



This bulletin replaces "FSB 652-004,
Torque Rod Replacement" distributed
2/12.

Date	Group	No.	Release	Page
3.2012	652	004	2	1(5)

SB-10043808-5002

Torque Rod Replacement
CHU, CXU, GU, TD

FSB 652-004, Torque Rod Replacement

(March 2012)

Note: This bulletin does not apply to Mack Trucks Australia.

Note: Information is subject to change without notice.
Illustrations are used for reference only, and may differ slightly from the actual vehicle
being serviced. However, key components addressed in this information are represented
as accurately as possible.

Torque rod on front rear axle makes contact with carrier during articulation. The following
procedure must be performed on the front and rear torque rod at the same time.
This applies to MACK axles only. This bulletin applies to vehicles equipped with HH and
HN suspensions only.

Torque Rod Replacement (Front and Rear Lateral Torque Rods)

1 Park the vehicle on a level surface with the transmission in neutral and wheels chocked.

2

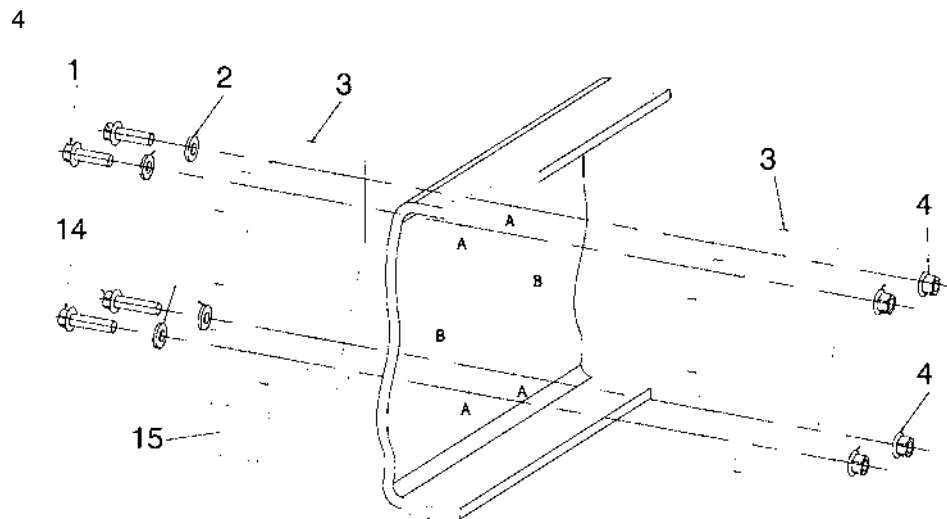
Note: Kit does not include torque rods, which may be required.

Parts List: Kit 85130549

Quantity	Part ID Number	Part Number	Description	Note for Relocation of Torque Rod
4	1	966360	Screw M14x50	Additional Standard Part
8	2	966838	Washer	Additional Standard Part
4	3	21679186	Plate Reinforcement	New Part to be Used
8	4	971097	Nut M14	Additional Standard Part
4	5	975128	Screw M16	Additional Standard Part
2	6	21679179	Bracket Torque Rod	New Part to be Used
4	7	20706261	Washer	Additional Standard Part
4	8	969318	Nut M16	Additional Standard Part
4	9	25109220	Screw	Part to be Reused
4	10	25173404	Washer	Additional Standard Part
1	11	25176599	Torque Rod Front	May be required
1	12	25155774	Torque Rod Rear	May be required
4	13	25085424	Nut	New Standard Part to be Used
4	14	966363	Screw M14x65	New Standard Part to be Used
NA	15	Varies	Bump Stop	Part to be Reused

Support the wheel end with a jack stand supporting the rear axle and remove the rear wheels and tires.

3 Disconnect the torque rod and all associated parts from the frame rail.

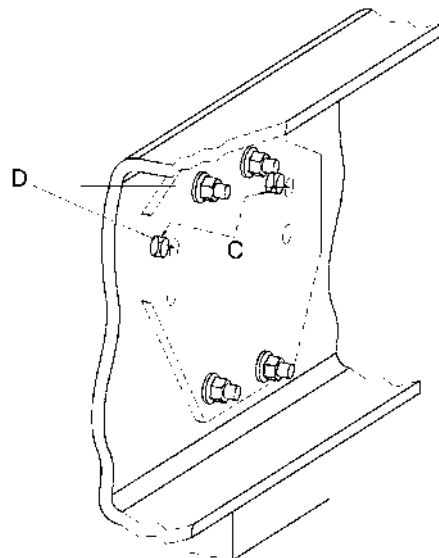


W6070237

Note: Numbered call-outs correspond to "Part ID Number" in the "Parts List".

Assemble the new parts (inner and outer plates) onto the frame rail where the torque rod will be re-installed. Tighten the fasteners to 200 ± 30 Nm (148 ± 22 ft-lb).

