



Mack Trucks, Inc.
Greensboro, NC USA

Field Service Bulletin Trucks

SB-10052251-9850

Date	Group	No.	Release	Page
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Exhaust Mounting Reinforcement
CHU

FSB 813-001, Exhaust Mounting Reinforcement

(May 2013)

To address concerns of B-pillar cracks forming at the upper exhaust mounting on certain MACK CHU vehicles, a new reinforcement has been developed which improves the durability of the B-pillar.

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

Required Parts

- 1 – Spacer Tube, 82733838
- 1 – Fastener, 995536

Procedure

You must read and understand the precautions and guidelines in Service Information, Function Group 8, "General Safety Practices, Cab" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.

Note: This procedure applies to both sides of the vehicle.

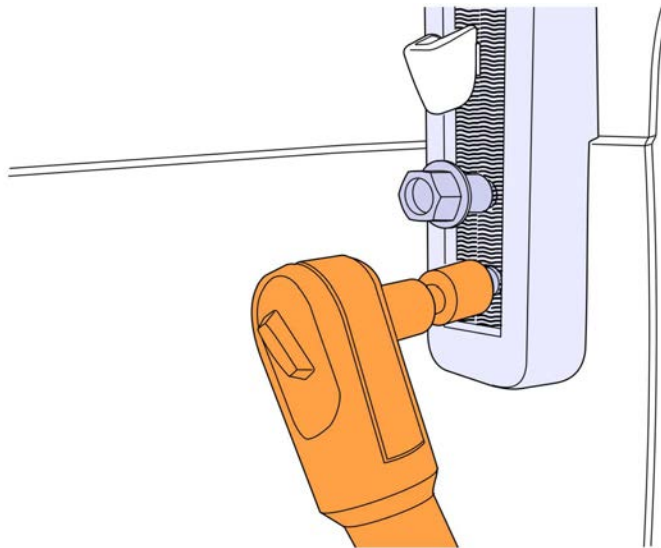


DANGER

Do not attempt to repair or service a vehicle without the proper training, tools and service information. Failure to do so may result in component damage, serious 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 Disconnect all cables from the negative (ground) and positive battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
- 3 Drain the vehicle air system.

- 4 With assistance, remove the seat. If applicable, disconnect the seat's air supply lines and wiring harness.
- 5 Remove the seat belt.



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- 6 Carefully remove the seat belt assembly.
- 7 If applicable, remove the rear speaker.
- 8 From inside the vehicle, remove the cab corner trim.
- 9 Loosen the cab mounted exhaust clamps. With assistance remove the cab mounted exhaust.
- 10 Inspect the interior re-enforcement bracket for damage. Repair or replace the bracket if needed.

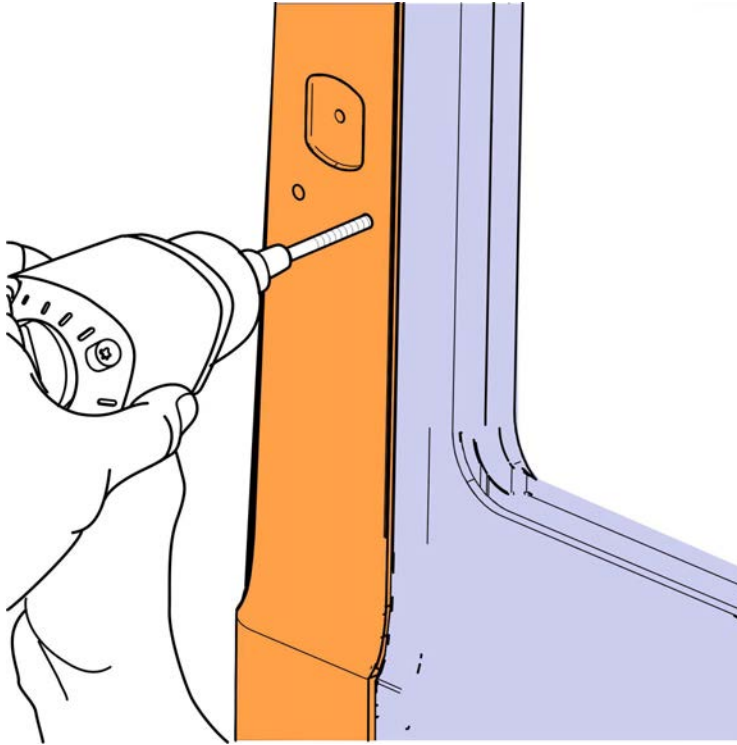
Note: Steps and time for repairing or replacing the bracket are not contained within this procedure.

- 11 Repair any body damage per existing procedures.

