

Subject: Freightliner Business Class M2 Transmission Cooler Lines.

Models Affected: Specific M2 vehicles manufactured January 15, 2015, through March 3, 2015, built with ISL Cummins Engine and Allison Automatic Transmission.

General Information

Daimler Trucks North America LLC, on behalf of its Freightliner Trucks Division, is initiating Field Service Campaign SF510A to modify the vehicles mentioned above.

On certain vehicles the transmission cooler line tube return was built with an incorrect fitting orientation.

The cooler line tube return will be replaced.

There are approximately 86 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 part number(s) listed below from your facing Parts Distribution Center.

If our records show your dealership has ordered any vehicle(s) involved in campaign SF510A, 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.

Table 1 - Replacement Parts for SF510A

Campaign Number	Part Number	Part Description	Qty. per Part
SF510A	07-23933-000	TUBE-RETURN,AUTO 3K,ISL,ITOC	1 ea
	BHT 91099	RETAINING CLIP	2 ea

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.

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Labor Allowance

Table 2 - Labor Allowance

Campaign Number	Procedure	Time Allowed (hours)	SRT Code	Corrective Action
SF510A	Replace Tube Return	6.4	996-0956A	12-Repair Recall/Campaign

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 OWL:

- Claim type is **Field Service Campaign**.
- In the Campaign field, enter the campaign number and appropriate group (**SF510-A**).
- In the Primary Failed Part field, enter **25-SF510-000**.
- In the Parts section, enter the appropriate part number(s) as shown in the Replacement Parts Table.
- In the Labor section, enter the appropriate SRT from the Labor Allowance Table. Administrative time will be included automatically as SRT 939-6010A for 0.3 hours.
- The VMRS Component Code is **026-013-017** and the Cause Code is **A1 - Campaign**.

This Field Service Campaign will **terminate on July 31, 2016**. Dealers will be notified of any changes to the termination date via Important Campaign Information Letter posted on AccessFreightliner.com.

IMPORTANT: 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.

For questions, 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.

Copy of Notice to Owners

Subject: Freightliner Business Class M2 Transmission Cooler Lines.

Daimler Trucks North America LLC, on behalf of its Freightliner Trucks Division, is initiating Field Service Campaign SF510A to modify specific M2 vehicles manufactured January 15, 2015, through March 3, 2015, built with ISL Cummins Engine and Allison Automatic Transmission.

On certain vehicles the transmission cooler return line was built with an incorrect fitting orientation.

The cooler return line will be replaced.

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.Daimler-TrucksNorthAmerica.com / Contact Us / Find a Dealer. The campaign will take approximately 6.5 hours and will be performed at no charge to you.

This Field Service Campaign will **terminate on July 31, 2016**. 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

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Work Instructions

Subject: Freightliner Business Class M2 Transmission Cooler Lines.

Models Affected: Specific M2 vehicles manufactured January 15, 2015, through March 3, 2015, built with ISL Cummins Engine and Allison Automatic Transmission.

Replacement Procedure

1. Check the base label (Form WAR259) for a completion sticker for SF510 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 completion sticker is present, no work is needed. If a completion sticker is not present, continue with the next step.
2. Park the vehicle on a level surface, shut down the engine and set the parking brake. Chock the tires.
3. Disconnect the batteries.
4. Drain the transmission fluid into a clean pan.
5. Disconnect the transmission cooler return line (**Fig. 1, item 2**) from the transmission.

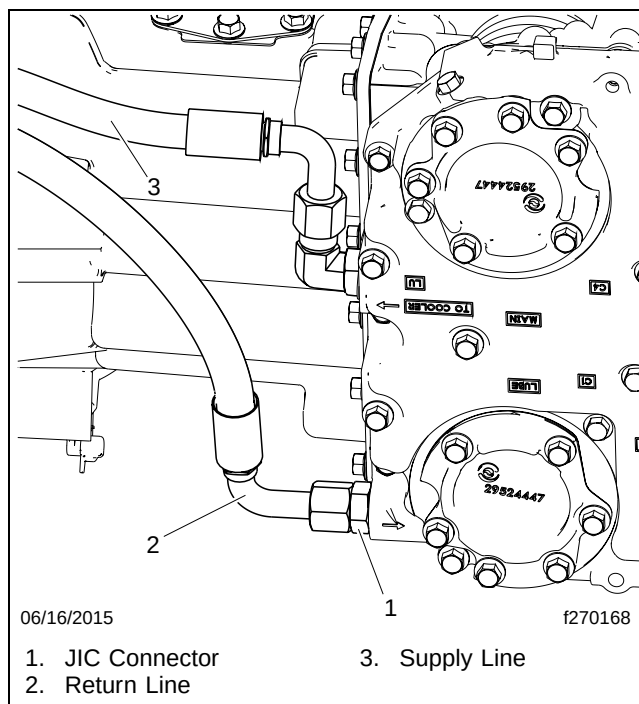


Fig. 1, Transmission Cooler Line Connections at the Transmission

6. Remove the bumper. See *Business Class M2 Workshop Manual*, **Section 31.01**.
7. Remove the hood. See *Business Class M2 Workshop Manual*, **Section 88.00, Subject 110**.
8. Remove the transmission cooler line support clamps.

