

# SS 1033297: WST 4900 Low Max Exhaust Pipe Installation improvements

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## WST 4900 Low Max Exhaust Pipe installation improvements

### Applicable Vehicles

WST 4900 Low Max w/DD13 Engines

### Symptoms

Early Failures of Exhaust Pipe from Turbo to ATS, Part Nr: 04-32700-000 .

### Issue

Exhaust Pipes were installed in preloaded condition in the early production vehicles, due to the correct assembly sequence was not included in the initial installation drawing, which caused premature Exhaust Pipe Failures.

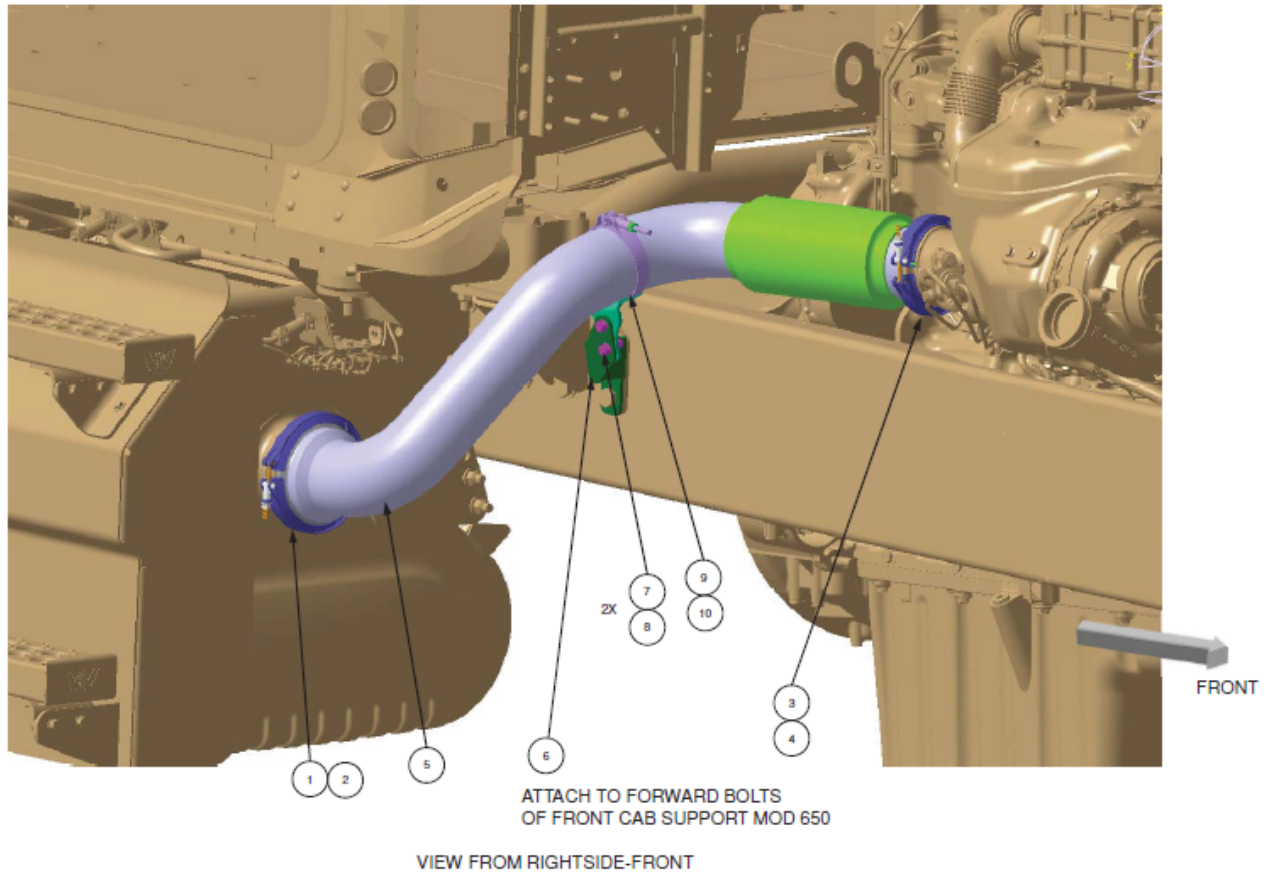
### Solution

Exhaust Pipe Installation drawing has been revised and the installation sequence has been added to eliminate the preloading conditions in the exhaust pipes.

When replacing or inspecting the Exhaust Pipe installation follow the recommended sequence below included in installation drawing D04-32154-000:

1. REFER TO D04-21646 FOR CLAMP TORQUE SPECIFICATIONS
2. TORQUE ALL FASTENERS PER SPEC 49-00104 UNLESS OTHERWISE NOTED.
3. PROPER INSTALL SEQUENCE DURING PIPE INSTALLATION IS KEY TO PREVENT PRELOADING OF EXHAUST PIPE AND PREVENT FAILURES IN THE FIELD. ENSURE BELOW SEQUENCE IS FOLLOWED WHEN INSTALLING EXHAUST PIPE
  - A) ALIGN THE BELLOWS END OF EXHAUST PIPE CENTERLINE WITH THE ENGINE TURBO FLANGE AND THE OTHER FLARED END OF THE PIPE WITH THE ATS INLET FLANGE.
  - B) TIGHTEN BOTH MARMON FLANGE CLAMPS TO SPEC
  - C) BRING PIPE SUPPORT BRKT, 04-20376-000, UP TO THE BOTTOM OF EXHAUST PIPE AND TIGHTEN THE SUPPORT BRKT MOUNT BOLTS, THEN TIGHTEN THE PIPE SUPPORT CLAMP AROUND PIPE TO SPEC

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Refer to attached installation for Torque Specifications.  
Contact your WST DSM if you have comments or questions.  
This bulletin is for information purpose only.