



**Mack Trucks, Inc.**  
Greensboro, NC USA

SR-10040396-6204  
**Service Program**  
**Trucks**

This document replaces PV729-PI0820 (USA57673) dated 03.13

Date	Group	No.	Release	Page
3.2013	<b>218</b>	<b>001</b>	<b>02</b>	1(6)

Incorrect Hardware on Front Engine Mount  
LEU

## PI0820, Incorrect Hardware on Front Engine Mount

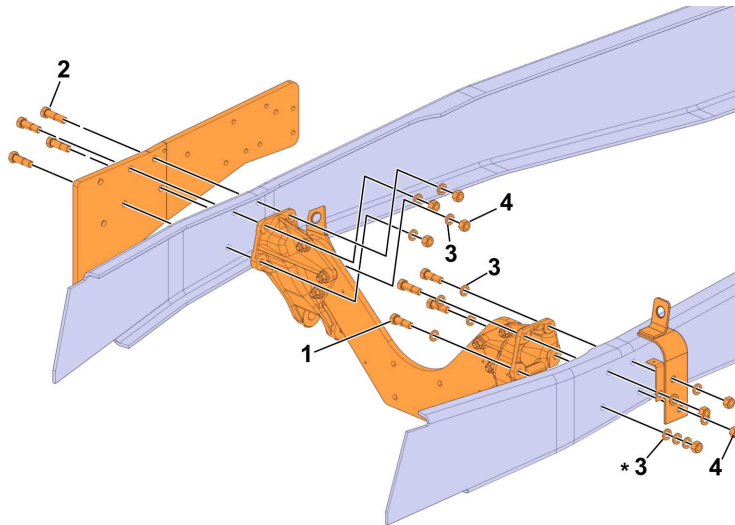
(March 2013)

Certain LEU vehicles may have been assembled using the incorrect grade and/or length of bolts in the front engine mount for both the left and right side of the vehicle. Bolt part numbers and length and washer stack up vary depending on the engine model installed on the vehicle. To complete the repair and install the proper bolts, utilize the installation drawings and part number lists included in this document.

**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.

## Frame Engine Mount Installation

*LEU, Engine Mount Installation, Cummins Engine*



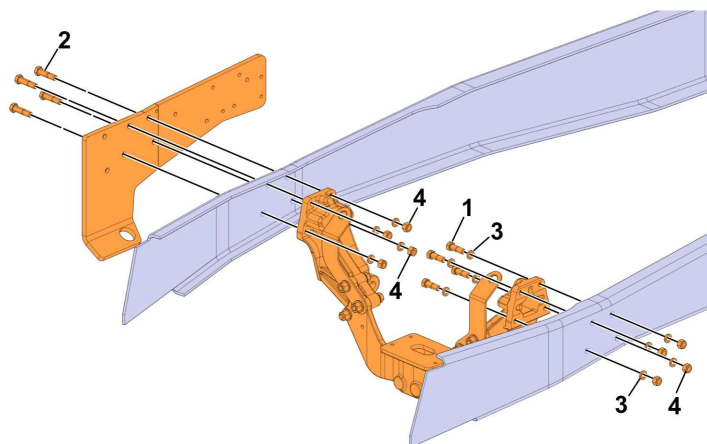
W7080300

Description	Part Number	Quantity	Illustration Number
Shoulder Bolt	25085600	4	1
Shoulder Bolt	25087900	4	2
Washer	25088675	14	3
Hexagon Nut	20760812	8	4

**Note:** \* Ensure that the washer stack up is as shown in the illustration.

**Note:** Ensure that the head of the bolts are installed as shown in the illustration.

*LEU, Engine Mount Installation, Mack Engine*



W7080180

Description	Part Number	Quantity	Illustration Number
Shoulder Bolt	25085600	4	1
Shoulder Bolt	25087900	4	2
Washer	25088675	12	3
Hexagon Nut	20760812	8	4

**Note:** Ensure that the head of the bolts are installed as shown in the illustration.

## Procedure

You must read and understand the precautions and guidelines in Service Information, Function Group 70, "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.

