**Daimler Truck North America LLC**

# Recall Campaign

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## Subject: Brake Caliper Bolts

| Models Affected | | | | | |
|---|---|---|---|---|---|
| **Make** | **Model** | **Model Yr. Start** | **Model Yr. End** | **Prod. Start Date** | **Prod. End Date** |
| Freightliner | CASCADIA | 2025 | 2026 | 6/14/2024 | 6/2/2025 |
| Freightliner | CASCADIA FIFTH GEN | 2026 | 2026 | 3/4/2025 | 5/20/2025 |
| Freightliner | 108SD | 2025 | 2026 | 6/25/2024 | 1/15/2025 |
| Freightliner | 114SD | 2025 | 2026 | 8/1/2024 | 4/2/2025 |
| Freightliner | BUSINESS CLASS M2 | 2025 | 2026 | 6/6/2024 | 5/20/2025 |
| Freightliner Custom Chassis Corporation | XCR | 2025 | 2025 | 9/26/2024 | 11/6/2024 |
| Freightliner Custom Chassis Corporation | XCP | 2025 | 2026 | 6/20/2024 | 1/2/2025 |
| Freightliner Custom Chassis Corporation | XCM | 2025 | 2026 | 7/16/2024 | 6/18/2025 |
| Freightliner Custom Chassis Corporation | XBS | 2025 | 2025 | 6/6/2024 | 11/22/2024 |
| Freightliner Custom Chassis Corporation | MT45 | 2025 | 2025 | 8/23/2024 | 10/7/2024 |
| Freightliner Custom Chassis Corporation | MT45G | 2025 | 2026 | 8/6/2024 | 4/22/2025 |
| Freightliner Custom Chassis Corporation | MT50E | 2026 | 2026 | 7/1/2025 | 7/1/2025 |
| Freightliner Custom Chassis Corporation | MT55 | 2026 | 2026 | 12/5/2024 | 12/5/2024 |
| Freightliner Custom Chassis Corporation | MT55G | 2025 | 2026 | 5/29/2024 | 1/30/2025 |
| Thomas Built Buses | SAF-T-LINER C2 | 2025 | 2026 | 6/19/2024 | 4/29/2025 |
| Thomas Built Buses | SAF-T-LINER C2 JOULEY | 2025 | 2026 | 9/17/2024 | 6/12/2025 |
| Western Star | 47X | 2025 | 2026 | 6/14/2024 | 5/28/2025 |
| Western Star | 49X | 2025 | 2026 | 6/7/2024 | 6/2/2025 |
| Western Star | 57X | 2025 | 2025 | 6/24/2024 | 9/9/2024 |

**Daimler Truck**
**North America LLC**

# Recall Campaign

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## General Information

On behalf of the entities listed below, Daimler Truck North America LLC (DTNA) has decided that a defect that relates to motor vehicle safety exists on the vehicles mentioned above.

- Freightliner Trucks Division
- Wholly owned subsidiaries Freightliner Custom Chassis Corporation, Thomas Built Buses, Western Star Truck Sales, Inc.

| | |
|---|---|
| **PROBLEM:** | The brake caliper mounting bolts may not have been sufficiently tighten and may loosen and detach. This can result in reduced brake performance and damaged tires and wheels, increasing the risk of a crash. |
| **SOLUTION:** | The caliper mounting bolts will be inspected and replaced as needed. |

There are approximately 456 vehicles involved.

**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.

Please contact Warranty Campaigns for consideration of additional charges prior to performing the repair.

## 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.

If our records show your dealership has ordered any vehicle(s) involved in campaign number F1023, a list of the customers and vehicle identification numbers will be available on DTNA Portal. Please refer to this list when ordering parts for this recall.

**Daimler Truck**
**North America LLC**

# Recall Campaign

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

**IMPORTANT - After Repair is Complete*:**
Attach a red completion sticker (WAR260) to the base label (WAR259).

If the vehicle does not have a base label, clean a spot on the appropriate location, and attach a base label, prior to attaching the completion sticker.

If a campaign kit is not required, write the campaign number on a blank sticker and attach it to the base label.

(Failure to install a completion sticker may result in a chargeback of the campaign claim.)

* TBB is exempt from the completion sticker process

**Table 1 – Replacement Parts for F1023 A - J**

| Group | Part Description | Part Number | Qty |
|---|---|---|---|
| A - J | KIT-HARDWARE, CALIPER MOUNTING | WEM 3000129S4 | As needed per axles |
| All Groups | Blank Completion Sticker | WAR260 | 1 ea |

## Removed Parts

- For U.S. and Canadian Dealers, use the part disposition in OWL to determine how to manage removed parts (return, scrap, etc.). Dispositions are available at the date of the repair.
- For Export Dealers, destroy removed parts unless otherwise advised.

## Claim Reimbursement - Labor Allowance

**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.

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.

- In OWL, use the 'Retrieve' function and select the appropriate procedure. This will auto-populate the PFP, component code, replacement parts, cause, corrective action and SRT code.

**Table 2 – Claim Reimbursement Table**

| | |
|---|---|
| **Claim Type** | Recall Campaign |
| **Campaign** | F1023 (A-J) |
| **VMRS Component Code** | F99-999-005 |
| **Cause Code** | A1 – Campaign |
| **Primary Failed Part** | 25-F1023-000 |

**Daimler Truck**
**North America LLC**

# Recall Campaign

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

| Group | Procedure | Description | Axle | Time Allowed (hours) | SRT Codes | Corrective Action |
|---|---|---|---|---|---|---|
| A | 1 | 4x2 Hydraulic Disc Brakes | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| A | 1 | 4x2 Hydraulic Disc Brakes | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| A | 1 | 4x2 Hydraulic Disc Brakes | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| A | 2 | 4x2 Air Disc Brakes WABCO | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| A | 2 | 4x2 Air Disc Brakes WABCO | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| A | 2 | 4x2 Air Disc Brakes WABCO | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| A | 3 | 4x2 Air Disc Brakes Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| A | 3 | 4x2 Air Disc Brakes Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| A | 3 | 4x2 Air Disc Brakes Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| A | 4 | 4x2 Air Disc Brakes Bendix | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| A | 4 | 4x2 Air Disc Brakes Bendix | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| A | 4 | 4x2 Air Disc Brakes Bendix | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| A | 5 | 4x2 Air Disc Brake Front Radial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| A | 5 | 4x2 Air Disc Brake Rear Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| A | 5 | 4x2 Air Disc Brakes F Radial R Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| B | 1 | 6x2 Air Disc Brakes Bendix | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| B | 1 | 6x2 Air Disc Brakes Bendix | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 1 | 6x2 Air Disc Brakes Bendix | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 1 | 6x2 Air Disc Brakes Bendix | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| B | 2 | 6x4 Air Disc Brakes WABCO | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| B | 2 | 6x4 Air Disc Brakes WABCO | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 2 | 6x4 Air Disc Brakes WABCO | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 2 | 6x4 Air Disc Brakes WABCO | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| B | 3 | 6x4 Air Disc Brakes Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| B | 3 | 6x4 Air Disc Brakes Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 3 | 6x4 Air Disc Brakes Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 3 | 6x4 Air Disc Brakes Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| B | 4 | 6x4 Air Disc Brakes Bendix | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| B | 4 | 6x4 Air Disc Brakes Bendix | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 4 | 6x4 Air Disc Brakes Bendix | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 4 | 6x4 Air Disc Brakes Bendix | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| B | 5 | 6x4 Air Disc Brakes F Radial R Axial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| B | 5 | 6x4 Air Disc Brakes F Radial R Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |

