

SS 1034831 Replacement Parts to Address Exhaust Brackets

Service Solution Title -- Replacement Parts to Address Exhaust Brackets or Clamp.

Applicable Vehicles--B2 TBB School Buses built between 2017 to 2020.

Symptoms--Exhaust pipe brackets and/or band clamp may fail.

Issue--Exhaust pipe brackets and/or band clamp may fail.

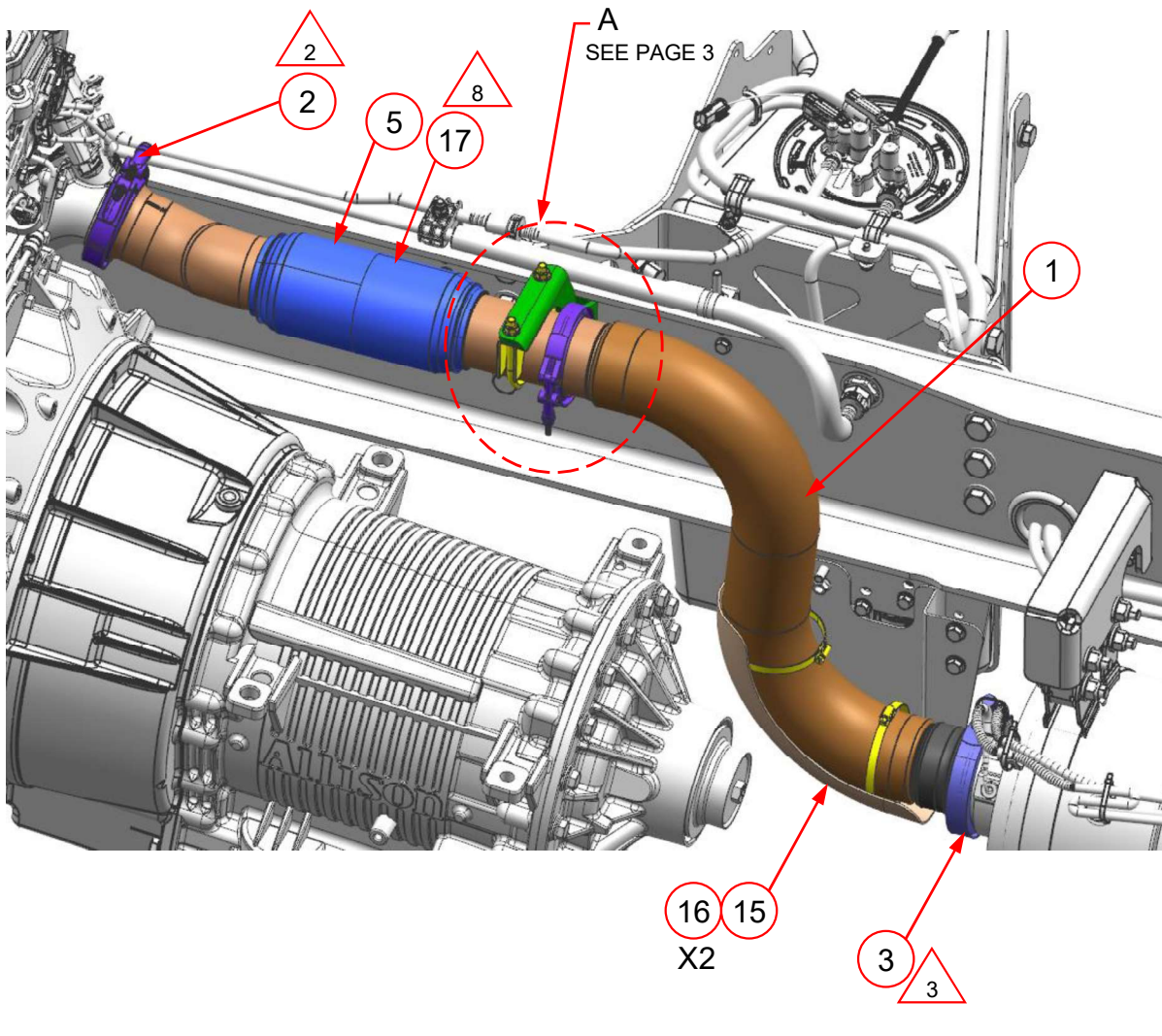
Solution--Exhaust pipe brackets and/or band clamp may fail. If either of the existing brackets or band clamp fails, the replacement parts will be the following using the attached Install drawing D04-35531-000.

