

Subject: Freightliner Argosy and Coronado Axle Tower Brackets - Export Only

Models Affected: Specific Freightliner Argosy and Coronado vehicles manufactured January 1, 2010, through December 7, 2015, equipped with Neway AD 246 rear suspension and Meritor RT-52-185 tandem rear axle.

General Information

Daimler Trucks North America LLC, on behalf of its Freightliner Trucks Division, is initiating Field Service Campaign SF516A to modify the vehicles mentioned above.

Certain vehicles may have an incorrect transverse torque rod tower bracket installed on the rearmost drive axle. An incorrect axle tower bracket results in poor alignment of the transverse torque rod and premature failures of the transverse rod tapered pin and/or bushing.

The axle tower bracket on the rearmost drive axle and the transverse torque rod will be replaced.

REVISION: A certified welder is required to complete this repair. If no certified welder is on-site, then sublet this portion of the repair. The maximum sublet amount is 450 USD. Sublet charges will be entered in the "other" section of Recall claim, with the invoice attached.

There are approximately 329 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 SF516A, 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.

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Table 1 - Replacement Parts for SF516

Campaign Number	Kit Number	Part Description	Part Number	Qty. per Kit
SF516A	25-SF516-000	BRKT-TRKBAR,TIMKN R170/ WHT134C	11-09696-000	1 ea
		CTRL ROD-TP,438,24.75,.65,113	IPC 942181	1 ea
		SCREW-CAP,HEX5/8-11X5.00 GR8PO	23-09444-500	2 ea
		WASHER- HRDN,0.69X1.31X.177,ZN	23-09114-000	4 ea
		NUT-HEX,PT,5/8-11,C,ZN/AL,.559	23-13833-110	2 ea
		COMPLETION STICKER	WAR261	1 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.

Labor Allowance

Table 2 - Labor Allowance

Campaign Number	Procedure	Time Allowed (hours)	SRT Code	Corrective Action
SF516A	Replace axle tower bracket and transverse torque rod	3.5	996-0965A	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:

REVISION: A certified welder is required to complete this repair. If no certified welder is on-site, then sublet this portion of the repair. The maximum sublet amount is 450 USD. Sublet charges will be entered in the "other" section of Recall claim, with the invoice attached.

- Claim type is **Field Service Campaign**.
- In the Campaign field, enter the campaign number and appropriate group (**SF516-A**).
- In the Primary Failed Part field, enter **25-SF516-000**.
- In the Parts section, enter the appropriate kit 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.
- In the Other section, enter the total sublet amount. Attach the sublet invoice to the claim.
- The VMRS Component Code is **016-009-024** and the Cause Code is **A1 - Campaign**.

This Field Service Campaign will **terminate on January 31, 2017**. 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.

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Copy of Notice to Owners

Subject: Freightliner Argosy and Coronado Axle Tower Brackets - Export Only

Daimler Trucks North America LLC, on behalf of its Freightliner Trucks Division, is initiating Field Service Campaign SF516A to modify specific Freightliner Argosy and Coronado vehicles manufactured January 1, 2010, through December 7, 2015, equipped with Neway AD 246 rear suspension and Meritor RT-52-185 tandem rear axle.

Certain vehicles may have an incorrect transverse torque rod tower bracket installed on the rearmost drive axle. An incorrect axle tower bracket results in poor alignment of the transverse torque rod and premature failures of the transverse rod tapered pin and/or bushing.

The axle tower bracket on the rearmost drive axle and the transverse torque rod 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 three and a half hours and will be performed at no charge to you.

This Field Service Campaign will **terminate on January 31, 2017**. 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: Freightliner Argosy and Coronado Axle Tower Brackets - Export Only

Models Affected: Specific Freightliner Argosy and Coronado vehicles manufactured January 1, 2010, through December 7, 2015, equipped with Neway AD 246 rear suspension and Meritor RT-52-185 tandem rear axle.

REVISION: A certified welder is required to complete this repair. If no certified welder is on-site, then sublet this portion of the repair. The maximum sublet amount is 450.00 USD. Sublet charges will be entered in the "other" section of Recall claim, with the invoice attached.

Transverse Torque Rod And Tower Bracket Replacement

1. Check the base label (Form WAR259) for a completion sticker for SF516 (Form WAR261) 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 a completion sticker is not present, proceed to the next step.
2. Park the vehicle on a level surface. Shut down the engine, set the parking brake, and chock the tires.
3. Disconnect the batteries.
4. Cut off the zip ties on the rearmost axle transverse torque rod, noting the location of the zip ties, lines, and wires. Tie the wires and lines out of the way.

IMPORTANT: When removing fasteners, spacers, and shims, make sure the shims are stored so that they will be installed in the same place.