**Daimler Truck**
**North America LLC**

# Recall Campaign

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

| Group | Procedure | Description | Axle | Time Allowed (hours) | SRT Codes | Corrective Action |
|---|---|---|---|---|---|---|
| B | 5 | 6x4 Air Disc Brakes F Radial R Axial Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| B | 5 | 6x4 Air Disc Brakes F Radial R Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| C | 1 | 8x4 Air Disc Brakes Bendix | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| C | 1 | 8x4 Air Disc Brakes Bendix | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 1 | 8x4 Air Disc Brakes Bendix | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 1 | 8x4 Air Disc Brakes Bendix | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 1 | 8x4 Air Disc Brakes Bendix | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| C | 2 | 8x4 Air Disc Brakes Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| C | 2 | 8x4 Air Disc Brakes Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 2 | 8x4 Air Disc Brakes Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 2 | 8x4 Air Disc Brakes Meritor | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 2 | 8x4 Air Disc Brakes Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| C | 3 | 8x4 Air Disc Brakes F Radial Axial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| C | 3 | 8x4 Air Disc Brakes F Radial Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 3 | 8x4 Air Disc Brakes F Radial Axial Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 3 | 8x4 Air Disc Brakes F Radial Axial Meritor | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 3 | 8x4 Air Disc Brakes F Radial Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| C | 4 | 8x6 Air Disc Brakes F Radial Axial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| C | 4 | 8x6 Air Disc Brakes F Radial Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 4 | 8x6 Air Disc Brakes F Radial Axial Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 4 | 8x6 Air Disc Brakes F Radial Axial Meritor | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| C | 4 | 8x6 Air Disc Brakes F Radial Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Tag/Pusher | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 1 | 10x4 Air Disc Brakes F Radial R Axial Bendix | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Tag/Pusher | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

| Group | Procedure | Description | Axle | Time Allowed (hours) | SRT Codes | Corrective Action |
|---|---|---|---|---|---|---|
| D | 2 | 10x4 Air Disc Brakes F Radial R Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Rear Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Rear Middle | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Tag/Pusher | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Tag/Pusher | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| E | 1 | 12x4 Air Disc Brakes F Radial R Axial Meritor | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| F | 1 | 4x2 Air Disc Brakes Bendix Front only | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| F | 1 | 4x2 Air Disc Brakes Bendix Front only | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| G | 1 | 6x2 Air Disc Brakes Bendix Front only | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| G | 1 | 6x2 Air Disc Brakes Bendix Front only | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| H | 1 | 6x4 Air Disc Brakes Meritor Front only | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| H | 1 | 6x4 Air Disc Brakes Meritor Front only | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| I | 1 | 4x2 Air Disc Brakes Bendix School Bus | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| I | 1 | 4x2 Air Disc Brakes Bendix School Bus | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| I | 1 | 4x2 Air Disc Brakes Bendix School Bus | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |
| J | 1 | 4x2 Air Disc Brakes Bendix Elec School Bus | Front | 1.0 hrs. | 996-R258A | 12-Repair Recall/Campaign |
| J | 1 | 4x2 Air Disc Brakes Bendix Elec School Bus | Rear | 1.1 hrs. | 996-R258B | 12-Repair Recall/Campaign |
| J | 1 | 4x2 Air Disc Brakes Bendix Elec School Bus | Per Axle | 0.5 hrs. | 996-R258C | 12-Repair Recall/Campaign |

- Claim type is **Recall Campaign**.
- In the Campaign field, enter the campaign number and appropriate group (F1023-A, F1023-B, etc.).
- In the Primary Failed Part field, enter 25-F1023-000.
- In the Parts section, enter the appropriate part number(s) as shown in the Replacement Parts Table.
- In the Labor section, enter the appropriate SRT from the Labor Allowance Table. Administrative will auto-populate if applicable using SRT 939-6010A, for 0.3 hours (0.4 hours for RVs).
- 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.)

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

- Submit an OWL Recall Pre-Approval Request for a decision.
- Include the approved amount on your OWL 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.
- The Dealer is required to 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, contact the Warranty Campaigns Department via Web inquiry at DTNAPortal.com/WSC, if you have any questions or need additional information. Export distributors, submit a Web inquiry 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.

**Daimler Truck North America LLC**

# Recall Campaign

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## Copy of Notice to Owners

## Subject: Brake Caliper Bolts

**For Notice to U.S. Customers:** This notice is sent to you in accordance with the requirements of the *National Traffic and Motor Vehicle Safety Act*. **For Notice to Canadian Customers:** This notice is sent to you in accordance with the requirements of the Motor Vehicle Safety Act.

Daimler Truck North America LLC (DTNA), on behalf of its Freightliner Trucks Division, and wholly owned subsidiaries, Freightliner Custom Chassis Corporation, Western Star Truck Sales, Inc., Thomas Built Buses, has decided that a defect, which relates to motor vehicle safety, exists in certain model year 2025 to 2026 vehicles, including the Freightliner Cascadia, 108SD, 114SD, M2 106, M2 112; Western Star 47X, 49X, 57X; and Freightliner Custom Chassis XCR, XCP, XCM, XBS, MT45, MT50, MT55. See below for additional details:

See below for additional details on vehicle applicability:

| **Models Affected** | | | | | |
|---|---|---|---|---|---|
| **Make** | **Model** | **Model Yr. Start** | **Model Yr. End** | **Prod. Start Date** | **Prod. End Date** |
| Freightliner | CASCADIA | 2025 | 2026 | 6/14/2024 | 6/2/2025 |
| Freightliner | CASCADIA FIFTH GEN | 2026 | 2026 | 3/4/2025 | 5/20/2025 |
| Freightliner | 108SD | 2025 | 2026 | 6/25/2024 | 1/15/2025 |
| Freightliner | 114SD | 2025 | 2026 | 8/1/2024 | 4/2/2025 |
| Freightliner | BUSINESS CLASS M2 | 2025 | 2026 | 6/6/2024 | 5/20/2025 |
| Freightliner Custom Chassis Corporation | XCR | 2025 | 2025 | 9/26/2024 | 11/6/2024 |
| Freightliner Custom Chassis Corporation | XCP | 2025 | 2026 | 6/20/2024 | 1/2/2025 |
| Freightliner Custom Chassis Corporation | XCM | 2025 | 2026 | 7/16/2024 | 6/18/2025 |
| Freightliner Custom Chassis Corporation | XBS | 2025 | 2025 | 6/6/2024 | 11/22/2024 |
| Freightliner Custom Chassis Corporation | MT45 | 2025 | 2025 | 8/23/2024 | 10/7/2024 |
| Freightliner Custom Chassis Corporation | MT45G | 2025 | 2026 | 8/6/2024 | 4/22/2025 |
| Freightliner Custom Chassis Corporation | MT50E | 2026 | 2026 | 7/1/2025 | 7/1/2025 |
| Freightliner Custom Chassis Corporation | MT55 | 2026 | 2026 | 12/5/2024 | 12/5/2024 |
| Freightliner Custom Chassis Corporation | MT55G | 2025 | 2026 | 5/29/2024 | 1/30/2025 |
| Thomas Built Buses | SAF-T-LINER C2 | 2025 | 2026 | 6/19/2024 | 4/29/2025 |
| Thomas Built Buses | SAF-T-LINER C2 JOULEY | 2025 | 2026 | 9/17/2024 | 6/12/2025 |
| Western Star | 47X | 2025 | 2026 | 6/14/2024 | 5/28/2025 |
| Western Star | 49X | 2025 | 2026 | 6/7/2024 | 6/2/2025 |

