

Day Cab Conversion Closure Panel

M-811-001

(April 2009)

Valid for

All CX cabs and later style CH cabs

Case description

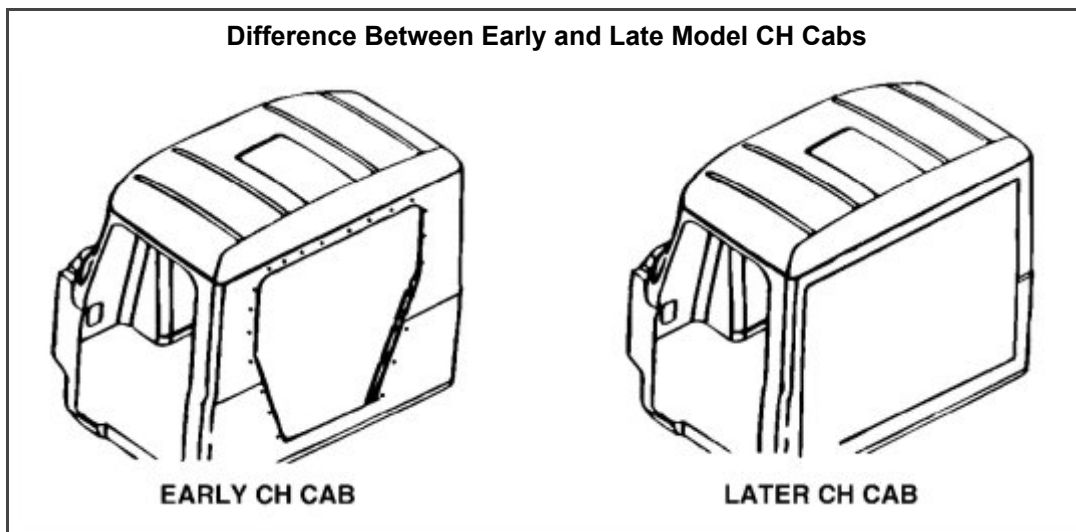
A closure panel kit (reference No. 204SX403A) is available for converting a CX or CH (with CX-style cab having a "walk-through" sleeper opening) sleeper cab to a day cab.

Note: Not applicable to Mack Trucks Australia.

Parts

Reference Number	Description
204SX403	Closure panel and reinforcement brackets
204SX404	Interior trim panel kit (available in medium warm gray only)
204SX405	Hardware kit
204SX412	Cab suspension kit (CH & CX)
204SX419	Cab suspension kit (CHN, CXN, CHU & CXU)
20QS53M	Cab rear glass
23QS525M	Cab-to-closure panel lower gasket
23QS526M	Cab-to-closure panel upper gasket

Note: For CH model chassis, this closure panel kit (reference No. 204SX403A) is only applicable for later models having the CX-style cab (cab base part number 1QS51122M, including all M number variations). This kit does not apply to earlier CH sleeper chassis having cab base No. 1QS5112M. On earlier CH model chassis, the opening through the back of the cab is keyhole shaped, whereas on later chassis, the entire back of the cab is opened (refer to the following illustrations to determine the differences between early and late model CH cabs).



Kit part Nos. 204SX403 and 204SX405 include the following components:

Panel Kit part number 204SX403 Contents		
Qty.	Part number	Description
1	NSS	Closure panel assembly
2	NSS	Reinforcement brackets, left- and right-hand, upper
1	NSS	Reinforcement bracket, left-hand, lower
1	NSS	Reinforcement bracket, right-hand, lower
Hardware Kit part number 204SX405 Contents		
1	335AM3	Rivnut, clearance lamp/marker lamp assemblies
4	27AM9	Bolt, closure panel-to-cab
4	271AM10	Washer, closure panel-to-cab
34	26AM14	Bolt, cab-to-closure panel
38	271AM8	Washer, cab-to-closure panel
4	29AM10	Bolt, cab-to-lower closure panel at sill
2	545-2PH265209	Spacer, B-post reinforcement
2	545-2C2239342	AVK nut, B-post reinforcement
1	16QS412AM	Seal, cab rear window
6	335AM14	AVK nuts, lower sill and B-post reinforcement
4	56MO327	Department of Transportation (DOT) reflectors
4	35AX236	Spacer, seat belt-to-floor tether
4	27AM5008	Bolt, seat belt-to-floor tether
1	3198-1010064335	Air conditioner plug, #6, with O-ring
1	3198-1010064336	Air conditioner plug, #10, with O-ring
Parts Supplied Separately, Not Part of a Kit		
1	20QS53M	Window glass, cab rear
1	23QS525M	Gasket, cab-to-closure panel, lower
1	23QS526M	Gasket, cab-to-closure panel, upper

The interior trim panels are available in medium warm grey only. Parts included in the trim panel kit (part number 204SX404) are as follows:

Interior Trim Panel Kit part number 204SX404 Contents		
Qty.	Part number	Description
1	3200-31C8106710M	Panel, cab rear sill
1	3200-31C8106708M	Panel, cab rear wall right-hand side
1	3200-31C8106709M	Panel, cab rear wall left-hand side
1	3200-31C8102419M	Panel, vinyl, cab rear wall lower
1	3200-31C8102429M	Panel, vinyl, cab rear wall upper
14	3200-8079378	Push fasteners, dual head, black
10	73AX121	Push fasteners, warm grey

CH & CX ONLY

When converting a sleeper chassis to a day cab, the rear cab suspension must be changed. Components necessary for this conversion are available in the cab suspension kit (part number 204SX412). This kit includes the following:

Suspension Kit part number 204SX412 Contents		
Qty.	Part number	Description
1	227QS312AM	Spring (airbag), cab rear
2	14QK391BM2	Shock absorbers
8	159AM2	Huck®-Fit collar
4	191AM2	Nut
2	20AX3	Nut
14	26AM13	Bolt
10	271AM8	Washer, fairing
2	27AM31	Bolt
2	30QS2268M	Pad
2	30QS2284M	Sleeve
4	30QS2285M	Isolator
2	30QS4224M3	Bracket
1	30QS4225M2	Bracket
1	30QS4244M	Bracket
8	4AM10M2	Huck®-Fit pin
2	71RU21613M	Spacer
1	97AX286	Snap ring
1	90AX20	Rod, cab levelling valve
1	20QE2373	Valve, cab levelling

CHN, CXN, CHU & CXU ONLY

When converting a sleeper chassis to a day cab, the rear cab suspension must be changed. Components necessary for this conversion are available in the cab suspension kit (part number 204SX419). This kit includes the following:

Suspension Kit part number 204SX419 Contents		
Qty.	Part number	Description
2	227QS47M	Spring (airbag), cab rear
2	14QK3103M	Shock absorbers
12	159AM5	Huck®-Spin collar
1	191AM2	Nut
2	20AX3	Nut
4	26AM13	Bolt
2	35AX1026	Washer
2	27AM21	Bolt
2	30QS3579M2	Bracket - Cab Mtg
1	30QS3596M	Bracket - Shock, Rear Cab Mtg LH
1	30QS3596M2	Bracket - Shock, Rear Cab Mtg RH

1	30QS4535M	Bracket - Cab, Rear LH
1	30QS4535M2	Bracket - Cab, Rear RH
2	30QS4538M	Cab Support - Rear
7	49AX283	Plasti-Plug
12	4AM34	Huck®-Spin Bolt
2	36AX1	Lock Washer
2	22AX19	Nut
1	18QK36	Valve, Link
1	30QS3599M	Cab Levelling Valve Bracket - Upper
2	37AX471	Flat Washer
1	26AM14	Screw
4	48RU2313	Band Clamp
2	14QK146	Kit

An optional map pocket is available. The following parts are required for installation of the map pocket:

Qty.	Part number	Description
1	39QR434M2	Map pocket
2	127AM5002	Screws
2	39QR435M2	Covers, screw
2	228AM3	U-nuts
3	400AX35	Screws
3	271AM5006	Washers

When converting a chassis equipped with a high-rise sleeper to a day cab, installation of clearance and marker lamps will be necessary:

Qty.	Part number	Description
5	38MO4105M	Clearance/marker lamp assembly
5	111MO58	Bezel
5	87AX66	Grommet
10	77AM11	Screws

In addition to the above parts, one Rivnut (part number 335AM3) will be required. This Rivnut is included in the hardware kit (part number 204SX405).

For easier access to the area behind the cab for servicing the glad hands and trailer cord, a wider deck plate is available. The wider deck plate covers the gap between the frame rail and the fuel tank on the left-hand side of the vehicle, and allows access to the area behind the cab by way of the fuel tank steps. Installation of the deck plate requires two rubber mounting strips and two rubber pads. Part numbers for these components are as follows:

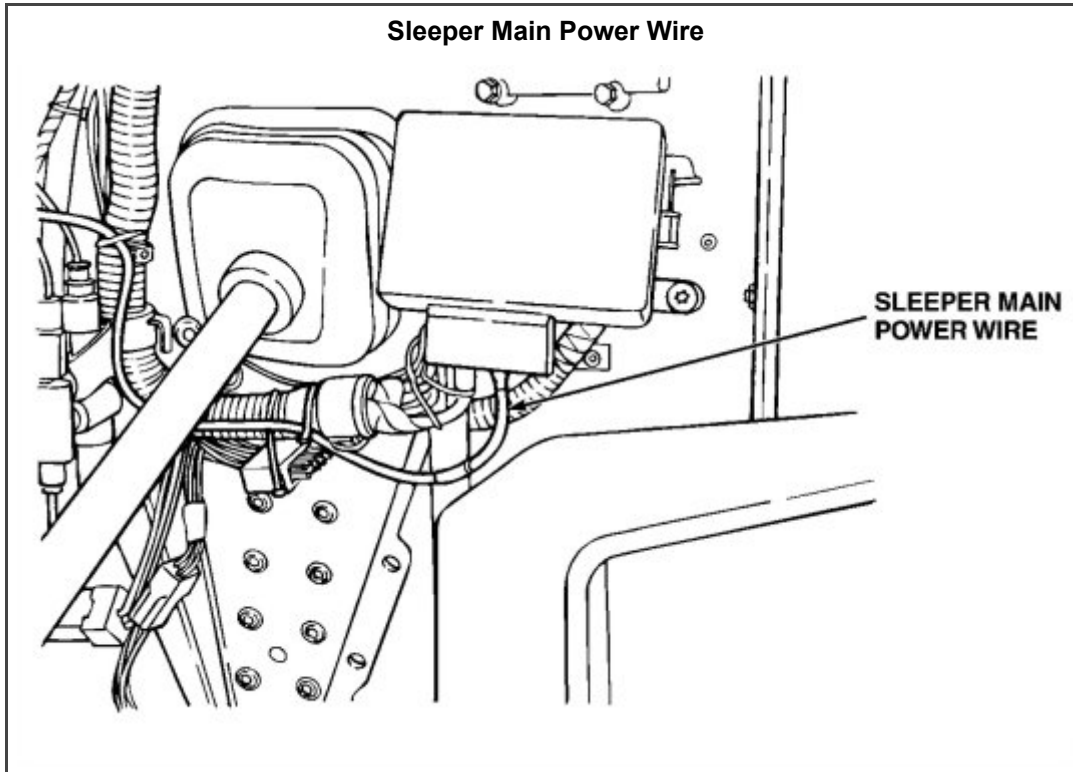
Qty.	Part number	Description
1	39QL4157M	Deck plate
2	12AX147F	Rubber strips
2	39QL2541M	Rubber pads

Sleeper Box Removal

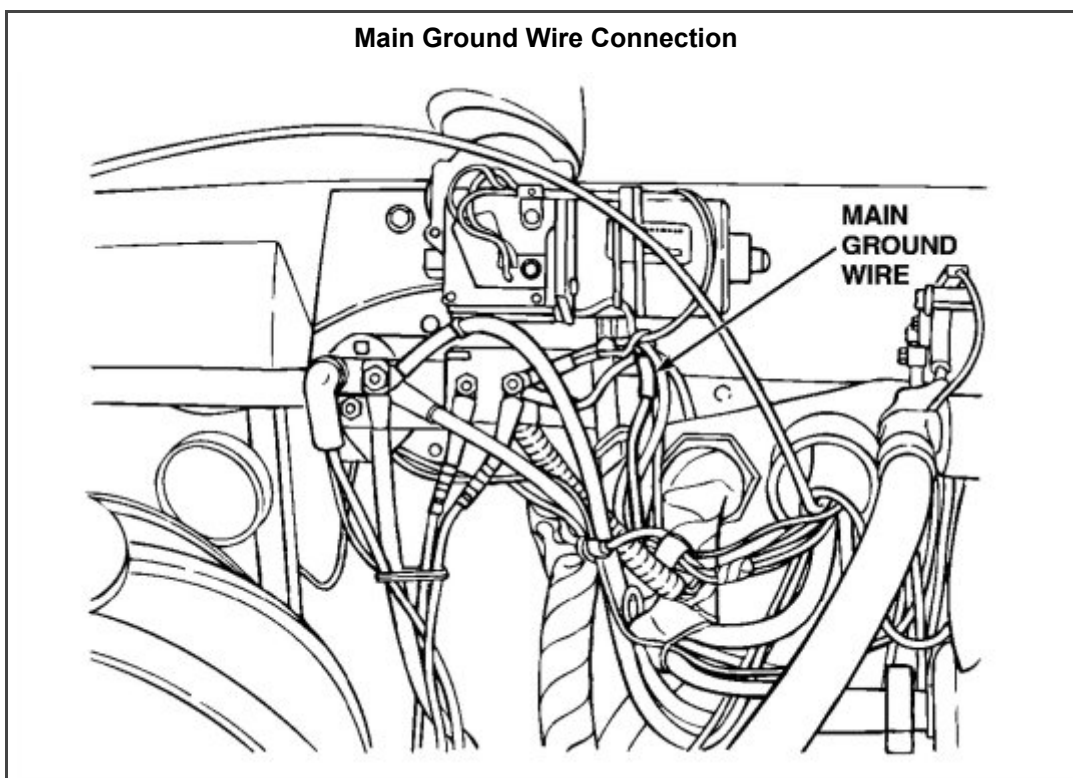
1. Secure the chassis for service, apply the parking brakes and block the rear wheels to prevent the vehicle from moving.
2. Disconnect the batteries by disconnecting the negative cable first, then the positive cable.
3. Evacuate and recover the air conditioning refrigerant.
4. Drain the engine coolant into a suitable container, and retain for refilling the cooling system after the day cab conversion has been completed.

Note: Draining the entire cooling system is not necessary. It is only necessary to drain the system low enough so that the heater hoses can be disconnected.

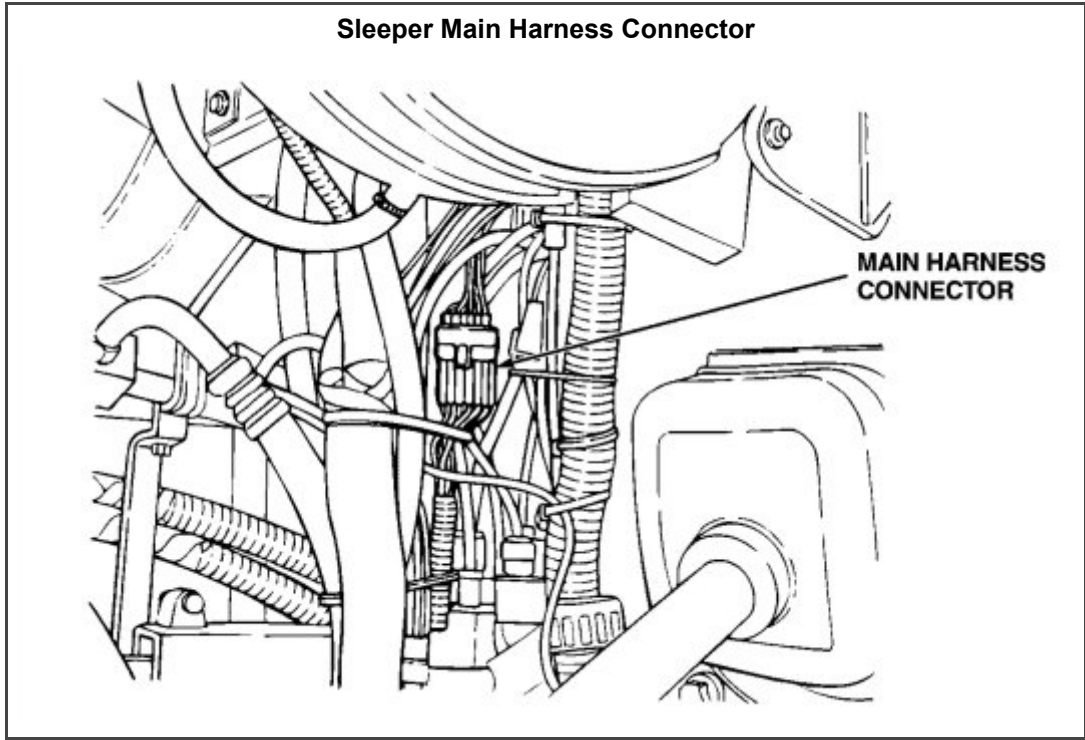
5. Disconnect the sleeper main power wire from the electronic control power module (ECPM). The ECPM is located inside the engine compartment, on the left-hand side of the cab mounted on the bulkhead.



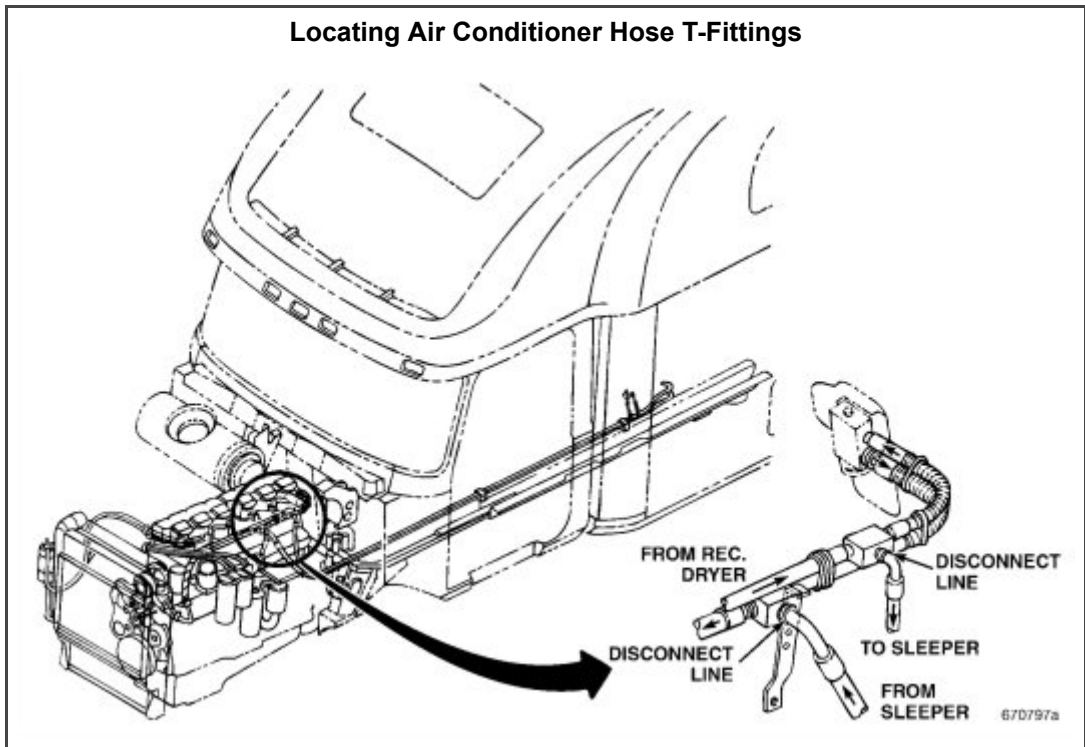
6. Disconnect the sleeper main ground wire, located on the left-hand side of the cab below the windshield wiper motor, secured to the bulkhead.



