

Bright-Finish Grille Surround Replacement Procedures

M-823-001

(June 2008)

Valid for

All Gu Models

Case description

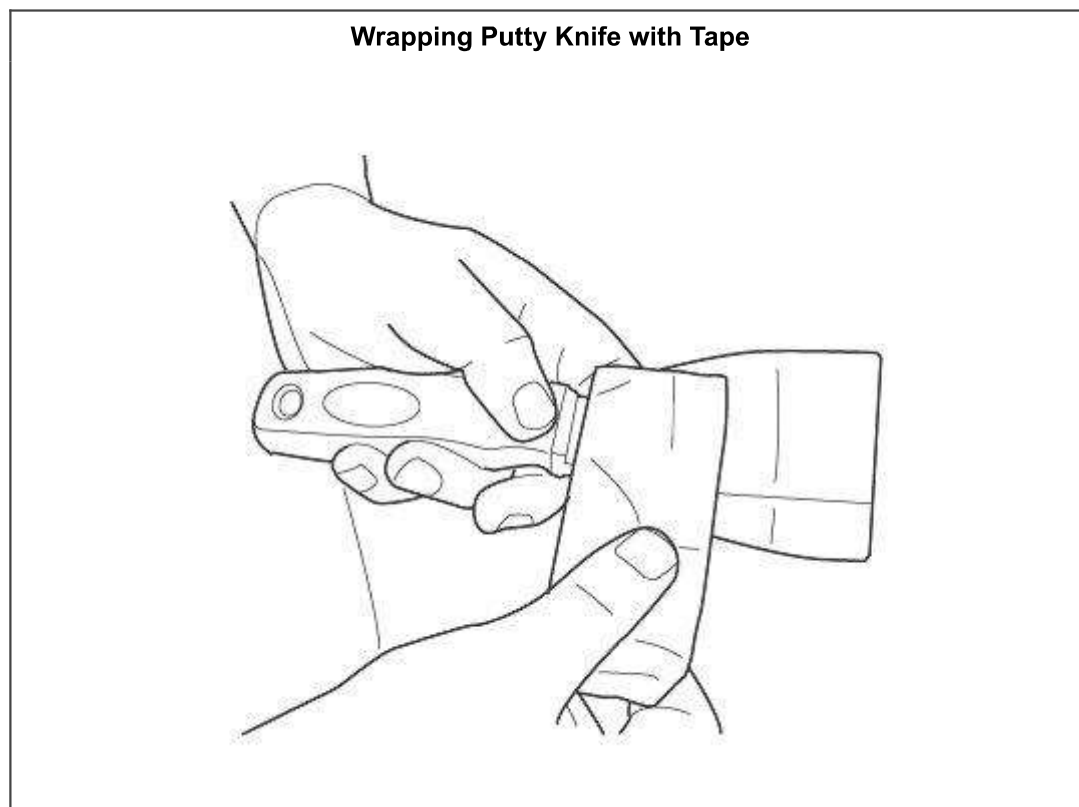
Effective February 1, 2008, a new method of securing the bright-finish grille surround to the hood was implemented into production on GU model chassis. This method utilizes a combination of two-sided tape and 3M® 540 polyurethane adhesive. Prior to the February 1, 2008, implementation of the dual-adhesive method, two-sided tape alone was used. Should replacement of a grille surround be necessary, the procedures outlined below should be used to remove and install the replacement surround.

Note: Grille surrounds, which are secured to the hood with two-sided tape and 3M® brand adhesive can be removed by applying heat and prying the surround loose, but the surround cannot be removed without being damaged. The same procedures are used to remove grille surrounds, which are secured with two-sided tape only, but the surround will be easily removed without damage. Bright-finish grille surrounds are secured to the hood with two-sided tape only, on all CTP and CT models, and GU models manufactured prior February 1, 2008.

