

General Information

Modine Manufacturing has changed their procedure for replacing the tank gaskets on copper/brass bolted downflow radiators. See "Radiator Rebuilding" below for the current approved procedure. Replacing the tank(s) is no longer required. Adding silicone sealer to the gasket ends is no longer an acceptable practice.

Subject 20.02, 130 of the *Western Star Workshop Manual* is revised to reflect these changes.

Radiator Rebuilding

Refer to [Fig. 1](#) for this procedure.

1. Remove the radiator from the vehicle. For instructions, refer to [Subject 20.02, 100](#) of the *Western Star Workshop Manual*.
2. Remove the CAC.
3. Remove and discard the tank bolts, nuts, gaskets, and bolting bars. Do not reuse these items.
4. Clean the gasket sealing surfaces.
5. Position the gasket segments.

NOTICE

Proper installation of fasteners is critical. Failure to install the fasteners in the correct position and orientation may cause damage to the radiator.

6. Position the tank, new bolting bars, and new hardware as shown in [Fig. 1](#).

NOTICE

Proper tightening sequence is necessary to prevent the radiator from leaking.

7. Tighten all of the bolts 25 to 29 lbf-ft (34 to 39 N·m) using one of the methods that follow.

With two people, starting at opposite corners of the radiator tank, each person tighten the bolts in a "U" shape around their side of the radiator as shown in [Fig. 2](#). Proceed at the same rate finishing where the other person started, then backtrack tightening each bolt a second time.

With one person, start at one corner and tighten every other bolt all the way around the tank until all bolts have been tightened twice.

8. Install the CAC. See [Fig. 1](#) for installation detail. Tighten the mounting nuts 26 lbf-ft (35 N·m).
9. Install the radiator. For instructions, refer to [Subject 20.02, 100](#) of the *Western Star Workshop Manual*.

Warranty

This bulletin is informational only. Warranty does not apply.