**Daimler Truck North America LLC**

# Recall Campaign

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

| Models Affected | | | | | |
|---|---|---|---|---|---|
| **Make** | **Model** | **Model Yr. Start** | **Model Yr. End** | **Prod. Start Date** | **Prod. End Date** |
| Western Star | 57X | 2025 | 2025 | 6/24/2024 | 9/9/2024 |

On the affected vehicles, the brake caliper mounting bolts may not have been sufficiently tightened and may loosen and detach. This can result in reduced brake performance and damaged tires and wheels, increasing the risk of a crash.

A Daimler Truck North America authorized service facility will inspect the caliper mounting bolts and tighten or replace them if necessary. The Recall will take approximately up to seven 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 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. **For Notice to US Customers:** If you have paid to have this recall service 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 Campaign, 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-War-Campaigns@Daimlertruck.com. For other concerns, you may contact the Customer Assistance Center at (800) 385-4357. **For Notice to US Customers:** 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. **For Notice to Canadian Customers:** 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

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## Reimbursement to Customers for Repairs Performed Prior to Recall

If you have already **paid** to have this 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.

**Daimler Truck North America LLC**

# Recall Campaign

**F1023 A-J**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## Work Instructions

### Subject: Brake Caliper Bolts

| Models Affected | | | | | |
|---|---|---|---|---|---|
| **Make** | **Model** | **Model Yr. Start** | **Model Yr. End** | **Prod. Start Date** | **Prod. End Date** |
| Freightliner | CASCADIA | 2025 | 2026 | 6/14/2024 | 6/2/2025 |
| Freightliner | CASCADIA FIFTH GEN | 2026 | 2026 | 3/4/2025 | 5/20/2025 |
| Freightliner | 108SD | 2025 | 2026 | 6/25/2024 | 1/15/2025 |
| Freightliner | 114SD | 2025 | 2026 | 8/1/2024 | 4/2/2025 |
| Freightliner | BUSINESS CLASS M2 | 2025 | 2026 | 6/6/2024 | 5/20/2025 |
| Freightliner Custom Chassis Corporation | XCR | 2025 | 2025 | 9/26/2024 | 11/6/2024 |
| Freightliner Custom Chassis Corporation | XCP | 2025 | 2026 | 6/20/2024 | 1/2/2025 |
| Freightliner Custom Chassis Corporation | XCM | 2025 | 2026 | 7/16/2024 | 6/18/2025 |
| Freightliner Custom Chassis Corporation | XBS | 2025 | 2025 | 6/6/2024 | 11/22/2024 |
| Freightliner Custom Chassis Corporation | MT45 | 2025 | 2025 | 8/23/2024 | 10/7/2024 |
| Freightliner Custom Chassis Corporation | MT45G | 2025 | 2026 | 8/6/2024 | 4/22/2025 |
| Freightliner Custom Chassis Corporation | MT50E | 2026 | 2026 | 7/1/2025 | 7/1/2025 |
| Freightliner Custom Chassis Corporation | MT55 | 2026 | 2026 | 12/5/2024 | 12/5/2024 |
| Freightliner Custom Chassis Corporation | MT55G | 2025 | 2026 | 5/29/2024 | 1/30/2025 |
| Thomas Built Buses | SAF-T-LINER C2 | 2025 | 2026 | 6/19/2024 | 4/29/2025 |
| Thomas Built Buses | SAF-T-LINER C2 JOULEY | 2025 | 2026 | 9/17/2024 | 6/12/2025 |
| Western Star | 47X | 2025 | 2026 | 6/14/2024 | 5/28/2025 |
| Western Star | 49X | 2025 | 2026 | 6/7/2024 | 6/2/2025 |
| Western Star | 57X | 2025 | 2025 | 6/24/2024 | 9/9/2024 |

IMPORTANT: Vehicles may have both axial and radial mounted calipers. Follow the work instructions based on the type of calipers on the vehicle:

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Table 1 – Caliper Type and Instruction Page Number

| Caliper Type | Campaign Group | Axle Position | Page Number |
|---|---|---|---|
| Bendix Axial | F1023A<br>F1023B<br>F1023C<br>F1023D<br>F1023F (Front Only)<br>F1023G (Front Only)<br>F1023I<br>F1023J | Front/Rear<br>Front | 12 |
| Meritor Axial | F1023A<br>F1023B<br>F1023C<br>F1023H (Front Only) | Front/Rear<br>Front | 18 |
| Meritor Radial | F1023A<br>F1023B<br>F1023C<br>F1023D<br>F1023E | Front/Rear | 21 |
| WABCO Maxxus Axial | F1023A<br>F1023B | Front/Rear | 25 |
| Hydraulic Disc Brakes | F1023A | Front/Rear | 27 |

**Table 1 – Caliper Type and Instruction Page Number**

# Inspection and Installation of the Front and/or Rear Caliper/Carrier Assembly

## Bendix Axial Mounted Calipers

1. Check the base label (Form WAR259) for a completion sticker for F1023 (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 sticker is present for F1023, 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 tires.

## ⚠ DANGER

**When working on the vehicle, shut down the engine, set the parking brake, and chock the tires. Before working under the vehicle, always place jack stands under the frame rails to ensure the vehicle cannot drop. Failure to follow these steps could result in serious personal injury or death.**

3. Raise the vehicle and support it on jack stands.

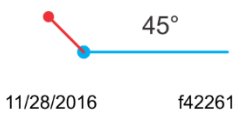
4. Remove all of the wheel assemblies.

NOTE: In all steps that require a torque wrench, use a Snap On torque wrench ATECH4RS600, or an equivalent, with a center to handle length of 47 inches (119 cm).

5. Set a torque wrench to 350 lbf·ft (475 N·m) and tighten the caliper mounting bolts. If they do not turn, go to step 13. If they turn, go to step 6. Due to limited caliper bolt access, it may be necessary to use tool DDC DSNCHA018005 referenced in tool letter 18TL18. If the tool is needed, use tool DDCDSNCHA018005 only and no other tools. See Fig. 1 tool DDC DSNCHA018005. See Table 2. for torque specifications.