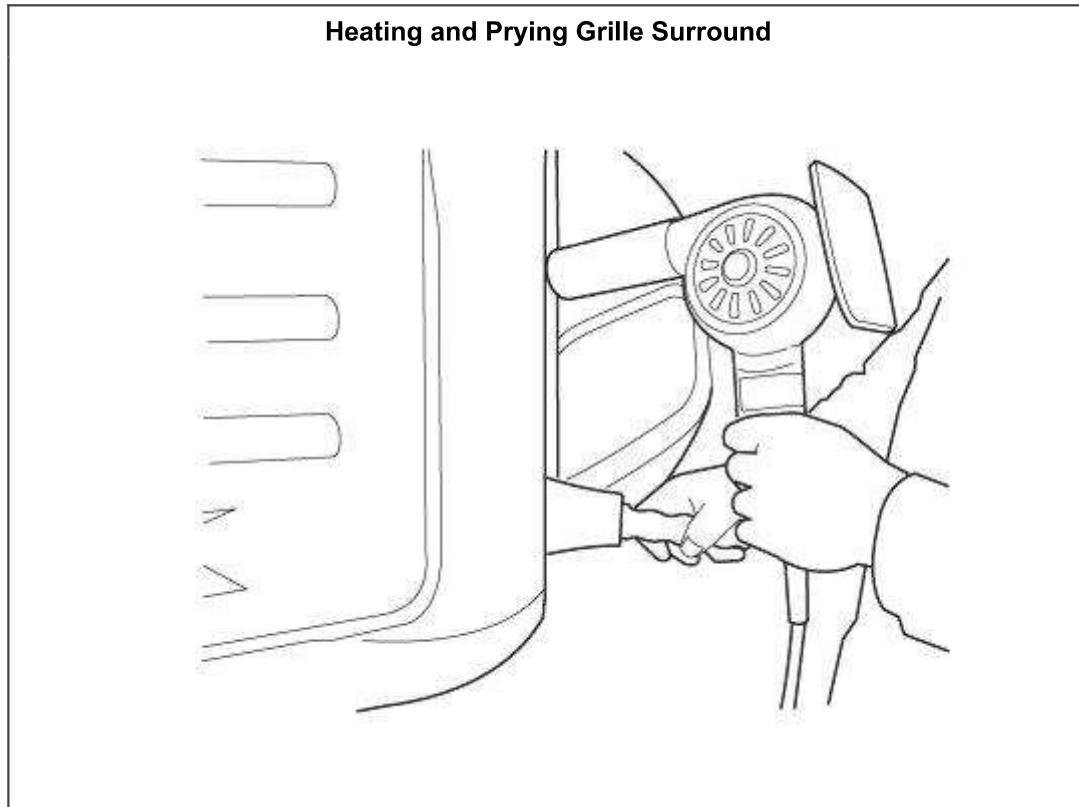
Note: Not applicable to Mack Trucks Australia.