5. Remove the three mounting fasteners from the transverse torque rod and discard the rod and fasteners. Save the shims. See **Fig. 1**.

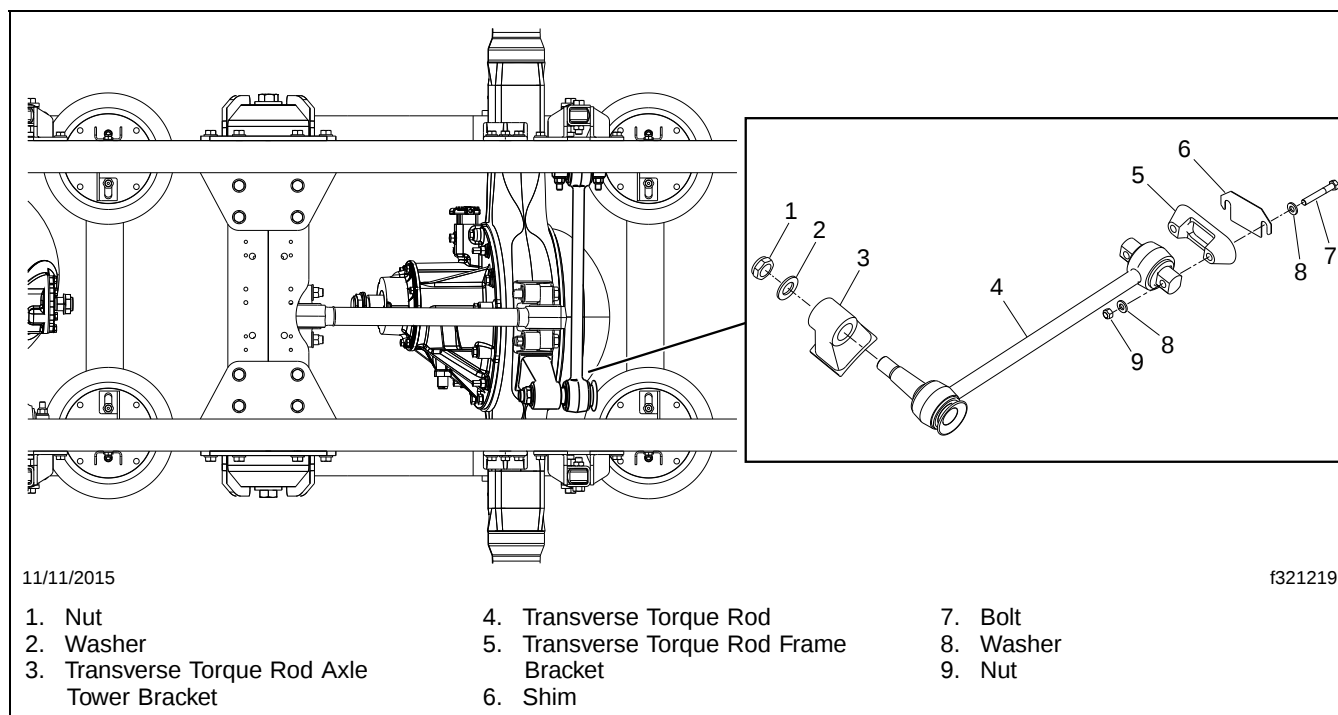


Fig. 1, Neway Suspension Rearmost Axle Assembly

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6. Use grinding cloths to cover up items that need to be protected from sparks, this includes air bags, electrical connections, hoses, and air lines.
7. Raise the rear of the truck to provide more clearance when accessing the torque rod tower bracket.

IMPORTANT: Remove the welds with minimal grinding on the axle housing.

8. Use a disc grinder to grind out the weld and remove the tower bracket. Discard the bracket.
9. Remove any weld residue, ridges, or ripples from the surface of the housing. All areas must be flat with the housing wall and bracket. Do not gouge or leave sharp edges on any surface.
10. Remove the paint in a 3-inch radius from the area to be welded.
11. Clean the area using a wire brush and a cleaning solvent that will remove dirt and grease.
12. Dump the air from the rear suspension.
13. Set the suspension ride height using frame jacks to raise the rear of the vehicle until the distance between the rearmost axle's forward weld seam and the frame rail measures 9.5 inches (24 cm). See **Fig. 2**.