**Fig. 1, DDC DSNCHA018005 30mm Air Disc Brake Caliper Brake Bolt Torque Adaptor**

Table 2 – Torque Check with 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005

| **Angle View** | **Extension Angle** (degrees) | **Target Torque** lbf·ft (N·m) | **Tool Setting** lbf·ft (N·m) |
|---|---|---|---|
|  | 0 | 350 (475) | 296 (401) |
|  | 45 | | 310 (420) |

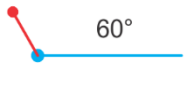
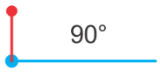
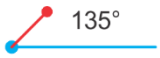
| Angle View | Extension Angle (degrees) | Target Torque lbf·ft (N·m) | Tool Setting lbf·ft (N·m) |
|---|---|---|---|
|  11/06/2018 f422668 | 60 | | 320 (434) |
|  11/28/2016 f422615 | 90 | | 350 (475) |
|  11/06/2018 f422669 | 120 | | 386 (523) |
|  11/28/2016 f422616 | 135 | | 402 (545) |

**Table 2, Torque Check with 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005**

**⚠WARNING**

**When replacing brake pads, shoes, rotors, or drums, always replace components as an axle set.**

- **Always reline both sets of brakes on an axle at the same time.**
- **Always replace both rotors/drums on an axle at the same time.**
- **Always install the same type of linings/pads or drums/rotors on both axle ends of a single axle, and all four axle ends of a tandem axle, at the same time. Do not mix component types.**

**Failure to do so could cause uneven braking and loss of vehicle control, resulting in property damage, personal injury, or death.**

6. Remove the retainer pin, cotter pin, and brake pad retainer. Inspect the brake pad hardware to ensure it is in good condition. If it is, reuse the brake pad hardware. If the brake pad hardware is not in good condition, replace brake pad sets on both ends of the axle.

7. Remove the brake pads.

8. Remove the caliper bolts.

IMPORTANT: The caliper/carrier assemblies are left and right-handed. Ensure that the correct assembly (left or right) is installed on each side of the vehicle.

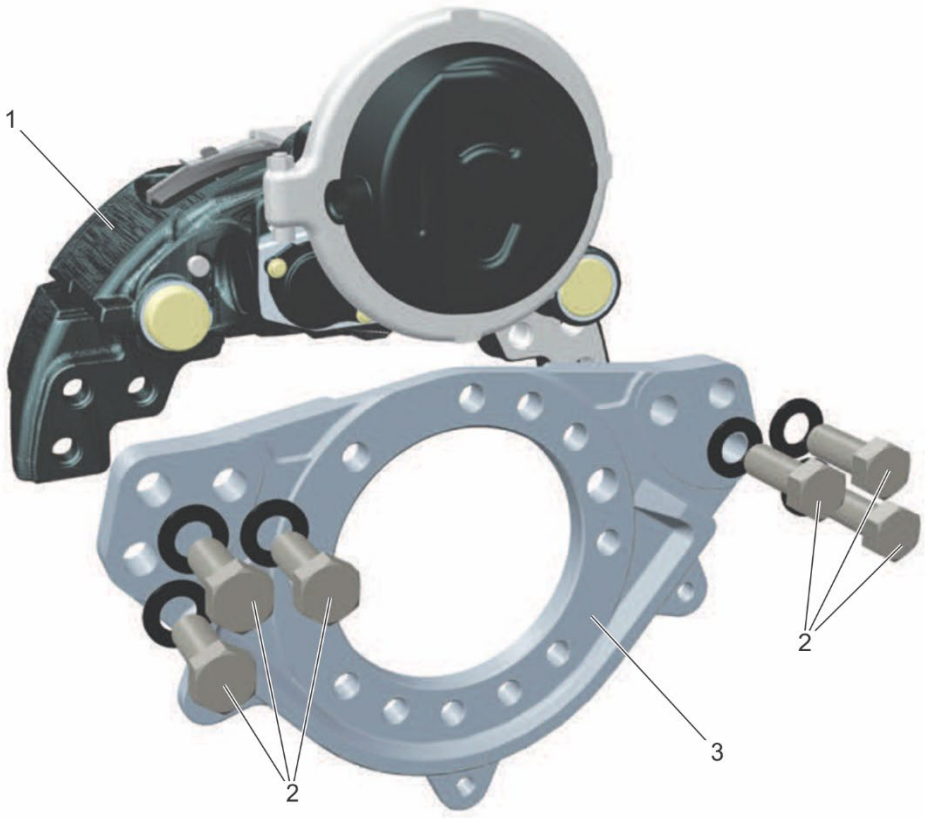
9. Align each caliper/carrier assembly with the rotor by pushing the caliper against the shelf on the torque plate, then

install the caliper/carrier assembly using new caliper mounting bolts. See Fig. 2.

10. Tighten the carrier mounting bolts in two steps as follows.

    10.1. Start on one side of the caliper and tighten all three bolts 20 to 60 lbf·ft (27 to 81 N·m), beginning with the inner-most bolt and moving to the outer-most bolt. Then tighten the three bolts on the other side of the caliper 20 to 60 lbf·ft (27 to 81 N·m), beginning with the inner-most bolt and moving to the outermost bolt. See Fig. 3 for the left-front caliper and Fig. 4 for the right-front caliper.

    10.2. Repeat this process, increasing the torque value to 350 to 400 lbf·ft (475 to 542 N·m). If tool DDC DSNCHA018005 referenced in tool letter 18TL18 is used, see Table 3 for torque specifications.




10/01/2018 f422664

1. Caliper/Carrier Assembly (showing service actuator)
2. Mounting Bolts and Washers (qty. 6)
3. Anchor Plate/Torque Plate

**Fig. 2, Bendix Axial Mounted Caliper**

| | |
|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
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| **Transport Canada #** | **2025-480** |

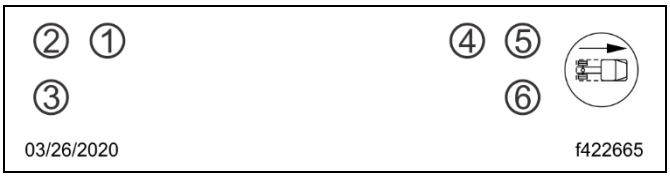
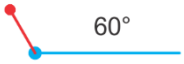
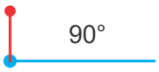
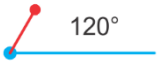



**Fig. 3, Tightening Pattern, Left-Front Bendix Axial Caliper**


**Fig. 4, Tightening Pattern, Right-Front Bendix Axial Caliper**

Table 3 – Torque Check with 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005

| **Angle View** | **Extension Angle** (degrees) | **Target Torque** lbf·ft (N·m) | **Tool Setting** lbf·ft (N·m) |
|---|---|---|---|
|   11/28/2016 f422613 | 0 | 375 (508) | 317 (430) |
|   11/28/2016 f422614 | 45 | | 332 (450) |
|   11/06/2018 f422668 | 60 | | 343 (465) |
|   11/28/2016 f422615 | 90 | | 375 (508) |
|   11/06/2018 f422669 | 120 | | 413 (560) |

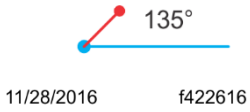
| Angle View | Extension Angle (degrees) | Target Torque lbf·ft (N·m) | Tool Setting lbf·ft (N·m) |
|---|---|---|---|
|   | 135 | | 431 (584) |

**Table 3, Torque Check with 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005**

**NOTICE**

Do not use a motor driven tool to tighten the manual brake adjuster nut, or use excessive force to tighten the nut. Doing so could damage the manual brake adjuster nut.

