

Link Auxiliary Axle Hardware, Retorque  
VN**SP 657-002, Link Auxiliary Axle Hardware, Retorque****(July 2019)**

For certain Volvo VN trucks built between 09/21/2015 and 09/07/2018, a new improved torque procedure has been introduced to maintain and distribute torque properly on the hardware attaching the Link auxiliary axle to the frame mounted brackets. Follow the repair instructions outlined in this document for retorquing the indicated nuts or bolts.

## **Link Auxiliary Axle Hardware, Retorque Procedure:**

You must read and understand the precautions and guidelines in Service Information, group 70, "General Safety Practices, Frame, Springs, Shocks and Springs" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.

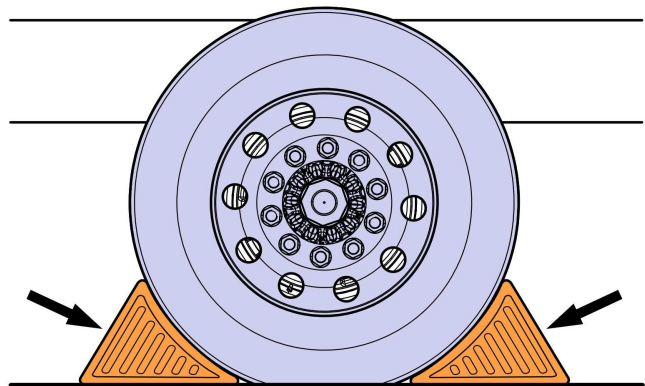


### **DANGER**

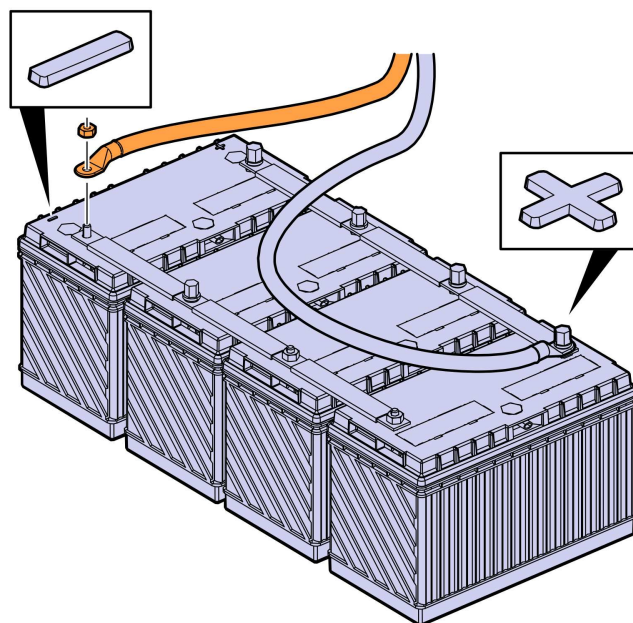
Do not attempt to repair or service this vehicle without having sufficient training, the correct service literature and the proper tools. Failure to follow this could make the vehicle unsafe and lead to serious personal injury or death.

- 1 Park the vehicle on a level surface.
- 2 Apply the parking brake.
- 3 Place the transmission in neutral or park.

- 4 Install the wheel chocks.

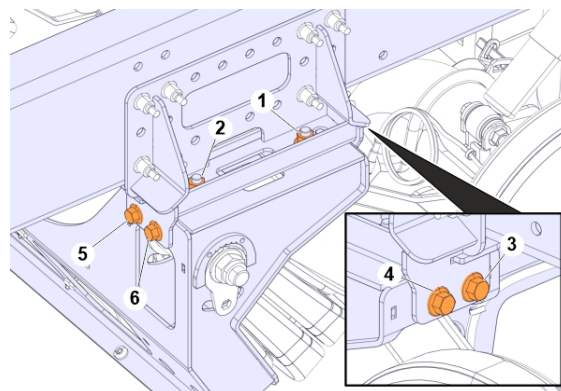


- 5 Disconnect the cable from the battery's negative terminal.



