

Subject: Cascadia Premium Insulation

Models Affected: Specific Freightliner Cascadia vehicles with XT or raised roof assemblies manufactured August 9, 2013, through August 23, 2013.

General Information

Daimler Trucks North America LLC, on behalf of its Freightliner Trucks Division, is initiating Field Service Campaign SF489A-D to modify the vehicles mentioned above.

Certain Cascadia vehicles received standard insulation on the XT or raised roof assembly.

Vehicles will be inspected for the presence of premium insulation. If standard insulation is found, it will be replaced with premium insulation.

There are approximately 365 vehicles involved.

Additional Repairs

Dealers must complete all outstanding 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 WAR261).

Replacement Parts

Replacement parts are now available and can be obtained by ordering the kit number listed below from your facing Parts Distribution Center.

If our records show your dealership has ordered any vehicle(s) involved in campaign SF489A-D, a list of the customers and vehicle identification numbers will be available on AccessFreightliner.com. Please refer to this list when ordering parts for this campaign.

Field Service Campaign

Daimler Trucks
North America LLC

January 2014
SF489A-D

Table 1 - Replacement Parts for SF489A-D

Campaign Number	Kit Number	Part Description	Part Number	Qty. per Kit	Suggested Wholesale*
SF489A	25-SF489-000	48" XT Premium Insulation	18-59682-001	2 ea	\$337.55 US \$344.30 CAN
			18-59684-001	1 ea	
			18-59685-001	1 ea	
			18-62785-001	2 ea	
			18-62786-001	1 ea	
			18-62852-002	1 ea	
			18-62853-000	2 ea	
			18-62854-002	2 ea	
			18-63234-001	1 ea	
SF489B	25-SF489-001	60" XT Premium Insulation	18-59254-001	1 ea	\$359.00 US \$366.18 CAN
			18-59682-001	2 ea	
			18-59683-201	2 ea	
			18-59684-001	1 ea	
			18-59685-001	1 ea	
			18-59686-201	1 ea	
			18-62852-001	1 ea	
			18-62853-000	2ea	
			18-62854-001	2 ea	
18-63234-001	1 ea				
SF489C	25-SF489-002	72" XT Premium Insulation	18-59254-001	1 ea	\$379.51 US \$387.10 CAN
			18-59682-001	2 ea	
			18-59683-001	2 ea	
			18-59684-001	1 ea	
			18-59685-001	1 ea	
			18-59686-001	1 ea	
			18-62852-000	1 ea	
			18-62853-000	2 ea	
			18-62854-000	2 ea	
18-63234-001	1 ea				
SF489D	25-SF489-003	72" Raised Roof Premium Insulation	18-59674-001	1 ea	\$329.71 US \$336.31 CAN
			18-59675-001	1 ea	
			18-59676-001	1 ea	
			18-59680-001	1 ea	
			18-59681-001	2 ea	
			18-62618-001	1 ea	
			18-62617-001	2 ea	
			18-62524-000	1 ea	
			18-62523-000	1 ea	
			18-62522-000	2 ea	

* Please charge all U.S. and Canadian Direct Warranty Customers the above-listed price for the kit, as they are authorized to perform their own Recalls. This pricing does not apply to Export Distributors.

Table 1

Removed Parts

U. S. and Canadian Dealers, please follow Warranty Failed Parts Tracking shipping instructions for the disposition of all removed parts. Export distributors, please destroy removed parts unless otherwise advised.

Labor Allowance

Table 2 - Labor Allowance

Campaign Number	Procedure	Time Allowed (hours)	SRT Code	Damage Code
SF489A-D	Inspect cab insulation	.5	996-0922A	000-Inspected
	Inspect and Replace cab insulation	5.5	996-0922B	000-Modifiedx

Table 2

IMPORTANT: When the campaign has been completed, locate the base completion label in the appropriate location on the vehicle, and attach the gray completion sticker provided in the field service kit (Form WAR261). If the vehicle does not have a base completion label, clean a spot on the appropriate location of the vehicle and first attach the base completion label (Form WAR259). If a field service kit is not required or there is no completion sticker in the kit, write the campaign number on a blank sticker and attach it to the base completion label.

Claims for Credit

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. Please reference the following information in QuickClaim or OWL:

- Claim type is **Field Service**.
- In the FTL Authorization field, enter the campaign number and appropriate condition code (e.g. **SF489A, SF489B** etc).
- In the Primary Failed Part Number field, enter **25-SF489-000**.
- In the Parts field, enter the appropriate kit number(s) as shown in the Replacement Parts Table.
- In the Labor field, first enter the appropriate SRT from the Labor Allowance Table. For administrative time, enter SRT 939-0010A for 0.3 hours.
- For OWL, the VMRS Component Code is 002-050-398 and the Cause Code is A1 - Campaign.

This Field Service Campaign will **terminate on January 31, 2015**. Dealers will be notified of any changes to the termination date via Important Campaign Information Letter posted on AccessFreightliner.com.

IMPORTANT: ServicePro or OWL must be viewed prior to beginning work to ensure the vehicle is involved and the campaign has not previously been completed. Also, check for a completion sticker before beginning work.

All claims must be submitted within 30 days of the repair and within 30 days of the termination date of the campaign. U.S. and Canadian Dealers: All excess inventory to be returned to the PDC following the conclusion of the campaign must be returned in resaleable condition to the Memphis PDC within 90 days from the termination date. Please submit a PAR to request return to the Memphis PDC. (Canadian dealers should return the kits to their facing PDC.) Export Distributors: Excess inventory is not returnable.

U.S. and Canadian dealers, contact the Warranty Campaigns Department from 7:00 a.m. to 4:00 p.m. Pacific Time, Monday through Friday, via Web inquiry at AccessFreightliner.com / Support / My Tickets and Submit an Inquiry, or the Customer Assistance Center at (800) 385-4357, after normal business hours, if you have any questions or need additional information. Export distributors submit a Web inquiry or contact your International Service Manager.

Field Service Campaign

Daimler Trucks
North America LLC

January 2014
SF489A-D

Copy of Notice to Owners Subject: Cascadia Premium Insulation

Daimler Trucks North America LLC, on behalf of Freightliner Trucks Division, is initiating Field Service Campaign SF489A-D to modify specific Freightliner Cascadia vehicles with XT or raised roof assemblies manufactured August 9, 2013, through August 23, 2013.

Certain Cascadia vehicles received standard insulation on the XT or raised roof assembly.

Vehicles will be inspected for the presence of premium insulation. If standard insulation is found, it will be replaced with premium insulation.

Please contact an authorized Daimler Trucks North America dealer to arrange to have the campaign performed and to ensure that parts are available at the dealership. To locate an authorized dealer, search online at www.DaimlerTrucksNorthAmerica.com. If replacement is necessary, the campaign will take approximately five and a half hours and will be performed at no charge to you.

This Field Service Campaign will **terminate on January 31, 2015**. Please make sure the campaign is completed prior to this date. Work completed after this date will be done at the customer's expense.

As stated in the terms of your express limited warranty, Daimler Trucks North America LLC will not pay for any damage caused by failure to properly maintain your vehicle. Daimler Trucks North America LLC considers the work necessary under this campaign to be proper maintenance and will, therefore, not pay for any damage to your vehicle caused by your failure to have the repairs that are the subject of this campaign performed in a reasonable time.

Contact the Warranty Campaigns Department at (800) 547-0712, from 7:00 a.m. to 4:00 p.m. Pacific Time, Monday through Friday, e-mail address DTNA.Warranty.Campaigns@Daimler.com, or the Customer Assistance Center at (800) 385-4357, after normal business hours, if you have any questions or need additional information.

WARRANTY CAMPAIGNS DEPARTMENT

Enclosure

Work Instructions

Subject: Cascadia Premium Insulation

Models Affected: Specific Freightliner Cascadia vehicles with XT or raised roof assemblies manufactured August 9, 2013, through August 23, 2013.

NOTE: The following procedures are for the 72-inch raised roof. Other models are similar.

