

Suspension Crossmembers with AL Suspension

M-711-001

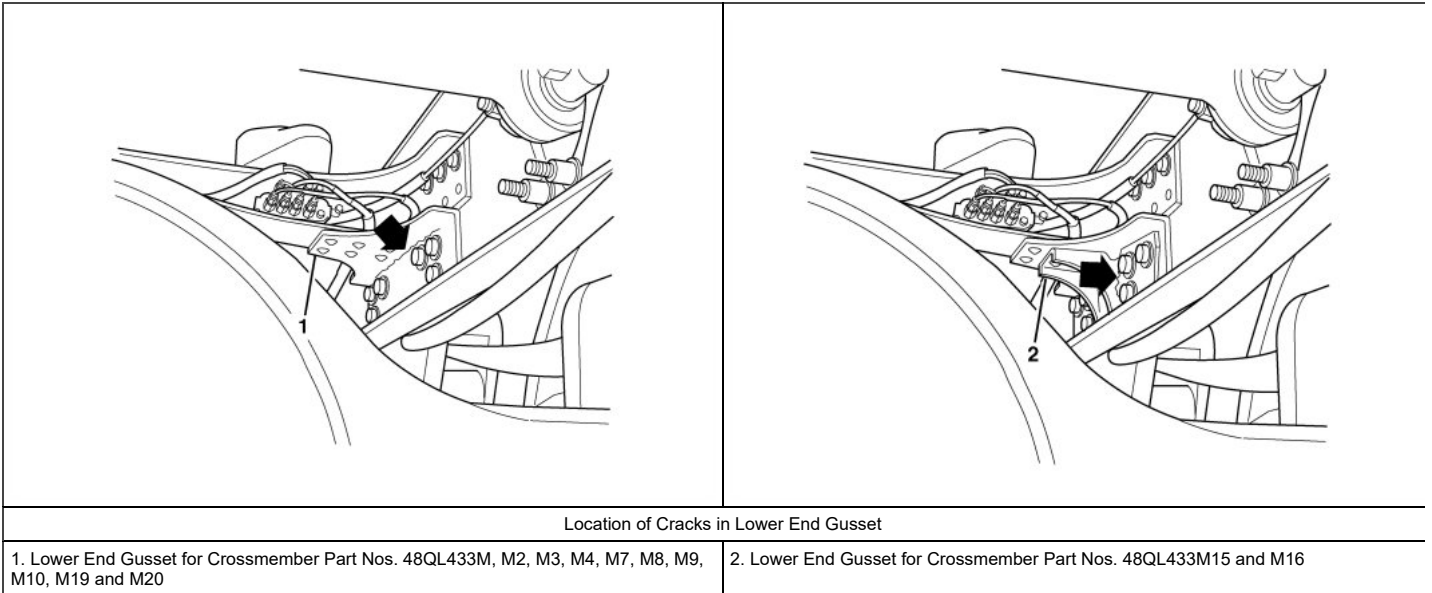
(Sep 2007)

Valid for

All CXN,CXP,CXU,CHN and CHU Macks built with AL suspension.

Case description

On certain CXN, CXP, CXU, CHN and CHU model chassis equipped with the MACK AL suspension utilizing rear suspension crossmember part Nos. 48QL433M, M3, M4, M7, M8, M9, M10, M19 and M20, cracks may develop in the horizontal radius of the lower end gusset. On chassis utilizing rear suspension crossmember part Nos. 48QL433M15 and 48QL433M16, cracks may develop in the lower end gusset along the mounting holes.

