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**FIELD SERVICE CAMPAIGN – 18111**

19 September 2018

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**SUBJECT:**

Lift Axle Huck Bolts

**MODELS INVOLVED:**

International® HX® Series and WorkStar® Vehicles

**DEFECT DESCRIPTION:**

Certain International® HX® and WorkStar® models may have been built with incorrect huck bolt washers for the lift axle bolts resulting in loosened huck bolt fasteners.

**ELIGIBILITY:**

This procedure applies ONLY to vehicles marked in the International® Service Portal<sup>SM</sup> with FSC 18111. Also complete any other open campaigns listed on the Service Portal at this time.

**TOOLS REQUIRED:**

**IMPORTANT:** If requesting a tool through the Loaner Tool Program, it is necessary to schedule as many vehicles as possible for repair prior to arrival of the tool. Due to limited availability, loaner tools are issued for one week only.

**NOTE:** If necessary, create a tool case file and obtain through Loaner Tool Program.

**NOTE:** Tools requested through the Loaner Tool Program are Huck-Spin® 2 Type Only.

Description	Tool Number
Air Hammer and Chisel	Obtain Locally
Huck Tool and Appropriate Nose Piece Adaptor	TRK-HS220-NC

**Table 1** Tools Information

**CAUTION:** To prevent vehicle / component damage, when reassembling, use the same size bolt or huck removed during disassembly.

**PARTS REQUIRED:**

Part Number	Description	Quantity
28425R1	WASHER, FLAT, HARDENED, 5/8, ZN6A	12
3691090C1	BOLT, HUCK-SPIN 5/8 DIA-24	4
3691091C1	BOLT, HUCK-SPIN 5/8 DIA-28	8
3691083C1	NUT, HUCK-SPIN COLLAR 5/8 DIA	12

**Table 2** Parts Information

**WORK INSTRUCTIONS**

**GOVERNMENT REGULATION:** Engine fluid (oil, fuel, and coolant) may be a hazard to human health and the environment. Handle all fluid and other contaminated materials (such as filters and rags) in accordance with applicable regulations. Recycle or dispose of engine fluids, filters, and other contaminated materials according to applicable regulations.

**WARNING!** To prevent property damage, personal injury, and / or death, park vehicle on hard flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in both directions.

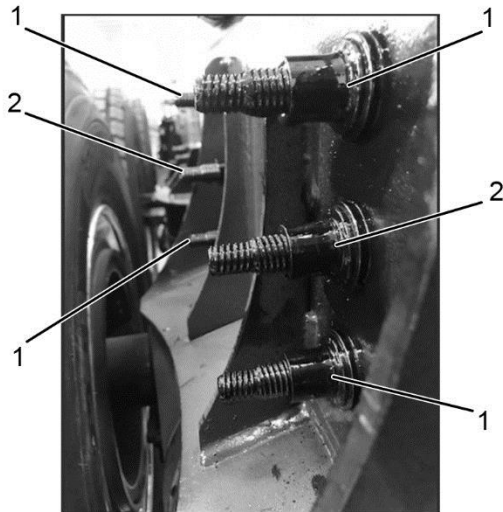
**WARNING!** To prevent personal injury and / or death, if the vehicle must be raised, do not work under vehicle supported only by jacks. Jacks can slip or fall over.

**WARNING!** To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

**WARNING!** To prevent property damage, personal injury, and / or death, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

1. Park vehicle on flat surface.
2. Shift transmission into Park or Neutral and set parking brake.
3. Install wheel chocks.
4. Using a floor jack positioned at a safe location, raise and support lift axle using appropriately rated jack stands.

5. Identify 6 huck bolts requiring change on each side of lift axle.
6. If necessary, remove wheels from lift axle to gain access to lift axle huck bolts.



