

Transmission Bolt Inspection

Service Category Service

Section Function Group 431

Technician Skill Level A

Market North America

Applicability

VOLVO

Years	Models
2021	VN, VHD

Introduction

Volvo has received reports of certain VN and VHD chassis containing possible incorrect transmission mounting hardware. This hardware inconsistency could cause lack of force needed to retain the transmission to the engine. This campaign will require removing the bell housing flange screws one at a time, inspecting, and possibly replacing the flange screws.

Production Change Information

This bulletin applies to vehicles built within the specified production changes below.

Brand	Engine	Emission Level	Starting Build Date	Ending Build Date
Volvo	D11, D13	EOBD U20	8-September-2020	18-November-2020

Warranty Information

This repair is covered by an authorized Service Program. Reimbursement is obtained through the normal claim handling process.		
Claim Type (used only when uploading from the Dealer Bus. Sys.)		B
Main Labor Code	Description	Hours
1720-16-09-01	Campaign, General (0.1 per bolt) (x12 for Allison or x6 for I-Shift)	0.6 - 1.2
Causal Part	60112885	
SCC Authorization Code	S7605	
Expiration Date	February 28, 2022	

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Parts Information

If applicable

Part Numbers	Part Names	Quantity
60112885	Flange Screw (7/16 UNC *57)	As needed

Required Tools & Equipment

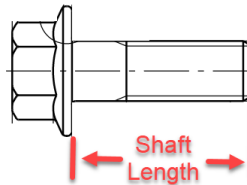
- None

Calibration Information

- None

Repair Procedure

1. Secure truck for service.
2. Properly support transmission during procedure.
3. Remove one of the bell housing flange screws, and measure the shaft length.



- a. If removed flange screw measures 57mm, reinstall and torque to specification.
- b. If removed flange screw measures 44mm, replace flange screw with part number 60112885 and torque to specification.

Torque Specification Table	
Allison Transmission	70 ± 5 Nm (52 ± 4 lbf-ft)
I-Shift Transmission	90 ± 5 Nm (66 ± 4 lbf-ft)

4. Report any incorrect hardware found by opening an E-Service Case to Reliability using the **Campaign Number S7605** in the title. Include the quantity of incorrect screws found.
5. Continue above procedure (one at a time) on the remaining flange screws (I-shift has 6 and Allison has 12 total screws)
6. Once all bell housing flange screws have been inspected, replaced as needed, and torqued to specification, the truck is ready to be returned to service.