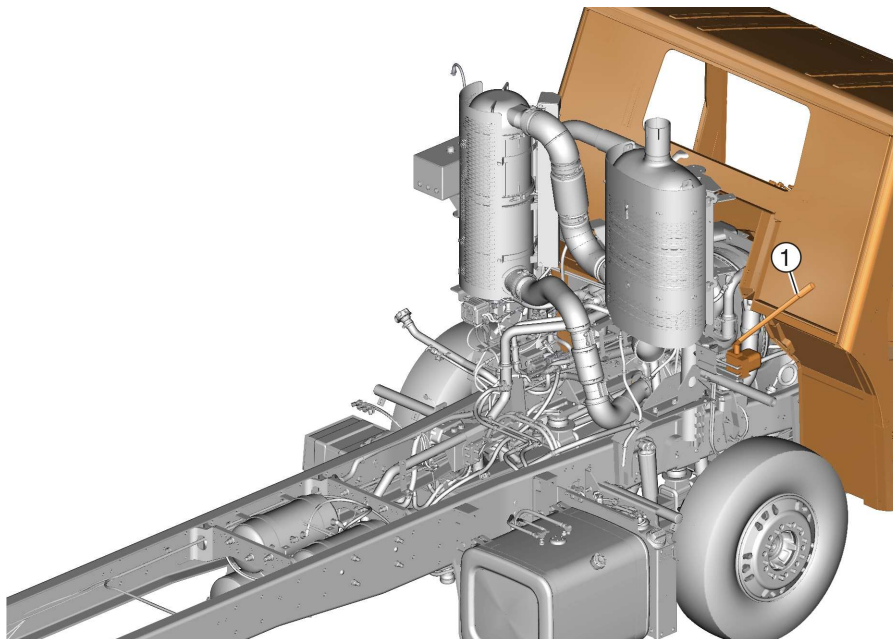


### DANGER

Before working on a vehicle, set the parking brakes, place the transmission in neutral, and block the wheels. Failure to do so can result in unexpected vehicle movement and can cause serious personal injury or death.

**Note:** This procedure applies to both sides of the frame rail and engine mount.

- 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 Remove all cables from the ground (negative) battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
- 3



W2055601

Using the hydraulic pump, raise cab to full upright locked position.

**Note:** Before you attempt to raise the cab make sure that there are no loose items within the cab that could fall and cause damage.

- 4 Remove the front tires and wheels.
- 5 Using a jack, raise the front axle slightly so that the weight of the axle is off of the front springs. Then use jack stands under the end of the axle for support.

**Note:** Rotate the steering wheel right and left to gain access to the work space as needed.

- 6 Support the front engine mount with a jack or jack stand.

**Note:** This support is used as a precaution only and is not supporting the full weight of the engine.

- 7 As needed, cut cable ties securing airlines or harnesses in the work area.  
8 Remove the nuts **one at a time** from the fasteners securing the front engine mount to the frame rail.  
9



**CAUTION**

To avoid component damage, do not allow the body bound bolts to turn in their respective holes. Otherwise, the interference between the holes and bolts is compromised.

Replace each bolt **one at a time** until all eight have been replaced and secured. Torque each fastener to  $298 \pm 24$  Nm ( $220 \pm 18$  ft-lb). Using a hammer of suitable size strike the bolt heads a few times to seat them properly. Re-torque each fastener to  $298 \pm 24$  Nm ( $220 \pm 18$  ft-lb).

**Note:** The eight fasteners securing the front engine mount to the frame are body bound bolts. Replace them one at a time.

- 10 Install cable ties as needed to secure the airlines and harnesses disconnected previously.  
11 Install the tires and wheels. Torque nuts to 610 – 678 Nm (450 – 500 ft-lb).  
12 Jack the vehicle up and remove all jack stands. Lower the vehicle.  
13 Lower the cab.  
14 Install all previously removed cables to the ground (negative) battery terminals.

**Reimbursement**

<b>This repair is covered by an authorized Service Program. Reimbursement is obtained via the normal claim handling process.</b>	
<b>Claim Type (used only when uploading from the Dealer Bus. Sys.)</b>	B
<b>Recall Status</b>	
Vehicle inspected, repair not required	1- Inspected OK
Vehicle repaired per instruction	2- Modified per instruction
<b>Labor Code</b>	
Primary Labor Code	2991D-ZV-96 1.2 hrs
Time to take charge and determine campaign status	101AA-0A-00 0.3 hrs.
<b>Causal Part</b>	25012714
<b>Authorization Number</b>	PI0820
<b>Expiration Date</b>	12/31/2013

**Note:** Take Charge Time is not included in the Labor Code for this operation. Take charge may be eligible but can only be used once per repair visit. If vehicle is having other warranty repairs performed, take charge should be charged to the warranty repair, otherwise take charge can be charged to this service program.