5

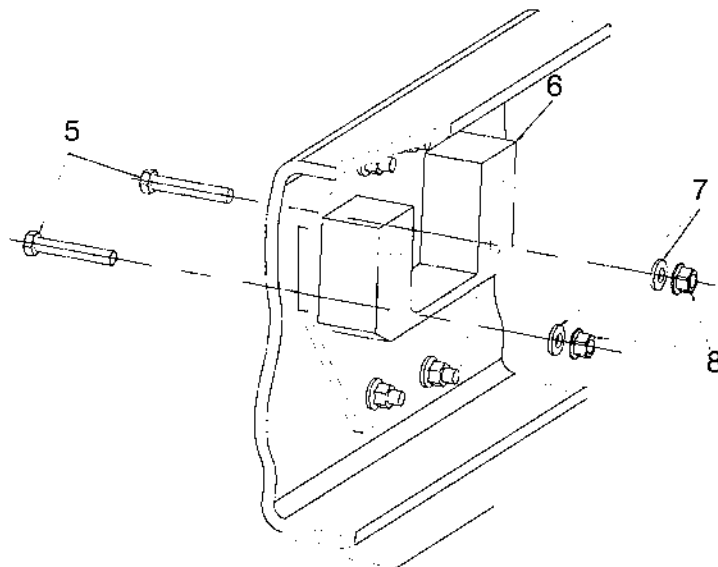


W6070238

Note: Prior to drilling new holes in frame ensure that all six existing holes in frame line up with holes in new reinforcement plates. Then, use reinforcement plate holes "D" as guide to drill holes "C" in frame as directed below. Failure to do so will result in frame rail damage requiring frame rail replacement.

Drill two new 17 mm (0.67 in.) holes in the frame rail using the holes in the plate installed in the previous step as a guide.

6

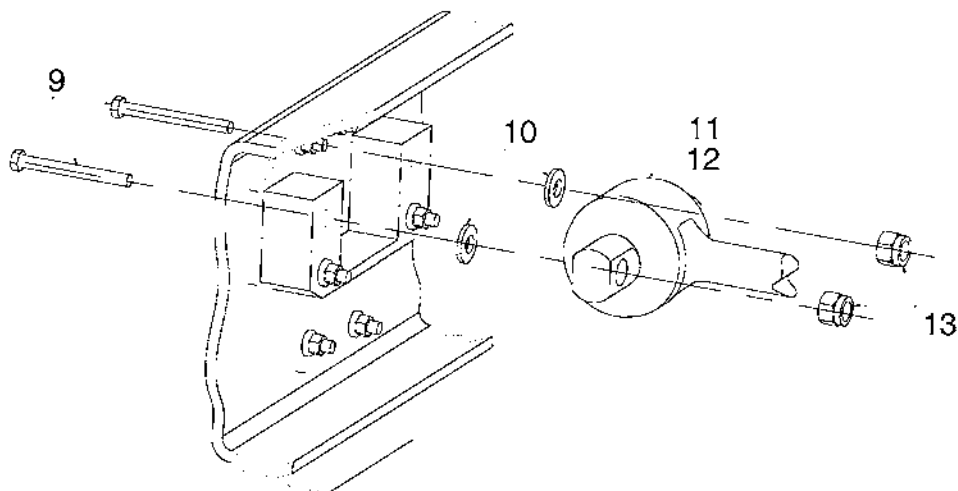


W6070239

Note: Numbered call-outs correspond to “Part ID Number” in the “Parts List”.

Install the new torque rod bracket and fasteners. Tighten the fasteners to 610–813 Nm (450 – 600 ft-lb).

7



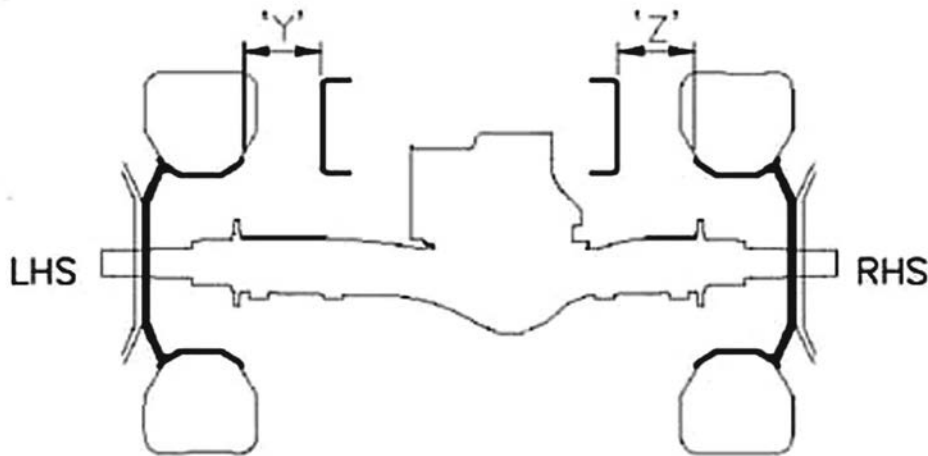
W6070240

Note: Numbered call-outs correspond to “Part ID Number” in the “Parts List”.

Connect the torque rod to the new holes on the frame rail torque rod bracket and tighten to specification 610–813 Nm (450 – 600 ft-lb).

8 Repeat steps 1 - 7 for rear torque rod.

- 9 Install the wheels and tires and tighten the wheel nuts to specification.
- 10



W6066446

- Check the thrust and lateral alignment of the drive axles.
- Truck should initially be reassembled using existing torque rods.
 - Perform measurements of tandem alignment per illustration. The difference between measurements 'Y' and 'X' should be less than 5 mm (0.2 in.).
 - If 5 mm specification is achieved by 'Y' and 'X' measurements having a difference of less than 5 mm, no further work is required. DO NOT REPLACE TORQUE RODS.
 - If 5 mm specification cannot be achieved by 'Y' and 'X' measurements having a difference of less than 5 mm, then replacement of torque rods using part numbers listed on first page is required and may or may not require shims. If torque rods are replaced then lateral alignment should be rechecked.

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 (Both sides without torque rods)	1353B-01-80 — 1.7 hrs
Causal Part	25155635