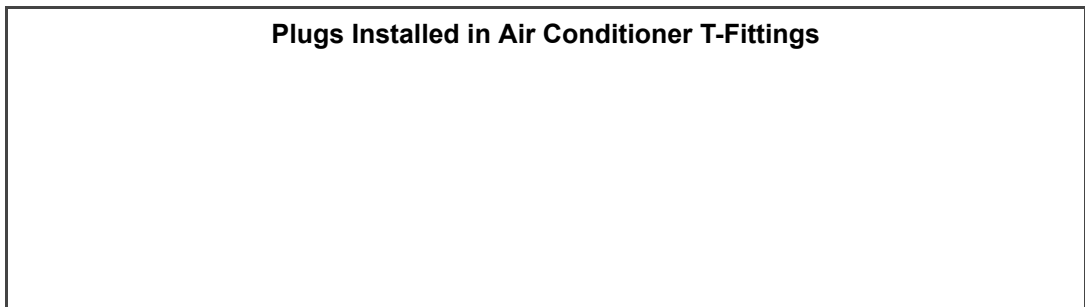
7. Disconnect the sleeper main harness connector which is located on the left-hand side of the cab.

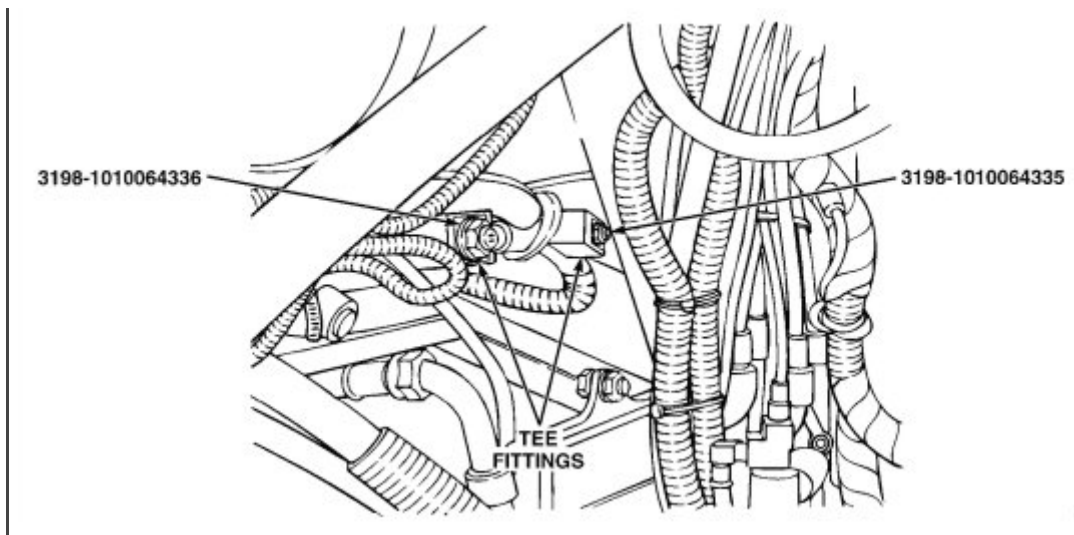


8. Disconnect the air conditioner supply and return hoses that supply the sleeper. These lines are connecting to the main air conditioning system by T-fittings located at the rear of the engine.

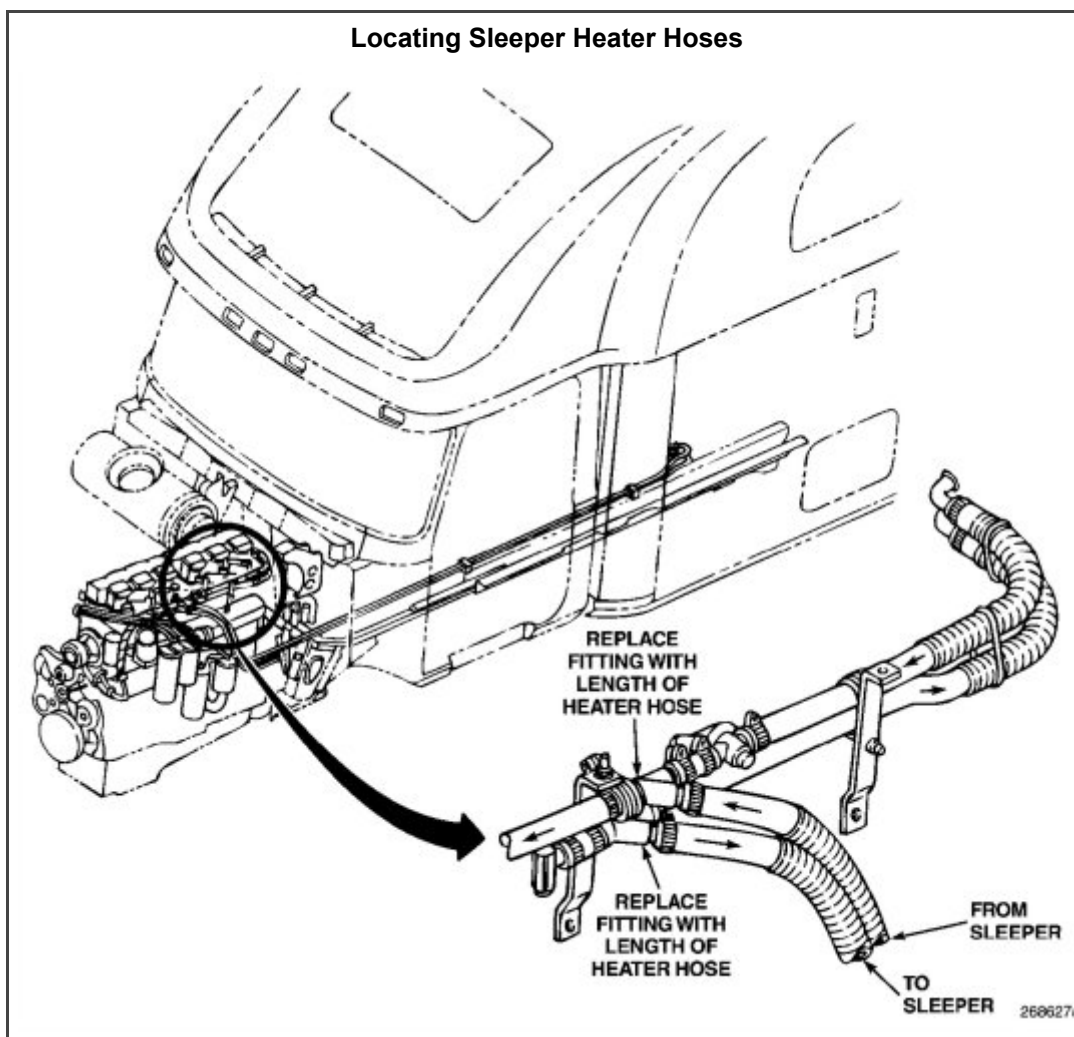


9. After disconnecting the lines, install the two plugs (part Nos. 3198-1010064335 [#6] and 3198-1010064336 [#10], supplied with O-rings) into the T-fittings. These fittings are included in the hardware parts kit.



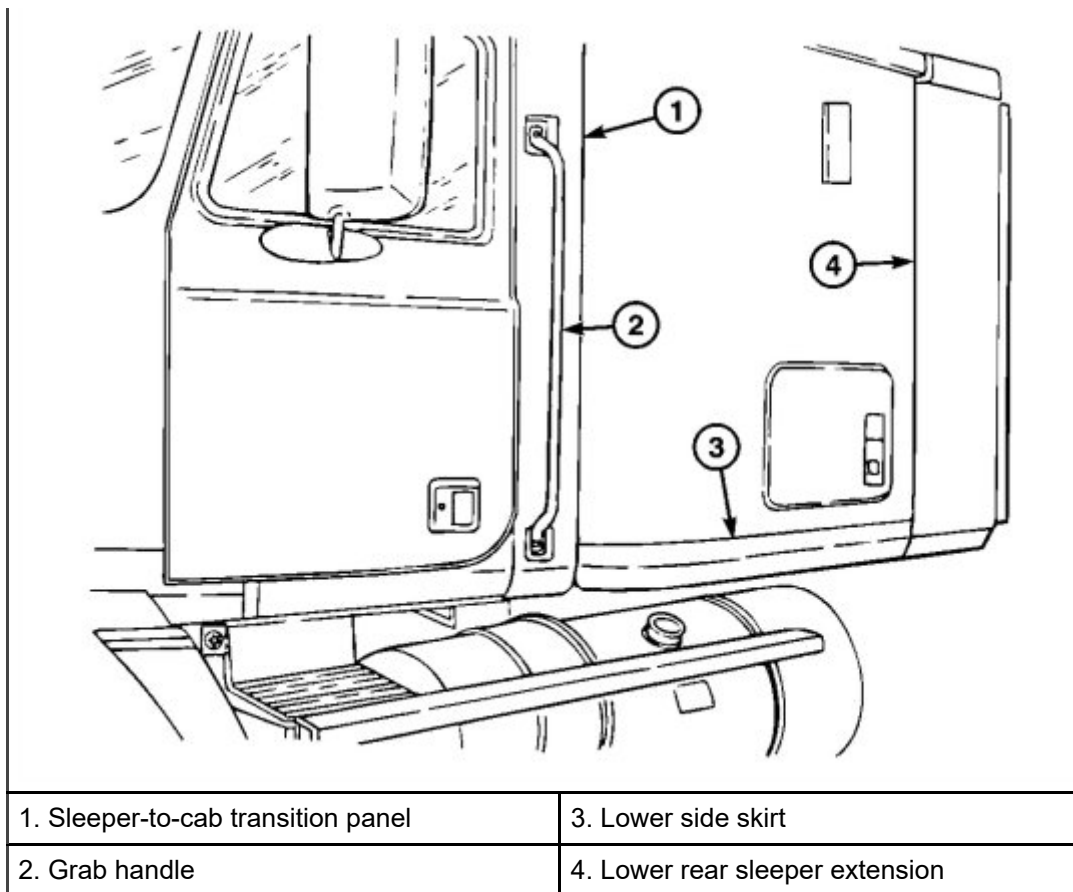


10. Cut the heater hoses that supply the sleeper heater core near the heater hose T-fittings located on the engine.



11. Eliminate the heater hose T-fittings (sleeper coolant supply) by replacing the existing two heater hoses on the engine with a length of new heater hose between the heater shut-off valve (if so equipped) and the port (or valve, if so equipped) at the front of the engine, and a length of new hose between the heater core and the port (or valve, if so equipped) located at the center of the engine.
12. Disconnect the air conditioner and heater hoses located under the sleeper floor from the climate control unit on the sleeper, then remove the hoses from the chassis.
13. Remove the cab entry grab handles from both sides of the cab.
14. Remove the sleeper-to-cab transition panels, the lower rear sleeper extension panels and the lower side skirt panels. After the sleeper-to-cab transition panels have been removed, reinstall the grab handles.

Sleeper Panels



15. Remove the muffler and exhaust stack.

16. Remove the Huck® fasteners that secure the exhaust stanchion to the frame, then remove the stanchion.

Note: For information concerning removal of Huck® frame fasteners, refer to the Frame, Axle and Suspension Service, and Total Vehicle Alignment Manual, 14–103.

17. Remove the exhaust pipe U-clamp from the frame bracket, and the band clamp from the exhaust pipe-to-flex pipe connection, then remove the exhaust pipe from the chassis. Remove the exhaust pipe U-clamp from the frame bracket, and the band clamp from the exhaust pipe-to-flex pipe connection, then remove the exhaust pipe from the chassis.

Note: Do not discard the exhaust pipe. The pipe will be cut to length and reused.

18. Remove the trailer hose coupling plate and glad hand storage bracket, and the pogo stick or towel bar.

19. Remove the fasteners that secure the sleeper to the cab subframe.

20. Clamp the seat air lines to seal, then disconnect the lines from the air seat.

21. Remove the seats and seat base assemblies from both the left- and right-hand sides of the cab for access to the sleeper retaining bolts.

22. Remove the seat belt retractors and the shoulder belt retainers from both the left- and right-hand sides of the chassis.

23. Remove the B-post trim panel, and the sleeper-to-cab header trim.

24. Remove the cab headliner.

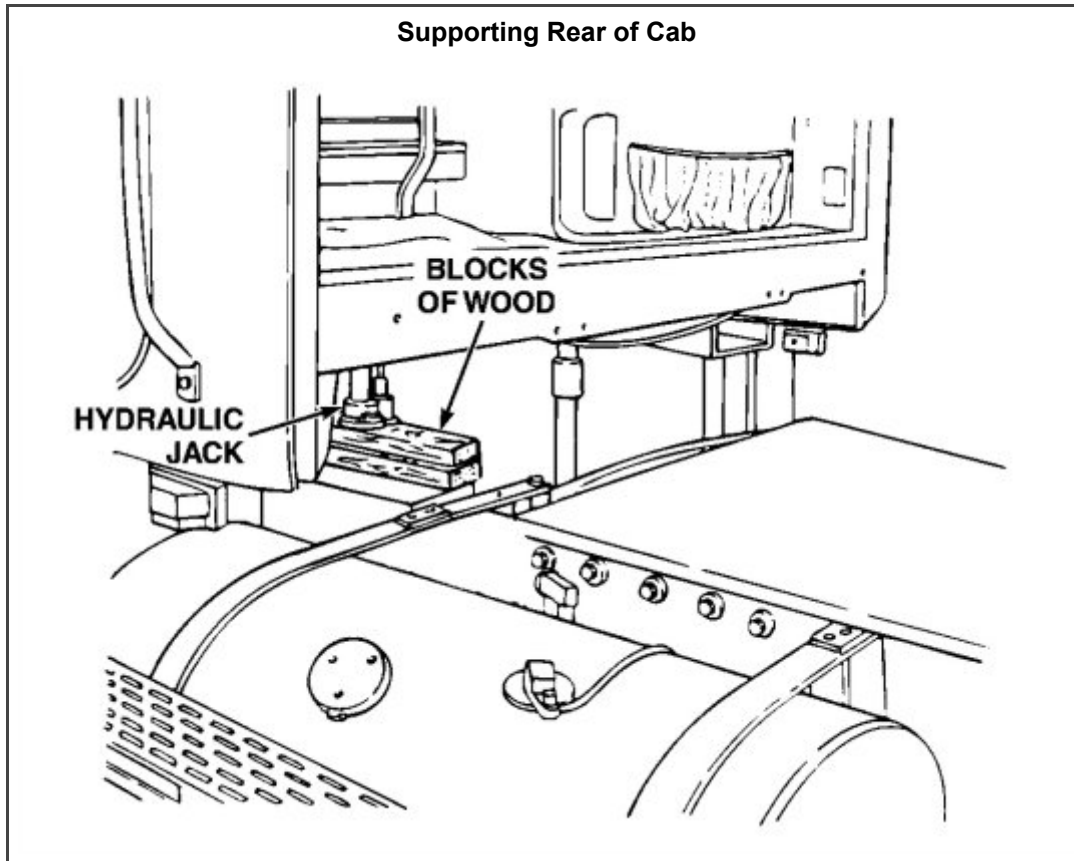
25. From the inside of the cab, remove the sixteen 8 mm bolts that secure the cab to the sleeper, and from the inside of the sleeper, remove the four 10 mm bolts that secure the sleeper to the cab.

Note: For high-rise sleepers only, an air deflector panel may be installed on the forward edge of the cab roof, below the sleeper shelf floor. This panel must be removed prior to removing the sleeper from the chassis. The mounting bolt holes in the cab roof for the air deflector must be sealed with silastic sealant. Refer to service bulletin SB-610-005 for additional information.

26. Slide the sleeper box rearward, away from the cab approximately 2 inches (far enough that the sleeper disengages the guide pins that protrude from the cab). The sleeper box can now be removed from the chassis by using two forklifts, or by using hydraulic jacks to raise the sleeper high enough so that straps can be slid underneath, for removal with either a hoist or overhead crane.

Sleeper Box subframe Removal

1. Using a hydraulic jack and wooden blocks as needed, support the rear of the cab.



2. Remove the sleeper box-to-cab subframes, along with all sleeper box suspension components.
3. Remove the Huck® fasteners that secure the sleeper suspension brackets to the frame, then remove the brackets.

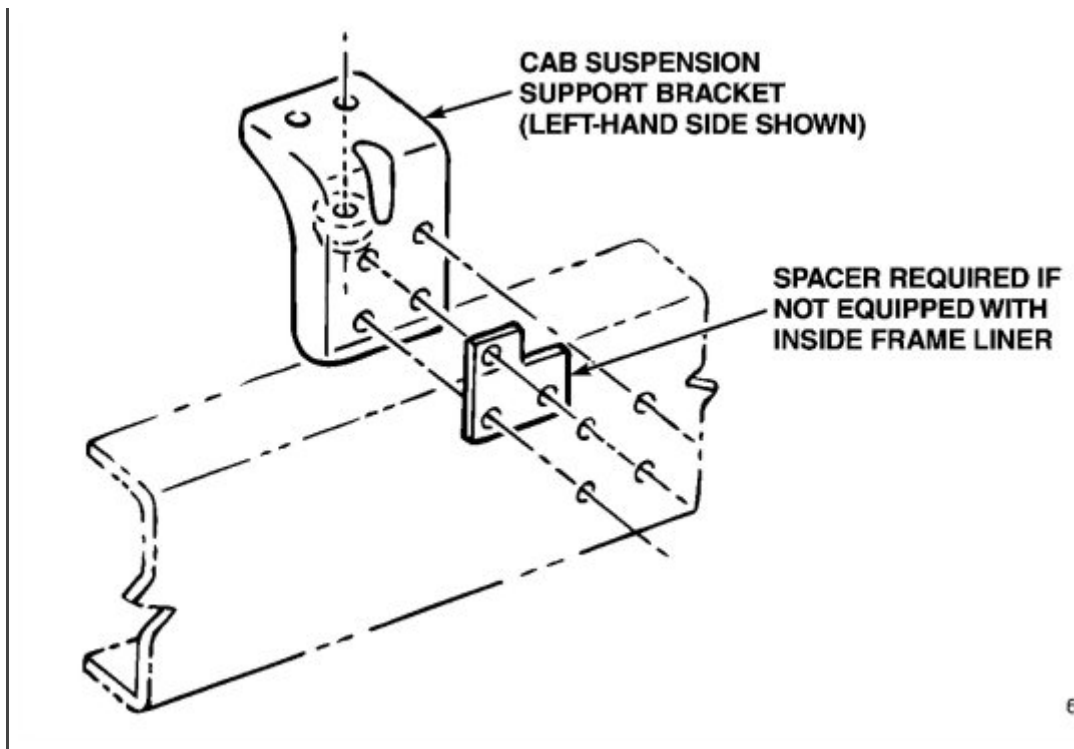
Cab Suspension Installation



The fuel tanks must be removed for access to the frame. The fuel tanks can be removed without draining the fuel if a jack or dolly with a suitable cradle is used to support the tanks. Fuel tanks filled with fuel are heavy. Use care if the tanks are removed without draining the fuel.