Insulation Inspection

1. Check the base label (Form WAR259) for a completion sticker for SF489 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, no work is needed. If there is no sticker, continue with these work instructions.
2. Park the vehicle on a level surface, shut down the engine and set the parking brake. Chock the tires.
3. Remove the cab dome light (see **Fig. 1**), as follows:
 - 3.1 Pop off the lens.
 - 3.2 Remove the two screws that attach the lamp housing to the cab roof.
 - 3.3 Disconnect the wiring.
4. Remove the five screws that attach the sleeper curtain rail to the cab roof.
5. Remove the overhead storage compartment trim. See **Fig. 2**.
6. Remove the fir-tree fasteners on both sides of the overhead storage compartment.

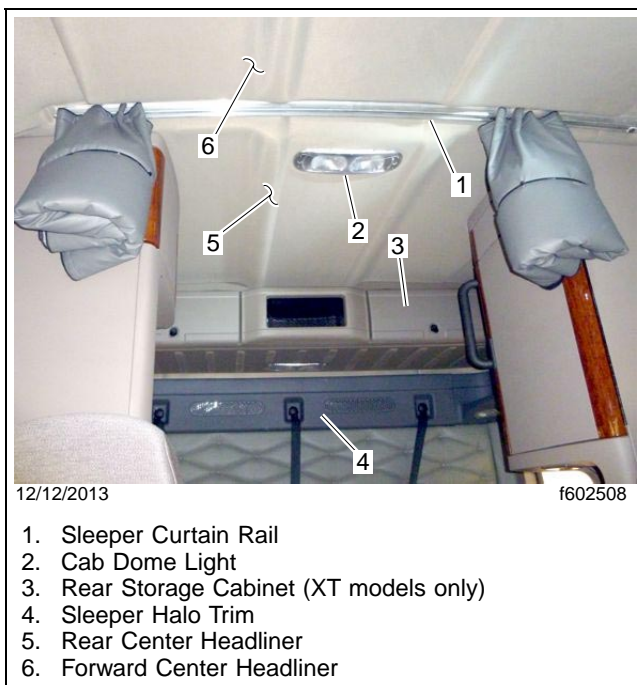


Fig. 1, Cab Dome Light and Sleeper Curtain (XT model shown)



Fig. 2, Overhead Storage Compartment

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NOTICE

Use care when pulling down the edge of the headliner. The headliner may crease if bent.

7. Through the dome light opening, measure the thickness of the sleeper roof insulation. Also, pull down the rear edge of the forward headliner far enough to inspect and measure the cab roof insulation thickness. See **Fig. 3**.

If the insulation is 7/8 inch (22mm) thick, and there is no additional insulation blanket present, the vehicle has standard insulation. Go to "Premium Insulation Installation" (below) in these Work Instructions and replace the standard insulation with premium insulation.

If the insulation is 1-5/16 inch (34 mm) thick, and there is an additional 1/4 inch (6 mm) thick insulation blanket present, the vehicle has premium insulation. Continue with the next step.



Fig. 3, Measuring Cab Roof Insulation Thickness

8. Install the fir-tree fasteners on both sides of the overhead storage compartment.
9. Install the overhead storage compartment trim.
10. Install the sleeper curtain rail.
11. Connect and install the cab dome light.
12. Clean a spot on the base label (Form WAR259), and attach a completion sticker (Form WAR 261) for campaign SF489 to the base label.

Premium Insulation Installation

NOTE: Have the customer remove all items from the sleeper storage cabinets (if so equipped).

1. If the vehicle is equipped with sleeper storage cabinets, remove the passenger seat to make room for cabinet removal. Refer to "Seat Removal and Installation" in these Work Instructions. See page 12.
2. Remove the storage cabinets, if so equipped. Refer to "Storage Cabinet Removal and Installation" in these Work Instructions. See page 14.
3. Remove the upper bunk or the rear storage cabinet, as applicable. For upper bunk removal, refer to "Upper Bunk Removal and Installation" in these Work Instructions. See page 18.

4. Remove the screws that secure the cab privacy curtain rails. Remove the rails and curtains. See **Fig. 4**.
5. Remove the side consoles and disconnect the speakers (if so equipped).
6. Remove the side storage bins (if equipped), located above the side consoles, as follows:
 - 6.1 Remove the fir-tree fasteners on the bottom of the storage bins, then remove the bin liner.
 - 6.2 Remove the two screws that secure the storage bin, then remove the bin.
7. Remove the screws that attach the overhead storage compartment to the roof cap.

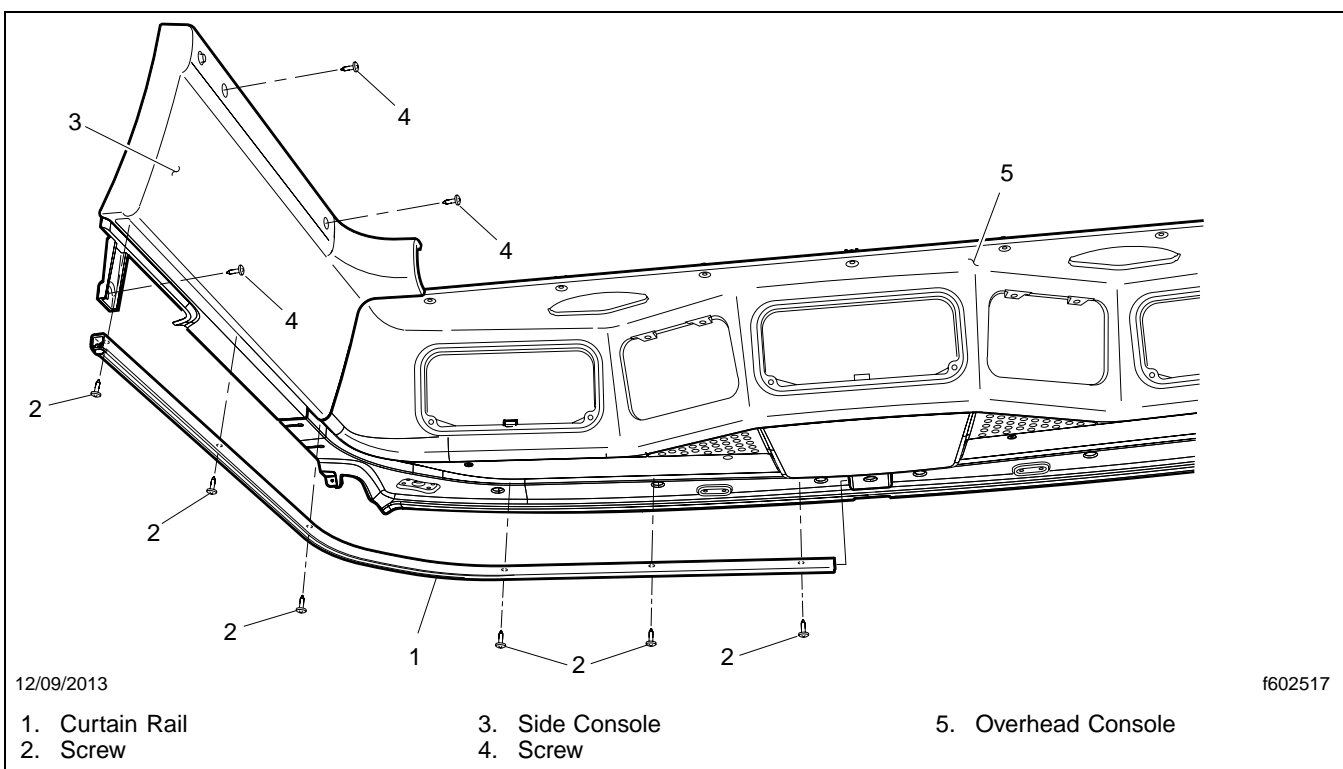


Fig. 4, Cab Privacy Curtains and Side Consoles

8. Remove the rear sleeper dome lights, if so equipped (see **Fig. 5**), as follows:
 - 8.1 Pop off the lens.
 - 8.2 Remove the two screws that attach the lamp housing to the sleeper roof.
 - 8.3 Disconnect the wiring.

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NOTE: Pulling the panel loose by the edges will pull the quarter-turn panel retainers loose from the fiberboard backing of the panel. If this happens the retainers will have to be installed back into the fiberboard before panel installation.

9. If the vehicle is a raised roof model, remove the sleeper rear trim panel, as follows:
 - 9.1 Remove the upper bunk latches (**Fig. 5**, item 6).
 - 9.2 Remove the fir-tree fasteners from the trim panel. See **Fig. 6**.
 - 9.3 Reach behind the panel with a panel removal tool, and pull the quarter-turn panel retainers loose from the back wall, leaving them installed on the fiberboard backing of the trim panel. See **Fig. 6**, item 1 for locations. Remove the panel.

