the cable gland connections 9 lbf·ft (12 N·m).
55. Tighten the lug fasteners 17 lbf·ft (23 N·m).
56. Install the HV cover and fasteners to the HV interface on the e-Axle. See **Fig. 13**.
57. Tighten the HV cover fasteners 4 lbf·ft (5 N·m).
58. Connect the LV to the e-Axle HV cover.
59. Install the support bracket on top of the eCarrier. Then, install the HV cable clamps. See **Fig. 14**.
60. Connect the flat ground cable straps to the e-Axle. See **Fig. 12**.
61. Install the zip ties on the flat ground cable straps.
62. Tighten the flat ground cable straps 18 lbf·ft (24 N·m).
63. Install the height control rod.
64. Install the wheel and tire. For instructions, see **Group 40** of the *eCascadia Workshop Manual*.
65. Remove the e-Axle cart.
66. Connect the coolant lines to the e-Axle. See **Fig. 16**.
67. Install the drive wheel fairings. For instructions, see **Section 31.04** of the *eCascadia Workshop Manual*.
68. Fill the eCarrier and housing with fluid until the oil level reaches the fill plug threads. For instructions, see **Section 35.03** of the *eCascadia Maintenance Manual*.
69. Commission the vehicle (Gen 2). For instructions, see **Section 08.08, Subject 100** of the *eCascadia Workshop Manual*.
70. Run DiagnosticLink® for the resolver relearn function on the inverter 3.
71. Fill and bleed the vehicle cooling system for circuit 1. For instructions, see **Section 20.01, Subject 160** of the *eCascadia Workshop Manual*.
72. Return the seal remover and the seal driver.
73. Complete the vehicle alignment and the calibration of the steering angle sensor.
74. Test drive the vehicle.
75. Clean a spot on the base label (Form WAR259), and attach a recall completion sticker for FL979 (Form WAR260), indicating this work has been completed.