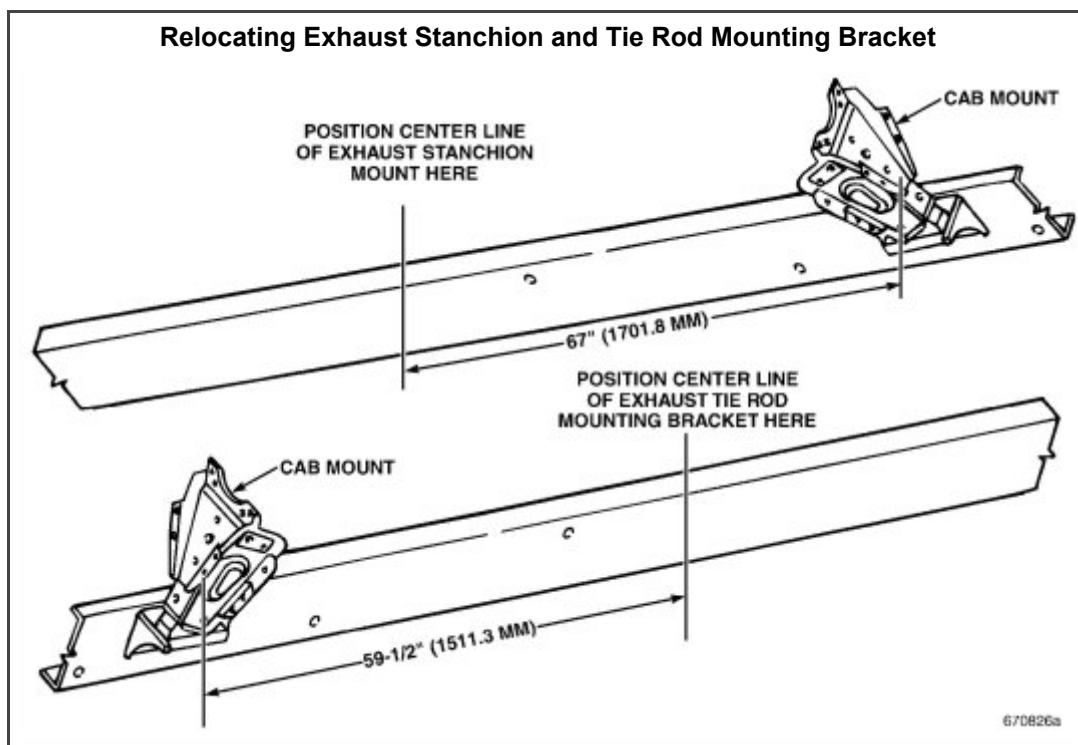
1. Drain the fuel from the fuel tanks, if necessary
2. Disconnect the fuel lines from the fuel tanks, and disconnect the harness connectors from the fuel tank sending units on both sides of the vehicle.
3. Place a suitable jack or dolly under the fuel tank to be removed.
4. Remove the nuts from the fuel tank strap T-bolts, then remove the tanks from the support brackets. Move the tanks away from the frame on both sides of the chassis.
5. Remove the Huck® fasteners that secure the forward fuel tank J-bracket, exhaust stanchion and exhaust tie rod frame-mounted bracket. These components must be removed so that the cab suspension frame brackets can be installed.
6. Install the left- and right-hand cab suspension support brackets (part number 30QS4224M3) to the frame.

Installing Cab Suspension Support Brackets



Note: Chassis having single frame rails without an inside frame liner will require spacers between the inside of the frame rail and the cab suspension support bracket. These spacers (part number 71RU21613M) are included in the suspension kit.

7. Use Huck® pins (part number 4AM10M2) and collars (part number 159AM2) to secure the cab suspension support brackets in place.
8. To provide adequate clearance between the cab and muffler, the exhaust stanchion and frame mounted tie rod bracket must be relocated as follows:
 - Locate the center line of the exhaust stanchion 67" (1701.8 mm) from the center line of the front cab-to-chassis isolator mount.
 - Locate the center line of the exhaust stanchion tie rod mounting bracket 59.5" (1511.3 mm) from the center line of the front cab-to-chassis isolator mount.



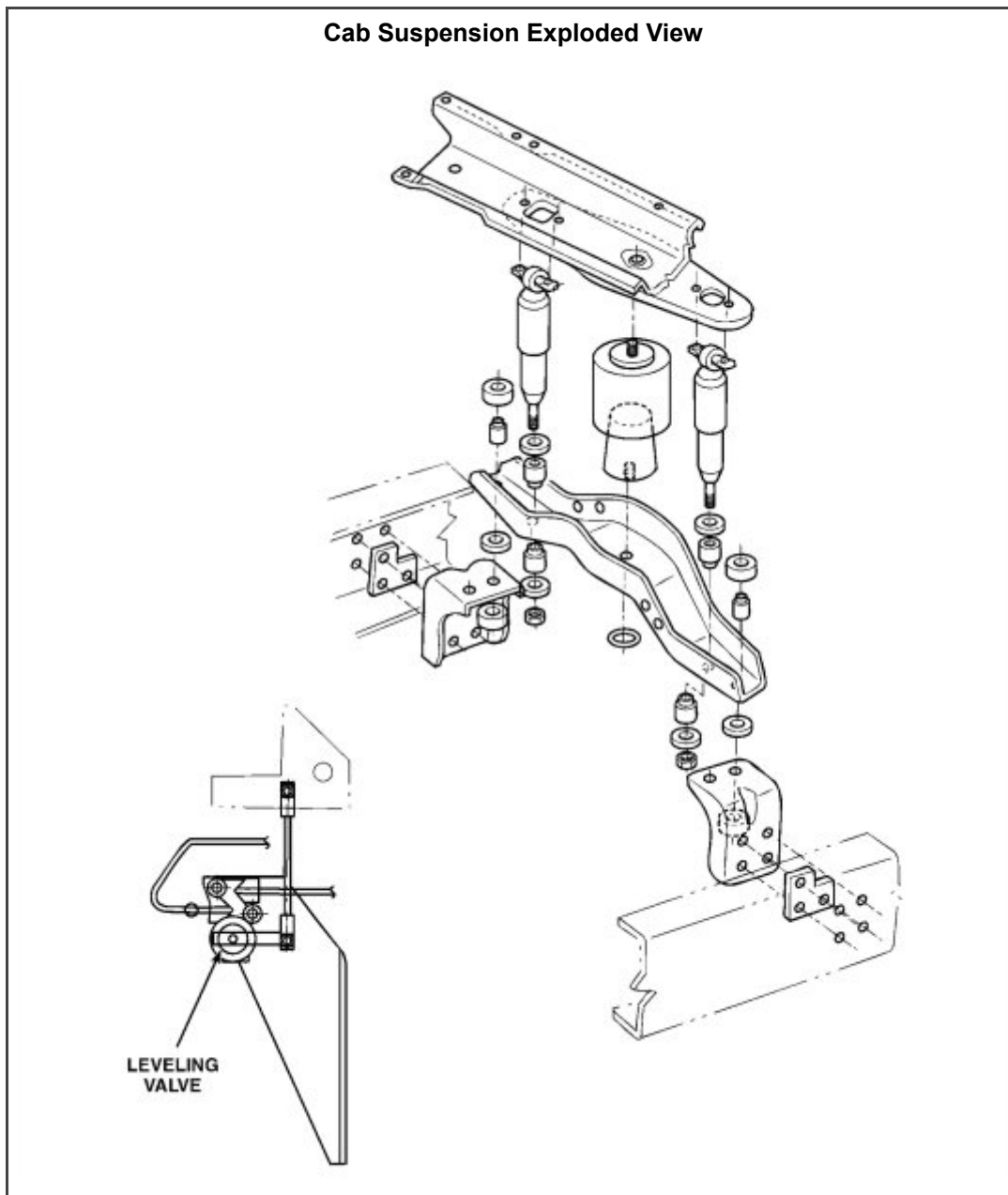
9. Using Huck® frame fasteners of proper length, reinstall the crossmembers to the frame where the sleeper suspension frame brackets were attached.

Note: A variety of Huck®-Fit frame fasteners of different lengths and diameters are available through the MACK Parts System. Lengths of the fasteners required are determined by the thickness of the frame and brackets to be secured.

Clean grease and dirt from all mating surfaces of the components to be secured prior to assembling the components and installing the Huck®-Fit fasteners.

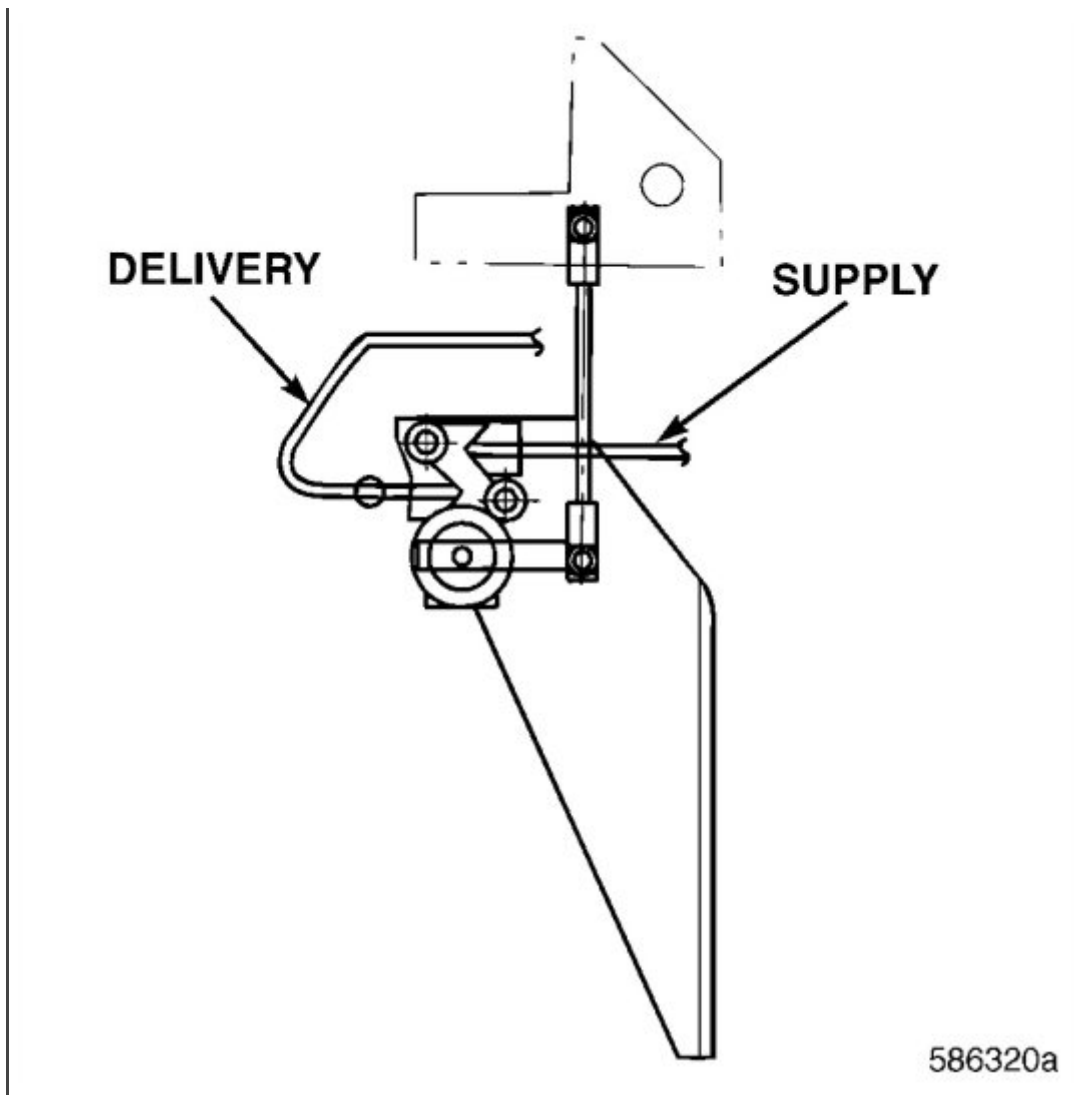
Installation of certain mounting brackets to the frame will require shims to properly align the brackets where on the original installation, the mounting bracket was mounted on top of another bracket that has now been eliminated with the removal of the sleeper.

10. Install the cab suspension crossmember to the frame, then install the cab airbag mounting bracket to the underside of the cab.
11. Install the cab airbag and cab shock absorbers.
12. Install the cab leveling valve (part No. 20QE2373) and linkage rod (90AX20), both included in the suspension kit. When installing the linkage rod, use the threaded rod ends and jam nuts from the original levelling valve linkage rod.



13. Shorten and connect the supply air line to the cab levelling valve. Connect the delivery line from the levelling valve to the airbag.

Cab Leveling Valve Air Lines



14. Remove the hydraulic jack and wooden blocks from underneath the cab.
15. Charge the air system, then adjust cab ride height to 7.671 ± 0.05 " (194.84 ± 1.27 mm) as outlined in service bulletin SB-668-008.

Note: If the air system has been drained, the system can be refilled with clean, dry shop air.

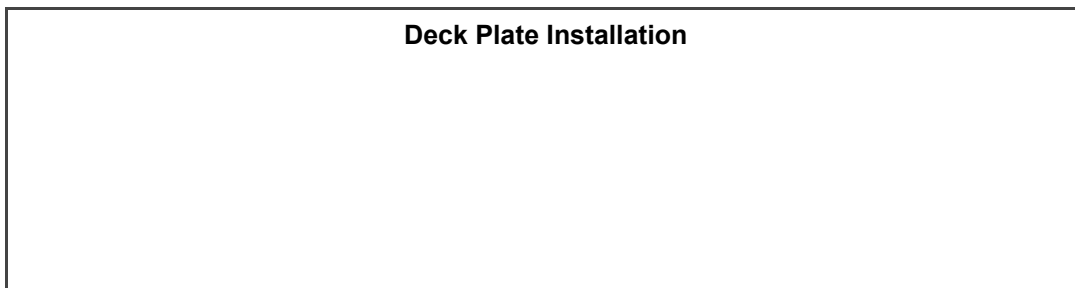
16. Reinstall the fuel tanks and reconnect the fuel lines and fuel level sending unit harness connectors.

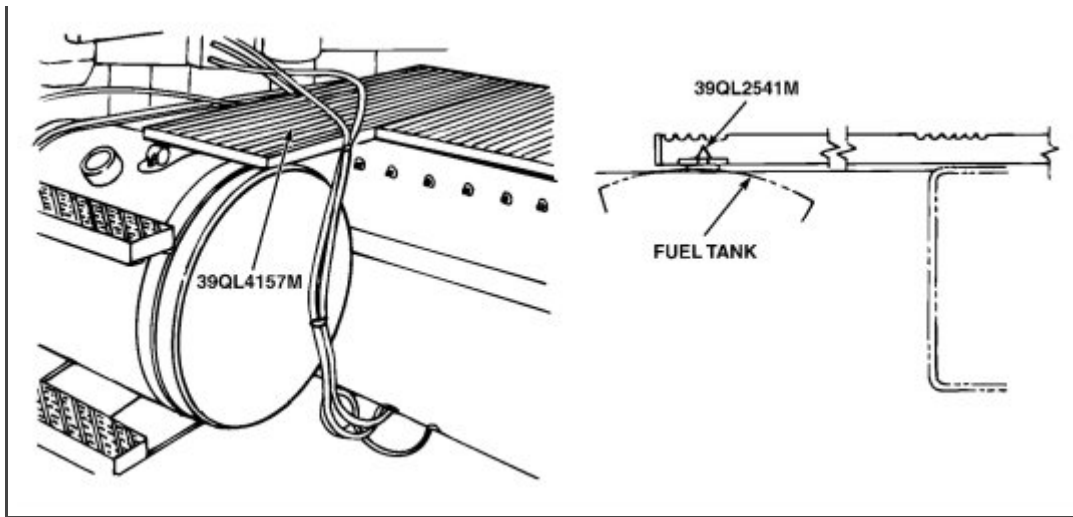
Note: Do not install the muffler and exhaust pipe at this time.

Wider Deck Plate Installation (Optional)

1. Remove the existing deck plate.
2. Remove the existing frame insulating rubber mounting strips.
3. Cut two pieces of rubber insulating strips (part number 12AX147F), long enough for both the wide deck plate and the original deck plate, then install the strips on the flange of the frame rail. Using two rubber pads (part number 39QL2541M), install the new wide deck plate (part number 39QL4157M) to the frame rails directly behind the cab. Install the original deck plate to the rear of the wide deck plate.

