

12/2/2020
CAL FTL 32-006

**Subject: Hendrickson Primaax EX 69,000 lb
Tri-Axle Rear Air Suspension Height-Control
Valve Relocation**

**Models Affected: Specific Freightliner M2 vehicles manufactured
between January 1, 2015 and June 4, 2020 equipped with a
Hendrickson Primaaz 69000 lb tri-axle rear air suspension**

NOTE: REVISED 12/2/2020: Step 8 drilling instructions expanded.

Our records indicate that you are the owner of certain vehicles, and therefore DTNA has decided to share the following documentation with you.

The attached document provides work instructions for relocating the height-control valve downward 1.62 inches (41.3 mm) to prevent the linkage from protruding above the top flange of the frame when the suspension air is dumped.

We hope you find this information helpful.

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Work Instructions

Subject: Hendrickson Primaax EX 69,000 lb Tri-Axle Rear Air Suspension Height-Control Valve Relocation

Models Affected: Specific Freightliner M2 vehicles manufactured between January 1, 2015 and June 4, 2020 equipped with a Hendrickson Primaaz EX 69000 lb tri-axle rear air suspension

NOTE: REVISED 12/2/2020: Step 8 drilling instructions expanded.

Work Instructions

1. Park the vehicle on a level surface, set the parking brakes, and *chock the tires*.
2. Put the transmission in neutral and build the air pressure to at least 100 psi. Shut down the engine.
3. Release the parking brakes.
4. Locate the height-control valves installed just rear of the mid-axle inside the left-hand and right-hand frame. See [Fig. 1](#).

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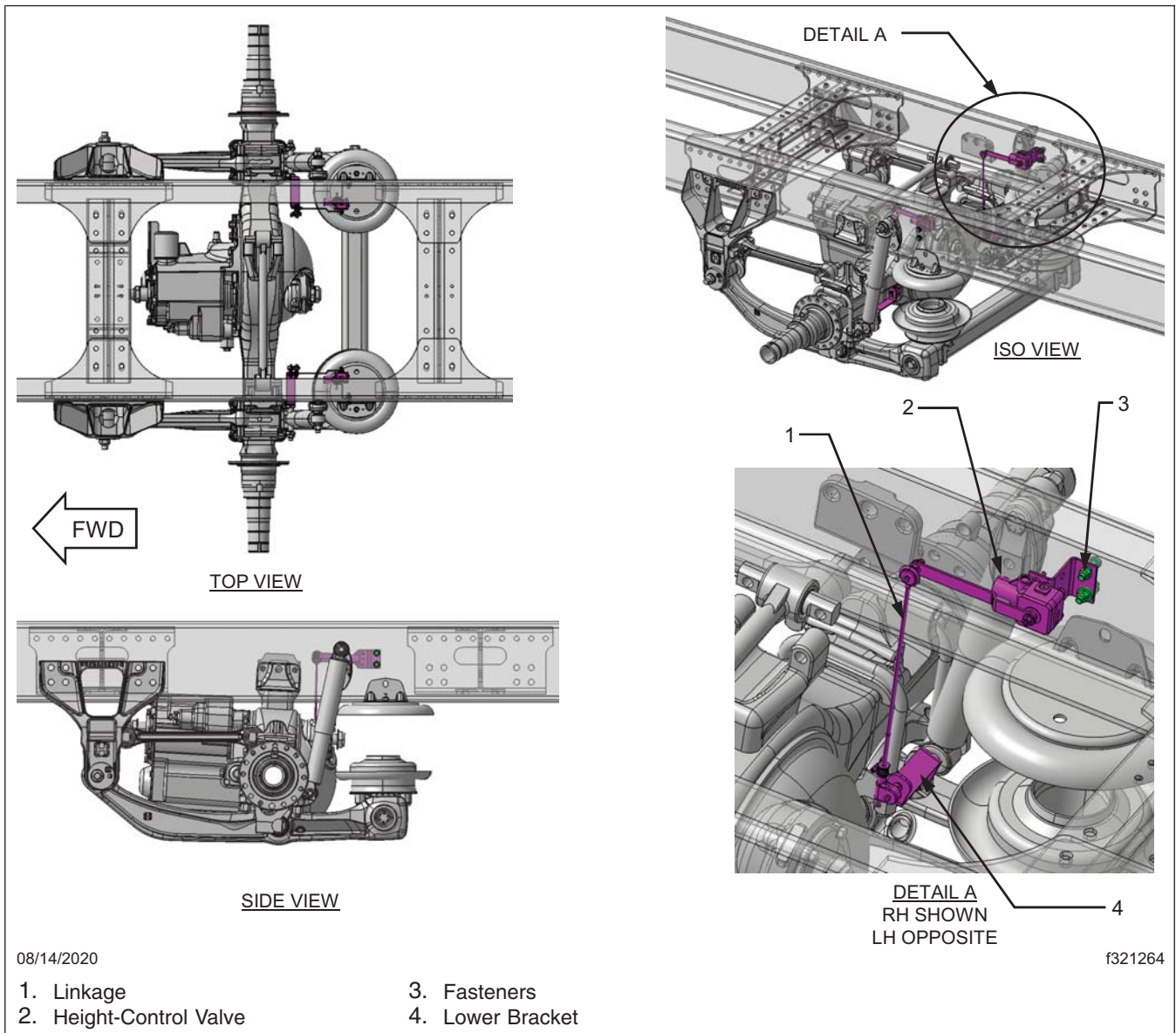


Fig. 1, Location of Height-Control Valves

5. Disconnect the linkage from the lower bracket on both sides of the vehicle.
6. Pin both height-control valve levers in the neutral position with a 5/32-inch drill bit.
7. Remove the height-control valve mounting fasteners from the frame and move the valves and linkages away from the frame.
8. Mark both the left-hand and right-hand frame rail 1.62 inches (41.3 mm) below the lower existing height-control valve drilling on each rail. See [Fig. 2](#).