11. Install the brake pads. Provided it is in good condition, use the brake pad hardware removed earlier.
12. Back off the adjuster nut three clicks.
13. Install the wheel assemblies.
14. Raise the vehicle, remove the jack stands, then lower the vehicle.
15. Charge the air system and check for leaks.

**⚠WARNING**

**Do not operate the vehicle until the brakes have been adjusted and checked for proper operation. To do so could result in inadequate or no braking ability, which could cause personal injury or death, and property damage.**

16. In a safe area, check for proper brake operation, as follows, before putting the vehicle in service.
    - 16.1. Apply and release the brakes several times to check for air leaks and proper operation.
    - 16.2. Perform six low-speed stops to ensure proper parts replacement and full vehicle control.
    - 16.3. Immediately after doing the above stops, check the rotor temperatures. Any rotors that are significantly cooler than others indicate a lack of braking effort on those wheels.
17. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for F1023 (Form WAR260).

## 1.1. Meritor Axial Mounted Calipers

1. Check the base label (Form WAR259) for a completion sticker for F1023 (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 sticker is present for F1023, 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 tires.

**⚠DANGER**

**When working on the vehicle, shut down the engine, set the parking brake, and chock the tires. Before working under the vehicle, always place jack stands under the frame rails to ensure the vehicle cannot drop. Failure to follow these steps could result in serious personal injury or death.**

3. Raise the vehicle and support it on jack stands.

4. Remove all of the wheel assemblies.

5. Set a torque wrench to 350 lbf·ft (475 N·m) and tighten the caliper mounting bolts. If they do not turn, go to step 13. If they turn, go to step 6. Due to limited caliper bolt access, it may be necessary to use tool DDC DSNCHA018005 referenced in tool letter 18TL18. If the tool is needed, use tool DDC DSNCHA018005 only and no other tools. See Fig. 1. See Table 4 for torque specifications.

**⚠WARNING**

**When replacing brake pads, shoes, rotors, or drums, always replace components as an axle set.**

- **Always reline both sets of brakes on an axle at the same time.**
- **Always replace both rotors/drums on an axle at the same time.**
- **Always install the same type of linings/pads or drums/rotors on both axle ends of a single axle, and all four axle ends of a tandem axle, at the same time. Do not mix component types.**

**Failure to do so could cause uneven braking and loss of vehicle control, resulting in property damage, personal injury, or death.**

6. Remove the retainer pin, cotter pin, and brake pad retainer. Inspect the brake pad hardware to ensure it is in good condition. If it is, reuse the brake pad hardware. If the brake pad hardware is not in good condition, replace brake pad sets on both ends of the axle.

7. Remove the brake pads.

8. Remove the caliper bolts.

IMPORTANT: The caliper/carrier assemblies are left and right-handed. Ensure that the correct assembly (left or right) is installed on each side of the vehicle.

NOTE: The Meritor axial mounted caliper is similar to the Bendix axial mounted caliper shown in Fig. 2.

9. Align each caliper/carrier assembly with the rotor by pushing the caliper against the shelf on the torque plate, then

install the caliper/carrier assembly using new caliper mounting bolts.

10. Tighten the carrier mounting bolts in two steps as follows.

    10.1. Start on one side of the caliper and tighten all the bolts 40 to 50 lbf·ft (54 to 68 N·m). Then tighten the bolts on the other side of the caliper 40 to 50 lbf·ft (54 to 68 N·m). See Fig. 3.

    10.2. Repeat this process, increasing the torque value to 350 to 450 lbf·ft (475 to 610 N·m). If tool DDC DSNCHA018005 referenced in tool letter 18TL18 is used, see Table 4 for torque specifications.

Table 4 – Meritor Installation with a 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005

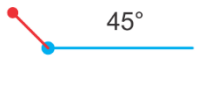
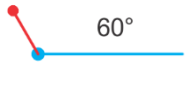
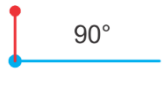
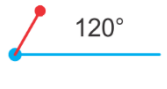
| **Angle View** | **Extension Angle** (degrees) | **Target Torque** lbf·ft (N·m) | **Tool Setting** lbf·ft (N·m) |
|---|---|---|---|
|  | 0 | 400 (542) | 338 (458) |
|  | 45 | | 354 (480) |
|  | 60 | | 366 (496) |
|  | 90 | | 400 (542) |
|  | 120 | | 441 (598) |
|  | 135 | | 460 (624) |

**Table 4, Meritor Installation with a 47 Inch (119 cm) Torque Wrench and Tool DDC DSNCHA018005**

## NOTICE

Do not use a motor driven tool to tighten the manual brake adjuster nut or use excessive force to tighten the nut. Doing so could damage the manual brake adjuster nut.

11. Install the brake pads. Provided it is in good condition, use the brake pad hardware removed earlier.
12. Back off the adjuster nut three clicks.
13. Install the wheel assemblies.
14. Raise the vehicle, remove the jack stands, then lower the vehicle.
15. Charge the air system and check for leaks.

## ⚠WARNING

**Do not operate the vehicle until the brakes have been adjusted and checked for proper operation. To do so could result in inadequate or no braking ability, which could cause personal injury or death, and property damage.**

16. In a safe area, check for proper brake operation, as follows, before putting the vehicle in service.
    - 16.1. Apply and release the brakes several times to check for air leaks and proper operation.
    - 16.2. Perform six low speed stops to ensure proper parts replacement and full vehicle control.
    - 16.3. Immediately after doing the above stops, check the rotor temperatures. Any rotors that are significantly cooler than others indicate a lack of braking effort on those wheels.
17. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for F1023 (Form WAR260).

## Meritor Radial Mounted Calipers

1. Check the base label (Form WAR259) for a completion sticker for F1023 (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 sticker is present for F1023, 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 tires.

**⚠DANGER**

**When working on the vehicle, shut down the engine, set the parking brake, and chock the tires. Before working under the vehicle, always place jack stands under the frame rails to ensure the vehicle cannot drop. Failure to follow these steps could result in serious personal injury or death.**

3. Raise the vehicle and support it on jack stands.

4. Remove all of the wheel assemblies.

NOTE: In all steps that require a torque wrench, use a Snap-On torque wrench ATECH4RS600, or an equivalent, with a center to handle length of 47 inches (119 cm).

5. Set a torque wrench to 350 lbf·ft (475 N·m) and tighten the caliper mounting bolts. If they do not turn, go to step 13. If they turn, go to step 6.

**⚠WARNING**

**When replacing brake pads, shoes, rotors, or drums, always replace components as an axle set.**

- **Always reline both sets of brakes on an axle at the same time.**
- **Always replace both rotors/drums on an axle at the same time.**
- **Always install the same type of linings/pads or drums/rotors on both axle ends of a single axle, and all four axle ends of a tandem axle, at the same time. Do not mix component types.**

**Failure to do so could cause uneven braking and loss of vehicle control, resulting in property damage, personal injury, or death.**

6. Remove the retainer pin, cotter pin, and brake pad retainer. Inspect the brake pad hardware to ensure it is in good condition. If it is, reuse the brake pad hardware. If the brake pad hardware is not in good condition, replace brake pad sets on both ends of the axle.

7. Remove the brake pads.

8. Remove the caliper bolts.

IMPORTANT: The caliper/carrier assemblies are left and right-handed. Ensure that the correct assembly (left or right) is installed on each side of the vehicle.