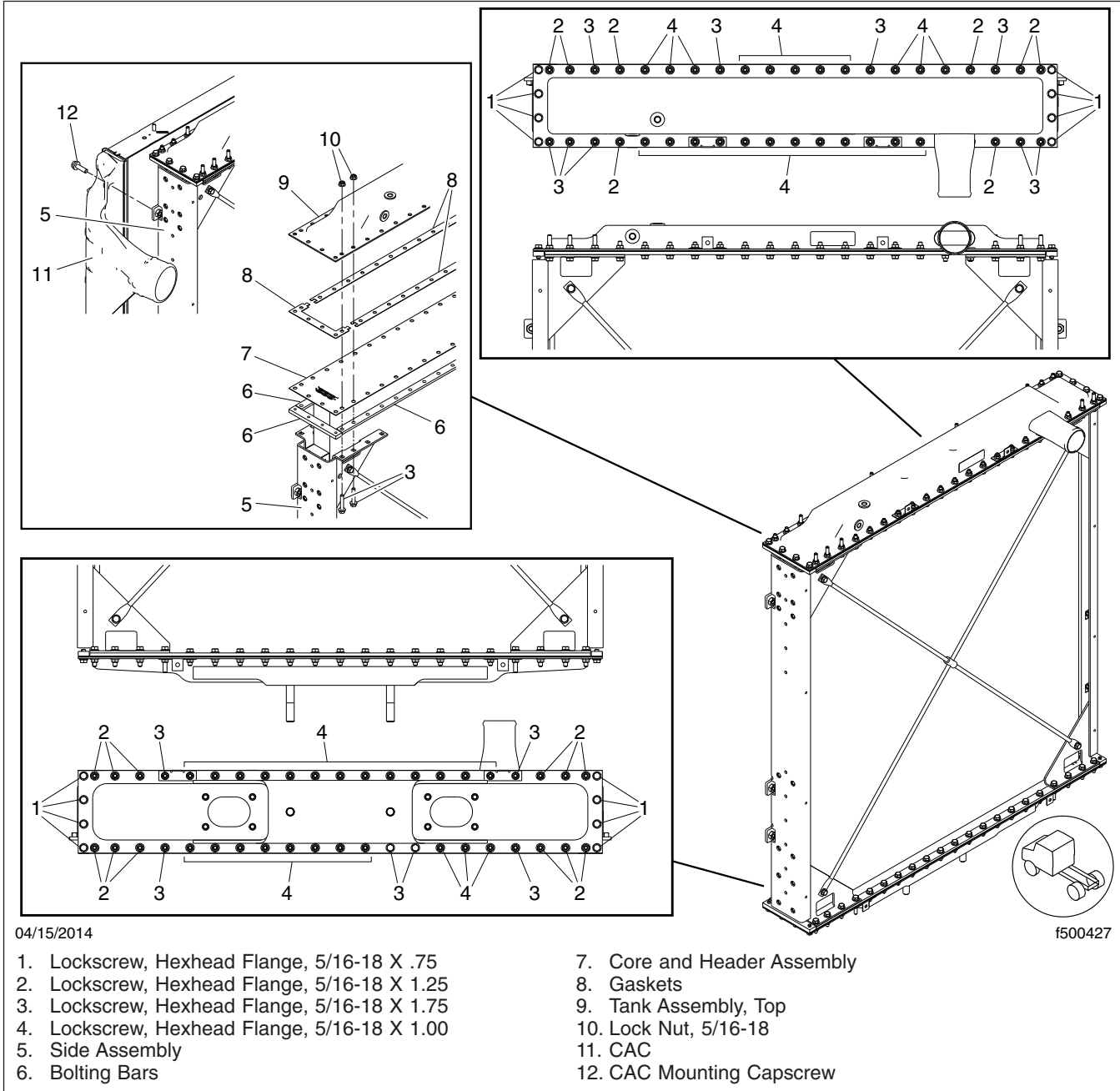


Fig. 1, Bolted Copper-Brass Downflow Radiator Assembly

> Constellation
 > Heritage
 > 4700 Models

4800 Models
 > 4900 Models
 5700 Models

5900 Models
 6900 Models

**Western Star
 Service Bulletin**

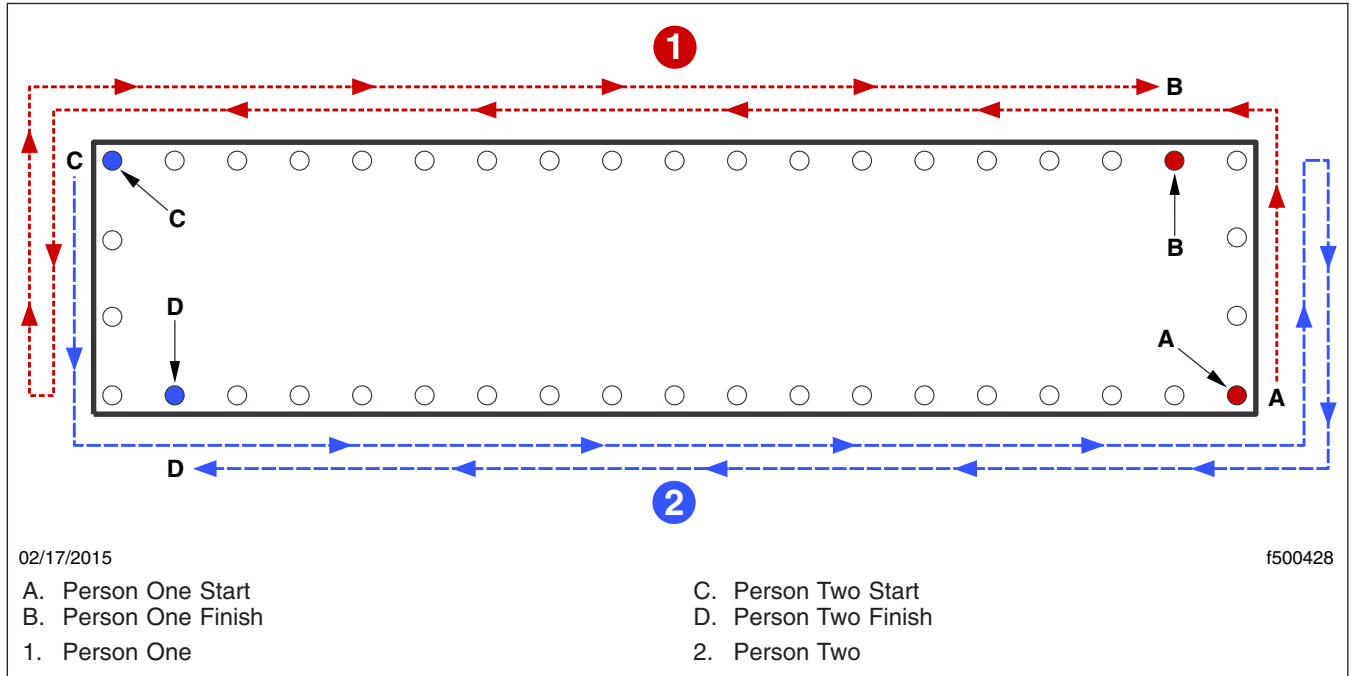


Fig. 2, Two-Person Tightening Sequence