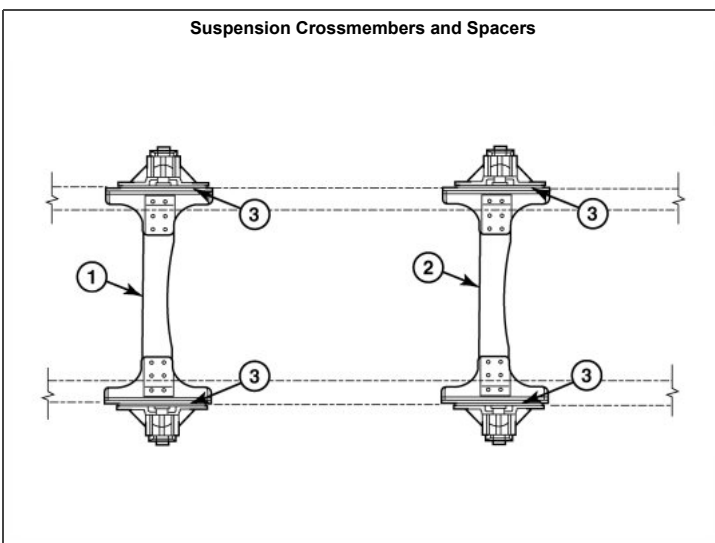


Note: Not applicable to Mack Trucks Australia.

Repair

To address this issue, revised crossmembers and spacers are available through the MACK Parts System. On tandem rear axle chassis, both crossmembers must be replaced if cracks are seen in either one of the two rear suspension crossmembers.

Part numbers for the replacement crossmembers and spacers are as follows:



Note: Some CXU, CXP, CXN, CHU and CHN chassis were originally assembled with crossmember part numbers 48QL433M3, 48QL433M9, 48QL433M4, 48QL433M10, 48QL433M15 and 48QL433M16, which included 5 mm spacers (part number 71RU3374M). Should replacement of one of the above mentioned crossmembers be required, the existing 5 mm spacers must be discarded and replaced with 10 mm spacers (part number 71RU3405M).

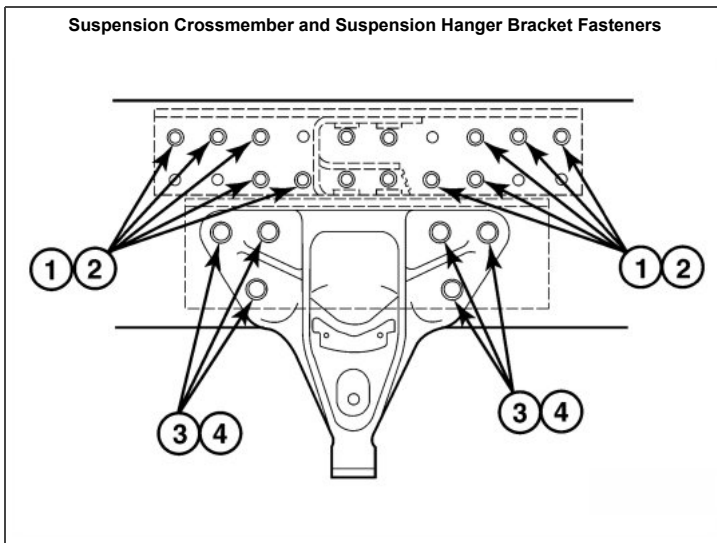
Note: Single rear axle chassis require only the front crossmember part number listed in the table below.

Item	Quantity	Part Number	Description	Replaces
1	1	48QL433M17	Suspension crossmember, single rear axle chassis or front on tandem rear axle chassis	48QL433M 48QL433M3*

				48QL433M7
				48QL433M9*
				48QL433M15*
				48QL433M19
2	1	48QL433M18	Suspension, rear on tandem rear axle chassis	48QL433M2
				48QL433M4*
				48QL433M8
				48QL433M10*
				48QL433M16*
				48QL433M20
3	4	71RU3405M	Spacer, 10 mm (two per crossmember required)	71RU3374M

Chassis equipped with crossmember part Nos. 48QL433M3, 48QL433M9, 48QL433M4, 48QL433M10, 48QL433M15 and 48QL433M16 included 5 mm spacers (part number 71RU3374M). Should one of these crossmembers require replacement, the 5 mm spacers must be replaced with the 10 mm spacers (part number 71RU3405M).