9. Align each caliper/carrier assembly with the rotor by pushing the caliper against the shelf on the torque plate, then install the caliper/carrier assembly using new caliper mounting bolts. See Fig. 5 and Fig. 6.

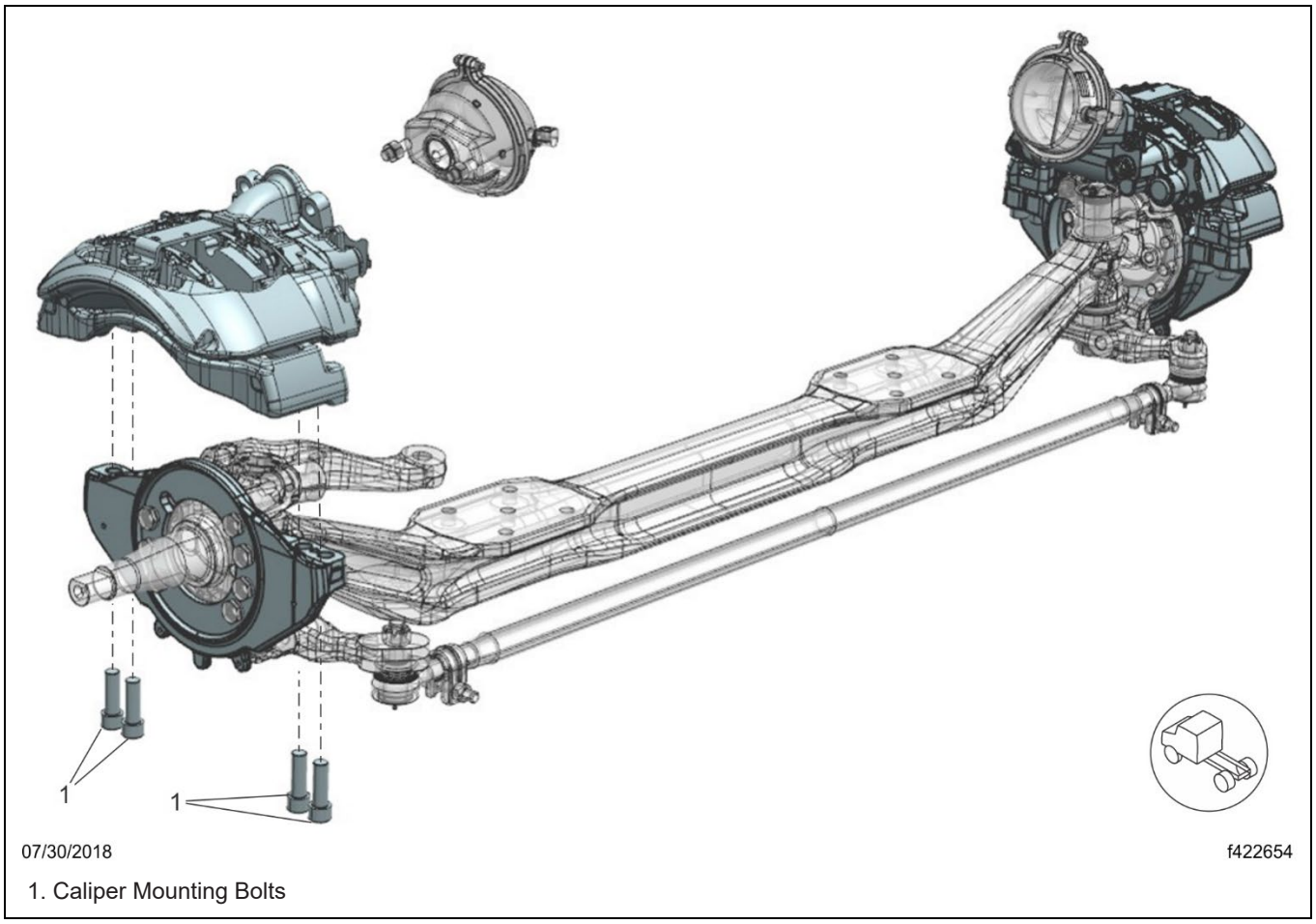


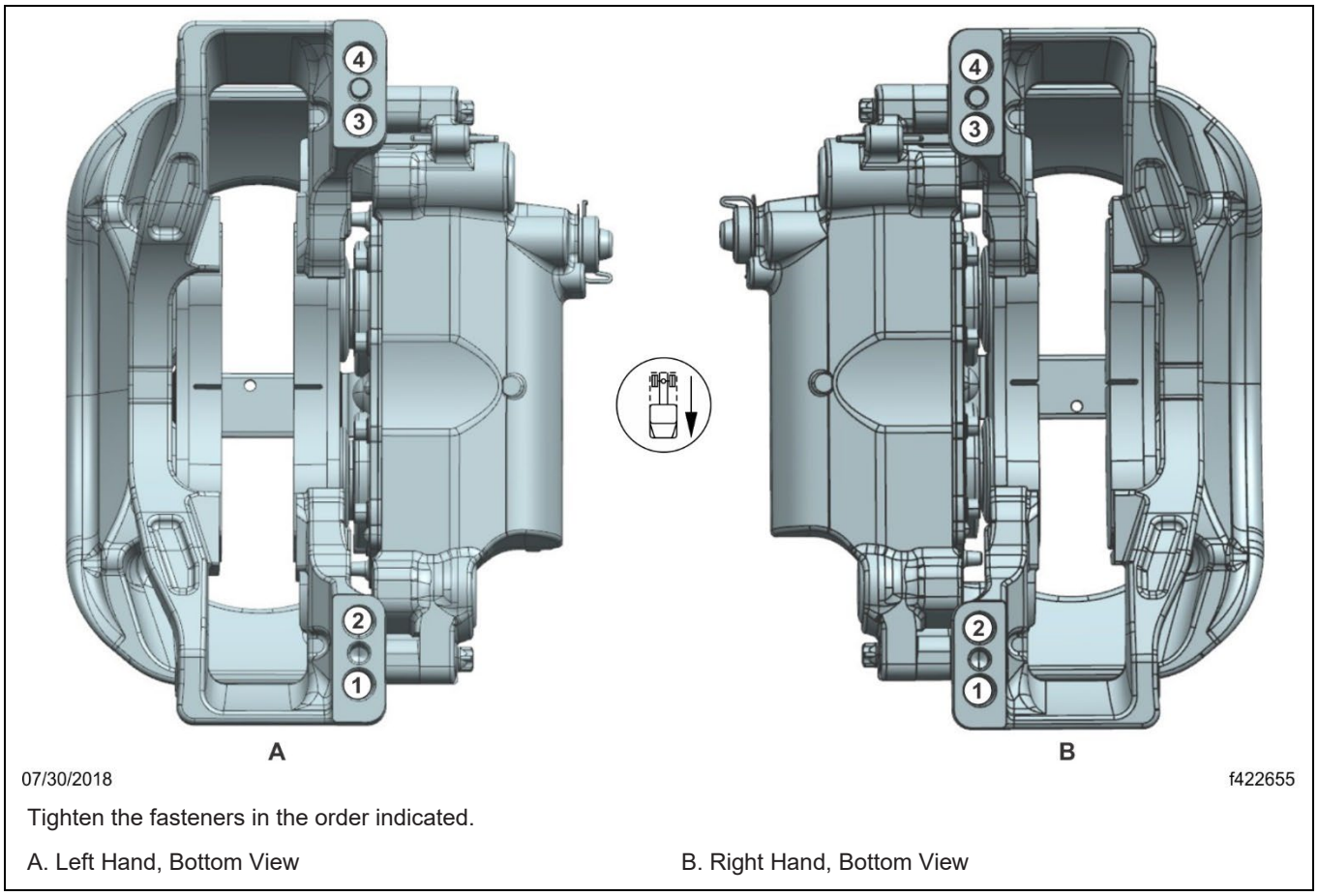

**Fig. 5, Meritor Radial Mounted Caliper**

NOTE: The tightening pattern will always start on the short (floating) pin side, with the bolt that passes through the sheer sleeve.