9. Drain the radiator into a clean pan.
10. Disconnect the charge air cooler (CAC) hoses.
11. Remove the A/C condenser and the receiver-dryer. Do not evacuate the refrigerant, just remove the fasteners and set the components out of the way. Be sure to support the components so the refrigerant does not leak out, and the condenser fins are not damaged.
12. Disconnect the coolant hoses from the radiator.
13. Remove the upper fan shroud.
14. Remove the radiator fan.
15. Remove the radiator mounting fasteners, as follows:
 - 15.1 Loosen, but do not remove, the fasteners that attach the LH upper radiator mounting bracket to the engine.
 - 15.2 Remove the fasteners that attach the radiator to both the LH and RH upper radiator mounting brackets.
 - 15.3 Remove the lower radiator mounting nuts and washers.
16. Use a hoist to support the radiator assembly.
17. Disconnect both transmission cooler lines from the radiator, as follows:
 - 17.1 Pull back the safety collar. See **Fig. 2**
 - 17.2 Remove and discard the retaining clip.
 - 17.3 Over a drain pan, pull the line out of the fitting.

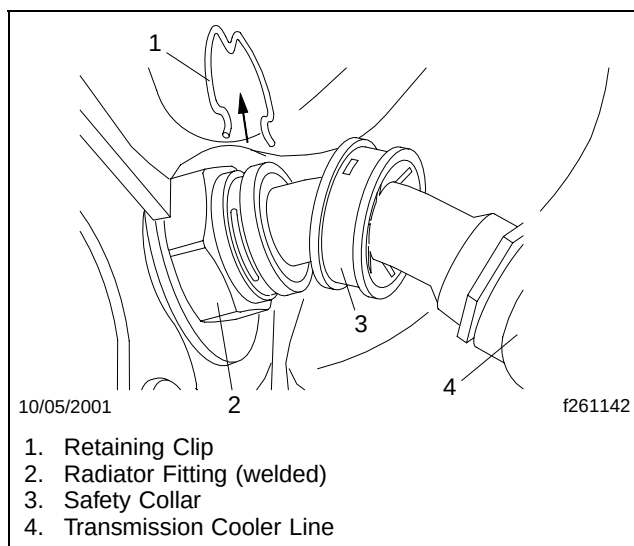


Fig. 2, Retaining Clip Removal

18. Raise the radiator assembly out of the way.
19. Extract and discard the transmission cooler line.
20. Insert the new transmission cooler line (07-23933-000) in position.
21. Make sure the O-ring in both radiator fittings is correctly positioned.
22. Install a new retaining clip (BHT 91099) in both radiator fittings.

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23. Lower the radiator into position.
24. Connect the new transmission cooler return line (07-23933-000) to the radiator, at the LH fitting, as follows:
 - 24.1 Push the end of the new line into the radiator fitting until it seats at the retaining clip. Gently pull the line to make sure it is fully seated.
 - 24.2 Push the safety collar around the fitting.
- NOTE: Do not connect the transmission cooler supply line (RH fitting) until the lower radiator mounting nuts have been tightened.
25. Tighten the radiator mounting bolts, as follows:
 - 25.1 Install the fasteners that attach the radiator to both the LH and RH upper radiator mounting brackets. Tighten the fasteners 79 lbf·ft (107 N·m).
 - 25.2 Tighten the fasteners that attach the LH upper radiator mounting bracket to the engine 46 lbf·ft (62 N·m).
 - 25.3 Install the lower radiator mounting nuts and washers. Tighten the nuts 119 lbf·ft (161 N·m).
26. Connect the transmission cooler supply line to the radiator, at the RH fitting, as follows:
 - 26.1 Push the end of the new line into the radiator fitting until it seats at the retaining clip. Gently pull the line to make sure it is fully seated.
 - 26.2 Push the safety collar around the fitting.
27. Install the transmission cooler line support clamps.
28. Connect the transmission cooler return line to the transmission. Tighten the fitting 70 to 78 lbf·ft (96 to 106 N·m).
29. Install the fan.
30. Install the upper fan shroud.
31. Connect the coolant hoses to the radiator.
32. Install the A/C condenser and the receiver-dryer.
33. Connect the CAC hoses.
34. Install the hood. See *Business Class M2 Workshop Manual*, **Section 88.00, Subject 110**.
35. Install the bumper. See *Business Class M2 Workshop Manual*, **Section 31.01**.
36. Fill the cooling system with the recovered coolant. If needed, top off the system with approved coolant.
37. Fill the transmission with the recovered fluid. If needed, top off the system with approved fluid..
38. Connect the batteries.
39. Start the engine and confirm that the fluid is at the minimum operating level.
40. Let the transmission reach normal operating temperature, inspect the fluid level again, and adjust if necessary.
41. Clean a spot on the base label (Form WAR259), and attach a completion sticker (Form WAR 261) for campaign SF510 to the base label.