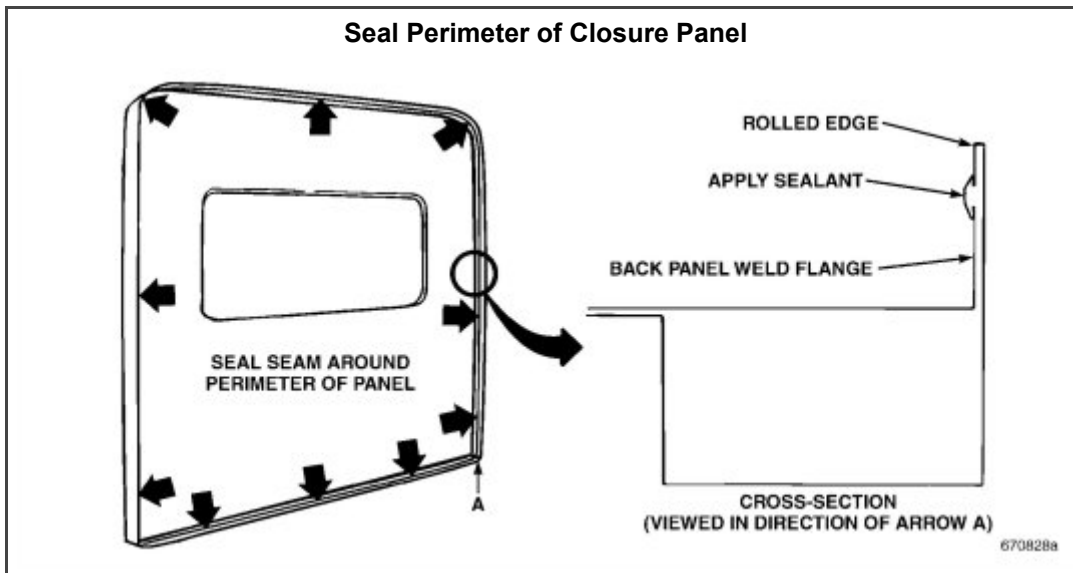
Deck Plate Installation



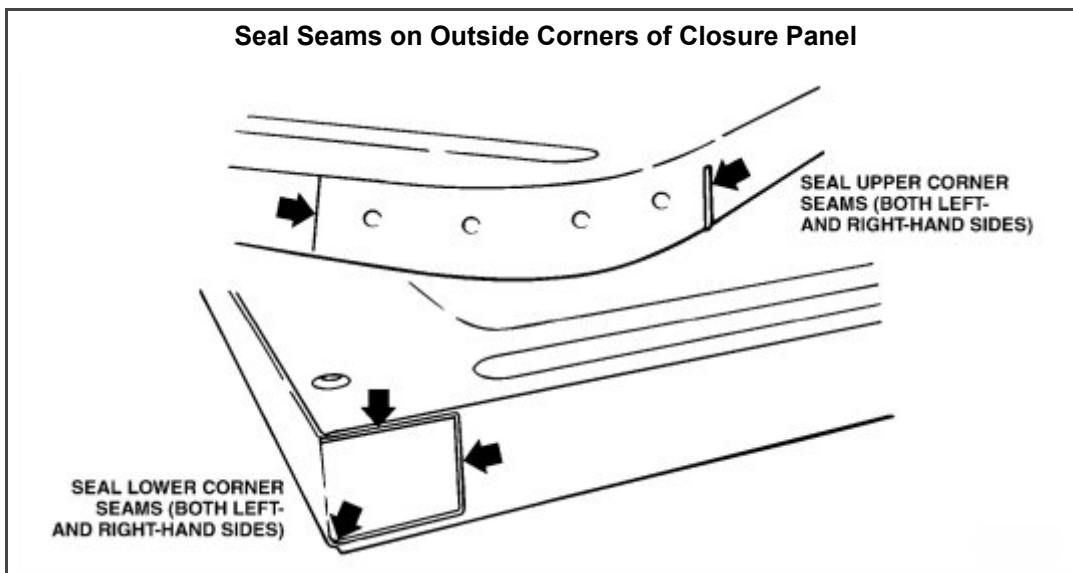


Preparing Closure Panel for Painting

1. Using a commercial grade automotive sealer, seal the entire seam around the perimeter of the closure panel where the rolled edge of the sheet metal wraps around the inboard side and butts against the return flange of the back sheet metal panel.

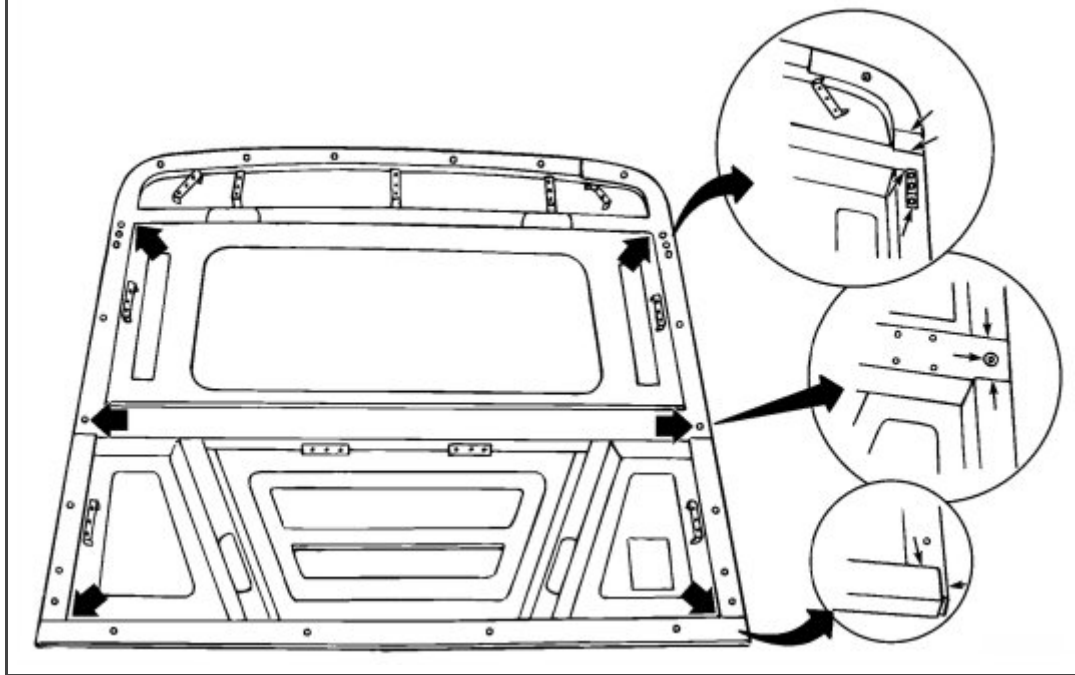


2. Seal all seams along the outside corners of the closure panel.



3. Seal seams on the gasket mating surface of the closure panel.

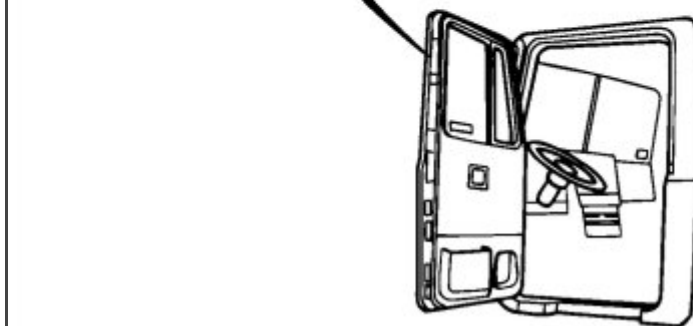
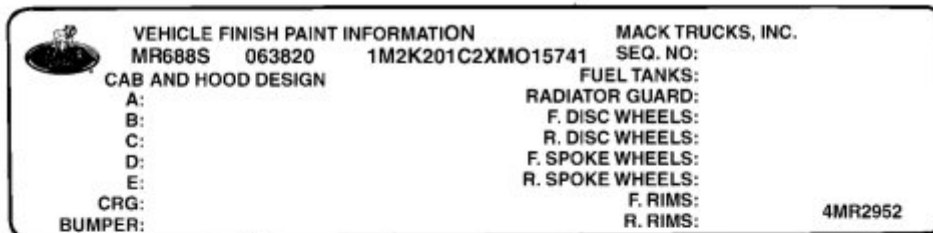
Seal Seams on Gasket Mating Surface



4. Paint the closure panel to match the color of the cab.

Note: The cab paint color code can be found on the paint code label located on the cab door edge.

Cab Paint Code Label

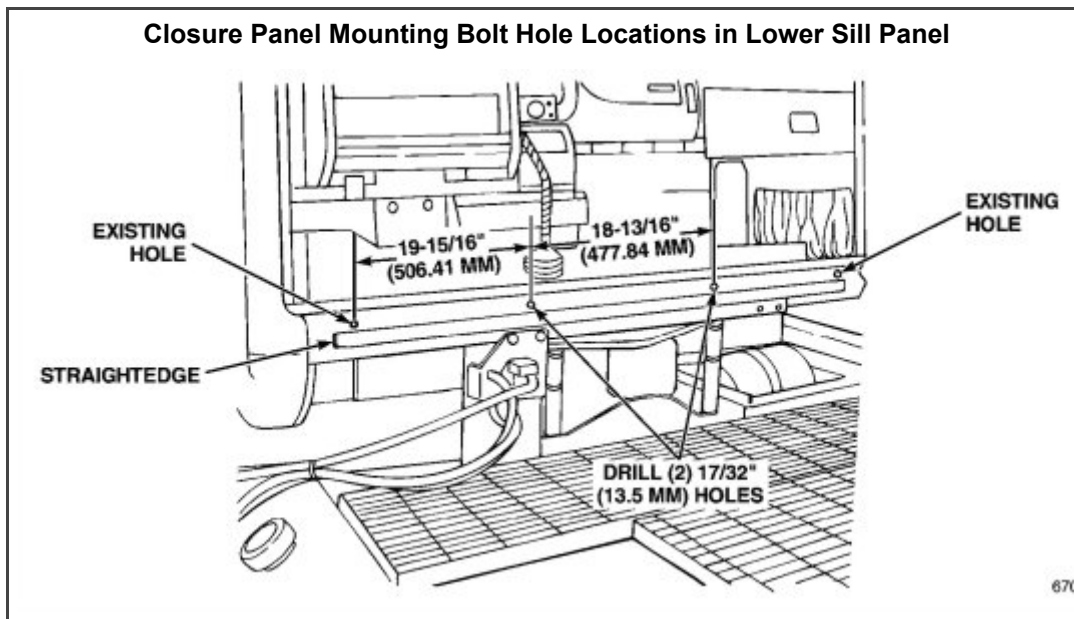


Paint the entire panel, inside and out, making sure to apply enough paint to the gasket mating surface and on the inside of the window pinch weld opening. Allow sufficient time for the paint to cure before handling the panel.

Note: The four reinforcement brackets may also be painted if so desired.

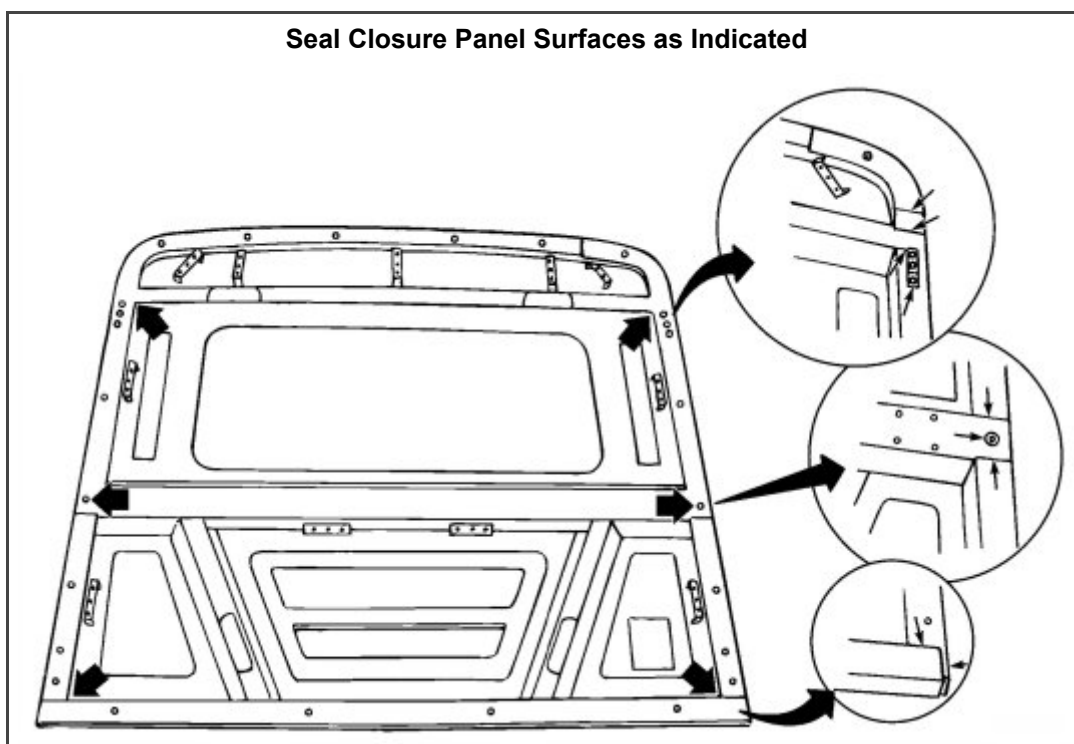
Closure Panel Installation

1. Mark the locations in the rear face of the lower sill panel where two $17/32$ " (13.5 mm) closure panel mounting bolt holes must be drilled as follows:

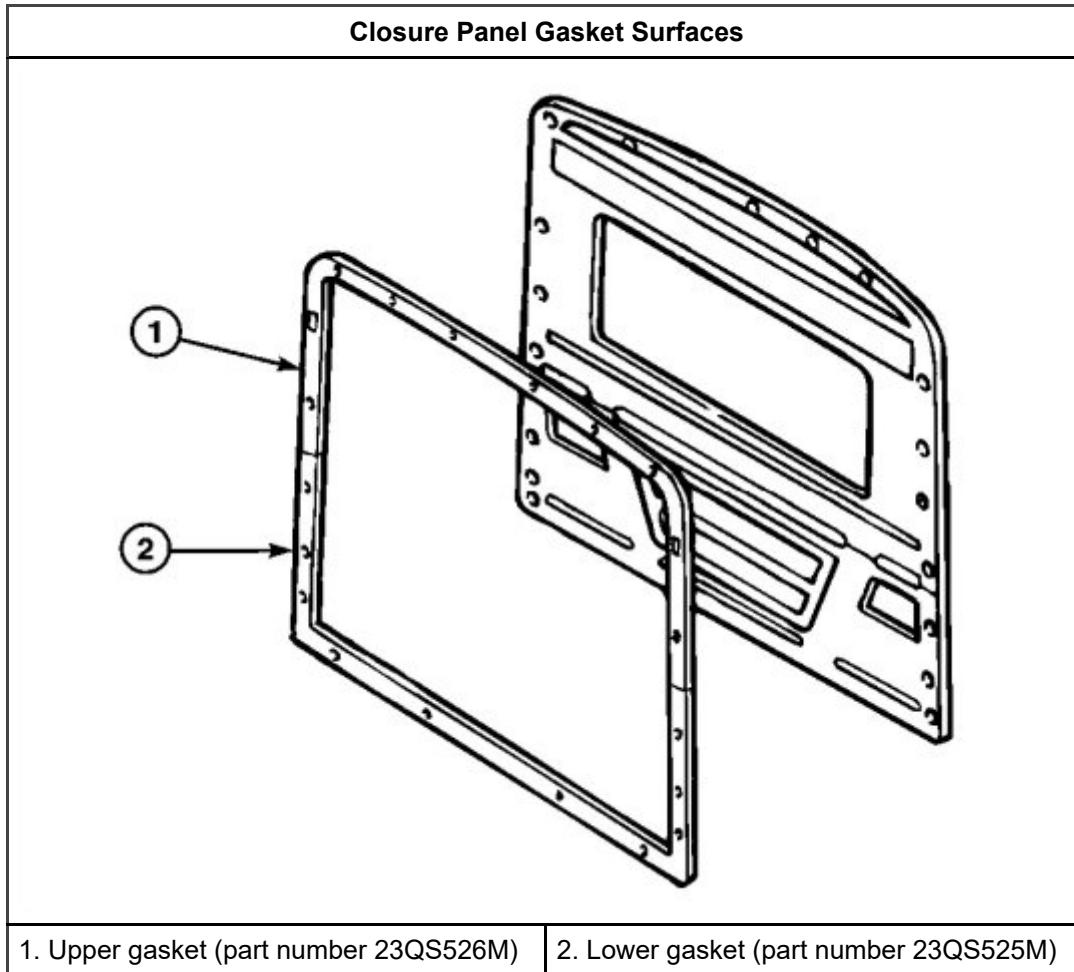


Note: If the sheet metal at the two existing outer sleeper mounting holes in the lower sill panel is deformed and "pulled-out" due to the sleeper mounting bolts, straighten the sheet metal by holding a sledge hammer against the front side of the lower sill panel and using a light hammer to gently tap the sheet metal flat.

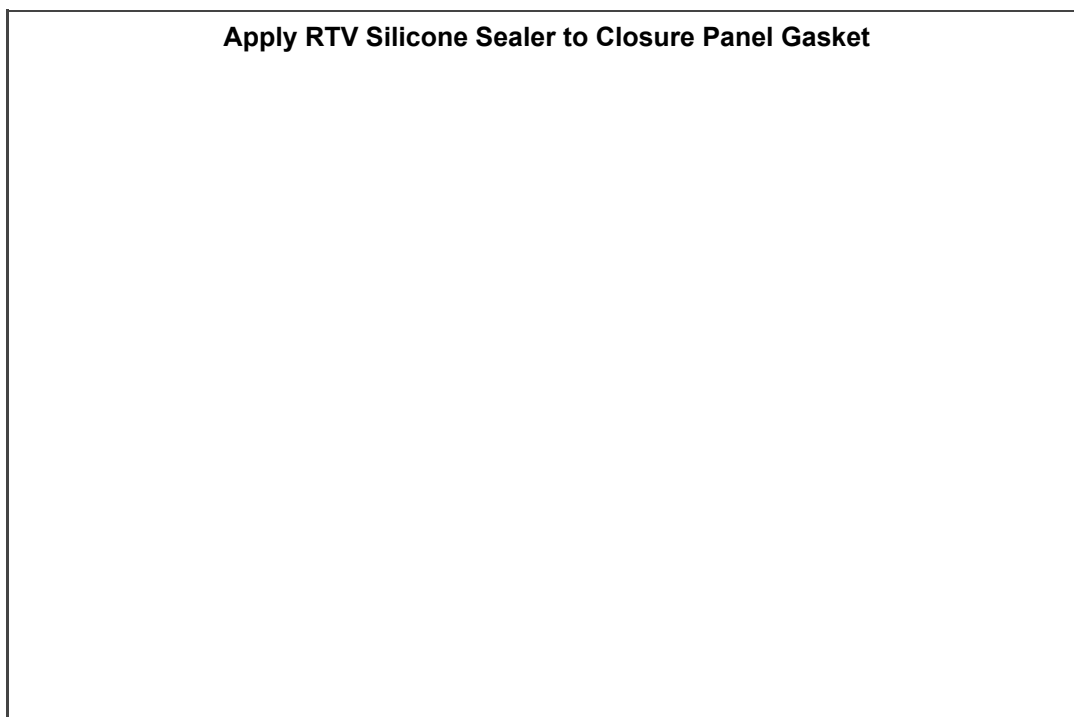
- a. Place a straightedge along the horizontal center line of the two outer sleeper box mounting bolt holes in the lower sill.
 - b. Mark the location for the first hole that is to be drilled in the lower sill $19-15/16$ " (506 mm) from the center of the existing mounting bolt hole on the left-hand side of the cab.
 - c. Mark the location for the second hole that is to be drilled in the lower sill $18-13/16$ " (478 mm) from the center of the marked location for the first hole.
 - d. Center punch the two marked locations.
 - e. Drill two $17/32$ " (13.5 mm) holes at the marked locations in the rear face of the lower sill panel.
2. Position the closure panel face down on a padded surface to prevent marring the paint (sturdy saw horses covered with carpet are recommended).
 3. Using RTV silicone sealer (part number 342SX32), apply a bead of sealant along the seam edges and mounting bolt hole recesses. Sealant is being applied to these areas to provide a smooth transition for the closure panel upper and lower gaskets.