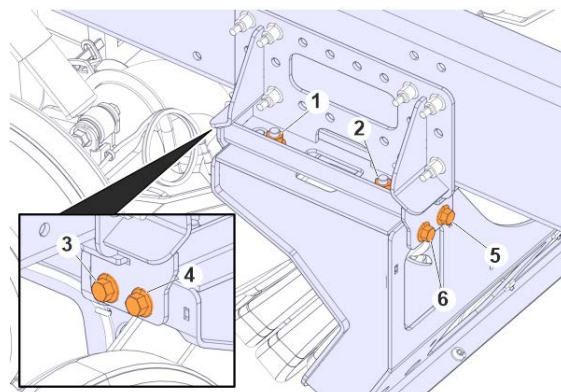
6. Torque tighten the screws and nuts.

| Tightening torque |                                                                                              |
|-------------------|----------------------------------------------------------------------------------------------|
| Fasteners         | Tightening sequence: 1-6<br>$305^{+14}_{-34}$ Nm<br>( $225^{+10}_{-25}$ lb <sub>r</sub> -ft) |

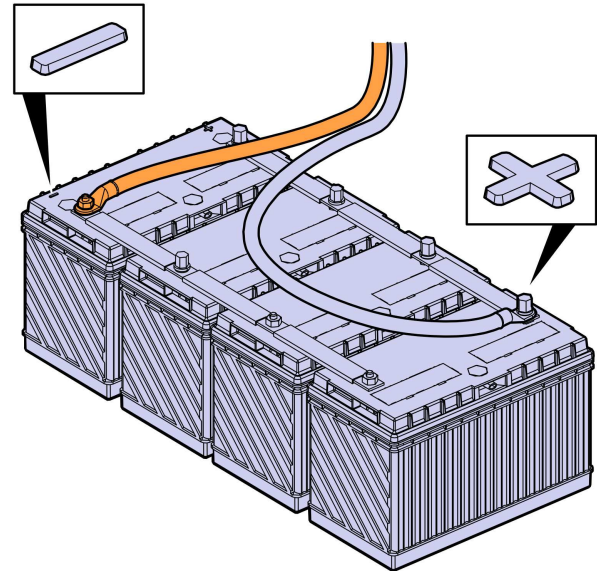


7. Torque tighten the screws and nuts.

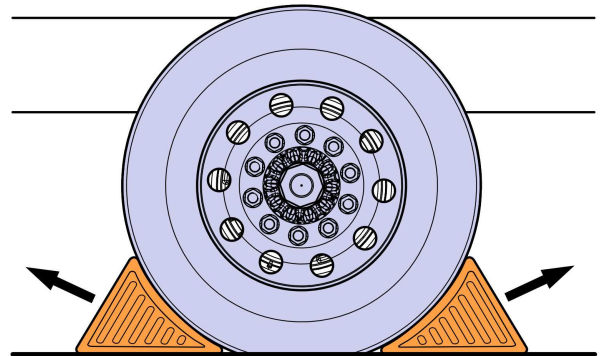
| Tightening torque |                                                                                              |
|-------------------|----------------------------------------------------------------------------------------------|
| Fasteners         | Tightening sequence: 1-6<br>$305^{+14}_{-34}$ Nm<br>( $225^{+10}_{-25}$ lb <sub>r</sub> -ft) |



9 Connect the cable to the battery's negative terminal.



10 Remove the wheel chocks.



**Reimbursement**

|                                                                                                                                  |                             |
|----------------------------------------------------------------------------------------------------------------------------------|-----------------------------|
| <b>This repair is covered by an authorized Service Program. Reimbursement is obtained via the normal claim handling process.</b> | <b>UCHP Reimbursement</b>   |
| <b>Recall Status</b>                                                                                                             |                             |
| Vehicle inspected, repair not required                                                                                           | 1- Inspected OK             |
| Vehicle repaired per instruction                                                                                                 | 2- Modified per instruction |
| <b>Labor Code</b>                                                                                                                |                             |
| Primary Labor Code – Link Auxiliary Axle, Torque Check                                                                           | 6579-16-09-01<br>0.4 hrs    |
| <b>Causal Part</b>                                                                                                               | 990954                      |
| <b>SCC Code</b>                                                                                                                  | S7398                       |
| <b>Authorization Number</b>                                                                                                      | N/A                         |
| <b>Expiration Date</b>                                                                                                           | 31-JULY-2020                |