Replacement procedures

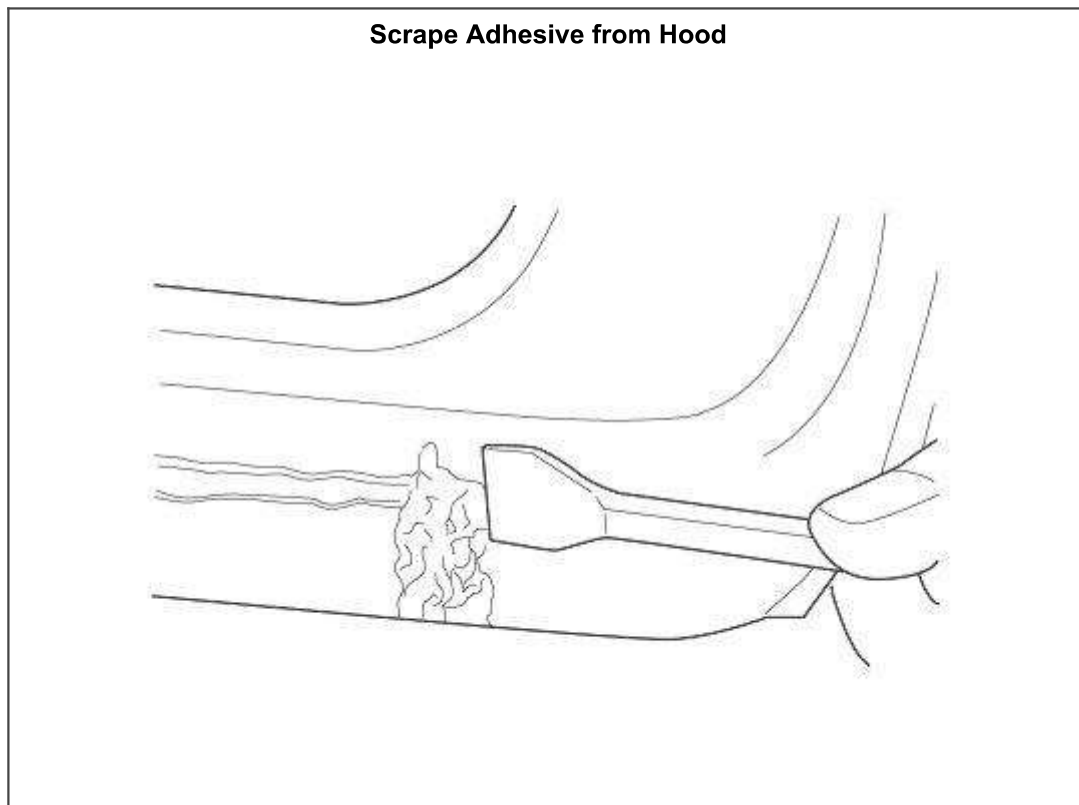
1. Prepare a putty knife for use as a removal tool by wrapping the blade with duct tape. This will cover the sharp edges and prevent damage to the painted surfaces of the hood.



2. Starting at the bottom corner of the grille surround, use a heat gun to heat the grille surround while using the putty knife wrapped with tape to pry the bottom corner loose.