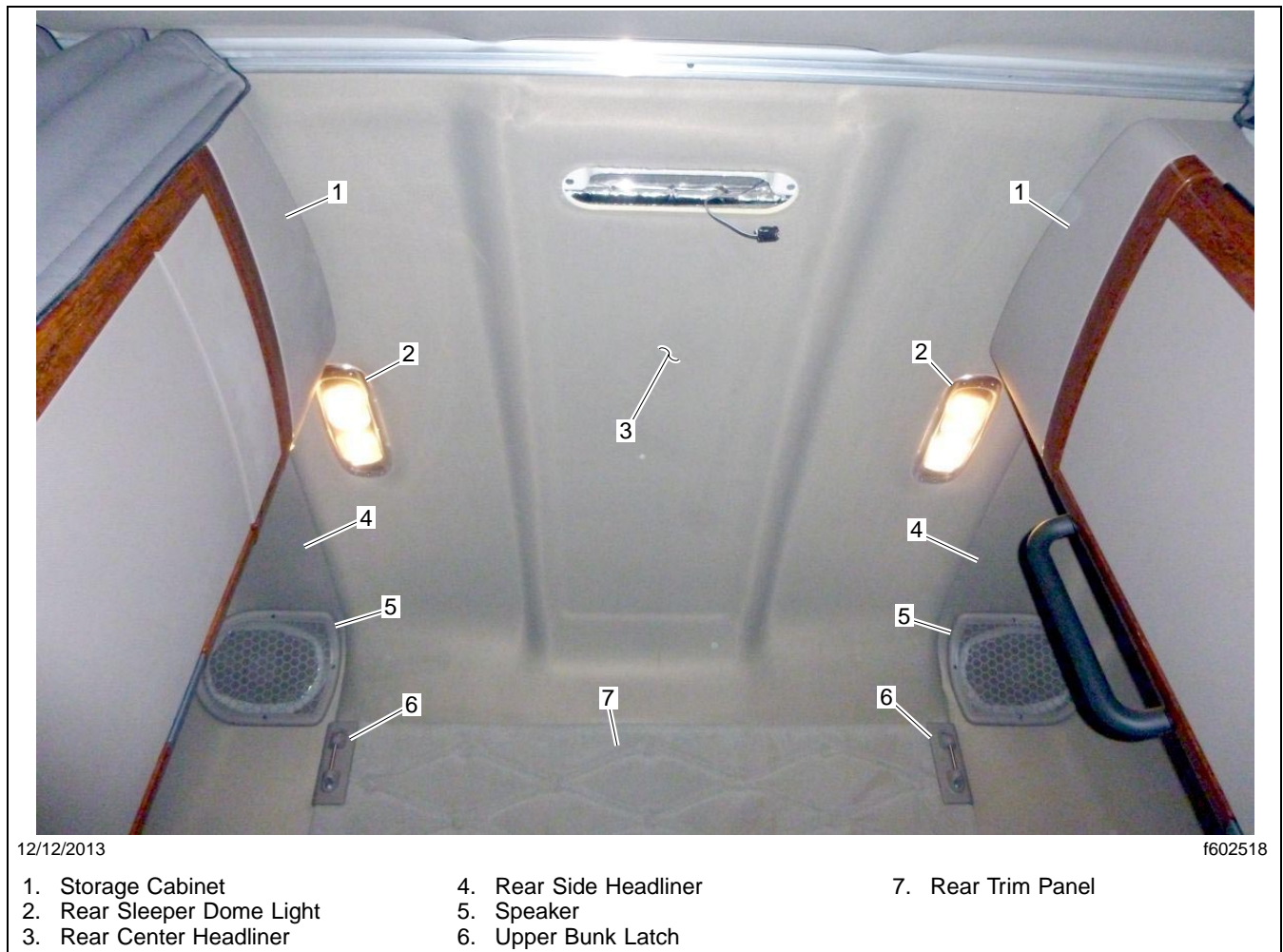


Fig. 5, Sleeper Roof (raised roof model shown)

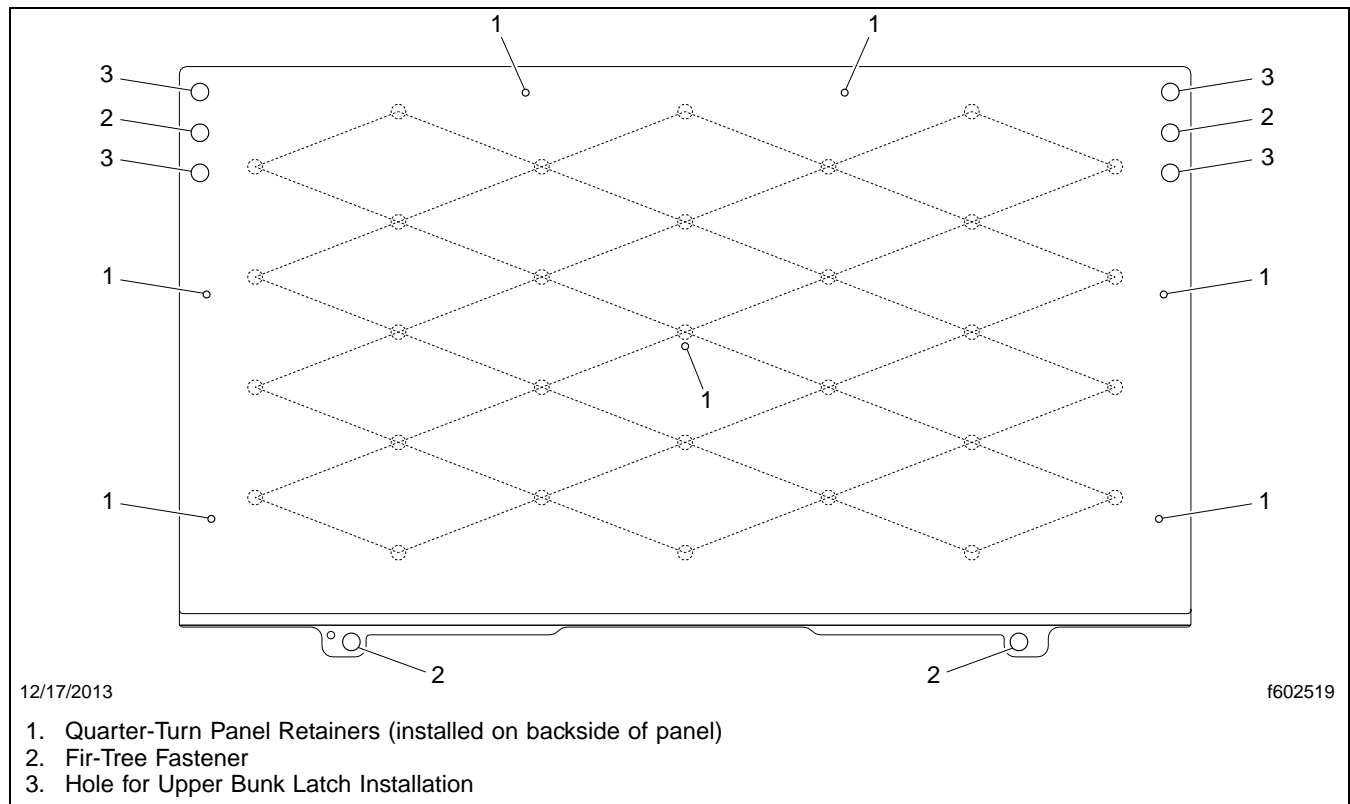


Fig. 6, Rear Trim Panel Fasteners

10. Remove the sleeper window trim.
11. Remove the bunk restraint from the halo trim panel.
12. Disengage the rear halo trim panel spring clips, and pull the panel up to disengage it from the wall brackets.
13. Remove the side halo trim panels.
14. Remove the speaker trim (if equipped) from the rear side headliners.
15. Remove the forward center headliner.
16. Remove the rear center headliner.
17. Remove the fir-tree fasteners that attach the forward side headliners to the cab walls. Remove the headliners.
18. Remove the rear side headliners.