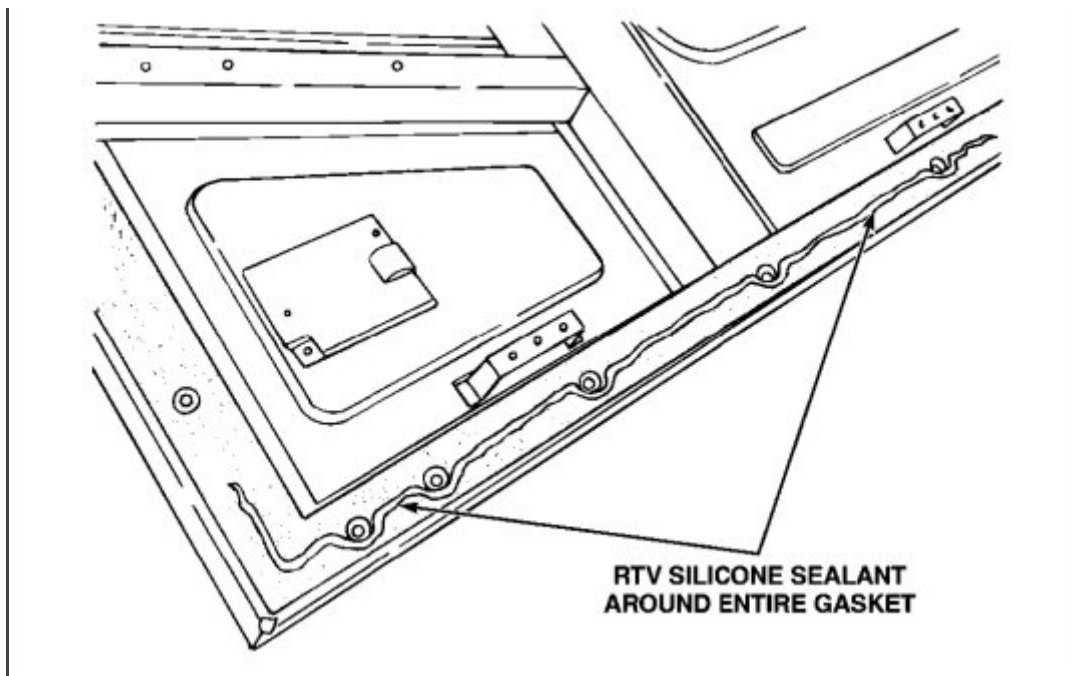


4. Peel the protective paper from the closure panel gaskets (part Nos. 23QS525M for the lower gasket, and 23QS526M for the upper gasket) to expose the adhesive.
5. Apply the upper and lower gaskets to the gasket mating surface of the closure panel.

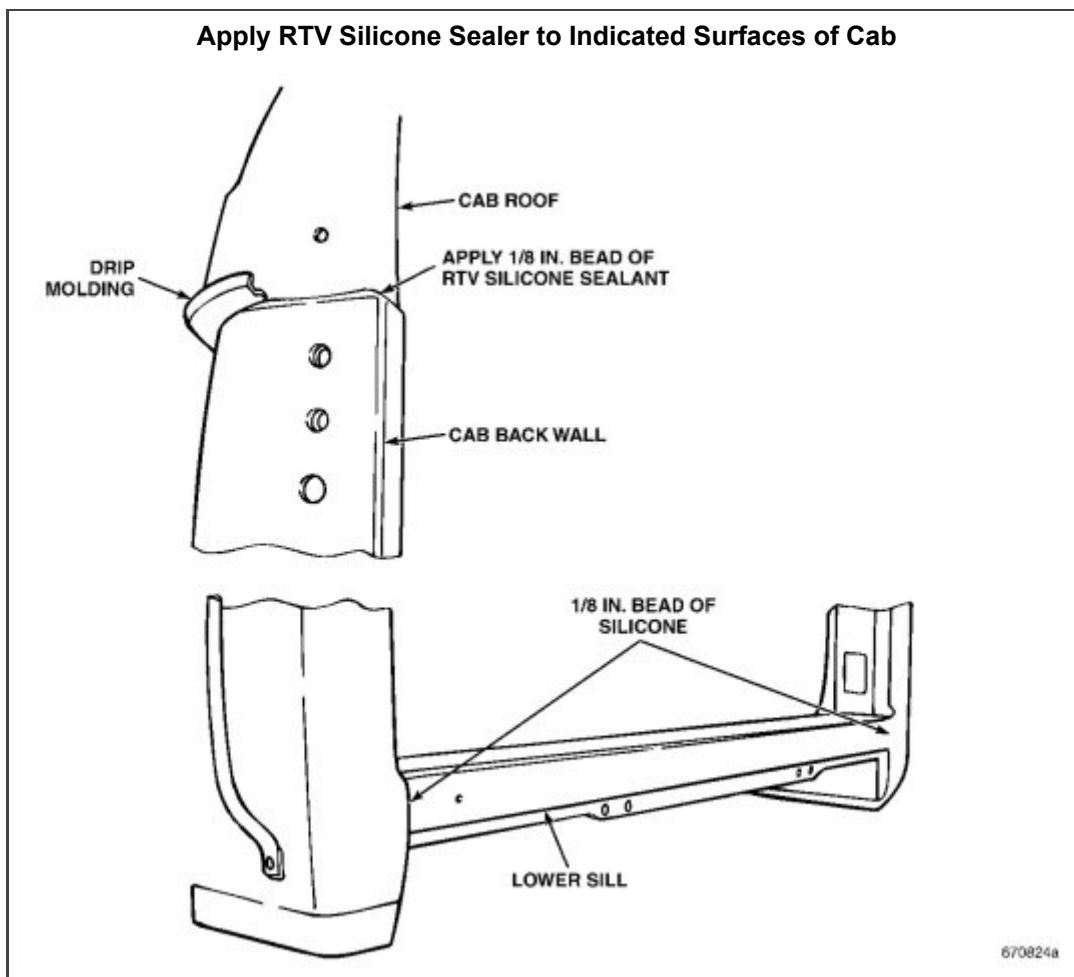


6. Install flat washers (part number 271AM8) onto fourteen 8 mm by 30 mm long closure panel mounting bolts (part number 26AM14) and four 8 mm by 25 mm long mounting bolts (part number 29AM10).
7. Install flat washers (part number 271AM10) on four 10 mm by 70 mm long mounting bolts (part number 27AM9).
8. Apply a 1/8" (6.35 mm) bead of RTV silicone sealer (part number 342SX32) to the surface of the closure panel seals as indicated in the following illustration. Apply the silicone sealer to the seal around the entire panel.



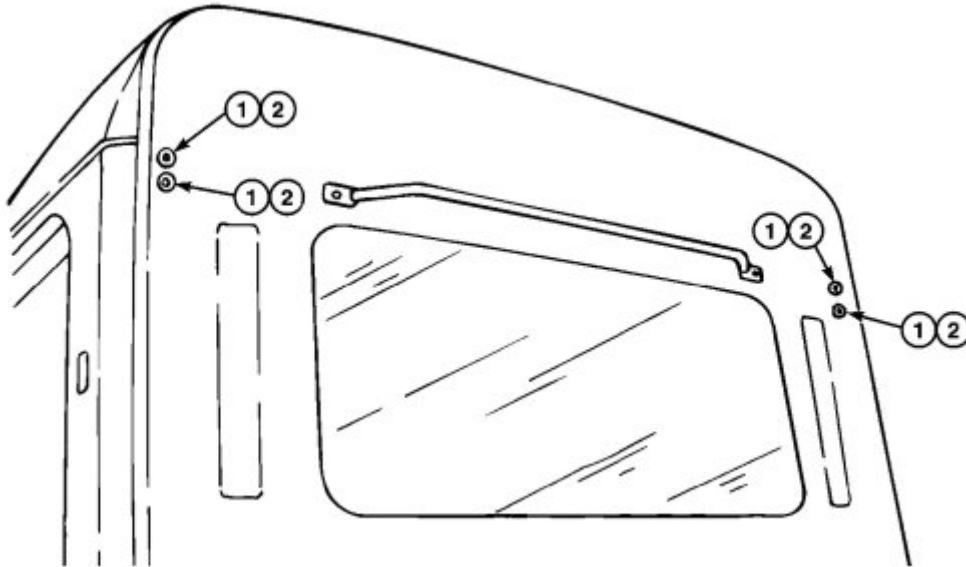


9. Apply a 1/8" (6.35 mm) bead of RTV silicone sealer to the closure panel mating surface on the back of the cab at the areas indicated in the following illustrations.



10. Apply RTV silicone sealer to the shanks and Loctite® 242 to the threads of the four 10 mm closure panel mounting bolts (part number 27AM9).
11. Find the two locating pins on the back of the cab, and the corresponding locating holes in the closure panel.
12. Lift the closure panel into place at the back of the cab and align the locating pins on the cab with the mating locating holes in the closure panel. Once aligned, push the panel forward until the gasket contacts the cab.
13. Install the four 10 mm bolts (part number 27AM9) and washers (part number 271AM10) through the closure panel mounting holes and into the cab. Tighten the bolts until snug.

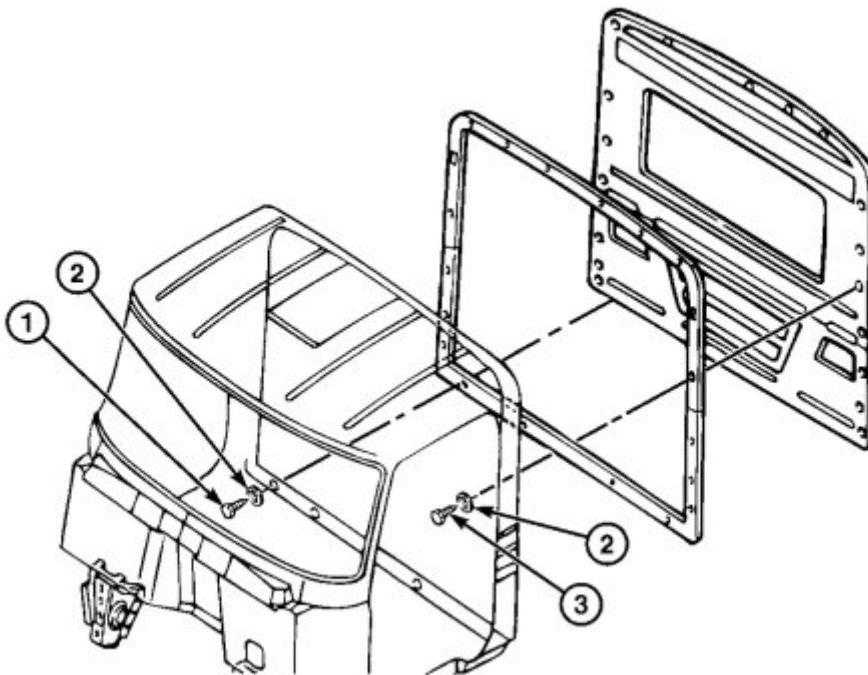
Closure Panel Mounting Bolts — Outside Cab



Key	Qty.	Part number	Description
1	4	27AM9	Bolt, M10 x 1.50 x 70 mm long
2	4	271AM10	Washer, M10

14. Apply Loctite® 242 to the threads of the closure panel mounting bolts. Install mounting bolts and flat washers, and tighten each until snug.

Closure Panel Mounting Bolts — Inside Cab



Key	Qty.	Part number	Description
1	4	29AM10	Cab sill-to-closure panel mounting bolt, M8 x 1.25 x 25 mm long
2	18	271AM8	Flat washer, 8 mm
3	14	26AM14	Cab-to-closure panel mounting bolt, M8 x 1.25 x 30 mm long, with conical point

15. Using a random criss-cross pattern, tighten each of the closure panel mounting bolts to the following torque specification:

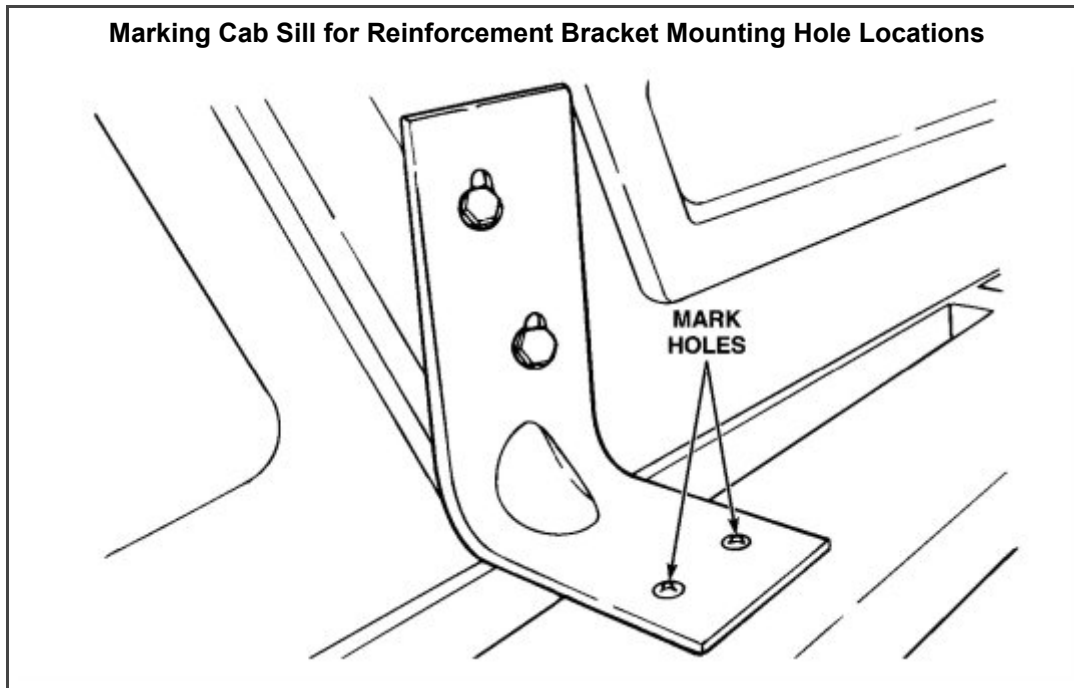
- 8 mm bolts inside cab (29AM10 and 26AM14) — 15 lb-ft (20 N·m)
- 10 mm bolts back of cab (27AM9) — 40 lb-ft (54 N·m)

16. Clean any silicone sealant from the painted surfaces that may have oozed from the joint between the closure panel and cab. Also clean any sealant from around the four bolts installed in the back of the closure panel.

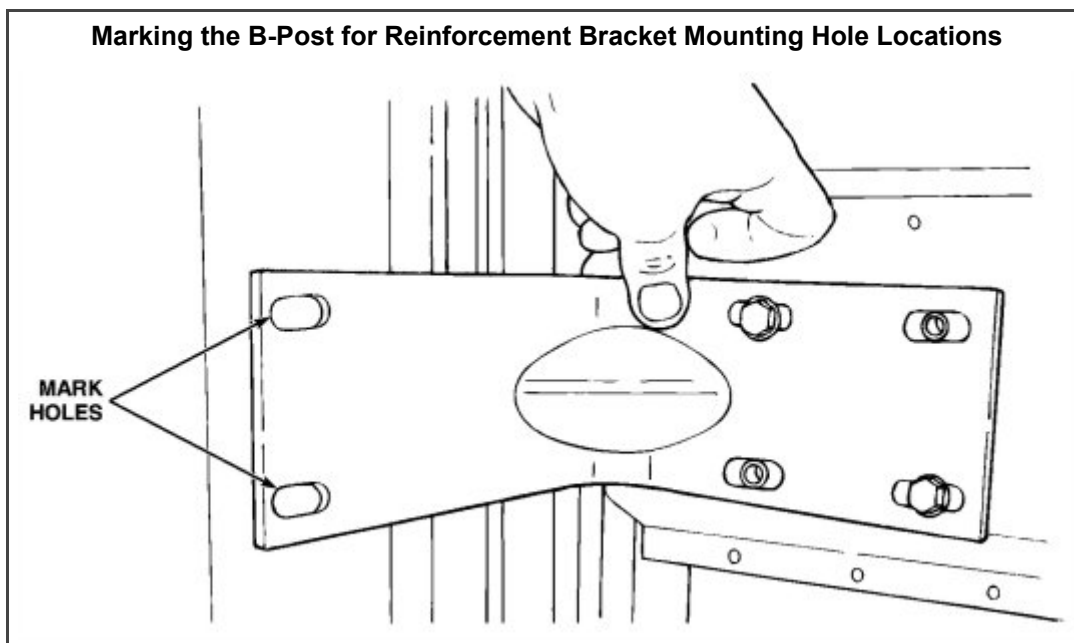
Note: Although the four 10 mm outer mounting bolts and washers are plated, they must be painted to prevent oxidation.

17. Temporarily install the four cab-to-closure panel reinforcement brackets (two brackets are installed at the bottom of the closure panel and two brackets are installed on the the left- and right-hand sides of the closure panel). Use eight 8 mm bolts (part No. 26AM14).

18. At the two bottom reinforcement brackets, use a center punch to mark the locations where the bracket mounting holes must be drilled in the cab sill.



19. At the two corner reinforcement brackets, use a center punch to mark the locations where the bracket mounting holes must be drilled in the B-post.



