

From: [REDACTED]

Sent: Monday, February 25, 2019 11:15 AM

To: [REDACTED]

Cc: [REDACTED]

Subject: RE: Ready Mix Bolts

1. The 8 horizontal bolts should be torqued to 249-305 Ft Lbs and not the 70 ft lbs as indicated in the workshop manual. I've submitted a notification to the publisher to correct the torque value. I would recommend setting a click type torque wrench to 249 ft lbs and check the torque on all eight fasteners. Should you come across any that can be removed by hand, I would recommend removing all eight of the fasteners since most likely Loctite 271 wasn't used. When reinstalling, please make sure Loctite 271 is used to secure the fastener. Torque the replacement fasteners to 277 ft lbs which is middle of the torque range. Caution should be taken in removing the existing bolts so that the aluminum flywheel housing isn't damaged due to the Loctite installed. It is recommended heating the area to ease in the bolt removal if it doesn't removal easily by hand.
 - a. Bolt part # is 23-09446-225
 - b. Torque is 249-305 ft lbs
 - c. Loctite required is Loctite 271
2. The vertical fasteners that secure the engine to the frame rail mounted bracket uses a grade 8 fastener with a prevailing torque nut. It's not uncommon for there to be a slight spinning movement of the lower isolator due to the weight of the engine compressing the upper rubber bushing. The bolt itself should not spin due to the isolators having an inner sleeve. Please set a click type torque wrench to 216 ft lbs and check the torque to make sure it hits the minimum torque value. The torque range of this fastener is 216-265 ft lbs.

I've included a screen shot of the proper torque values and I've attached a copy of the installation document used for this unit. It calls out for a -003 installation and the unit has a 3 degree angle set.

Please have Ft Worth submit a DPR for these loose fasteners.

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RELEASE NUMBER	REV	DESCRIPTION	BY	DATE	APPD
INITIAL RELEASE	0000			03/08/09	CTD
UPDATE BOM TO REFLECT ASSEMBLY	0001			03/18/14	ALM
UPDATE BOM TO REFLECT ASSEMBLY	0002			03/18/14	ALM
UPDATE BOM TO REFLECT ASSEMBLY	0003			03/18/14	ALM

1 APPLY THREADLOCKER PER SPEC 48-00094-131.

2 NUB ON BRACKET MUST ALIGN WITH HOLE IN FRAME.

3 TIP OF BOLT WILL BREAK OFF WHEN PROPER TORQUE IS ACHIEVED.

4 LOCATE BOLT HEADS DOWN FOR 5 DEG ENGINE ANGLE.

5 LH SHOWN, RH OPPOSITE. QUANTITIES REFLECT LH SIDE ONLY, EXCEPT WHERE NOTED.

6. DIMENSIONS ARE FOR REFERENCE ONLY.

7. TORQUE VALUES
M12 GR10.9: 100-125Nm (74-92 LB-FT) TO IRON BLOCK.
M12 GR10.9: 79-98Nm (58-72 LB-FT) TO ALUMINUM FLYWHEEL HSG.
M16 GR10.9: TORQUE CONTROLLED. SEE NOTE 2.
5/8" GR8: 166-202Nm (122-149 LB-FT).
3/4" GR8: 294-359Nm (216-265 LB-FT) TO REAR ISOLATOR ASSY.
3/4" GR8: 338-414Nm (249-305 LB-FT) TO ALUMINUM FLYWHEEL HSG.
3/4" GR8: 338-414Nm (249-305 LB-FT) TO IRON FLYWHEEL HSG.

D01-32930-004
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D01-32930-006
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D01-32930-007
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APPROVED BY	DATE	APPROVED BY	DATE
INSTL,SUPPT,ENGINE,MD			
D01-32930		C	1 of 9

Done

10:17 AM 7/25/2019

[REDACTED]
 District Service Manager
 Southeast Region
 Daimler Trucks North America, LLC
[REDACTED]