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19. Replace the standard insulation inserts with the premium inserts. Use Silaprene® (or equivalent) spray adhesive to attach the inserts to the roof cap.
- See **Fig. 7** for 48-inch XT roof cap insulation inserts.
 - See **Fig. 8** for 60-inch XT roof cap insulation inserts.
 - See **Fig. 9** for 72-inch XT roof cap insulation inserts.
 - See **Fig. 10** for 72-inch raised roof cap insulation inserts.

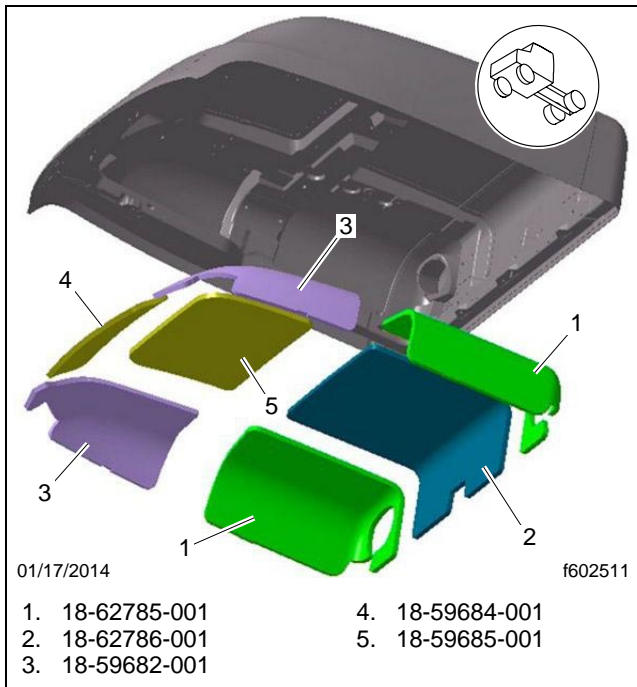


Fig. 7, 48-Inch XT Roof Cap Insulation Inserts

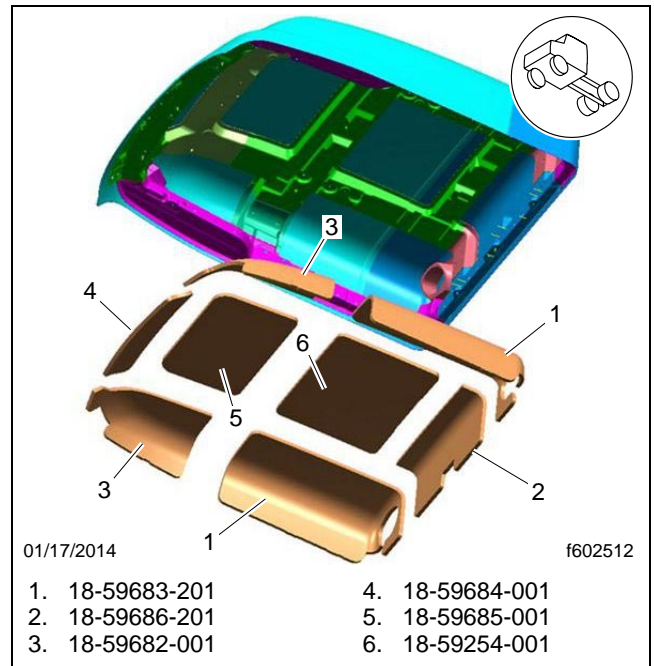


Fig. 8, 60-Inch XT Roof Cap Insulation Inserts

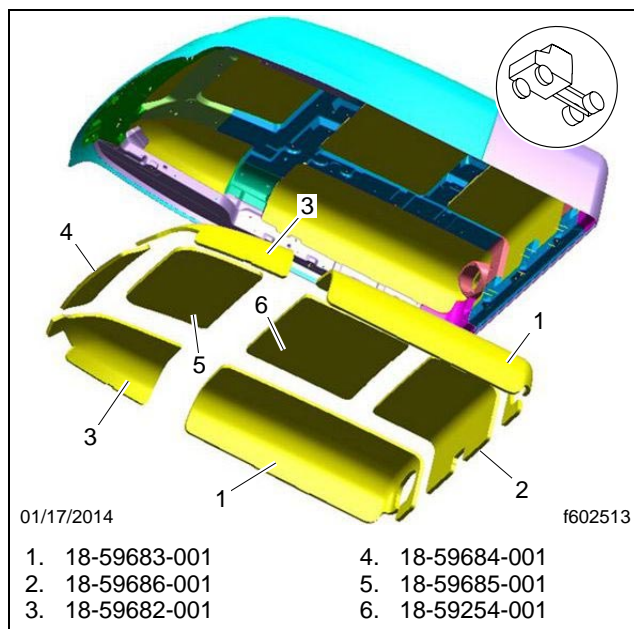


Fig. 9, 72-Inch XT Roof Cap Insulation Inserts

20. Using the Silaprene adhesive, install the premium insulation blankets on top of the premium inserts. For part identification, see **Fig. 11** or **Fig. 12**, as applicable.