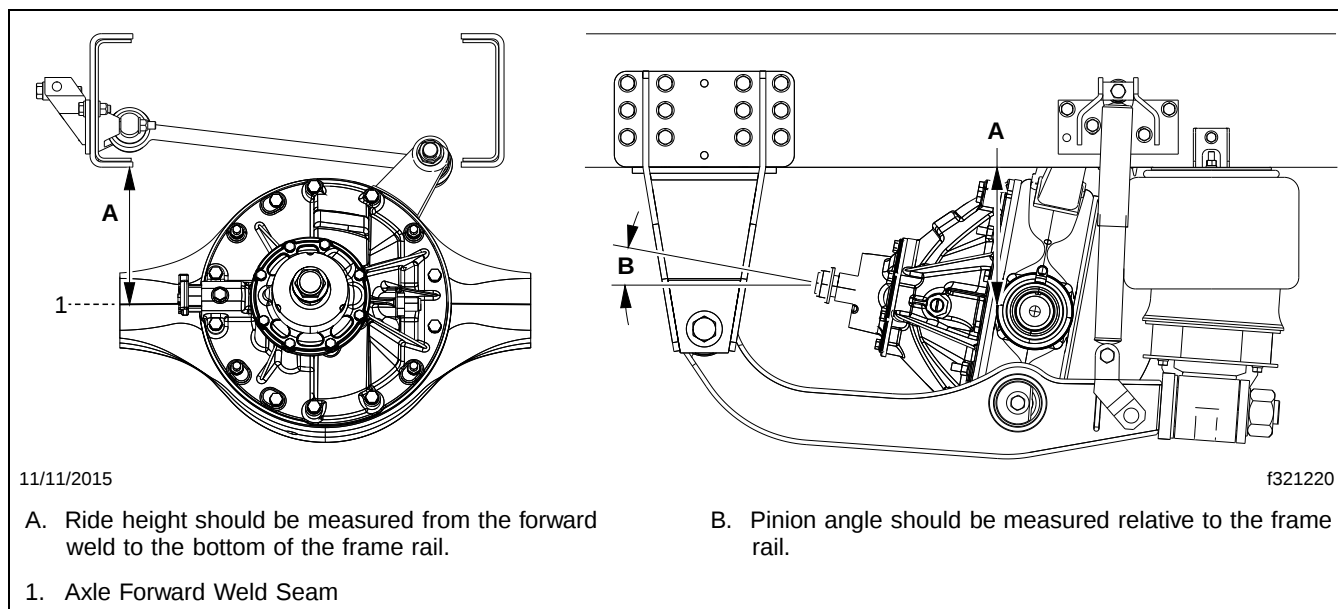


Fig. 2, Measuring Ride Height and Pinion Angle

14. Measure the pinion angle of the rearmost axle, which should be 10 degrees relative to the frame rail.
If the pinion angle is not correct, adjust the angle by adding or subtracting shims from the longitudinal torque rod. Measure and confirm the ride height after adjusting the pinion angle.
15. Grind off the outer coating on the surfaces of the new tower bracket that will be welded.
16. Install the new torque rod and frame bracket using the original shims. Tighten only enough to remove play. Do not apply the final torque.
17. Install the new tower bracket onto the torque rod. Tighten only enough to remove play. Do not apply the final torque.

18. Mark the center of axle and the center of the tower bracket for ease of alignment when tack welding the bracket to the housing. See **Fig. 3**.