Fasteners for securing crossmembers to the frame rails are as follows:

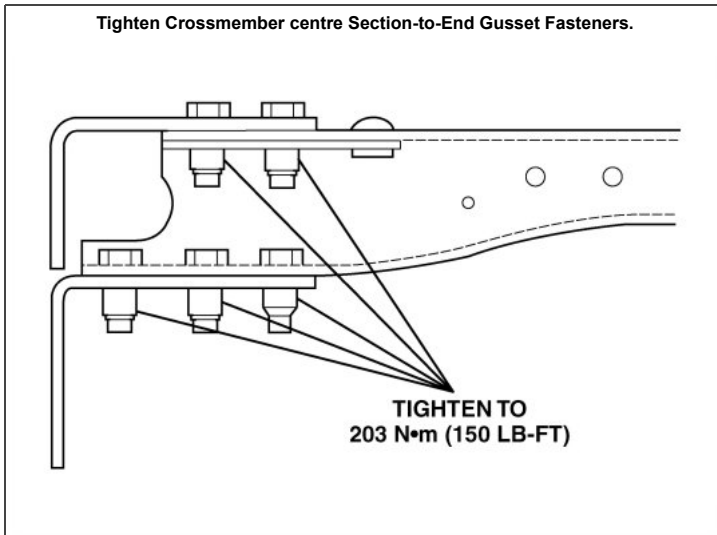


Item	Qty.	Part number	Description
1	20*	4AM36**	Pin, Huck-Spin®, 14 mm, crossmember-to-frame rail
2	20*	159AM5	Collar, Huck®, 14 mm, crossmember-to-frame rail
3	12	4AM23** or	Pin, Huck-Spin®, 20 mm, suspension frame hanger bracket-to-frame rail
	12	4AM23M2**	Pin, Huck-Fit®, 20 mm, suspension frame hanger bracket-to-frame rail
4	12	159AM3	Collar, Huck®, 20 mm, suspension frame hanger bracket-to-frame rail

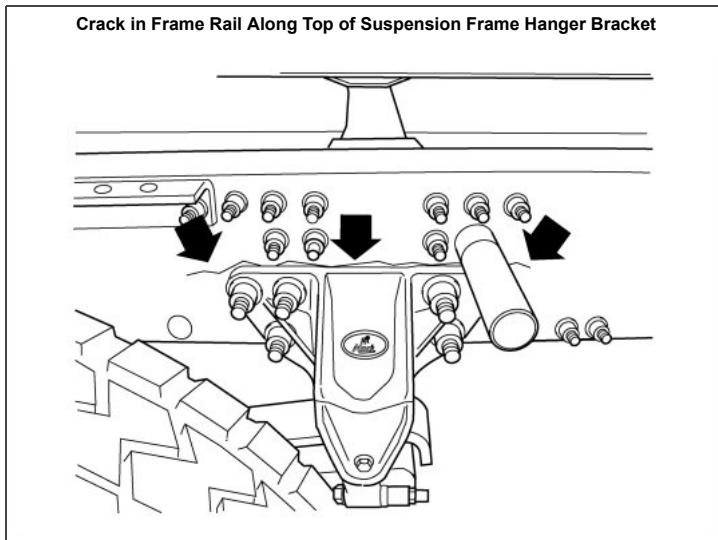
* Quantity per crossmember.

** 14 mm Huck® fasteners are available as Huck-Spin® only. The 20 mm Huck® fasteners are available as both Huck-Spin® and Huck-Fit®.

When assembling the crossmember centre section to the end gussets, tighten the body-bound bolts to 203 N•m (150 lb-ft).