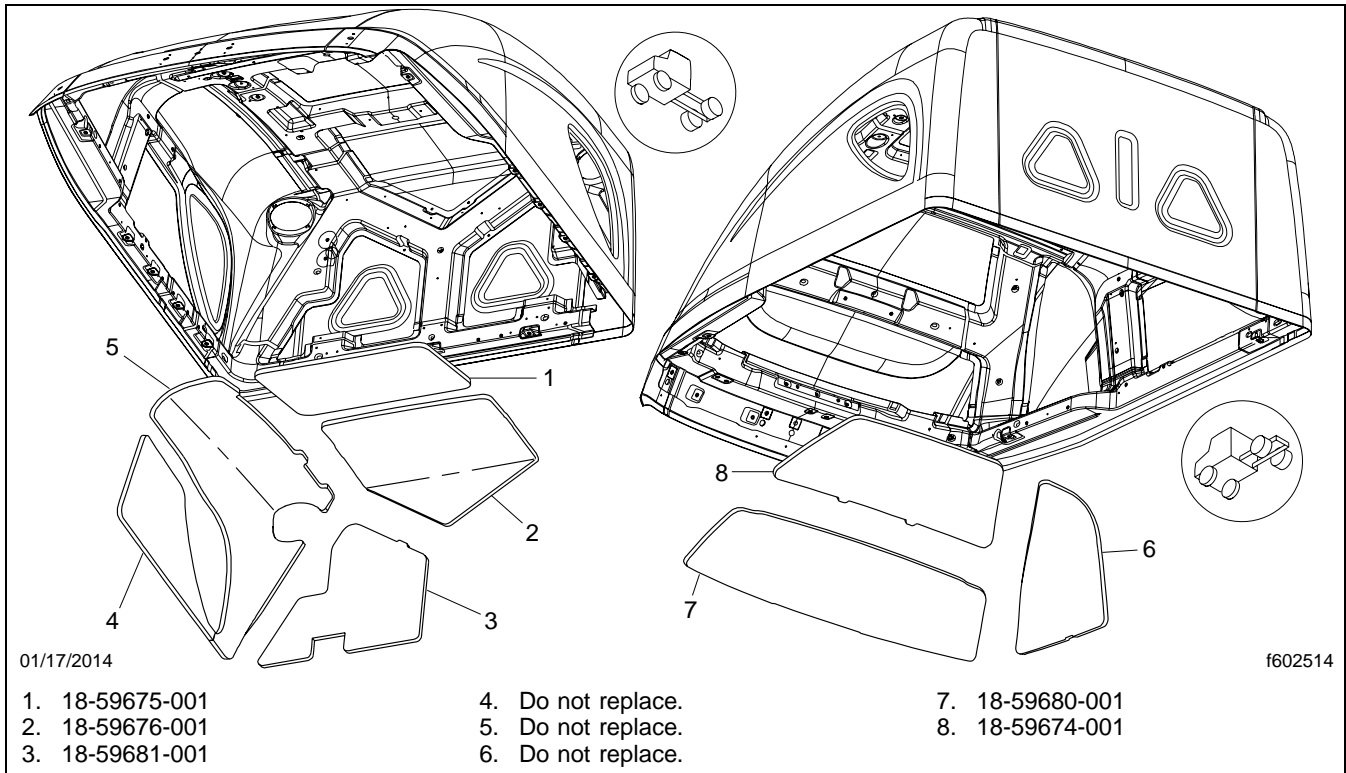


Fig. 10, 72-Inch Raised Roof Cap Insulation Inserts

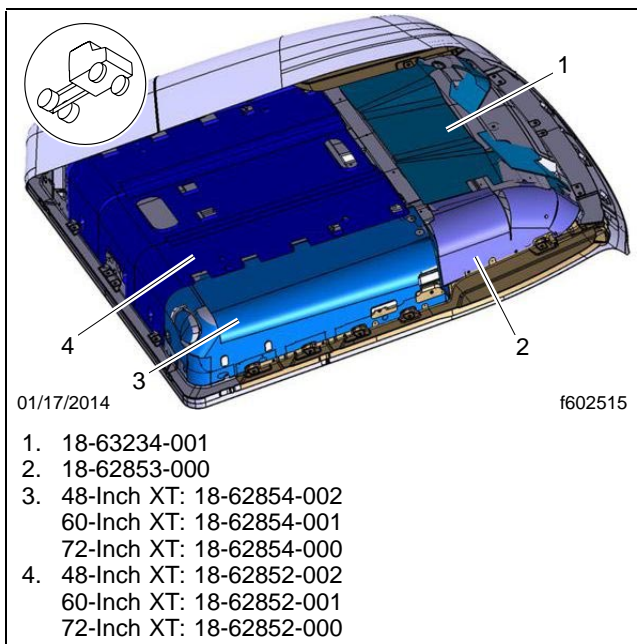


Fig. 11, XT Roof Cap Premium Insulation Blankets

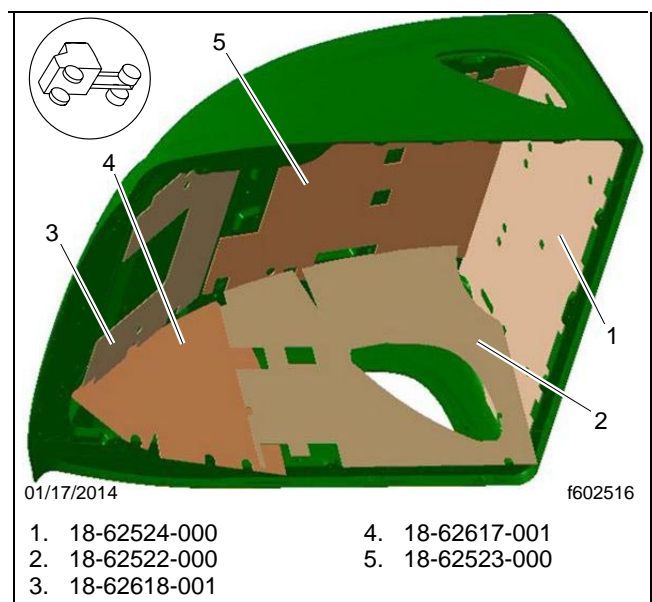


Fig. 12, Raised Roof Cap Premium Insulation Blankets

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21. Install the rear side headliners.
22. Install the forward side headliners.
23. Install the rear center headliner.
24. Install the forward center headliner.
25. Install the rear speaker trim.
26. Install the side halo trim panels.
27. Engage the back of the rear halo trim panel with the wall brackets, and push the panel into place.
28. Install the bunk restraint on the halo trim.
29. Install the sleeper window trim.
30. If the vehicle is a raised roof model, install the sleeper rear trim panel, as follows:
 - 30.1 If any of the quarter-turn panel retainers came loose from the fiberboard backing of the trim panel, insert them first into the fiberboard backing (quarter turn to insert). See **Fig. 6**, items 1, on page 9.
 - 30.2 Push the trim panel into place on the back wall, making sure the quarter-turn panel retainers are installed into the back wall.
 - 30.3 Install the fir-tree fasteners on the trim panel.
 - 30.4 Install the upper bunk latches.
31. Connect and install the sleeper dome lights, if so equipped.
32. Install the overhead storage compartment.
33. Using two screws for each, install the side storage bins, then install the bin liners and the push fasteners in the bottoms of the bins.
34. Connect the speakers and install the side consoles. See **Fig. 4**, on page 7.
35. Install the cab privacy curtain rails (if so equipped).
36. Install the upper bunk or the rear storage cabinet, as applicable. For upper bunk installation, refer to "Upper Bunk Removal and Installation" in these Work Instructions. See pages 18 and 19.
37. Install the storage cabinets, if so equipped. Refer to "Storage Cabinet Removal and Installation" in these Work Instructions. See pages 14 through 17.
38. If removed, install the passenger seat. Refer to "Seat Removal and Installation" below.
39. Install the trim on the front overhead storage compartment.
40. Install the sleeper curtain rail.
41. Connect and install the cab dome light.
42. Clean a spot on the base label (Form WAR259), and attach a completion sticker (Form WAR 261) for campaign SF489 to the base label.

Seat Removal and Installation

Removal

1. Adjust the seat to the maximum height.
2. To secure the seat suspension in the extended position, bind the two cross-rods together with a large tie strap, at either the top or bottom of the fully extended scissor arms.

CAUTION

Do not remove the seat without first draining the seat air spring, and holding the seat suspension extended by securing the cross-rods together at either the top or bottom of the fully extended scissor arms. If the seat suspension is not properly secured, the seat could lower unexpectedly, pinching a hand or finger between the suspension parts, resulting in personal injury.

3. Drain the vehicle air reservoirs.

WARNING

Air lines under pressure can whip dangerously if disconnected. Drain all air from the air tanks before disconnecting air lines. Disconnecting pressurized air lines can cause personal injury and/or property damage.

4. Disconnect the power supply from the seat, if applicable. See Fig. 13.
5. Disconnect the air supply tubing from the quickconnect union behind the seat.
6. Remove the Torx® screws that attach the seat belt and tether belts to the intermediate-connection-point (ICP) bar. See Fig. 14.