3. Use a gasket scraper to remove the adhesive and tape from the hood. Complete removal of the adhesive is not necessary. It is only necessary to remove the bulk of the adhesive. (Grille surrounds which were secured by two-sided tape only will not have any adhesive on the hood.)



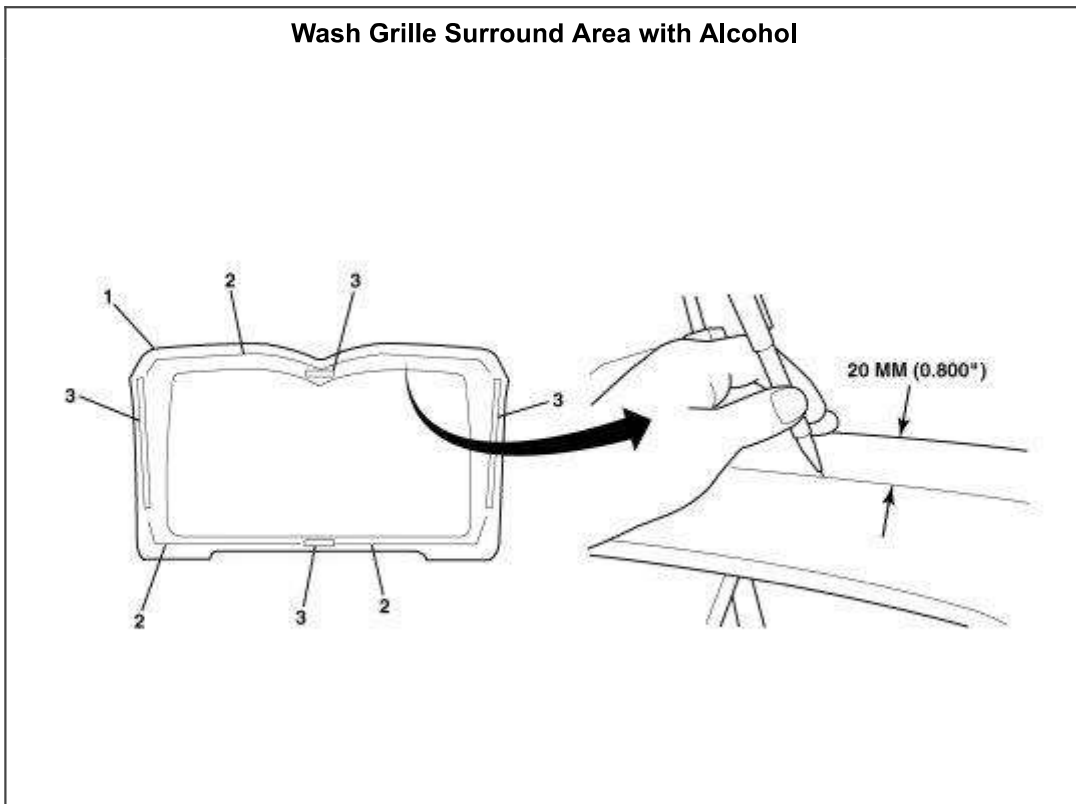
4. Wash the grille surround area of the hood with alcohol, and then dry the area with a clean, dry shop rag.