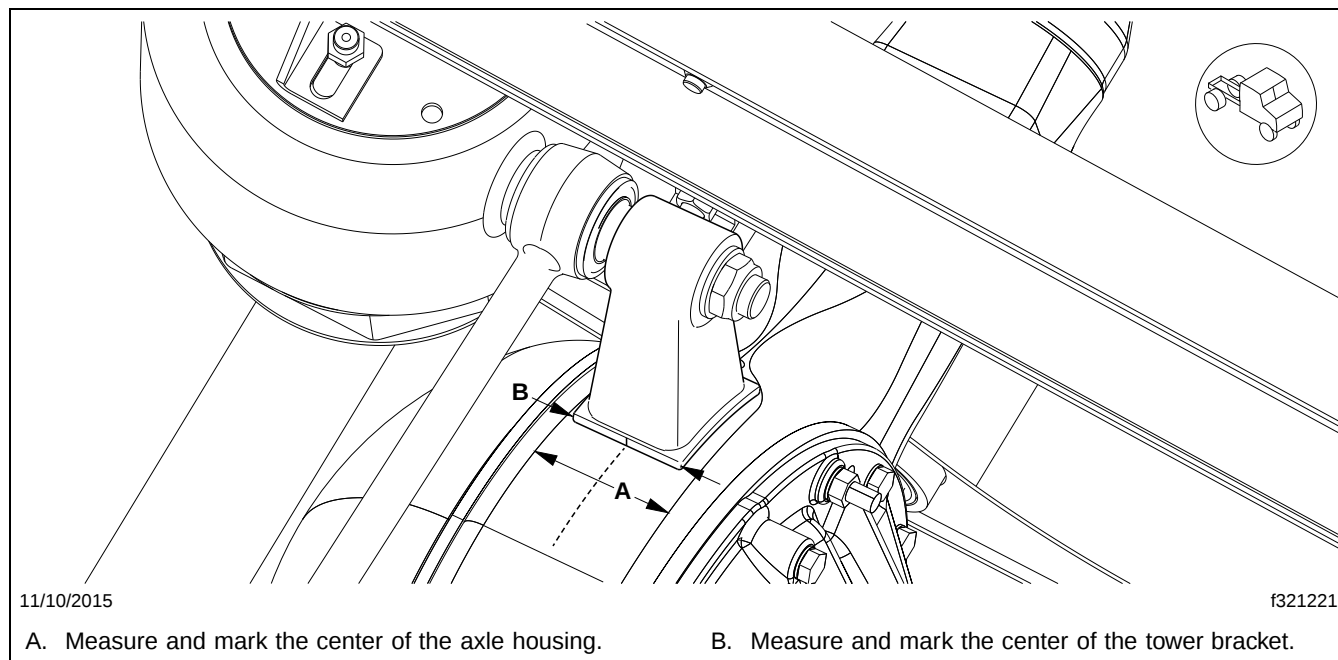


Fig. 3, Aligning the Tower Bracket and Axle Housing

19. Use the bracket attached to the new rod to establish the new position of the tower bracket. Using the lateral center line marks, make sure the torque rod is as perpendicular to the frame rail as possible.

! WARNING

The axle housing must be 70°F (21°C) or warmer before you weld onto the axle. Do not weld onto a cold axle or cold part. Cracks in the weld area, damage to components, and serious personal injury can result.

20. Ensure that the axle housing temperature measures 70°F (21°C) or warmer. If the axle housing temperature measures less than 70°F (21°C), store the axle in a heated room until the housing reaches the correct temperature.

IMPORTANT: The welding must be done by a certified welder. If the dealership does not have a certified welder, this may be sublet and charges up to 450 USD may be included on the field service claim with the invoice attached.

21. Preheat the joint to approximately 300°F (149°C) before welding.
22. Select suitable weld wire electrodes for the weld. Suitable weld wire electrodes include either BS EN 499 - E 42 2 B 32 H5 or BS EN 440 - G 42 2 M GSi (American Welding Society equivalents E7018 and ER70S3, respectively).
23. Attach the ground cable as near as possible to the weld area and only to components welded on the axle, such as a housing spring pad. Do not attach the ground cable at a suspension spring, U-bolt, or at a point that places a wheel bearing between the ground connection and the weld area.

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24. Press the bracket tight against the axle housing to reduce gaps, then tack weld the tower bracket into place.
25. Remove the new torque rod in preparation for final welding of the tower bracket.
26. Preheat the joint to approximately 300°F (149°C) before welding.
27. Weld the tower bracket onto the axle housing on the three accessible sides. Lay a full fillet in a single pass on each side. The fillet should be 0.315 to 0.50 inch (8 to 12.7 mm). Unless otherwise specified, the depth of fusion on the bracket is 0.063 inch (1.5 mm), +0.05/-0.0 inch (+1.27/-0.0 mm). The tolerance applies to weld size and depth of fusion.
28. Back fill the ends of the weld 0.315 to 0.512 inch (8 to 13 mm) to eliminate craters.
29. As needed for access to the tower bracket, raise the rear of the vehicle to let the rearmost axle hang down.
30. Weld the remaining side of the tower bracket, back filling to create a continuous weld.
31. Verify that the weld has a flat or slightly convex contour with a sufficient depth of fusion on both side walls. A concave contour is not allowed because it reduces the throat dimension of the weld. See **Fig. 4**.

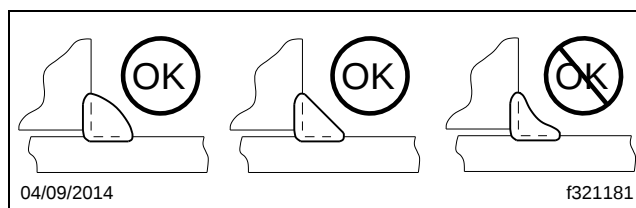


Fig. 4, Acceptable Weld Contours

32. Clean up all the metal shavings and dust on the chassis from the grinding and welding.
33. Once the weld is cool, clean the surrounding area and apply primer and paint to all exposed metal.
34. Lower the axles back down to ride height.
35. Install the torque rod and hand-tighten the fasteners.
36. Tighten the torque rod fasteners on the frame side 128 lbf·ft (173 N·m), and the torque rod pin side 375 to 425 lbf·ft (508 to 576 N·m).
37. Remove the jacks.
38. Tie the cables back to the torque rod with zip ties.
39. Reconnect the batteries. Tighten the connectors 10 to 15 lbf·ft (14 to 20 N·m).
40. Clean a spot on the base label (Form WAR259), and attach a completion sticker (Form WAR261) for campaign SF516 to the base label.