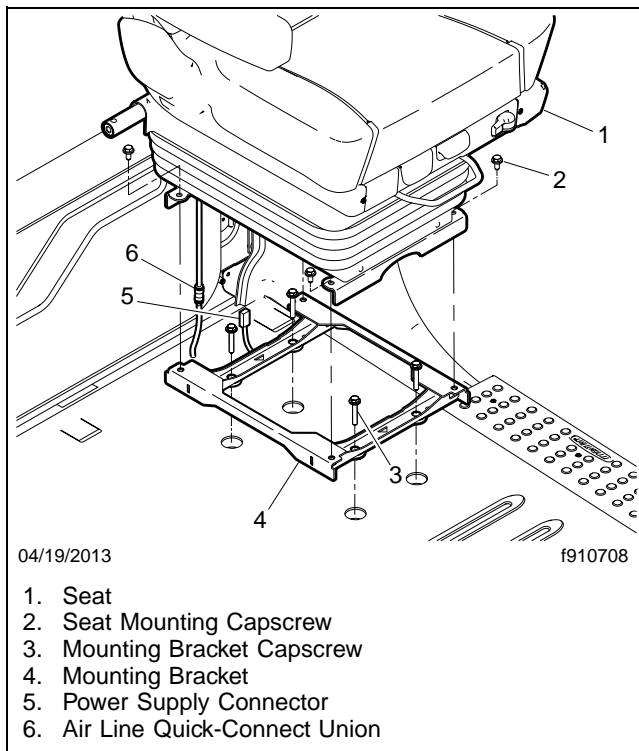


Fig. 13, Seat Installation

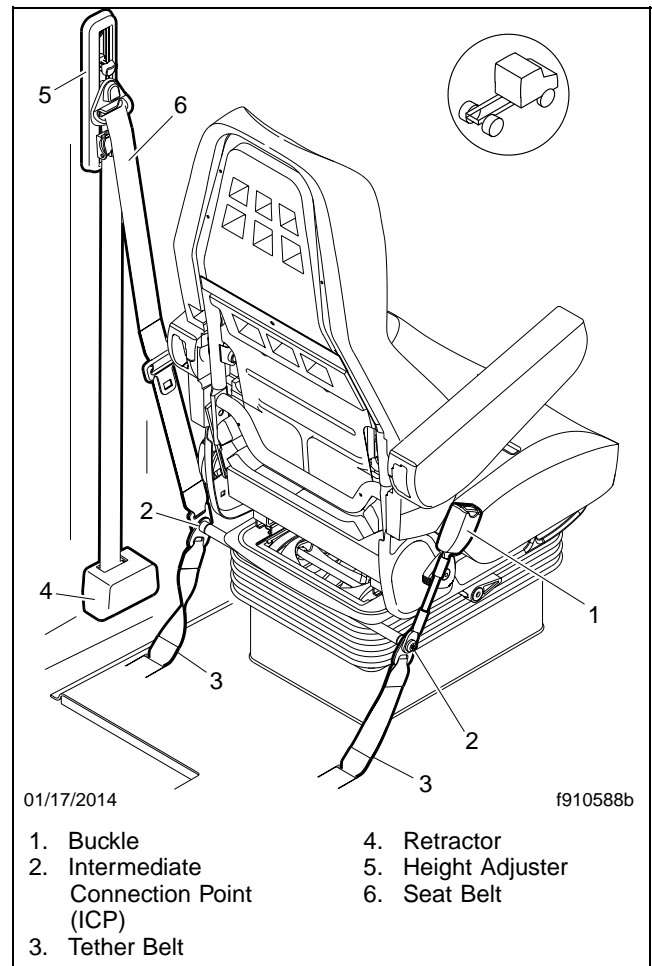


Fig. 14, Seat Belt Installation, Air Suspension Seats

7. Remove the four capscrews that attach the seat to the mounting bracket. Remove the seat from the cab.
8. Return to Premium Insulation Installation procedure, step 2 on page 6.

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Installation

1. Position the seat on the mounting bracket. Attach the seat to the mounting bracket with four capscrews. See **Fig. 13**. Tighten the capscrews 11 to 13 lbf-ft (15 to 18 N·m).
2. Attach the seat belt and tether belts to the intermediate-connection-point (ICP) bar. See **Fig. 14**. Tighten the Torx screws 35 to 50 lbf-ft (48 to 68 N·m).
3. Connect the air supply by pressing the tubing into the quick-connect union behind the seat.
4. Plug in the power supply to the seat, if applicable.
5. Start the engine and allow the air reservoirs to fill. Adjust the seat to its maximum height, then remove the tie strap that binds either the top or bottom cross-rods together.
6. Return to Premium Insulation Installation procedure, step 39 on page 12.

Storage Cabinet Removal and Installation

Removal

The right-side and left-side storage cabinets are slightly different, but the procedures are similar.

1. Fold up the upper bunk.
2. Lift up the lower bunk.
3. Remove the refrigerator, if so equipped.
4. Remove the sleeper switch panel wiring cover, if so equipped, from inside the cabinet by removing the two Torx screws that attach it to the cabinet assembly. See **Fig. 15**.
5. Remove the sleeper switch panel, if present. Disconnect the auxiliary HVAC, lights, and radio control from the back of the switch panel.
6. Pull the sleeper control panel wiring down through the hole between the compartments into the bottom compartment, and place it out of the way, in the lower compartment.
7. Remove the seat belt attached to the B-pillar in front of the cabinet, as follows:
 - 7.1 Remove the cover from the seat belt retractor. See **Fig. 16**.
 - 7.2 Detach the retractor from the B-pillar interior panel and the cab wall by removing the screw at the bottom of the retractor cover.
 - 7.3 Remove the two screws that attach the upper seat belt mount to the B-pillar panel and the cab wall. See **Fig. 17**.
8. Remove the grab handle by removing the fasteners that attach the grab handle to the B-pillar cover and the cab wall.
9. Remove the tread plate by removing the three screws that attach it to the door frame.
10. Remove the interior B-pillar cover, as follows:
 - 10.1 Remove the screw that attaches the interior B-pillar cover to the bottom of the door opening.
 - 10.2 Remove the Christmas-tree fasteners that attach the cover to the B-pillar.
 - 10.3 Pull the cover off the B-pillar.
11. Remove the two Torx screws and washers that attach the brackets at the top of the cabinet to the sleeper roof. See **Fig. 18**
12. Loosen the screws that attach the brackets to the cabinet assembly, and slide the brackets down.