Failure criteria	Replacement strategy	Additional parts to remove	Additional new parts
If 04-33140-000 fails	Replace with 04-35530-000	04-33141-000 and 04-20164-002	Saddle clamp 23-09289-001. TORQUE TO 23 FT-LBS, RANGE 20 -26 FT-LBS.
If 04-33141-000 fails	Replace with 04-35530-000	04-33140-000 and 04-20164-002	Saddle clamp 23-09289-001. TORQUE TO 23 FT-LBS, RANGE 20 -26 FT-LBS.
If 04-20164-002 Band clamp fails	Replace with saddle clamp 23-09289-001. TORQUE TO 23 FT-LBS, RANGE 20 -26 FT-LBS.	04-33141-000 and 04-33140-000	New bracket 04-35530-000.

RELEASE NUMBER	REV LTR	REVISION DESCRIPTION	BY	DATE	APPD
P60398-04	-	INITIAL RELEASE	A_V	07/28/20	MAB

1. FASTENER TORQUE CALLED OUT IN BILL OF MATERIAL.
2. TORQUE TURBO OUTLET CLAMP TO 16 FT-LBS, RANGE 14.5 - 17.5 FT-LBS.
3. TORQUE DPF INLET CLAMP TO 18.5 FT-LBS, RANGE 17 – 20 FT-LBS.
4. INSTALLATION PROCEDURE ON PAGE 4, TORQUE SEQUENCE ON PAGE 5.
5. TORQUE TO 23 FT-LBS, RANGE 20 -26 FT-LBS. TORQUE THIS CLAMP LAST IN TORQUE SEQUENCE.
6. FOLLOW SHOP PRACTICE K09-S0004-003 FOR BELLOWS INSTALLATION.
7. THE FOLLOWING STEPS ARE REQUIRED FOR AXIAL SLIP JOINT:
 1. ASSEMBLE SLIP FLARE AND GASKET IN FIRST INSTANCE INSURING SMOOTH TRANSITION OF GASKET TO CANNING.
 2. PULL TOGETHER TECONNEX SLIP JOINT COMPONENTS WITH SLIP FLARE AND CLAMP IN CORRECT CLOCKING POSITION.
 3. TIGHTEN SLIP JOINT ASSEMBLY TO 10.3 FT-LBS, RANGE 8.5 – 11.5 FT-LBS.
 4. TAP CIRCUMFERENCE OF THE CLAMP LIGHTLY WITH SOFT FACE HAMMER. THIS WILL SETTLE THE CLAMP AFTER INITIAL INSTALL
 5. RE-TIGHTEN SLIP JOINT ASSEMBLY TO 10.3 FT-LBS, RANGE 8.5 – 11.5 FT-LBS.
8. ITEM-17, BELLOWS INSULATION MUST BE INSTALLED ON THE BELLOWS AFTER ALIGNMENT AND SUCH THAT IT DOES NOT OVERLAP ON SPHERICAL JOINT AT ENGINE SIDE AND STOPS AT SADDLE STYLE U-BOLT CLAMP.