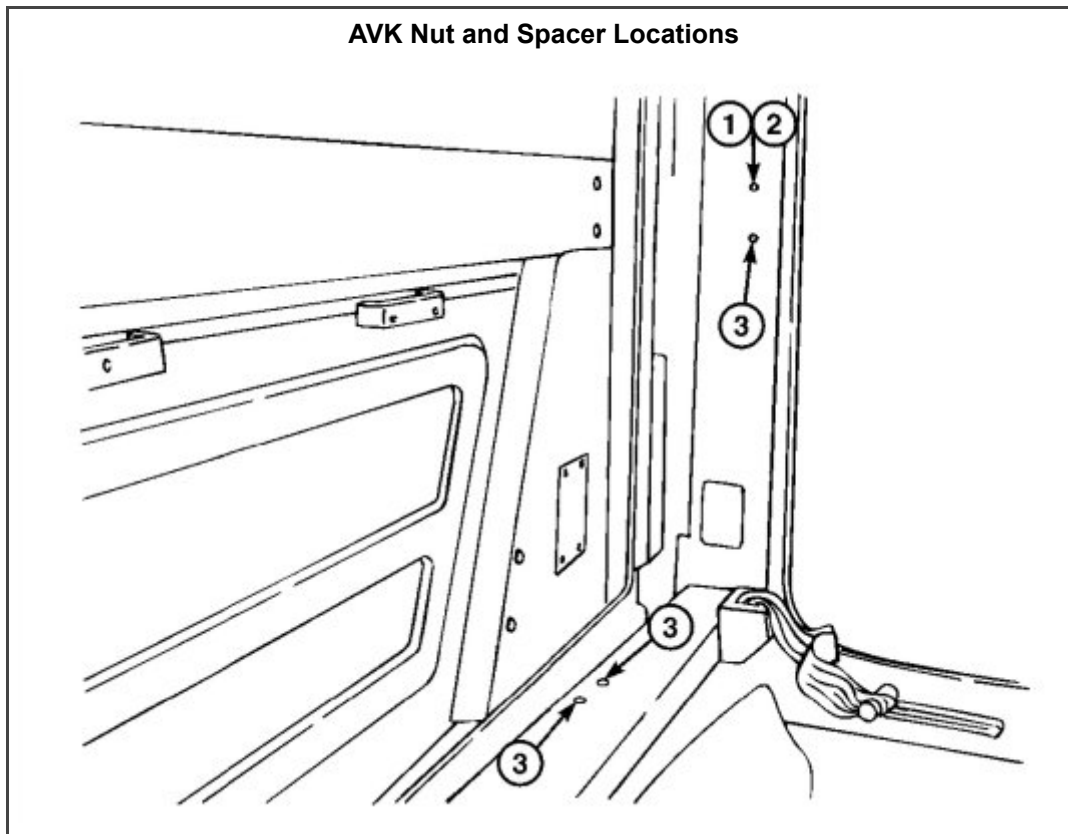
20. Remove the four reinforcement brackets

21. Drill a pilot hole at each of the eight mounting bolt hole locations, then use a 17/32" drill bit to enlarge the holes.

22. Using the AVK installation tool, install AVK nuts at the locations as follows:

- Install four AVK nuts (part No. 335AM14) into the holes drilled in the cab sill.

- Install two AVK nuts (part No. 335AM14) into the lower mounting holes in the B-post on both sides of the cab.
- Install two AVK nuts (part No. 545-2C2239342) and two spacers (545-2PH265209) into the upper mounting holes in the B-post on both sides of the cab.



Key	Qty.	Part number	Description
1	2	545-2C2239342	AVK nut
2	2	545-2PH265209	Spacer
3	6	335AM14	AVK nut

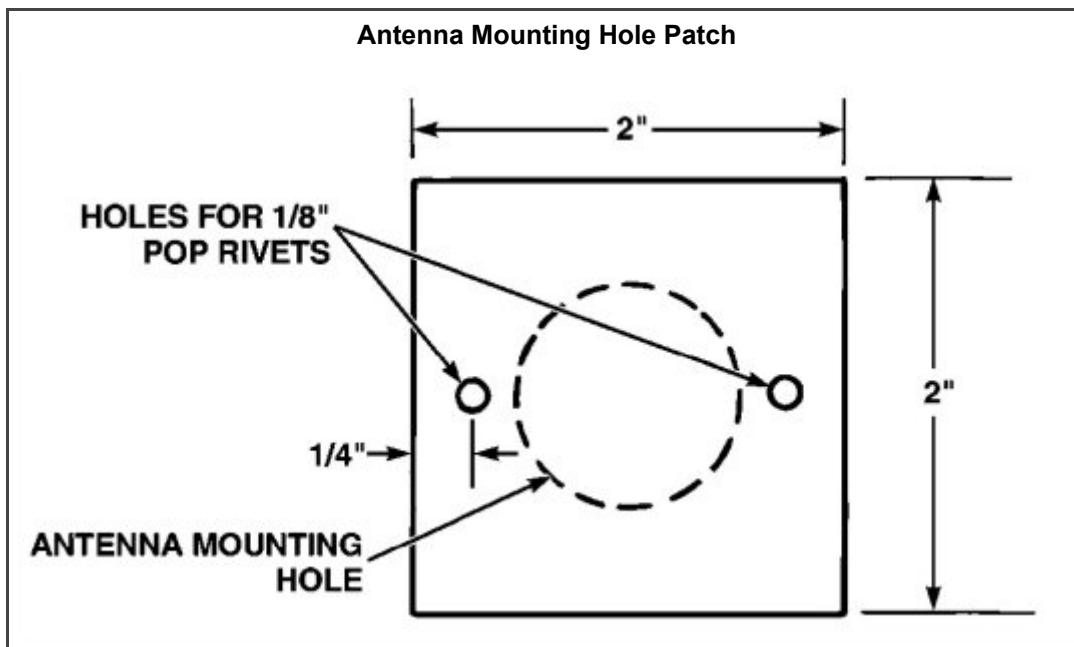
23. Apply Loctite® 242 to the threads of the reinforcement bracket mounting bolts (part No. 26AM14). Place washers (part No. 271AM8) on the mounting bolts, then install the four reinforcement brackets and tighten the mounting bolts to 15 lb-ft (20 N·m).

Antenna Mounting Hole Patch and Clearance/Marker Lamps Installation — Chassis Originally Equipped with High-Rise Sleeper

On cabs originally equipped with a high-rise sleeper, it will be necessary to install clearance and marker lamps. Additionally, relocation of the antenna and closing the original antenna mounting hole will be necessary. Part numbers for the clearance lamp assemblies and associated hardware are as follows:

Qty.	Part No.	Description
5	38MO4105M	Clearance/marker lamp assembly
5	111MO58	Bezel
5	87AX66	Grommet
10	77AM11	Screws
1	335AM3	Rivnut (included in hardware kit part No. 204SX405)

1. Cut a 2" x 2" (50.8 x 50.8 mm) piece of sheet metal, same gauge as the sheet metal used on the cab roof.
2. Drill two 1/8" holes at opposite sides of the sheet metal patch, 1/4" (6.35 mm) from the edge.



3. On the inside of the cab, center the patch over the antenna mounting hole in the cab roof, then mark and drill the two 1/8" holes in the roof.
4. Mix a two-part epoxy adhesive and apply to the cab roof around the antenna mounting hole on the inside of the cab.
5. Position the patch over the antenna mounting hole.
6. With an assistant inside the cab to hold the antenna patch in place, secure the patch with pop rivets. Install the pop rivets from the outside of the cab.

Except for the patch installed over the antenna mounting hole, the cab roof is already drilled for the clearance and marker lamp mounting holes and wire harness holes. When installing the marker lamp in the center of the cab roof, it will be necessary to install a Rivnut into the antenna patch for securing the lamp to the cab roof.

Procedures are as follows:

1. Position the marker lamp assembly (part No. 38MO4105M) and bezel (part No. 111MO58) in the center of the cab roof and temporarily secure with one mounting screw (part No. 77AM11) in the rear mounting hole.
2. Align the lamp assembly, then mark the location where the front mounting screw hole must be drilled in the cab roof.
3. Remove the lamp and bezel assembly.
4. Drill a 19/64" (7.5 mm) hole at the marked location, then install a Rivnut (part No. 335AM3).
5. Install grommets (part No. 87AX66) into the holes for the lamp wire harness holes at each of the locations in the cab roof.
6. Mount each lamp assembly (part No. 38MO4105M) to the cab roof with a bezel (part No. 111MO58) and mounting screws (part No. 77AM11). Apply RTV silicone sealant (342SX32) to the screws prior to installation, and also apply silicone sealant to the grommets and around the wires inside the cab.
7. Connect the lamp connectors to the existing wire harnesses.

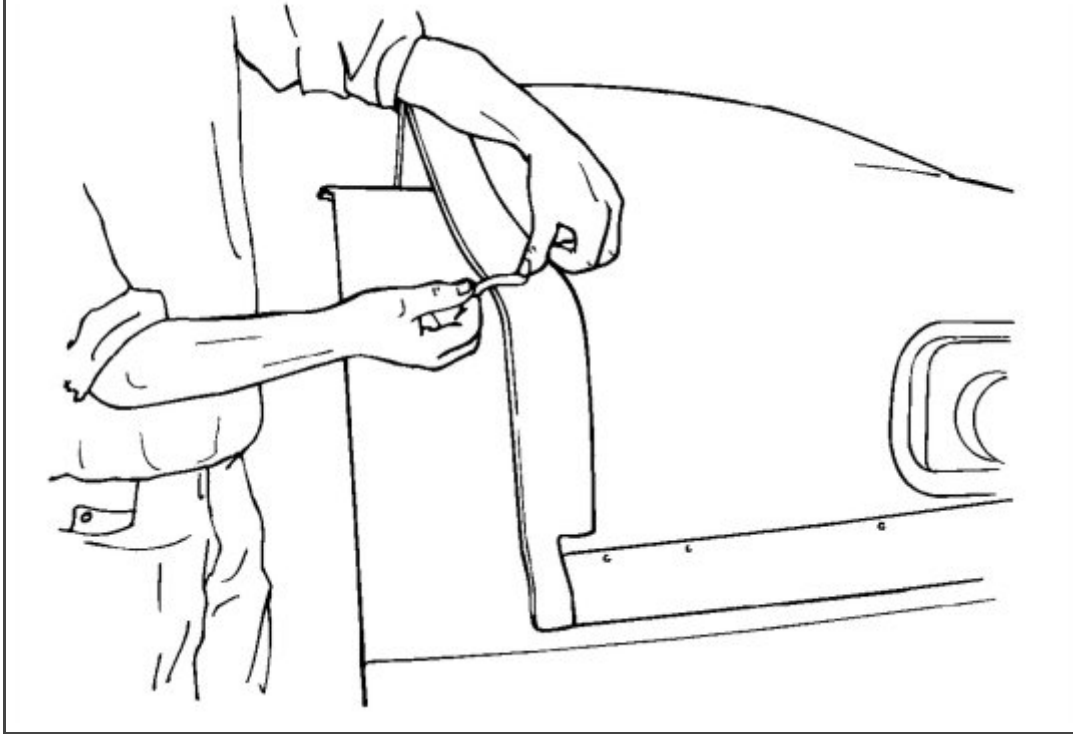
Interior Trim Installation

Note: The interior trim kit (part No. 204SX404) is only available in the color medium warm gray.

Note: If a hook-up lamp is to be installed on the rear of the cab, the lamp should be mounted and wire harness run to the lamp prior to installing the lower rear interior trim panel. Power to the hook-up lamp is supplied by wire No. 26-B located in cavity H of the sleeper harness connector (the sleeper harness connector is located on the bulkhead). The hook-up lamp harness should be routed along the same path as the original sleeper harness (across the cab rear sill, then up to the lamp). The size of the pass-through hole in the cab is determined by the size of the wire loom and the rubber grommet.

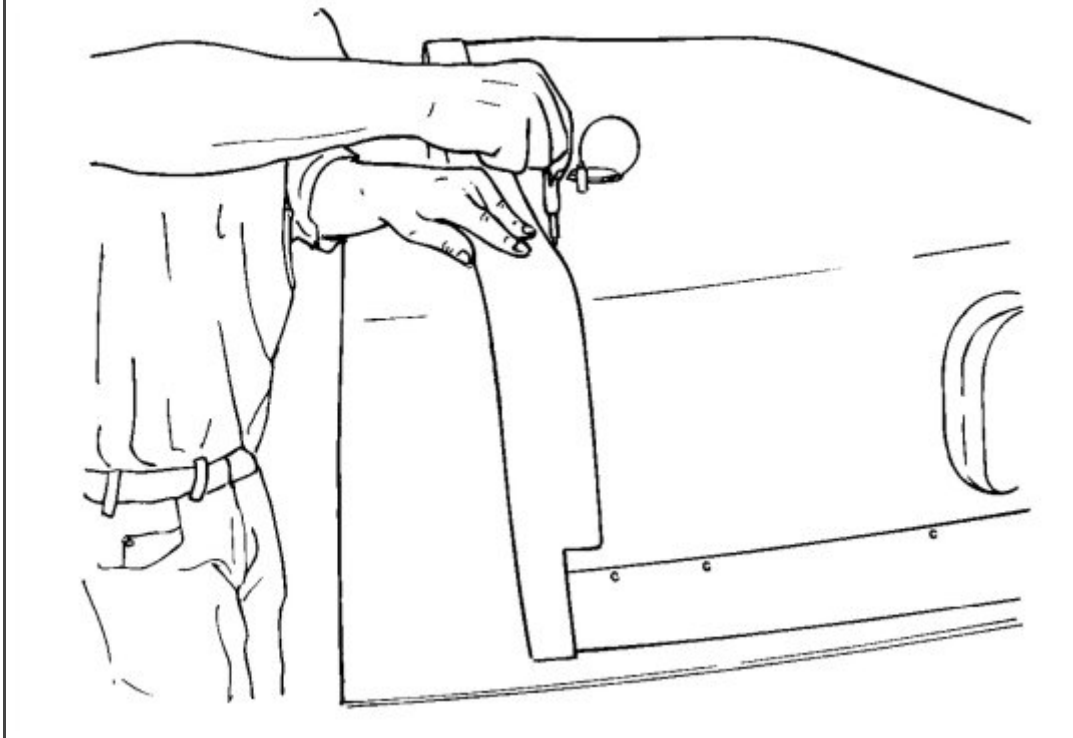
1. Locate the templates supplied in the interior trim kit (part No. 204SX404).
2. Position the headliner cutting template on the headliner, then secure the template in place with masking tape. The holes in the template align with the holes in the headliner.

Positioning and Securing Template on Headliner



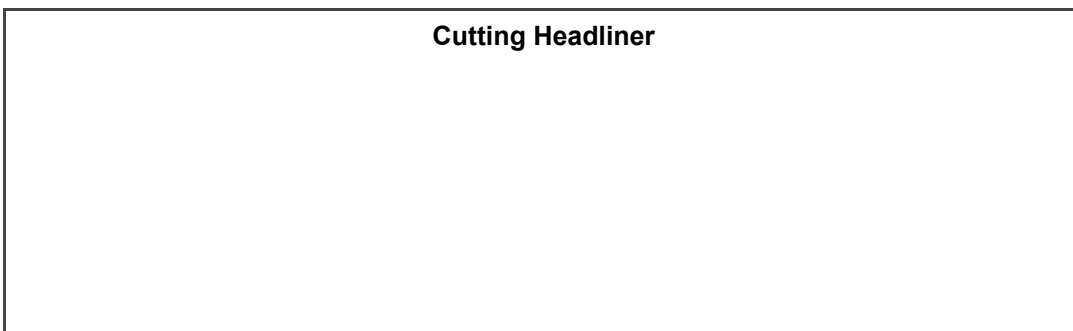
3. Using a pen, pencil or felt-tip marker, mark the headliner along the edge of the template.

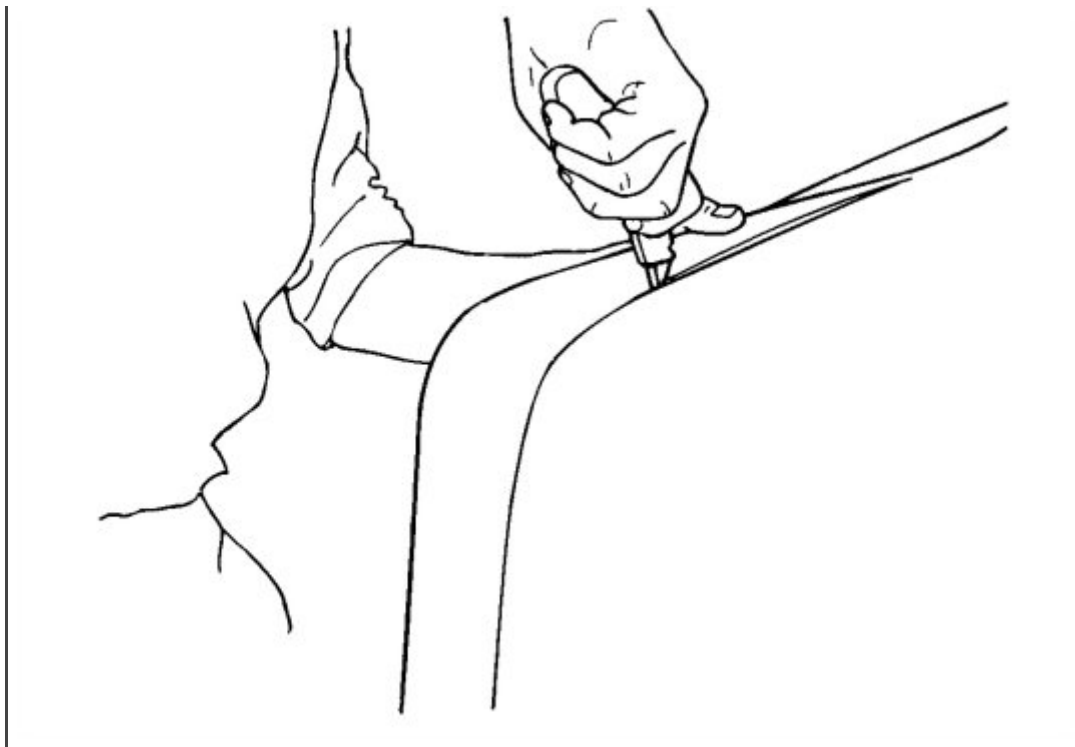
Marking Trim Line on Headliner



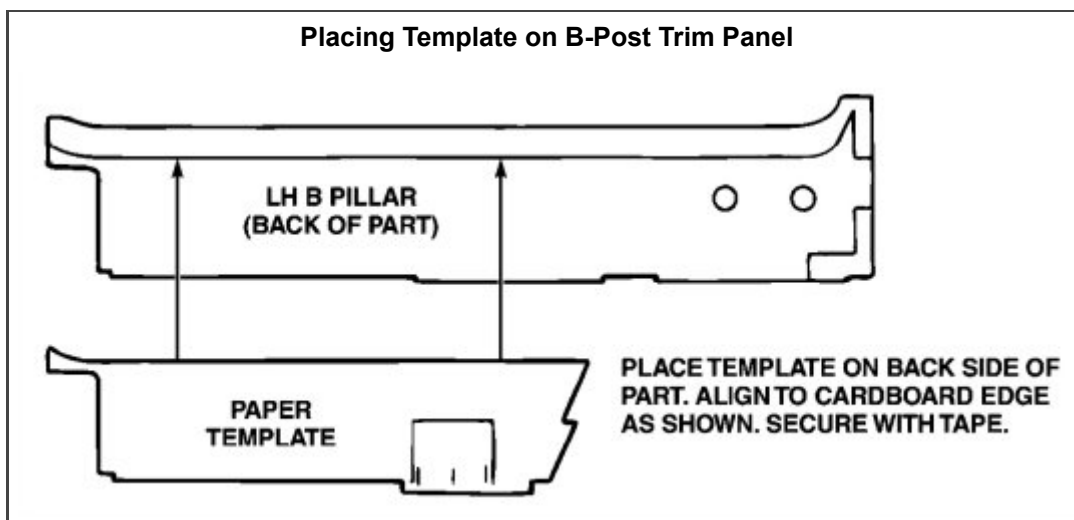
4. Using a sharp utility knife, carefully cut the headliner along the trim line.