Wash Grille Surround Area with Alcohol



5. Using a marker such as a Sharpie®, mark the areas of the new grille surround (part No. 6MF5134M) as shown in the illustration below. These lines, which will be marked 20 mm (0.800") down from the outer edge of the surround, will provide a guide for applying the adhesive.

Wash Grille Surround Area with Alcohol

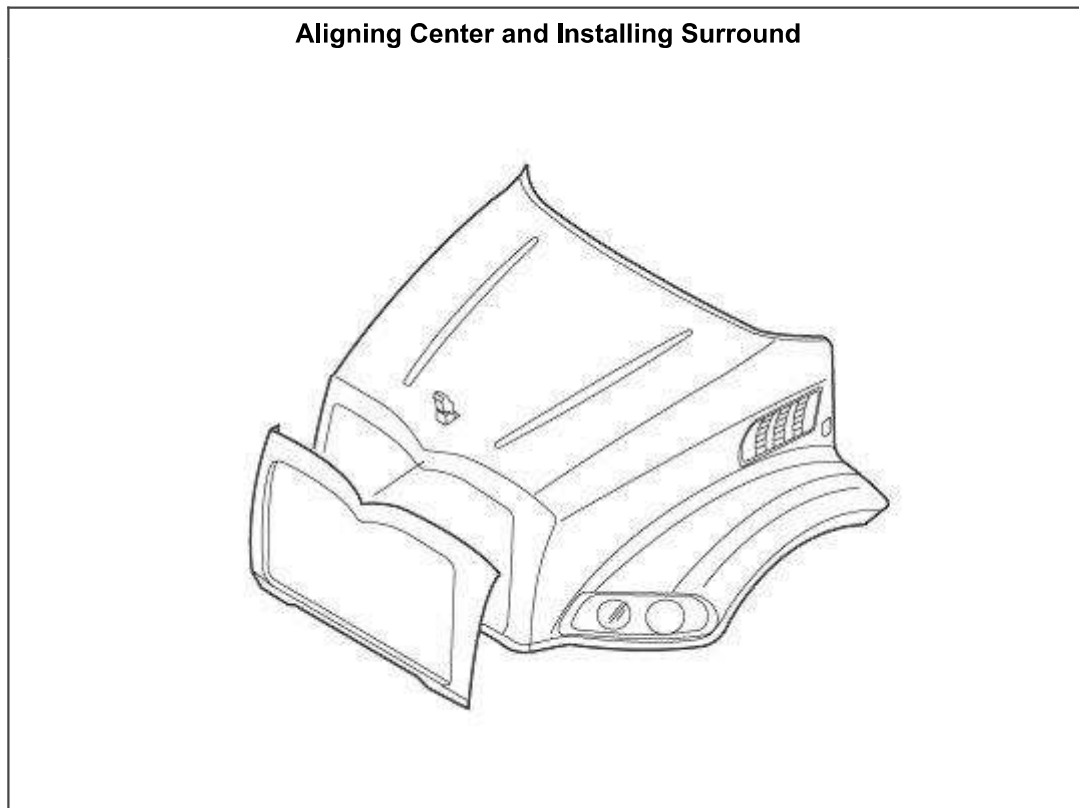


1. Bright-Finish Grille Surround (Part No. 6MF5134M)

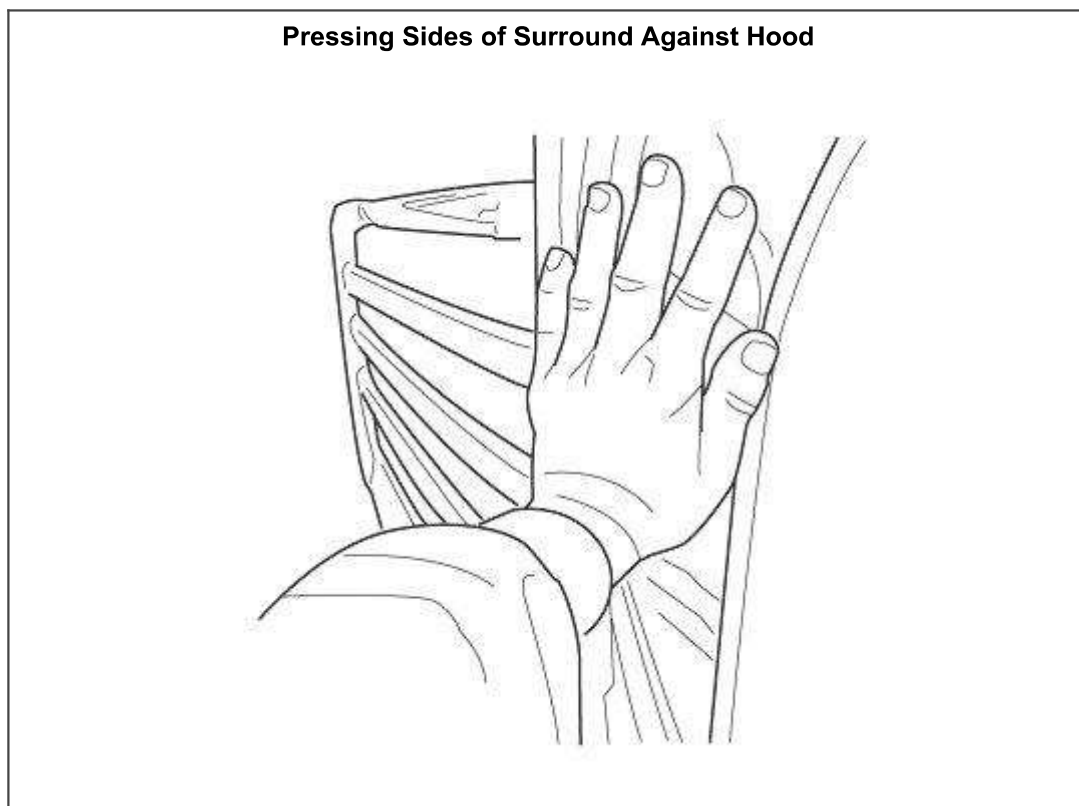
3. Two-Sided Tape

2. Line for Application of Adhesive

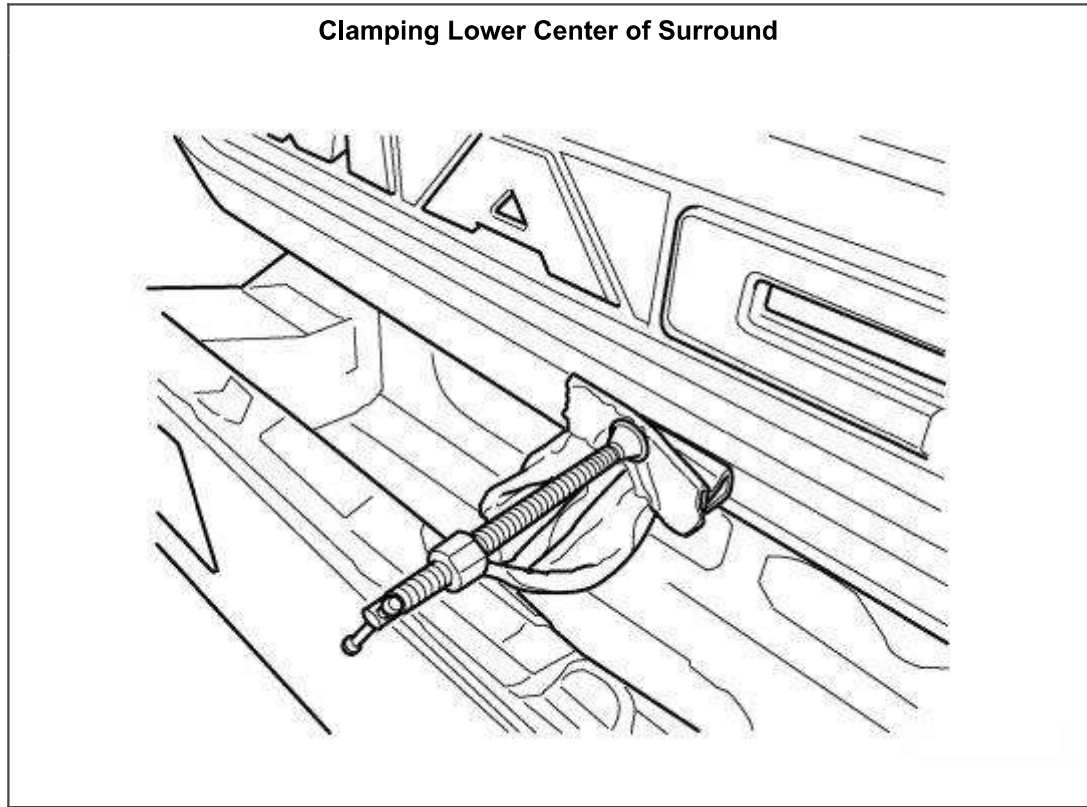
6. Apply a 9.5 mm (3/8") bead of the 3M® 540 Polyurethane adhesive to the marked areas shown in the illustration above.
7. After applying the adhesive, remove the protective film from the two-sided tape, and then install the surround by aligning the top middle portion of the surround with the hood.



8. Firmly push the grille surround against the hood, pushing against the sides of the surround to seat the two-sided tape. Push against the top and the bottom of the surround to allow the adhesive to flow into place. The two-sided tape will hold the surround in place until the adhesive cures.



- Using a suitable size C-clamp and a small piece of cardboard to protect the grille surround, clamp the lower center section of the grille surround to the hood. Allow the adhesive to cure at least 4 hours before returning the vehicle to service.



Warranty information

Reimbursement

<p>This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.</p>	<p>UCHP Reimbursement</p>
<p>Claim Type (used only when uploading from the Dealer Bus. Sys.)</p>	<p>W</p>
<p>Labor Code</p>	<p>622 1J 00 80 –1.0 hr.– Time allowed to remove and replace bright-finish grille surround on GU, CTP and CT model chassis. Does not include “take-charge” time.</p>

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.