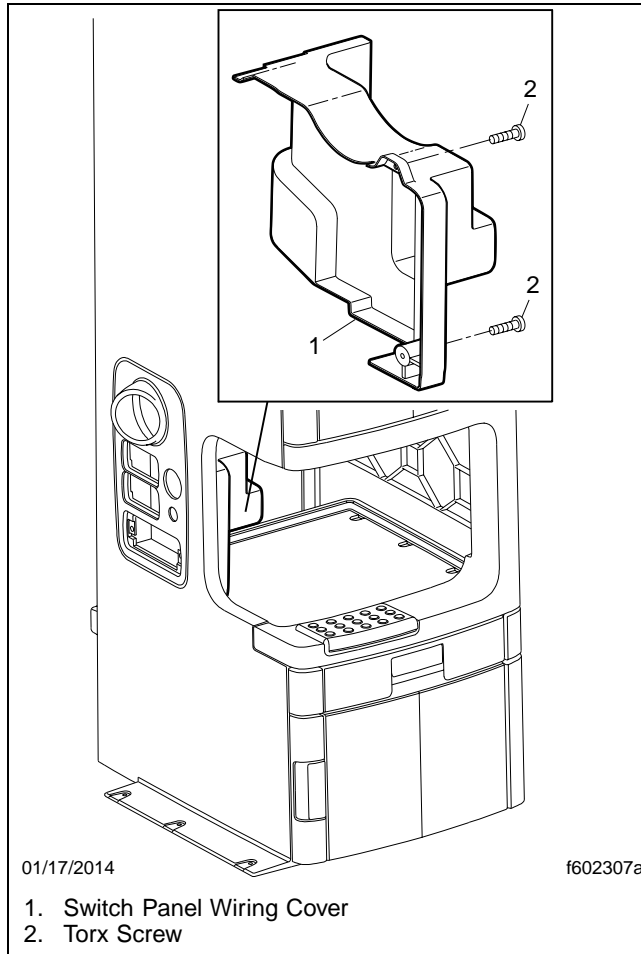


Fig. 15, Sleeper Switch Panel Wiring Cover

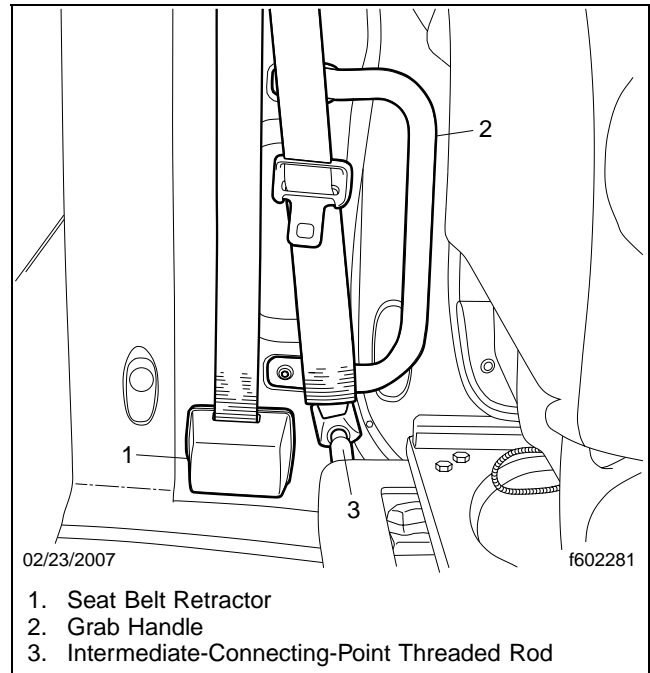


Fig. 16, Grab Handle and Seat Belt Installation

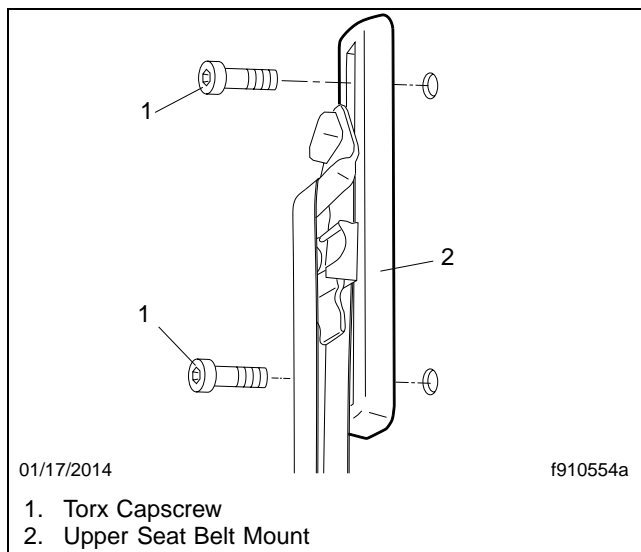


Fig. 17, Upper Seat Belt Mount

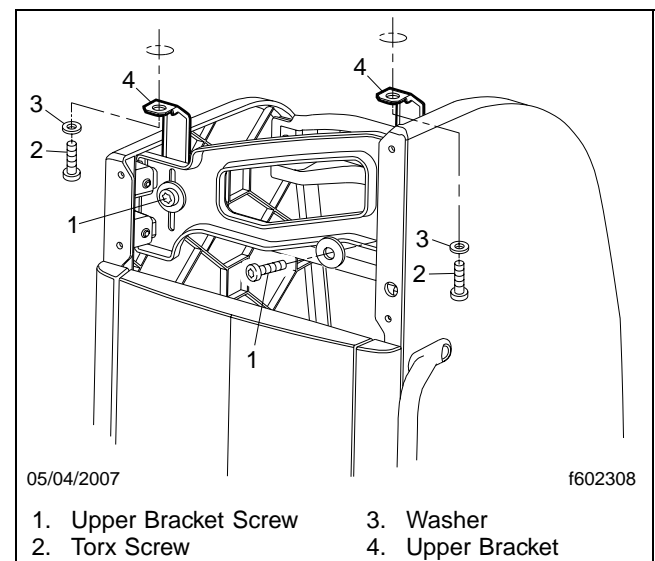


Fig. 18, Upper Cabinet Fasteners

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13. Remove the two screws and washers that attach the cabinet to the cab side wall behind the seat. See **Fig. 19**.
14. Inside the cabinet, remove the screws and washers that attach the cabinet to the sleeper wall. See **Fig. 20**.

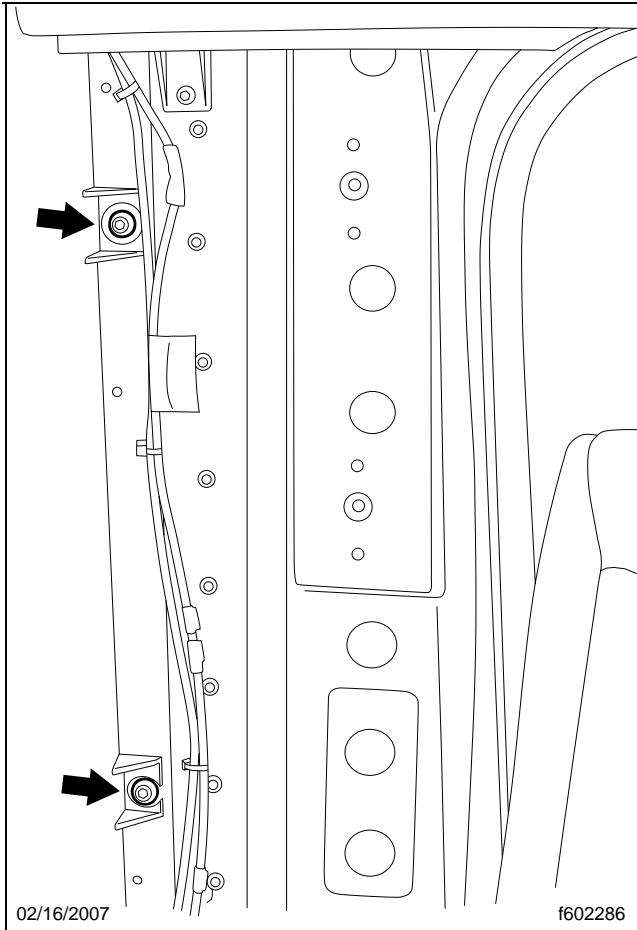


Fig. 19, Cabinet-to-Side Wall Fasteners Behind Seat

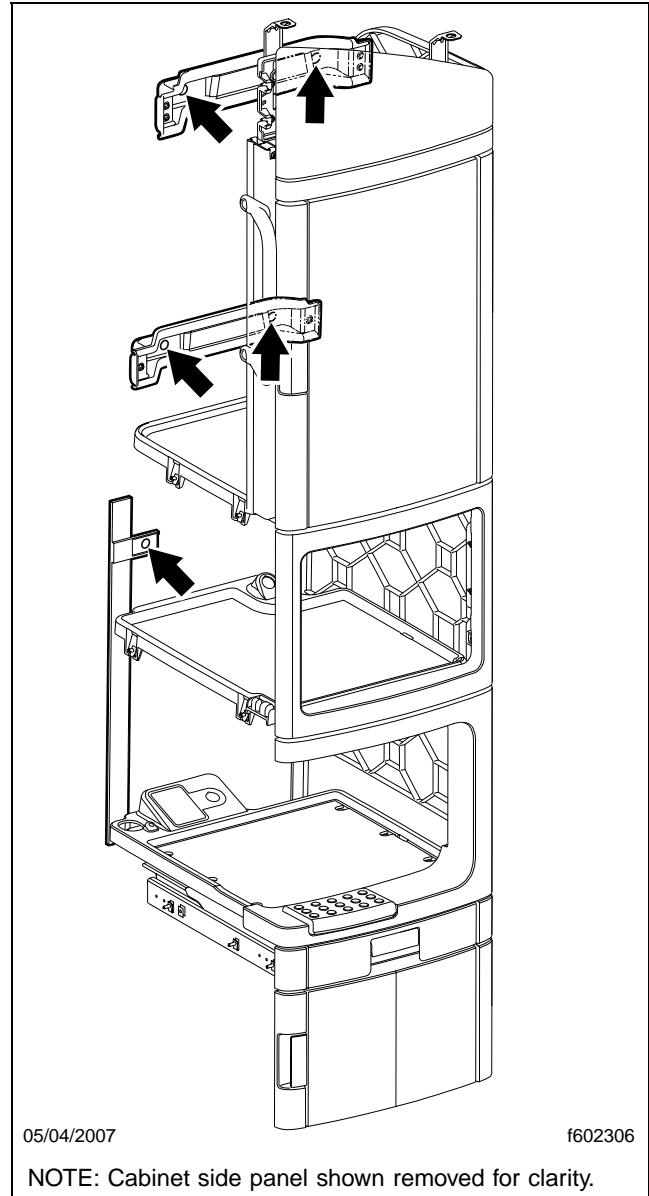


Fig. 20, Cabinet-to-Sleeper Wall Fasteners Inside Cabinet

15. Remove the upper cabinet from the lower cabinet or the auxiliary HVAC housing, as follows:
 - To remove the upper cabinet from the lower cabinet, remove the six screws and washers from inside the upper cabinet.
 - To remove the upper cabinet from the auxiliary HVAC housing, remove the three screws from inside the upper cabinet, and the three screws aft, outside the cabinet. See **Fig. 21** and **Fig. 22**.
16. Return to Premium Insulation Installation procedure, step 3 on page 6.

Installation

1. Install the upper cabinet on top of the lower cabinet or auxiliary HVAC housing, as applicable. To attach the upper cabinet to the lower cabinet, install the six screws and washers inside the upper cabinet. To install the upper cabinet to the auxiliary HVAC housing, install the three screws inside the upper cabinet, and the three screws aft, outside the cabinet. See **Fig. 21** and **Fig. 22**.