Cutting Headliner

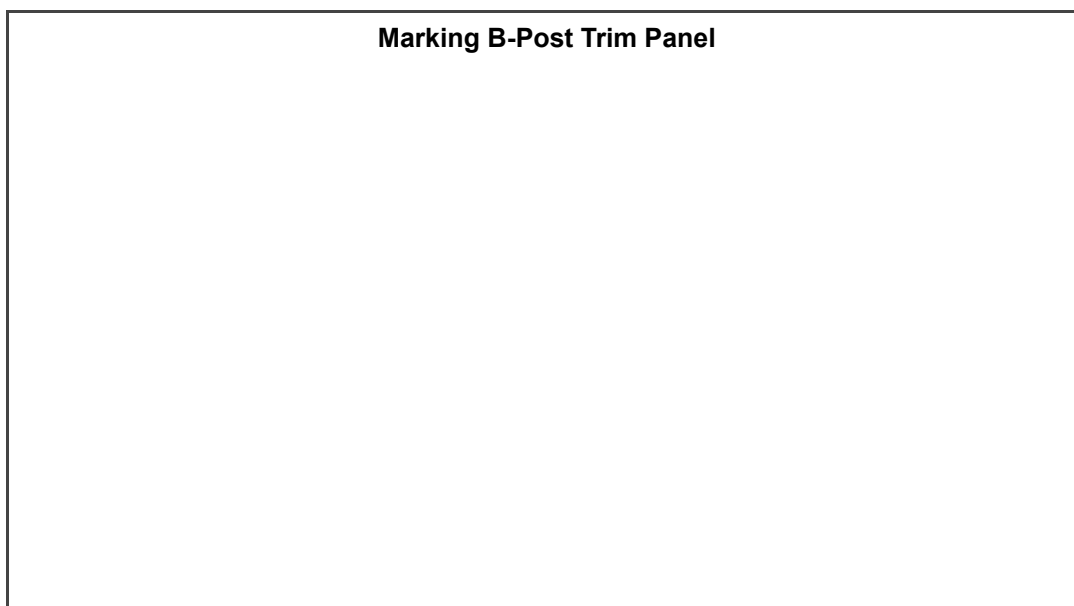


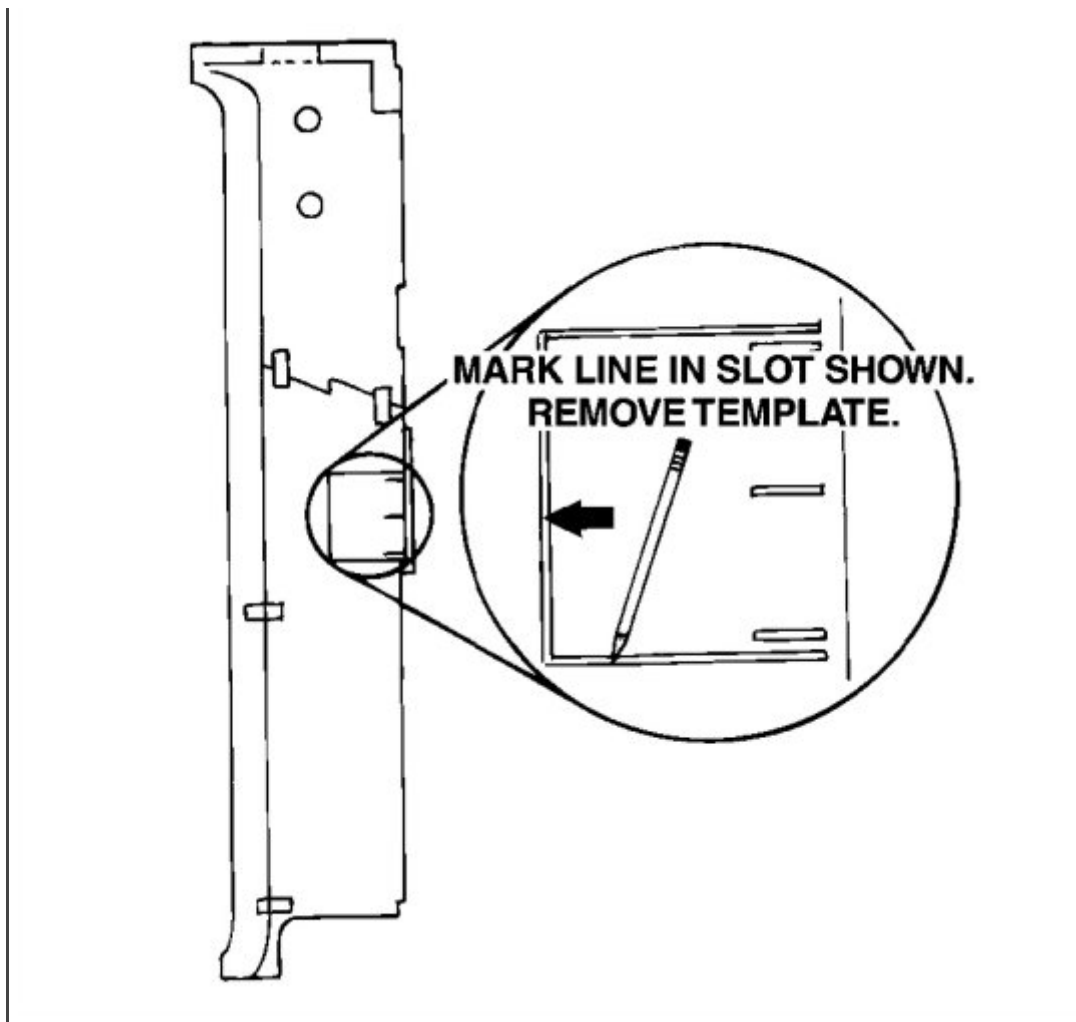


5. Place the B-post cutting template on the back side of the B-post trim panel with the edge of the template aligned against the edge of the cardboard as shown in the figure below.

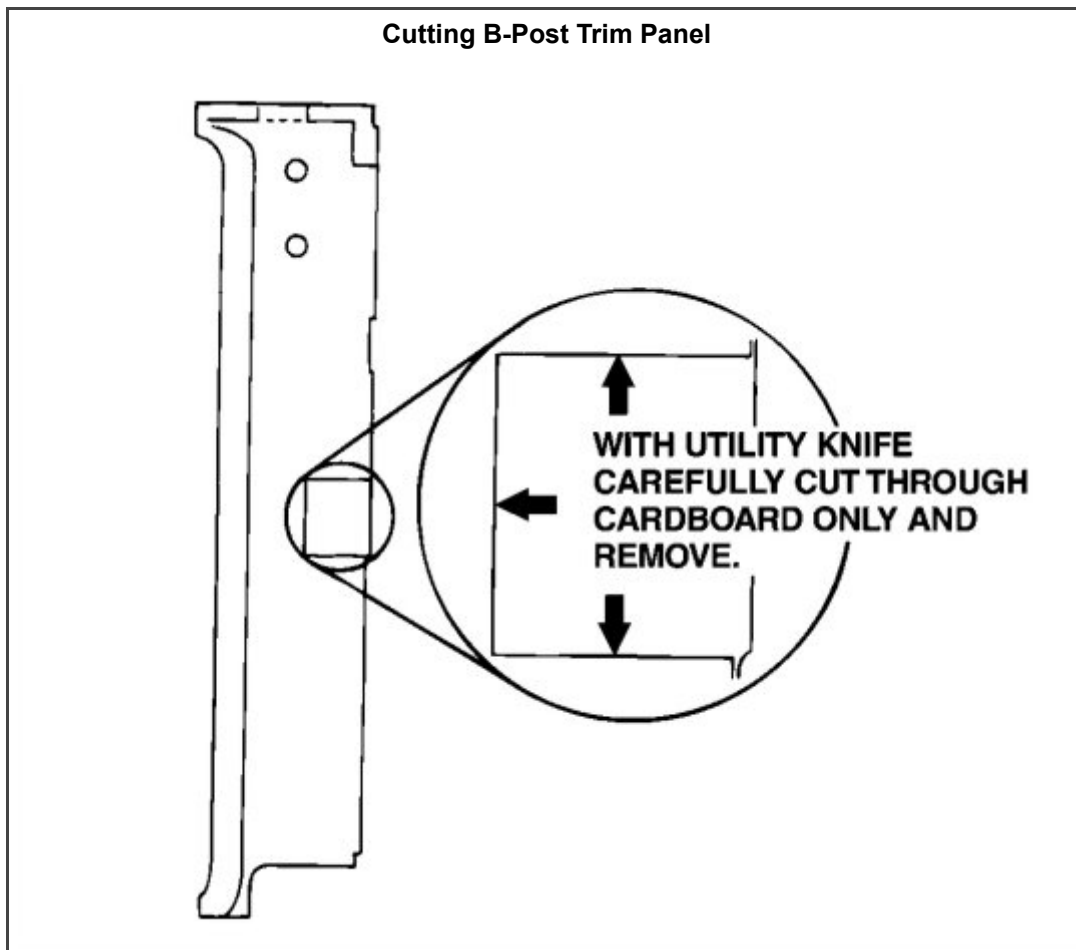


6. Secure the template in place with strips of masking tape, then use a pen, pencil or felt-tip marker to mark the three sides of the square on the trim panel.

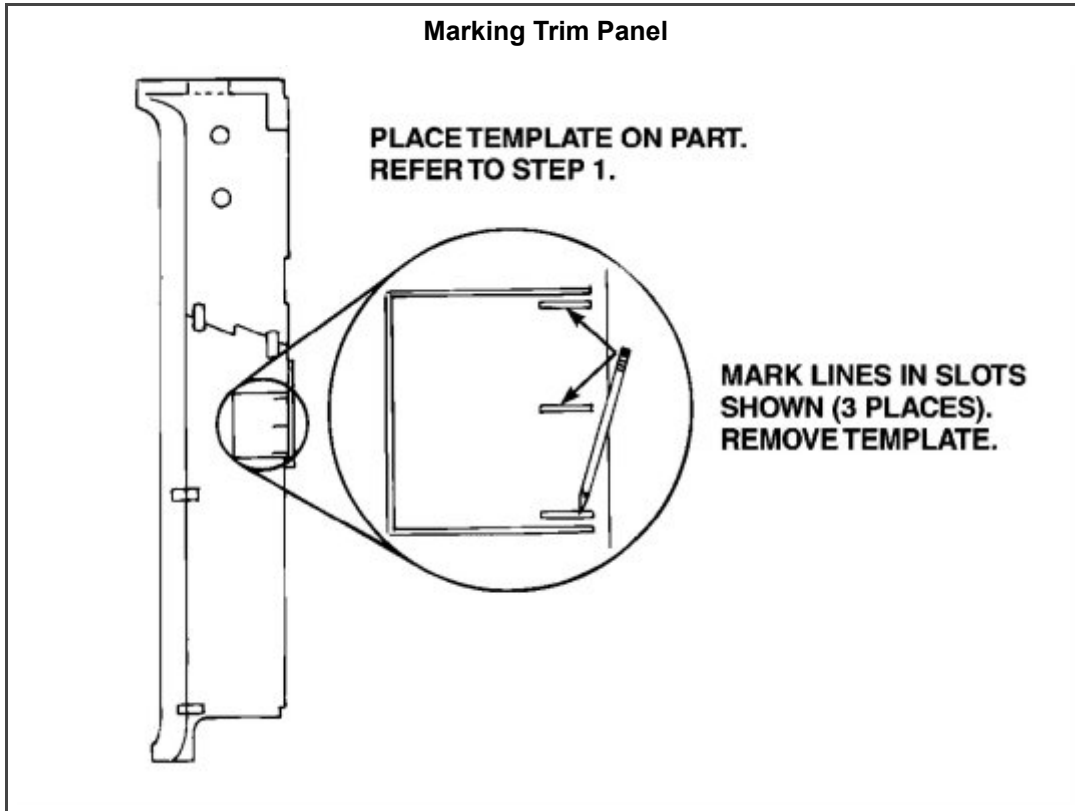




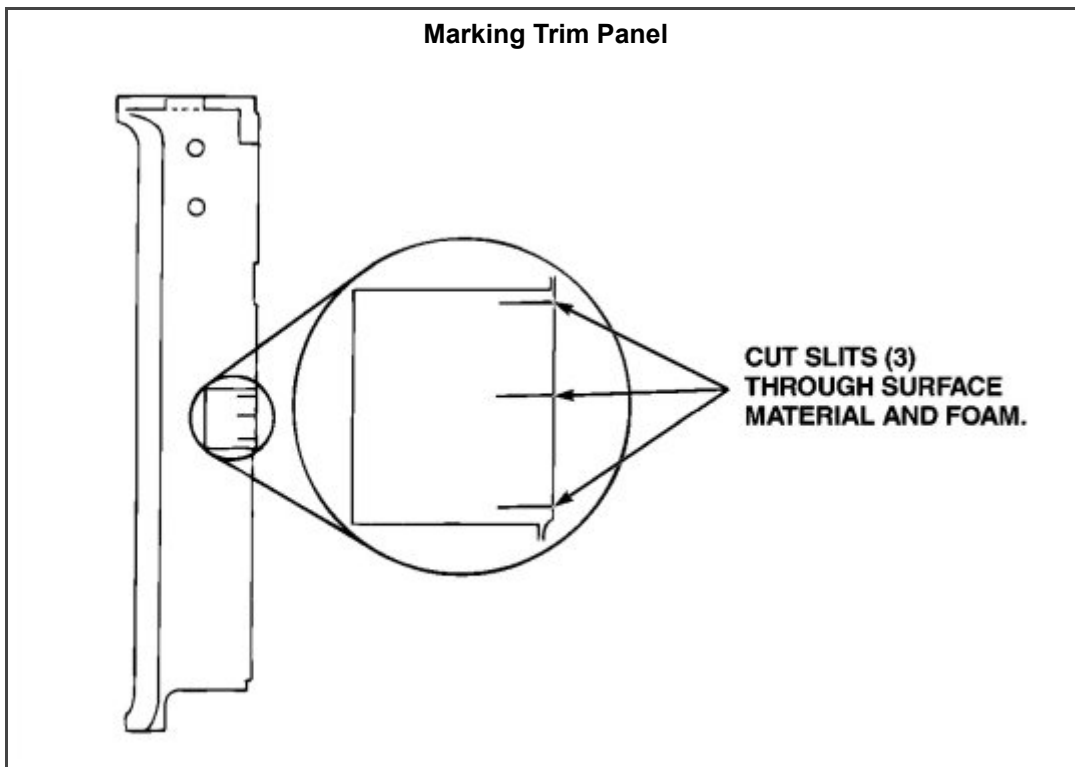
7. Remove the template, then carefully cut along the lines marked on the trim panel with a sharp knife. Cut through the cardboard ONLY. Do not cut through the vinyl. Remove and discard the piece of cardboard.



8. Again, position the template on the back of the trim panel with the edge of the template aligned against the edge of the cardboard, and secure the template in place with strips of masking tape. Using a pen, pencil or felt-tip marker, mark the three lines on the trim panel material through the slits in the template.



9. Remove the template. Using a sharp utility knife, cut the three slits through the foam and vinyl trim material.

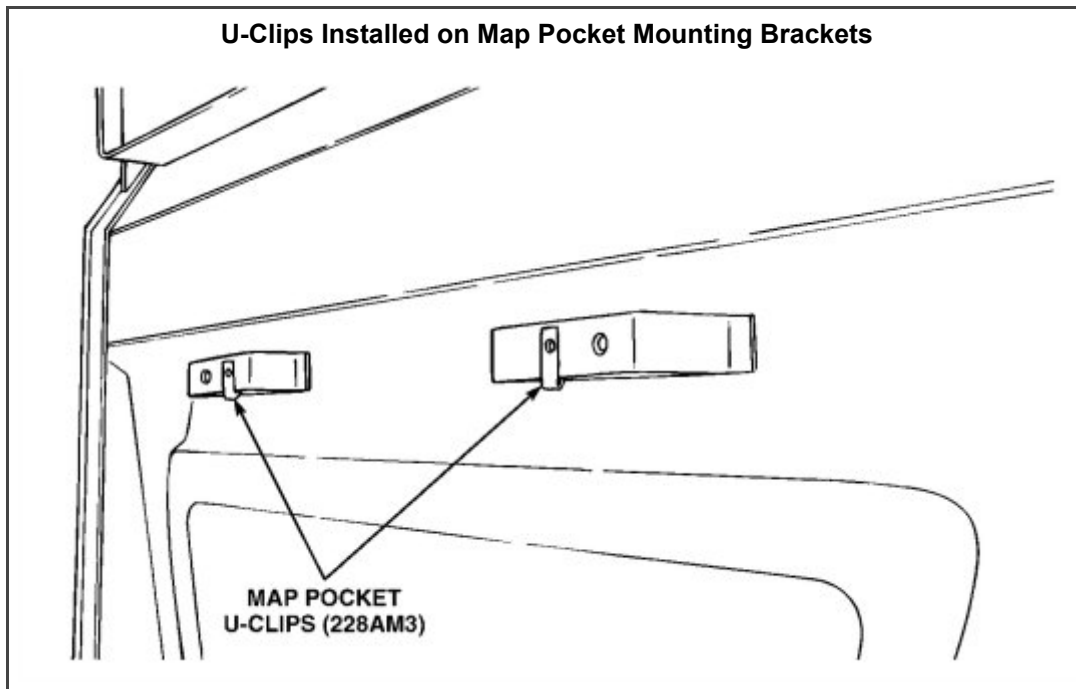


10. Repeat steps 5 through 9 above for the opposite B-post trim panel. Use the same template for the opposite side, simply turn the template over.
11. Position the trim panels onto the B-posts on both sides of the cab.
12. Install the trim panel onto the rear sill and secure with push fasteners.
13. Install the headliner into the cab and secure with push fasteners.