Note: Steps and time for repairing body panel damage are not contained within this procedure. For additional body damage repair procedures refer to the information in Function Group 8.

- 12 On the cab door frame, in the bolt hole closest to the door opening, drill 6.35 mm (1/4 inch) pilot hole through the inner body panels.

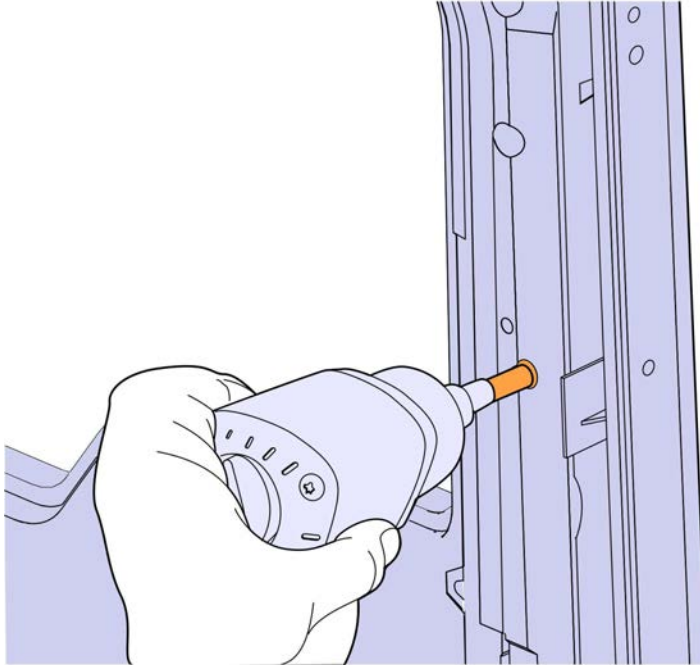
Note: Keep the drill level as possible to the door frame. If not, the reinforcement tube may not align properly.



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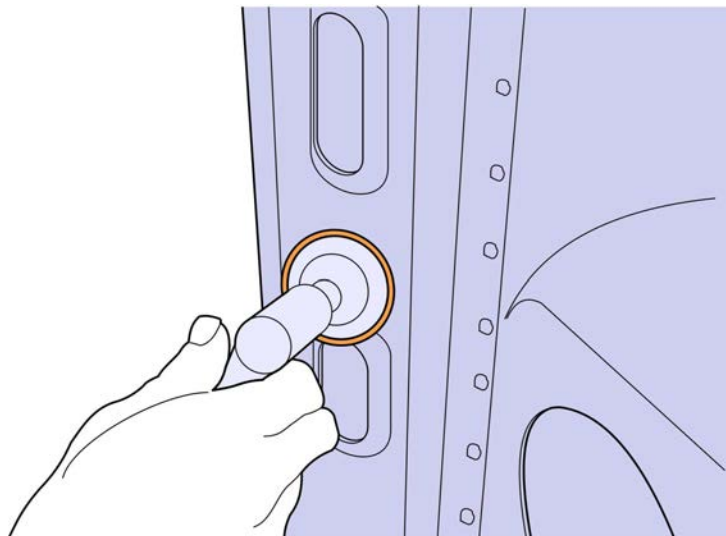
- 13 To remove the threads from the weld nut attached to the interior re-enforcement bracket, in the bolt hole closest to the door opening, using a 10 mm (3/8 inch) drill bit, drill through the nut.

- 14 On the inside of the cab, using the 6.35 mm (1/4 inch) pilot hole as a guide, drill through the **inner** two body panels with a 22 mm (7/8 inch) hole saw.



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- 15 Clean the area around the hole in the body panels for welding.



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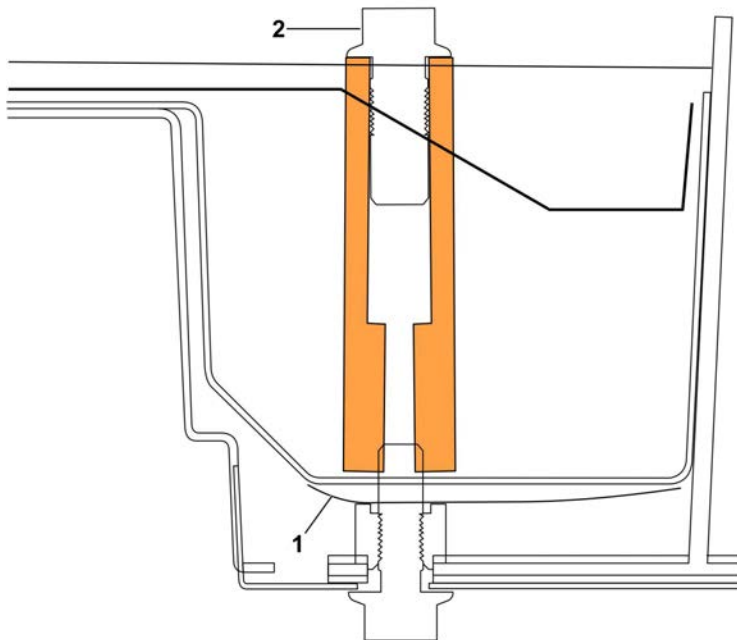
- 16 In the recessed end of the reinforcement tube, install an 8 mm fastener (part number 995536).

