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Crossmember Replacement

FSB 711-007, Crossmember Replacement

(January 2012)

LE, LEU, MR, MRU

Chassis equipped with bogie crossmember 25135262 (Hendrickson HMX Haulmax suspension) and 25131281 (Hendrickson HN suspension) have experienced cracking of the lower right side frame bracket. To resolve this issue Mack Trucks has designed a new crossmember assembly to directly replace the existing crossmembers. Applicable part numbers are listed below.

Required Parts

HMX Suspension Crossmembers	
21815424	54-inch Bogie Spring, Inside Channel Reinforcements and Meritor Axles
21815425	54-inch Bogie Spring, Inside Channel Reinforcements and Mack Axles
HN Suspension Crossmembers	
21815420	Without Inside Channel Reinforcements and Mack or Vendor Axles
21815421	With Inside Channel Reinforcements and Mack or Vendor Axles

Procedure

You must read and understand the precautions and guidelines in Service Information, Function Group 7, "General Safety Practices, Frame, Springs and Wheels" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.



DANGER

Do not attempt to repair or service this vehicle without having sufficient training, the correct service literature and the proper tools. Failure to follow this could make the vehicle unsafe and lead to serious personal injury or death.

- 1 Secure the vehicle for service by parking it on a flat level surface, applying the parking brake, chocking the rear wheel, and placing the transmission in neutral.
- 2 Mark frame so all bolts and brackets can be reinstalled correctly.
- 3 Drain air tanks.



WARNING

Before beginning any service work on any part of the air system, be certain that the air pressure has been released. Failure to do so may cause a component to violently separate, which can result in serious personal injury.

- 4 Remove all airlines, air line support brackets and electrical harnesses that are in the way of removing crossmember, including removing tie straps securing air lines.
- 5 Remove torque rod and mounting plates from frame mounted with bolts.
- 6 Remove all the bolts securing different parts to frame that need to be removed to slide crossmember back and out of frame.
- 7 Raise the vehicle and place jack-stands under both rear drive axles.
- 8 Remove all rear drive wheels and tires.
- 9 Using the Huck removal tool, remove the Huck fasteners from both sides of the frame rail, as necessary.
- 10 Lift and spread frame.
- 11 Remove the two rear crossmembers.



WARNING

Crossmembers are heavy. Use an assistant to remove and install crossmembers. Failure to use proper procedure can result in component damage and serious personal injury

- 12 Remove the bogie crossmember from frame rails.
- 13 Position the replacement crossmember between the frame rails and start fasteners.
- 14 Position the two rear crossmembers between the frame rails and start fasteners.
- 15 Tighten all bolts in the frame to 200 ± 30 Nm (148 ± 10 ft lbs) and/or tighten all Huck fasteners.
- 16 Install torque rods and mounting plates.
- 17 Install all air lines and electrical harnesses and necessary tie straps.
- 18 Install all rear drive wheels and tires.
- 19 Raise vehicle, remove jack-stands and lower vehicle.

Reimbursement

This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	01
Labor Code	
Primary Labor Code	1212M-01-80 – 4.0 hrs
Causal Part	25135262

Mack Trucks, Inc. engages in a comprehensive program of testing and evaluating to provide the best possible product. Mack Trucks, Inc. however, is not committed to, or liable for updating existing vehicles