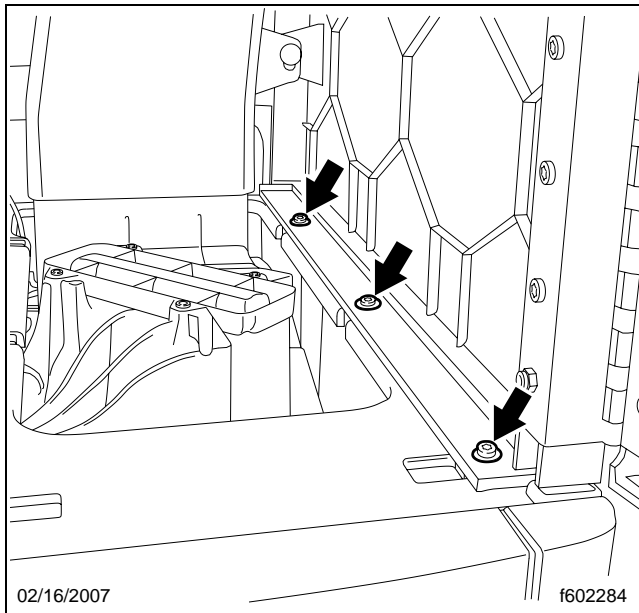


Fig. 21, Upper Cabinet-to-Auxiliary HVAC Housing Fasteners, Inside Cabinet

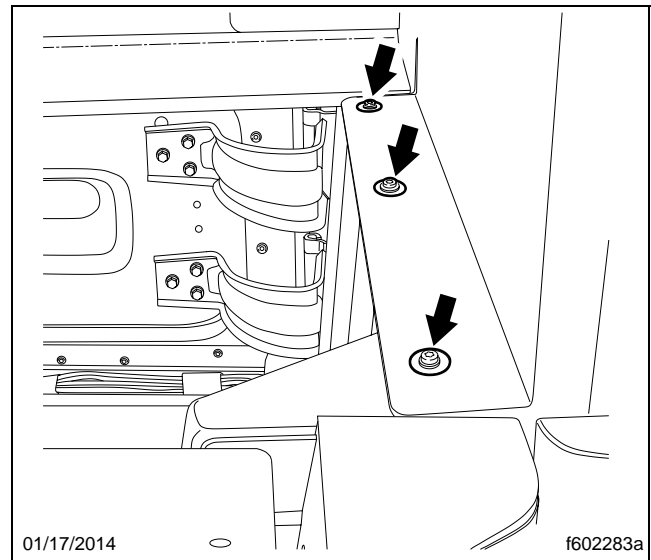


Fig. 22, Cabinet-to-Auxiliary HVAC Housing Fasteners, Aft Side

2. Inside the cabinet, install the screws and washers that attach the cabinet to the sleeper wall. See **Fig. 20**.
3. Install the two screws and washers that attach the cabinet to the cab wall behind the seat. See **Fig. 19**.
4. Slide up the two brackets at the top of the cabinet, and using the screws and washers, attach them to the sleeper roof. See **Fig. 18**.
5. Tighten the screws that attach the two brackets to the cabinet assembly.
6. Install the B-pillar cover, as follows:
 - 6.1 Position the B-pillar cover on the side wall.
 - 6.2 Attach the cover to the B-pillar with Christmas-tree fasteners.
 - 6.3 Attach the B-pillar cover to the bottom of the door opening with a screw.
7. Attach the tread plate to the bottom of the door opening with three screws.
8. Attach the grab handle, using two screws, to the B-pillar cover and the cab side wall. See **Fig. 16**.
9. Install the seat belt on the affected side, as follows:
 - 9.1 Install the upper seat belt mount on the B-pillar cover and the cab wall.
 - 9.2 Attach the seat belt retractor to the bottom of the B-pillar cover and the cab wall.
 - 9.3 Install the cover on the seat belt retractor.
 - 9.4 If the seat is installed, connect the seat belt to the intermediate-connecting-point threaded rod.

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10. Pull the sleeper switch panel wiring back through the hole between the compartments up into the main compartment.
11. Connect the wiring to the back of the sleeper switch panel. Attach the control panel to the cabinet.
12. Attach the sleeper switch panel wiring cover to the inside of the cabinet with two Torx screws. See **Fig. 15**.
13. Install the refrigerator, if so equipped.
14. Lower the lower bunk.
15. Return to Premium Insulation Installation procedure, step 38 on page 12.

Upper Bunk Removal and Installation

Removal

1. Remove the mattress from the upper bunk pan.
2. Unbuckle the bunk restraint, if so equipped, and move it out of the way.
3. Tilt the upper bunk up, and latch it securely.
4. Remove the bunk lights (if so equipped) from the "halo" trim panel corners, as follows: See **Fig. 23**
 - 4.1 Snap off the lens from the light fixture.
 - 4.2 Remove the light fixture from the trim panel.
 - 4.3 Disconnect the electrical wiring from the light fixture.

NOTE: If there is no light fixture under the upper bunk bracket, pop off the plastic plug.

5. Through the light-fixture opening, remove the nuts that attach the bunk to the bracket at each end of the bunk. See **Fig. 24**.
6. Cover the brackets, studs, and latches on the bunk with protective cloth, and remove the bunk from the cab.
7. Return to Premium Insulation Installation procedure, step 4 on page 7.

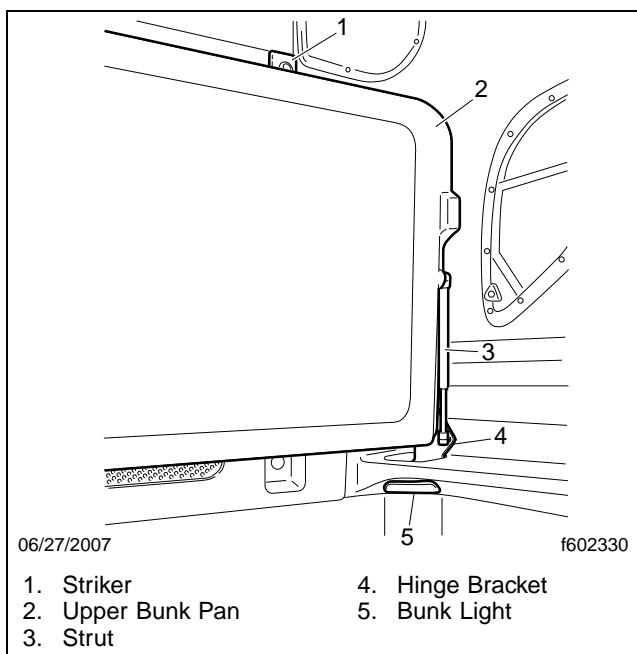


Fig. 23, Upper Bunk (shown folded up)

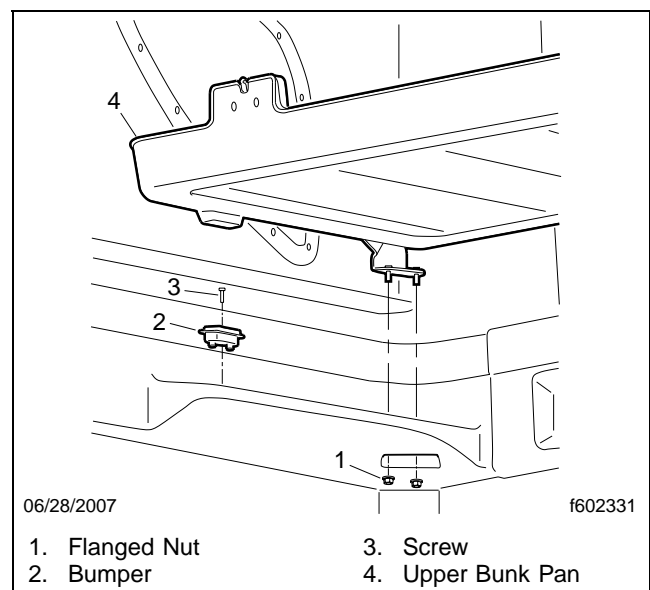


Fig. 24, Upper Bunk Installation

Installation

1. Place the upper bunk in the sleeper, remove the protective cloth, and make sure that the studs on the bunk hinge brackets are positioned through the holes in the support brackets. Latch the bunk strikers to the back wall.
2. Through the light-fixture opening, install the nuts on the studs. See **Fig. 24**.
3. Install the light fixtures, if so equipped, as follows: See **Fig. 23**.
 - 3.1 Connect the electrical wiring to the light fixture.
 - 3.2 Install the light fixture in the opening.
 - 3.3 Snap the lens on the light fixture.

NOTE: If there is no light fixture, install the plastic plug in the opening.

4. Unlatch and lower the bunk.
5. Place the mattress on the bunk.
6. Return to Premium Insulation Installation procedure, step 37 on page 12.