Note: The 8 mm fastener is used to hold the reinforcement tube when tightening the outer fastener.

17 From inside the cab, insert the spacer tube (part number 82733838) through the body panels. Then thread the fastener through the reinforcement bracket into the tube. Torque the fastener to 80 Nm (59 ft-lb).

Note: This action pulls the inner panel to the reinforcement bracket before welding.

Note: Use the inner fastener to keep the tube from turning.



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1 – Amount of deformation before welding
2 – Fastener inserted into tube

18

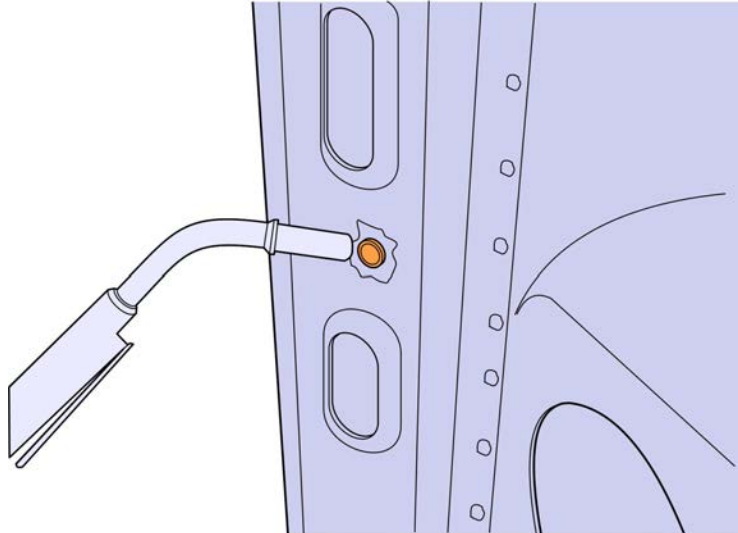


CAUTION

To avoid damage to the interior of the cab during welding, provide protection.

Tack weld the tube to the inner panel. Remove the inner fastener.

19 Weld the tube to the cab.



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20 Clean the welds and prep for painting.

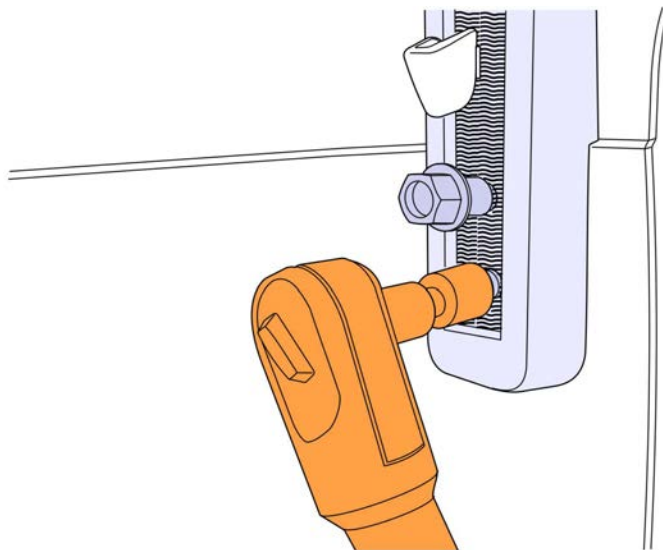
21 Paint the welded area inside the cab area.

22 Remove any items used to protect the cab interior during welding.

23 Install the cab corner trim inside the vehicle. Hand tighter until secure.

24 Install the rear speaker. Hand tighten only until secure.

25 Install the seat belt assembly. Torque fasteners to 58 ± 10 Nm (43 ± 8 ft-lb).



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26 With assistance, install the seat. If applicable, connect the air supply lines. Torque seat fasteners to 48 ± 8 Nm (35 ± 5.9 ft-lb).

27 With assistance, install the cab mounted exhaust. Torque fasteners to 24 ± 4 Nm (18 ± 3 ft-lb)

28 Install all previously removed cables to the ground (negative) battery terminals.

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.)	W
Labor Code	
Primary Labor Code	6001A-ZQ-80 2.6 hrs.
Causal Part	82734625 LH 84078739 RH

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