10. Tighten the carrier mounting bolts in two steps, using the pattern shown in Fig. 6.

    10.1. Initially tighten all six bolts 40 to 50 lbf·ft (54 to 68 N·m). Slide the caliper inboard and outboard, through the center of the chamber or brake. The caliper must have a minimum of 20 mm of travel. If the brake assembly does not move or requires more than 40 pounds of force to move, the caliper has a binding issue. Repeat the torque pattern again, if that does not resolve the binding issue, replace the caliper.

    10.2. Perform a final tightening spec of 350 to 450 lbf·ft (475 to 610 N·m). Slide the caliper inboard and outboard, through the center of the chamber or brake. The caliper must have a minimum of 20 mm of travel. If the brake assembly does not move or requires more than 40 pounds of force to move, the caliper has a binding issue. Repeat the torque pattern again, if that does not resolve the binding issue, replace the caliper.




Tighten the fasteners in the order indicated.

A. Left Hand, Bottom View

B. Right Hand, Bottom View

**Fig. 6, Tightening Pattern, Meritor Caliper**

## NOTICE

Do not use a motor driven tool to tighten the manual brake adjuster nut or use excessive force to tighten the nut. Doing so could damage the manual brake adjuster nut.

11. Install the brake pads. Provided it is in good condition, use the brake pad hardware removed earlier.
12. Back off the adjuster nut three clicks.
13. Install the wheel assemblies.
14. Raise the vehicle, remove the jack stands, then lower the vehicle.
15. Charge the air system and check for leaks.

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## ⚠WARNING

**Do not operate the vehicle until the brakes have been adjusted and checked for proper operation. To do so could result in inadequate or no braking ability, which could cause personal injury or death, and property damage.**

16. In a safe area, check for proper brake operation, as follows, before putting the vehicle in service.

    16.1. Apply and release the brakes several times to check for air leaks and proper operation.

    16.2. Perform six low speed stops to ensure proper parts replacement and full vehicle control.

    16.3. Immediately after doing the above stops, check the rotor temperatures. Any rotors that are significantly cooler than others indicate a lack of braking effort on those wheels.

17. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for F1023 (Form WAR260).

## WABCO Maxxus Axial Mounted Calipers

1. Check the base label (Form WAR259) for a completion sticker for F1023 (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 sticker is present for F1023, 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 tires.

**⚠DANGER**

**When working on the vehicle, shut down the engine, set the parking brake, and chock the tires. Before working under the vehicle, always place jack stands under the frame rails to ensure the vehicle cannot drop. Failure to follow these steps could result in serious personal injury or death.**

3. Raise the vehicle and support it on jack stands.

4. Remove all the wheel assemblies.

5. Set a torque wrench to 350 lbf·ft (475 N·m) and tighten the caliper mounting bolts. If they do not turn, go to step 13. If they turn, go to step 6. Due to limited caliper bolt access, it may be necessary to use tool DDC DSNCHA018005 referenced in tool letter 18TL18. If the tool is needed, use tool DDC DSNCHA018005 only and no other tools. See Fig. 1. See Table 4 for torque specifications.

**⚠WARNING**

**When replacing brake pads, shoes, rotors, or drums, always replace components as an axle set.**

- **Always reline both sets of brakes on an axle at the same time.**
- **Always replace both rotors/drums on an axle at the same time.**
- **Always install the same type of linings/pads or drums/rotors on both axle ends of a single axle, and all four axle ends of a tandem axle, at the same time. Do not mix component types.**

**Failure to do so could cause uneven braking and loss of vehicle control, resulting in property damage, personal injury, or death.**

6. Remove the retainer pin, cotter pin, and brake pad retainer. Inspect the brake pad hardware to ensure it is in good condition. If it is, reuse the brake pad hardware. If the brake pad hardware is not in good condition, replace brake pad sets on both ends of the axle.

7. Remove the brake pads.

8. Remove the caliper bolts.

IMPORTANT: The caliper/carrier assemblies are left and right-handed. Ensure that the correct assembly (left or right) is installed on each side of the vehicle.

NOTE: The Meritor axial mounted caliper is similar to the Bendix axial mounted caliper shown in Fig. 2.

9. Align each caliper/carrier assembly with the rotor by pushing the caliper against the shelf on the torque plate, then

install the caliper/carrier assembly using new caliper mounting bolts.

10. Tighten the carrier mounting bolts in two steps as follows.

    10.1. Start on one side of the caliper and tighten all the bolts 40 to 50 lbf·ft (54 to 68 N·m). Then tighten the bolts on the other side of the caliper 40 to 50 lbf·ft (54 to 68 N·m). See Fig. 3.

    10.2. Repeat this process, increasing the torque value to 350 to 450 lbf·ft (475 to 610 N·m). If tool DDC DSNCHA018005 referenced in tool letter 18TL18 is used, see Table 4 for torque specifications.

**NOTICE**

Do not use a motor driven tool to tighten the manual brake adjuster nut or use excessive force to tighten the nut. Doing so could damage the manual brake adjuster nut.

11. Install the brake pads. Provided it is in good condition, use the brake pad hardware removed earlier.

12. Back off the adjuster nut three clicks.

13. Install the wheel assemblies.

14. Raise the vehicle, remove the jack stands, then lower the vehicle.

15. Charge the air system and check for leaks.

**⚠WARNING**

**Do not operate the vehicle until the brakes have been adjusted and checked for proper operation. To do so could result in inadequate or no braking ability, which could cause personal injury or death, and property damage.**

16. In a safe area, check for proper brake operation, as follows, before putting the vehicle in service.

    16.1. Apply and release the brakes several times to check for air leaks and proper operation.

    16.2. Perform six low speed stops to ensure proper parts replacement and full vehicle control.

    16.3. Immediately after doing the above stops, check the rotor temperatures. Any rotors that are significantly cooler than others indicate a lack of braking effort on those wheels.

17. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for F1023 (Form WAR260).

## Hydraulic Disc Brakes Mounted Caliper

1. Check the base label (Form WAR259) for a completion sticker for F1023 (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 sticker is present for F1023, 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 tires.

**⚠DANGER**

**When working on the vehicle, shut down the engine, set the parking brake, and chock the tires. Before working under the vehicle, always place jack stands under the frame rails to ensure the vehicle cannot drop. Failure to follow these steps could result in serious personal injury or death.**

3. Raise the vehicle and support it on jack stands.

4. Remove all of the wheel assemblies.

NOTE: In all steps that require a torque wrench, use a Snap-On torque wrench ATECH4RS600, or an equivalent, with a center to handle length of 47 inches (119 cm).