ITEM NUMBER D04-35531-000 DESCRIPTION INSTL-PPG,ENG-DPF,B2,DD5	DAIMLER		Daimler Trucks North America	
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	MATERIAL APPROVAL	DATE	UNLESS OTHERWISE NOTED, DIMENSIONS AND TOLERANCES ARE DEFINED ACCORDING TO ASME Y14.5M- 1994, WITH EXCEPTION PER DTNA 09ENG-WI037	
	DRAWN BY	DATE		
	CHECKED BY	DATE		
RESPONSIBLE ENGINEER	DATE			
APPROVED BY	DATE			
DESCRIPTION INSTL-PPG,ENG-DPF,B2,DD5		THIRD ANGLE PROJECTION	UNITS OF MEASURE MM	
SUPPLEMENTAL DESCRIPTION 236A1				
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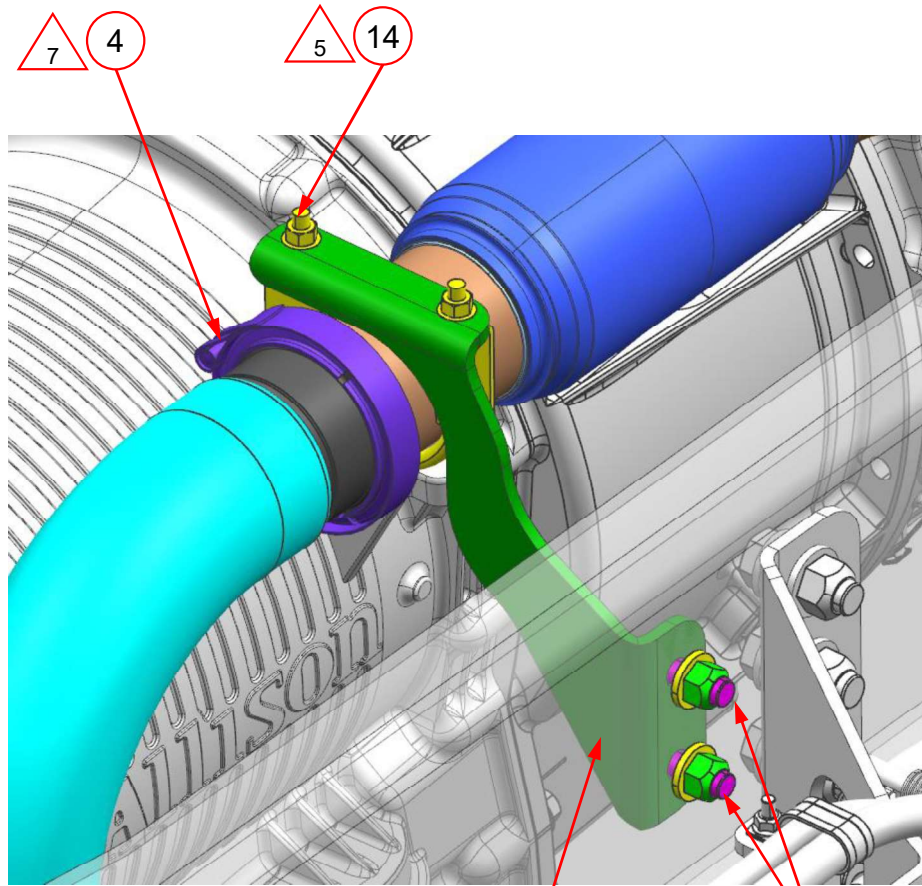
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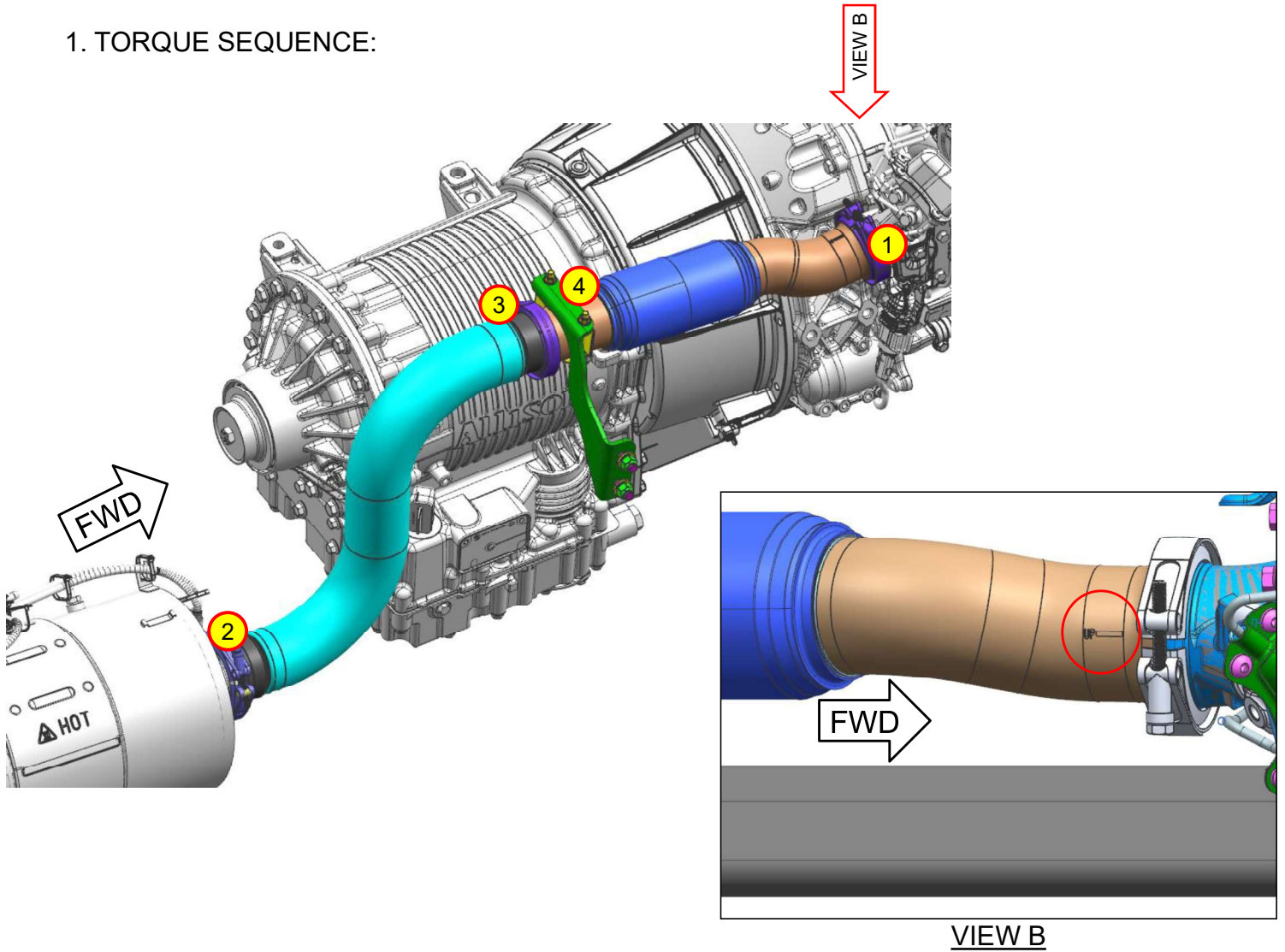
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1. INSTALLATION PROCEDURE:

1. INSTALL BELLOWS (005) AND SPHERICAL CLAMP (002) ON ENGINE. BELLOWS NEEDS TO BE ABLE TO ROTATE FREELY ON ENGINE FLANGE.
2. INSTALL U-BOLT CLAMP(014) ON STRAIGHT END OF BELLOWS AND THRU SUPPORT BRACKET (007), START NUT BUT DO NOT TIGHTEN.
3. INSERT INSULATED PIPE (001) IN BELLOWS, ALIGN THE AXIAL SLIP CLAMP (004) ON THE PIPE AND BELLOWS JOINT. START NUT, BUT DO NOT TIGHTEN.
4. CONNECT THE OTHER END OF INSULATED PIPE TO DPF INLET USING SPHERICAL CLAMP (003). MINIMUM PIPE INSERTION TO BELLOWS MUST BE MAINTAINED AT 20MM.
5. ALIGN BELLOWS BY ROTATING BELLOWS AT THE TURBO SO THAT MARKING NAMED "UP" IS VISIBLE FROM TOP VIEW AS SHOWN IN **VIEW-B** IN PAGE-5. ELIMINATE ANY VISIBLE BEND OR OFFSET IN BELLOWS.
6. TORQUE CLAMP ON ENGINE FIRST, DPF INLET SECOND, AXIAL SLIP ON BELLOWS THIRD, AND U-BOLT CLAMP (014) FOURTH.

1. TORQUE SEQUENCE:



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