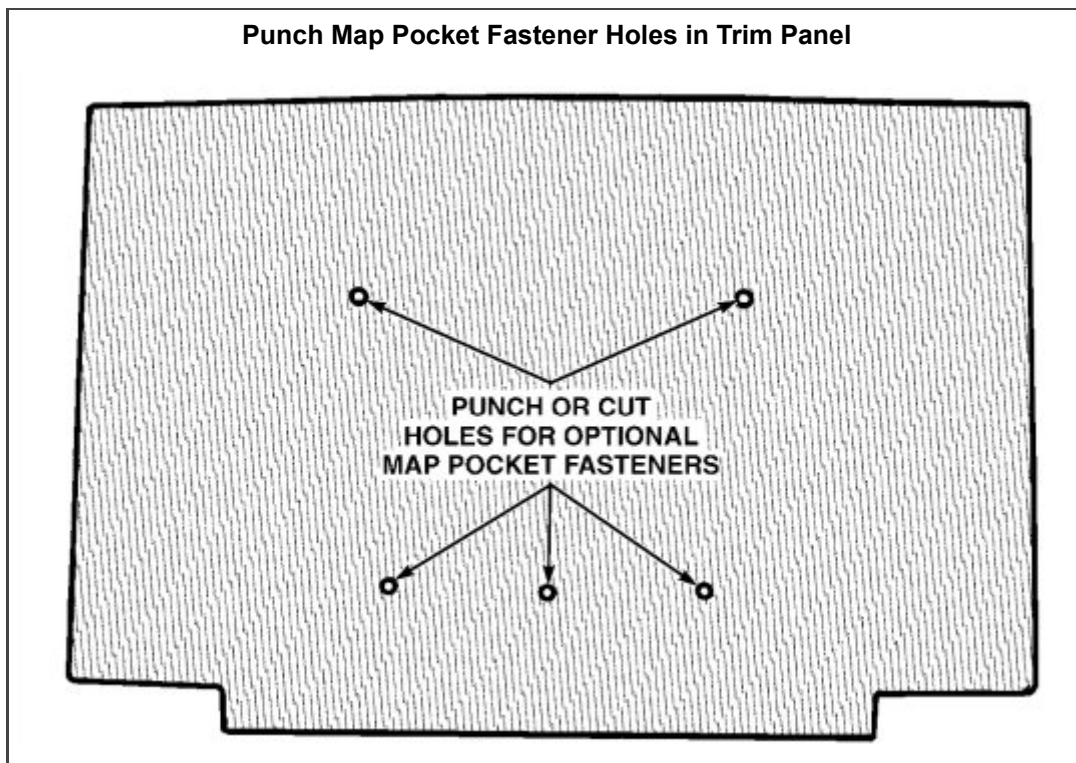
Note: If so desired, the sleeper dome light switch can be removed from the headliner and covered with a suitable cover.

14. If the optional map pocket is to be installed, install the U-clips (part No. 228AM3) onto the map pocket mounting brackets on the cab back (closure) panel.

Note: The map pocket must be ordered separately.

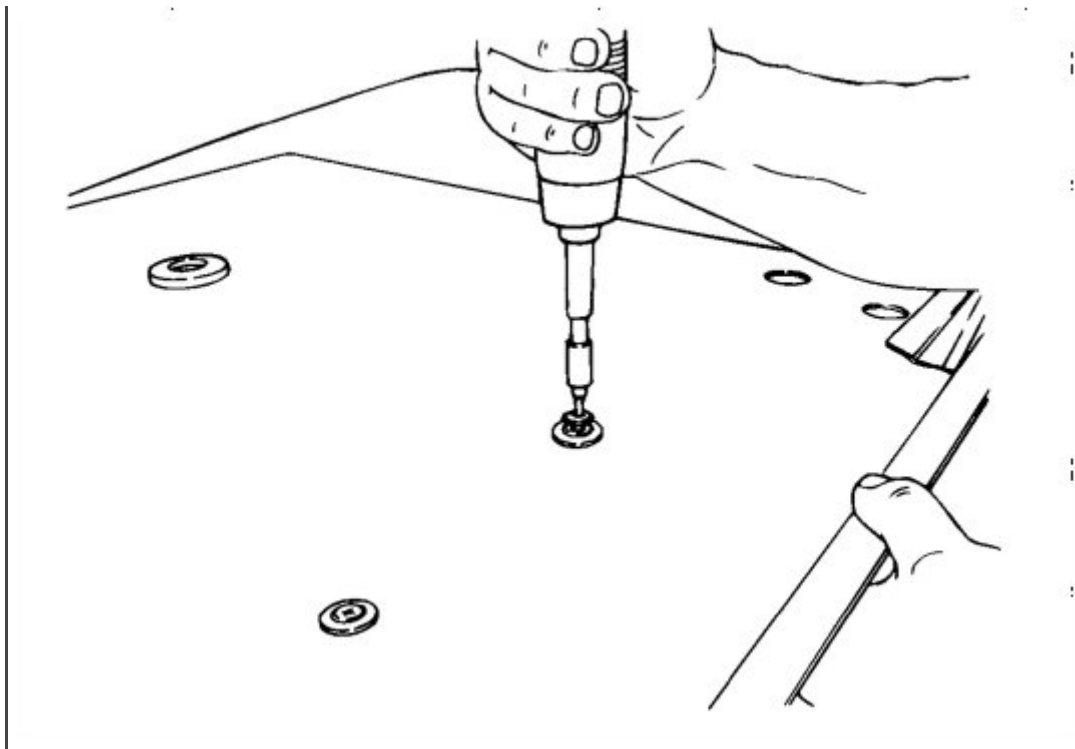


15. If the map pocket is being installed, cut or punch the vinyl trim on the lower rear trim panel for the map pocket fasteners. The trim panel backing board is already punched for the fasteners; it is only necessary to punch the vinyl trim.

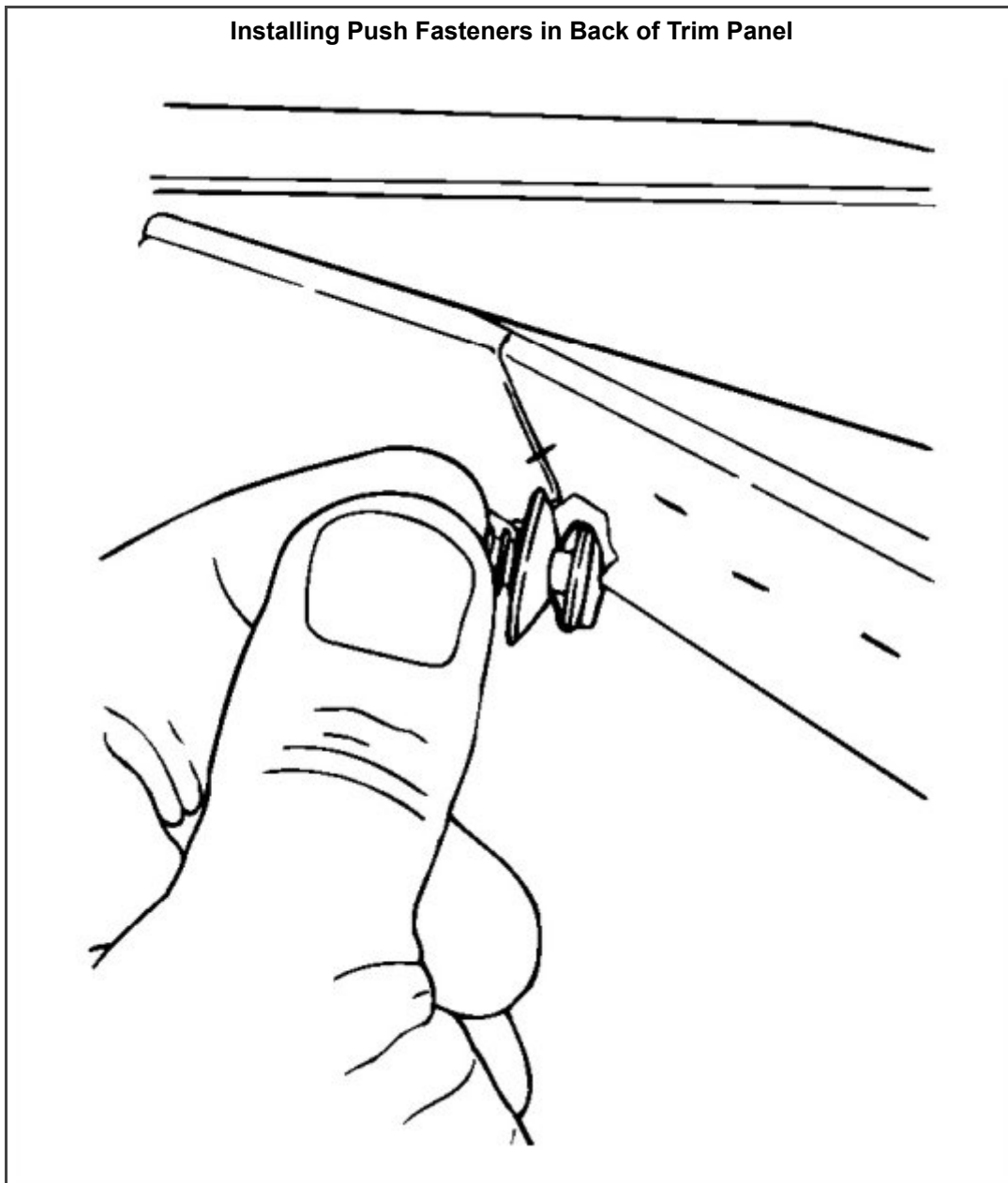


16. Install the map pocket to the trim panel using the three screws (part No. 400AX35) and three washers (part No. 271AM5006). The fasteners are installed from the rear of the panel as shown in the illustration below.

Installing Map Pocket Lower Fasteners Through Back of Trim Panel



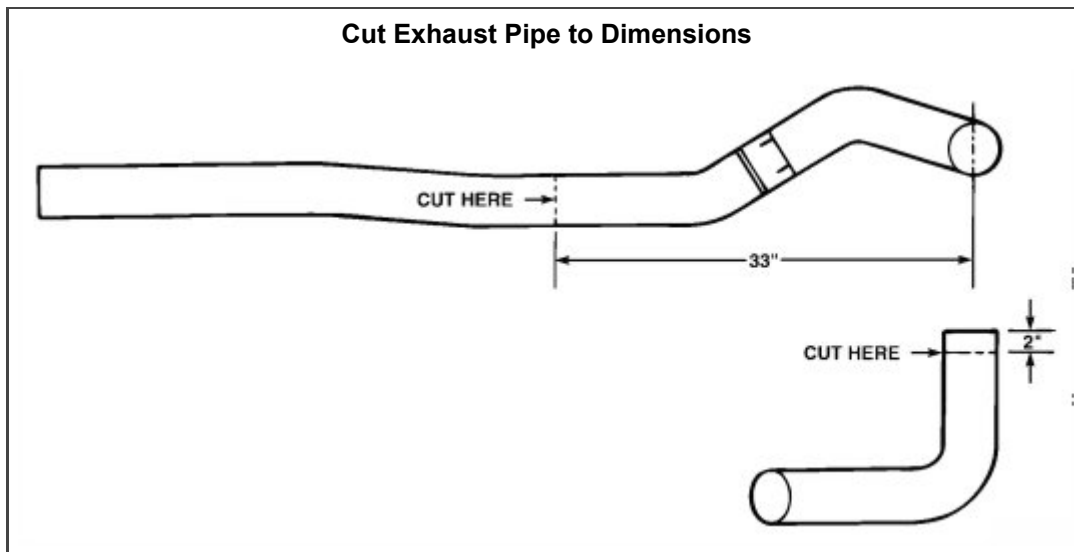
17. Install the push fasteners into the holes in the back of the upper and lower rear trim panels.



18. Install the trim panels by aligning the push fasteners on the back of the trim panels with the mounting holes in the back of the cab. Push the trim panels into place to secure.
19. Install the map pocket upper screws (part No. 127AM5002), then install the two screw covers (part No. 39QR435M2) over the upper map pocket fasteners.
20. Install the cab rear window and rubber seal (refer to service bulletin SB-631-001 for installation instructions). Be sure to use the required windshield glass sealer.

Completing Installation

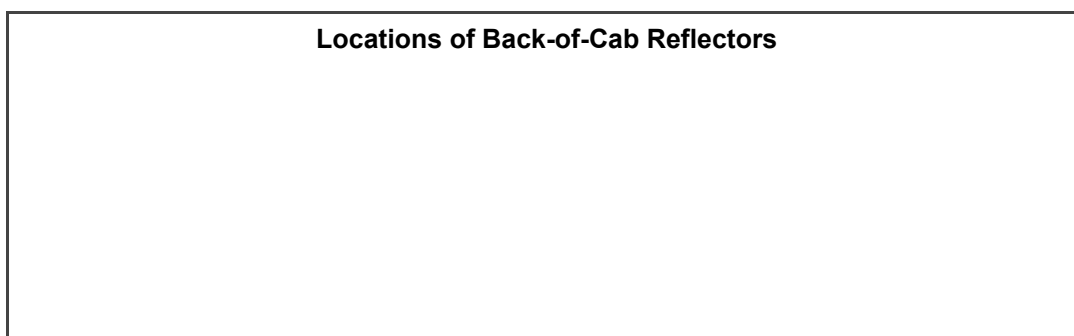
1. Install the driver's and rider's seats. Tighten the seat mounting hardware to 48 lb-ft (65 N·m)
2. Using the four 20 mm spacers (part No. 35AX236) and four bolts (part No. 27AM5008), install the seat belt tethers. The spacers must be installed between the floor and the tethers. Tighten the seat belt tether mounting bolts to 48 lb-ft (65 N·m).
3. Install the shoulder harnesses to the cab B-posts and tighten the mounting bolts to 48 lb-ft (65 N·m).
4. Install the seat belt retractors to the floor and tighten the mounting bolts to 48 lb-ft (65 N·m).
5. Reconnect the air lines to the seat(s).
6. If the exhaust flex pipe from the turbocharger outlet to the exhaust pipe is damaged or split, install a new flex pipe (part No. 4ME299P17), or the optional pipe (part No. 4ME22039P4).
7. Reinstall the muffler assembly.
8. Mark and cut the exhaust pipe to the dimensions as follows:
 - From the center line of the short elbow section, measure forward 33" (838.2 mm) and cut the pipe at that point.
 - Cut 2" (50.8 mm) from the height of the short elbow section.

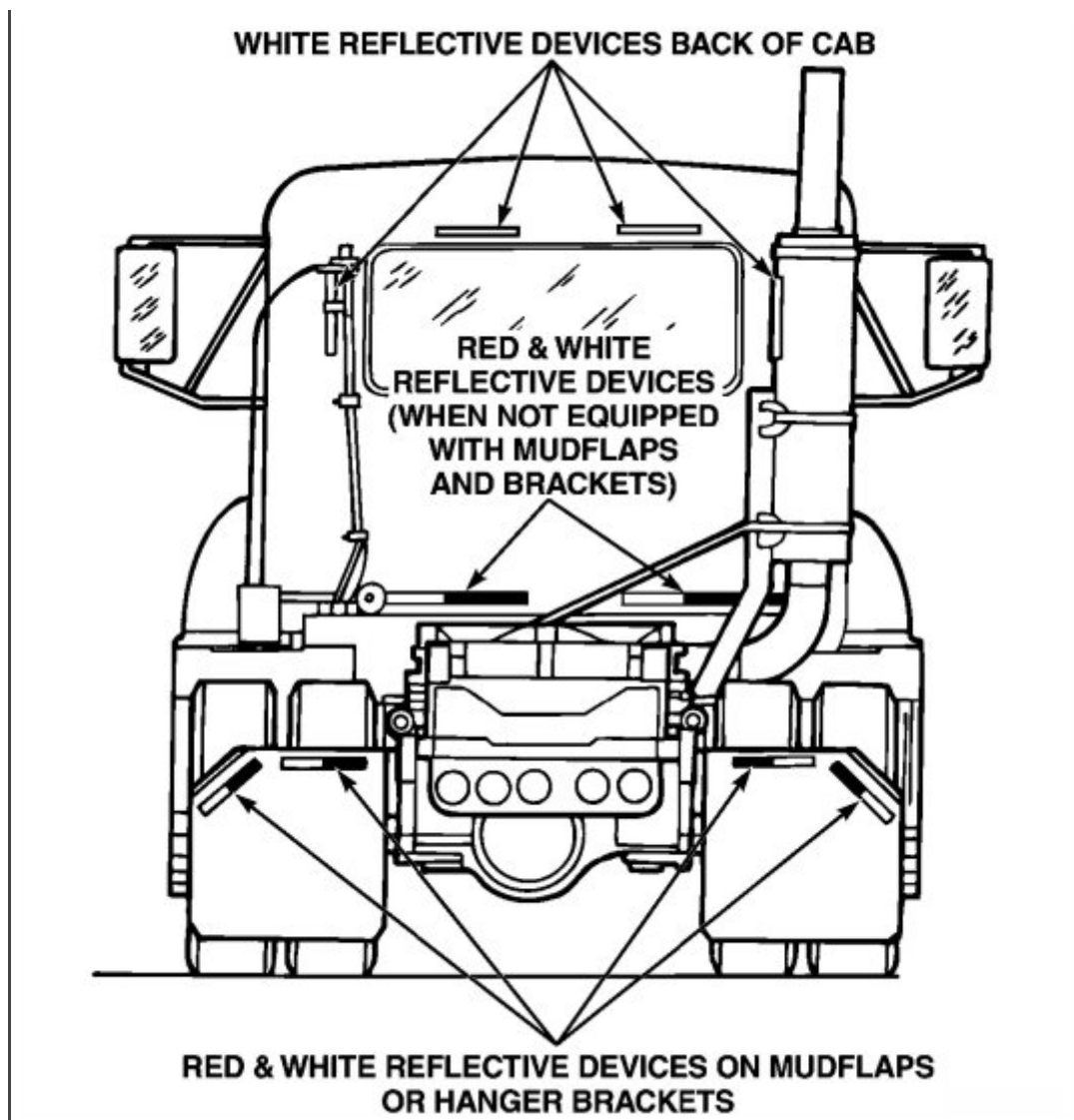


9. Connect the modified exhaust pipe to the flex pipe and muffler. Tighten all muffler and exhaust pipe clamps.

Note: The exhaust stack can be cut to a shorter height for day cab application.

10. Install the exhaust stanchion tie rod.
11. Department of Transportation regulations require reflective devices on the back of the cab. Install the four reflectors (part No. 56MO327) on the back of the cab at the locations shown in the following illustration.





12. Refill the cooling system with the proper coolant.
13. Evacuate and recharge the air conditioning system with 3.0 lb (1.36 kg) of 134a refrigerant (refer to the refrigerant label affixed to receiver/dryer mounting bracket).
14. Start the engine and check for air, coolant and exhaust leaks.
15. Turn the air conditioning system ON to ensure proper operation.
16. Road test the vehicle.

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