5. Set a torque wrench to 73 lbf·ft (99 N·m) and tighten the caliper mounting bolts. If they do not turn, go to step 13. If they turn, go to step 6.

**⚠WARNING**

**When replacing brake pads, shoes, rotors, or drums, always replace components as an axle set.**

- **Always reline both sets of brakes on an axle at the same time.**
- **Always replace both rotors/drums on an axle at the same time.**
- **Always install the same type of linings/pads or drums/rotors on both axle ends of a single axle, and all four axle ends of a tandem axle, at the same time. Do not mix component types.**

**Failure to do so could cause uneven braking and loss of vehicle control, resulting in property damage, personal injury, or death.**

6. Remove the retainer pin, cotter pin, and brake pad retainer. Inspect the brake pad hardware to ensure it is in good condition. If it is, reuse the brake pad hardware. If the brake pad hardware is not in good condition, replace brake pad sets on both ends of the axle.

7. Remove the brake pads.

8. Remove the caliper bolts.

IMPORTANT: The caliper/carrier assemblies are left and right-handed. Ensure that the correct assembly (left or right) is installed on each side of the vehicle.

9. Align each caliper/carrier assembly with the rotor by pushing the caliper against the shelf on the torque plate, then install the caliper/carrier assembly using new caliper mounting bolts. See Fig. 12.

10. Tighten the carrier mounting bolts in two steps as follows.

    10.1. Initially tighten all four bolts 40 to 50 lbf·ft (54 to 68 N·m). Beginning with the two inner bolts and then the two outer bolts. Slide the caliper inboard and outboard, through the center of the brake. The caliper must move freely. If it does not, repeat the torque pattern again. If that does not resolve the binding issue, replace the caliper.

    10.2. Tighten all four bolts 73 to 89 lbf·ft (99 to 121 N·m). Slide the caliper inboard and outboard, through the center of the brake. The caliper must move freely. If it does not, repeat the torque pattern again. If that does not resolve the binding issue, replace the caliper.

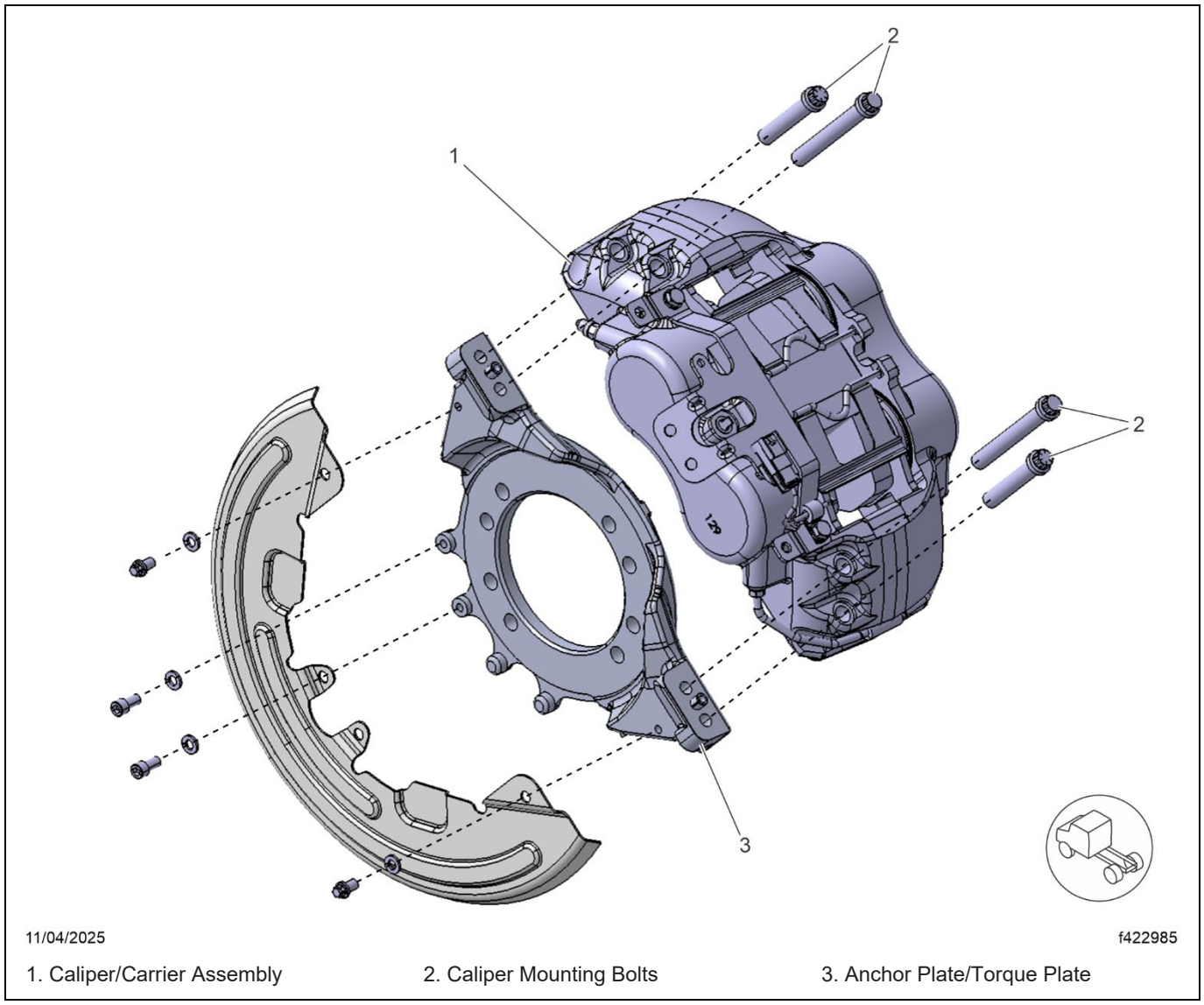


**Fig. 12, Hydraulic Disc Brakes Mounted Caliper**

11. Install the brake pads. Provided it is in good condition, use the brake pad hardware removed earlier.
12. Install the wheel assemblies.
13. Raise the vehicle, remove the jack stands, then lower the vehicle.

**F1023 A-J**

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|---|---|
| **Creation Date:** | **November 2025** |
| **NHTSA #** | **25V-601** |
| **NHTSA School Bus #** | **25V-602** |
| **Transport Canada #** | **2025-480** |

## ⚠WARNING

**Do not operate the vehicle until the brakes have been adjusted and checked for proper operation. To do so could result in inadequate or no braking ability, which could cause personal injury or death, and property damage.**

14. In a safe area, check for proper brake operation, as follows, before putting the vehicle in service.

    14.1. Apply and release the brakes several times to check for air leaks and proper operation.

    14.2. Perform six low speed stops to ensure proper parts replacement and full vehicle control.

    14.3. Immediately after doing the above stops, check the rotor temperatures. Any rotors that are significantly cooler than others indicate a lack of braking effort on those wheels.

15. Clean a spot on the base label (Form WAR259) and attach a campaign completion sticker for F1023 (Form WAR260).