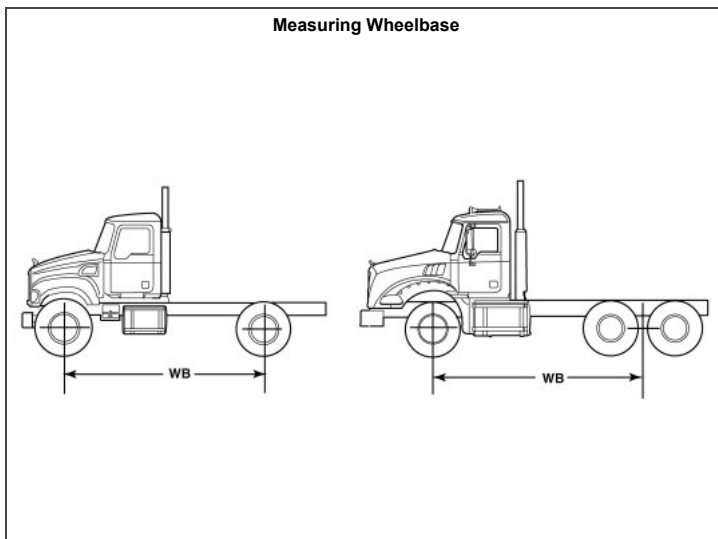


If a cracked crossmember has gone undetected for an extended period of time, the possibility exists for cracks to develop in the frame rail along the top of the AL suspension frame hanger bracket.



If a cracked frame rail is encountered, the affected rail must be replaced.

Note: If the chassis wheelbase has not been changed, fully drilled service replacement frame rails are available through the MACK Parts System. The following information explains how to place the order for fully drilled frame rails.



Part number requests for fully drilled frame rails are to be submitted by completing the attached Request for Frame Rails form, and faxing the completed form to the Mack Trucks Specifications Department at 610-709-3088. As an alternative, requests can be submitted electronically through the MACKnet Parts System.

The service replacement frame rail part numbers are determined according to the information supplied by the dealer on the Request for Frame Rails form, and are based on the original corporate chassis records. **If the chassis was altered in any way from original production, it is the responsibility of the dealer to inform the Specifications Department at the time the part number request is made. Fully drilled frame rails cannot be ordered for an altered chassis.**

Once the part numbers for the fully drilled frame rails have been determined, the Specifications Department will supply the part numbers in Section 2 of the form and return the form to the requesting dealer. If the requesting dealer wishes to place the order, a purchase order number must be supplied in Section 3 of the form and then the form must be faxed to the Customer Service Department at 610-709-2676.

Note: Phone call requests will NOT be accepted.

Be sure of your order. Fully drilled frame rails are NOT returnable.

Note: If the chassis wheelbase has been altered, service replacement frame rails that are not fully drilled must be ordered. These rails are only drilled from the front of the chassis to the back of the cab, and the remaining holes must be marked and drilled in the replacement frame rail. The removed frame rail can be used as a template to duplicate the drilling locations.

CXU, CXP, CXN, CHU and CHN models are available with 6 mm, 7 mm, 8 mm or 9.5 mm thick frame rails. If a non-fully drilled replacement frame rail is required, use the following information to identify and order the correct frame rail part number:

1. Check the chassis builds records to determine, and then record the original frame rail thickness.
2. Measure the chassis platform dimension (the platform dimension is the distance from the back of the cab to the back of the chassis).
3. Add 108" (2743.2 mm) to the platform dimension to determine the total frame length. (The 108" [2743.2 mm] dimension is the measurement from the front of the chassis to the back of the cab. This dimension is the same for both CXN and CHN models.)
4. Refer to the chart below to determine the replacement frame rail part numbers based on the measurement calculated above.

Rail Thickness	Frame Rail Part Numbers — Axle Forward (CHU and CHN Models)			
	Total Frame Length Less Than 8 559.8 mm (337")		Total Frame Greater Than 8 559.8 mm (337")	
	Left-Side part number	Right-Side part number	Left-Side part number	Right-Side part number
6 mm	3QL63397LP337	3QL63397RP337	3QL63397LP434	3QL63397RP434
7 mm	3QL63398LP337	3QL63398RP337	3QL63397LP434	3QL63398RP434
8 mm	3QL63399LP337	3QL63399RP337	3QL63399LP434	3QL63399RP434

9.5 mm	3QL63402LP337	3QL63402RP337	3QL63402LP434	3QL63402RP434
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Rail Thickness	Frame Rail Part Numbers — Axle Back (CXU, CXP and CXN Models)			
	Total Frame Length Less Than 8 559.8 mm (337")		Total Frame Greater Than 8 559.8 mm (337")	
	Left-Side part number	Right-Side part number	Left-Side part number	Right-Side part number
6 mm	4QL63397LP337	4QL63397RP337	4QL63397LP434	4QL63397RP434
7 mm	4QL63398LP337	4QL63398RP337	4QL63398LP434	4QL63398RP434
8 mm	4QL63399LP337	4QL63399RP337	4QL63399LP434	4QL63399RP434
9.5 mm	4QL63402LP337	4QL63402RP337	4QL63402LP434	4QL63402RP434

Note: For assistance in determining the correct service replacement frame rail part numbers, submit the request electronically through the MACKnet Parts System, or fax the request to the Mack Trucks, Inc. Specifications Department at 610-709-3088.