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**Figure 1. Huck Bolt Fasteners**

1. 28 mm huck fastener (4)
2. 24 mm huck fastener (2)

7. Using huck tool, air hammer, and chisel, cut and remove huck fasteners (Figure 1, Items 1 and 2) from lift axle.

**NOTE: The top and bottom fasteners are 28 mm long and the center fasteners are 24 mm long.**

8. Install new 28 mm huck fasteners (Figure 1, Item 1) in top and bottom fastener holes.

9. Install new 24 mm huck fasteners (Figure 1, Item 2) in middle fastener holes.

**NOTE: For instructions on swaging huck fasteners or huck tool usage, refer to appropriate frame service manual and / or appropriate training video.**

10. Starting with bottom huck bolts first, swage huck fasteners using huck tool.

11. Repeat Steps 6 thru 10 until all 12 huck bolts have been replaced using correct flat washers.
12. If necessary, install wheels on lift axles.
13. Lift vehicle and remove jack stands.

**NOTE: If necessary, lower the lift axle to the down position prior to tightening the wheel nuts.**

14. Using a torque wrench, tighten wheel nuts to 450 – 500 lb-ft (610 – 678 N•m).
15. Verify lift axle operation.
16. Remove wheel chocks.

### **LABOR INFORMATION**

Operation number must appear on all claims.

<b>Operation Number</b>	<b>Description</b>	<b>Time</b>
A40-18111-1	Remove and Install 12 Huck Bolts	1.1 hrs

**Table 3** Labor Information

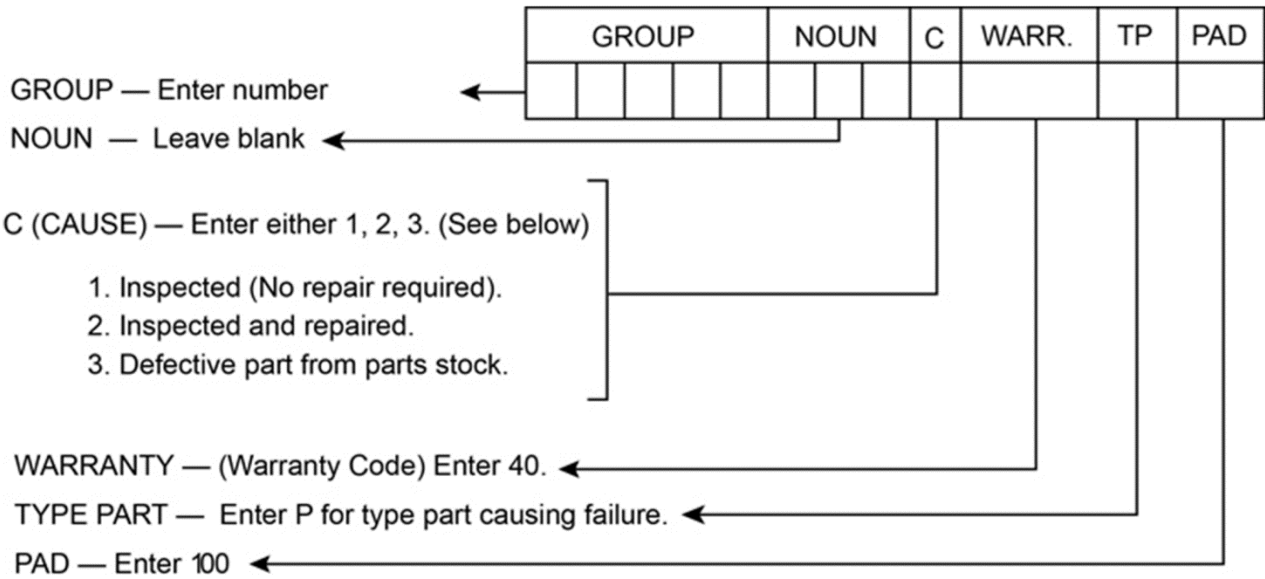
### **WARRANTY CLAIMS**

Warranty claim expense is to be charged to Warranty. Claims are to be submitted in the normal manner, making reference to Field Service Campaign 18111.

Section 7 of the Warranty Policy and Procedures Manual contains further information related to the submission and processing of AFC / Recall claims.

As with all claim submissions, items acquired locally must be submitted in the “Other Charges” tab. The cost of any bulk items (such as a bag of cable tie straps, roll of wire, barrel of oil, or tube of silicone) should be prorated for the cost of the individual pieces / amount used during each repair.

To make sure this important improvement is made in a timely manner, all claims for 18111 activity must be submitted by 19 September 2019 or within the normal warranty period for the component, if after 19 September 2019.



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