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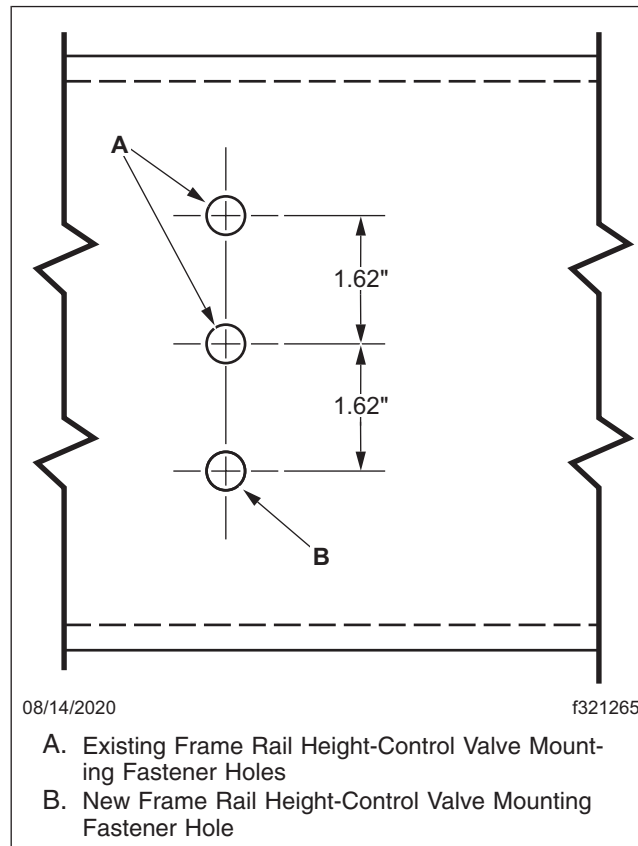


Fig. 2, Measuring For the New Frame Rail Holes

IMPORTANT: Drilling must be done at low-speed with a high-speed steel drill bit.

NOTE: Protect the air lines and wiring inside the frame when drilling the additional holes.

9. Drill a 1/4" diameter pilot hole at both the left-hand and right-hand frame rail marks.
10. Finish the mounting holes with a 7/16" diameter drill bit at low speed.
11. Install the height-control valves on the lower two holes using the existing 3/8" fasteners.
12. Install the linkage to the lower bracket by adjusting the rod in the lower rubber adjustment sleeve.
13. Remove the drill bit pins from the height-control valve levers.
14. Check the suspension ride height by measuring between the shock mounting bolts. Measure from the centerline of the upper shock bolt to centerline of the lower shock bolt. The distance should equal 20.07 inches (50.98 cm). If necessary, set the suspension height by adjusting the rod in the lower rubber adjustment sleeve to achieve 20.07 inches (50.98 cm). See [Fig. 3](#).

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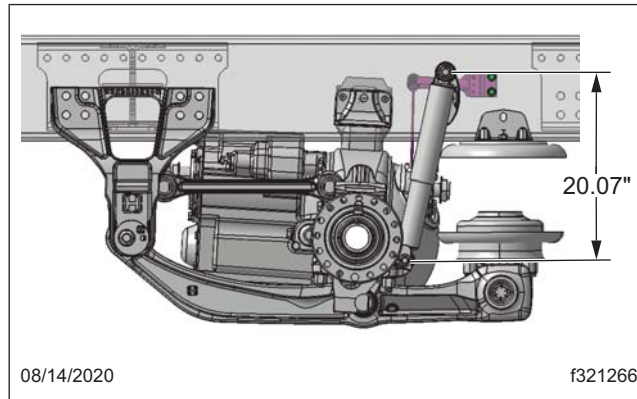


Fig. 3, Measuring the Suspension Ride Height

Warranty

This procedure is warrantable only if the described condition exists and the repair is performed within the applicable base or extended coverage warranty period. If a failure is not found, this procedure is considered preventive and warranty does not apply.

Normal warranty applies. See [Table 1](#) for OWL VMRS codes and labor allowance information. Enter this CAL bulletin number in the claim story as you would do for a Service Bulletin warranty claim.

OWL VMRS Codes and Labor Allowance					
Primary Failed Part	Component Code	Cause Code	SRT Code	Description	Time: Hours
HDR 58525 024	016-008-048	01	91C-5010A	BRACKET - LEVELING VALVE	1.4

Table 1, OWL VMRS Codes and Labor Allowance