Warranty information

Reimbursement

This Repair may be eligible for reimbursement if a product failure was experienced within the time and mileage limits of the applicable warranty coverage. Reimbursement is obtained via normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	01
Labor Code	
Primary Labor Code	Refer to the following labor code chart.
Causal Part	Part number for applicable failed crossmember.

CHU and CHN Models

121 8G 70 80	7.0 hrs. —	Time allowed to replace one suspension crossmember and install reinforcement plate on CHN 612 and CHU 612 single rear axle models. Includes time to remove and reinstall fifth wheel. Does not include "take-charge" time.
121 8E 70 80	9.0 hrs. —	Time allowed to replace two suspension crossmembers and install reinforcement plate on CHN 613 and CHU 613 tandem rear axle models. Includes time to remove and reinstall fifth wheel. Does not include "take-charge" time.
121 8F 70 80	S.T. —	Additional time to remove and reinstall any additional components necessary to gain access for crossmember replacement on CHN and CHU model chassis. Explanation of extra time must be submitted with warranty claim.
121 PF 70 46	S.T. —	Additional time to replace one frame rail on CHN and CHU models.
121 PF 70 47	S.T. —	Additional time to replace two frame rails on CHN and CHU models.

CXU, CXP and CXN Models

121 8G 71 80	7.0 hrs. —	Time allowed to replace one suspension crossmember and install reinforcement plate on CXN 612, CXP 612 and CXU 612 single rear axle models. Includes time to remove and reinstall fifth wheel. Does not include "take-charge" time.
121 8E 71 80	9.0 hrs. —	Time allowed to replace two suspension crossmembers and install reinforcement plate on CXN 613, CXP 613 and CXU 613 tandem rear axle models. Includes time to remove and reinstall fifth wheel. Does not include "take-charge" time.
121 8F 71 80	S.T. —	Additional time to remove and reinstall any additional components necessary to gain access for crossmember replacement on CXN, CXP and CXU model chassis. Explanation of extra time must be submitted with warranty claim.
121 PF 71 46	S.T. —	Additional time to replace one frame rail on CXN, CXP and CXN models.
121 PF 71 47	S.T. —	Additional time to replace two frame rails on CXN, CXU and CXN models.

Request for Frame Rails

Section 1 (Dealer)

Date	_____	Requestor's Name	_____
Dealer Code	_____	Fax	_____
Phone	_____	Serial Number	_____
Chassis Model	_____	GSO Number	_____
The part numbers given are based on the original corporate chassis record. If the chassis was altered in any way after production, it is the dealer's responsibility to inform us at the time of request. Fully punched rails are not eligible for return to the PDC or thru the PRS System.			
Warranty Replacement	_____	Non-Warranty Replacement	_____
Frame Rail:	RH _____	LH _____	
Inner Channel:	RH _____	LH _____	
Outer Channel:	RH _____	LH _____	
w/o VIN	_____	_____	

(Note: VIN will be stamped on all rails unless requested w/o VIN.)

Fax this form to Specifications at 610-709-3088

Section 2 (Specifications)

Frame Rail Part Number	RH	LH
Inner Channel Part Number	RH	LH
Outer Channel Part Number	RH	LH
		Specs:
***** After receiving frame rail part numbers, if you wish to order frame rails please fill out Section 3 (below).		

Section 3 (Dealer)

CUSTOMER SERVICE	
Purchase Order Number	_____
Fax to Customer Service at 610-709-2676.	

Issued by

Technical Service

Mack Trucks, Inc. engages in a continuous program of testing and evaluating to provide the best possible product. Mack Trucks, Inc., however, is not committed to, or liable for updating existing chassis.