



---

**FIELD SERVICE CAMPAIGN – 22127**

10 January 2023

---

**SUBJECT:**

Forward Chassis Terminating Resistor

**MODELS INVOLVED:**

International® LoneStar® Series Truck

**DEFECT DESCRIPTION:**

Certain International® LoneStar® Series trucks may have been built without forward chassis terminating resistors that could result in data communication error.

**ELIGIBILITY:**

This procedure applies ONLY to vehicles marked in the International® Service Portal<sup>SM</sup> with FSC 22127. Also complete any other open campaigns listed on the Service Portal at this time.

**TOOLS REQUIRED:**

Description	Tool Number
Crimping Tool	Locally Sourced
Wire Stripper, 22 to 10 AWG	
Diagonal Cutting Pliers	

**Table 1** Tools Information

**PARTS REQUIRED:**

Part Number	Description	Quantity
3572112R1	Harness, Elect, 19 Stand Twisted Pair	1 (This is sold as roll of 50 ft)
3549418C1	Terminal, Elect, Cable	2
3574277C1	Terminal, Cable	2
3683464C1	Terminal, Cable	4
2519455C1	Plug, Sealing, Elect Connector, Cable Terminal	4
3683465C1	Body, Elect Connector, Male 2-Way	2
3683466C1	Lock, Connector Body, Elect, Packard	2
2507598C1	Lock, Connector, Body	2

3769112C91	Resistor, 120 ohm Terminating Resistor	2
476074C1	Nut, Battery Terminal 3/8 inch UNC (One Time Use)	1
Source Locally	Cable Tie Strap	5 (as needed)

**Table 2** Parts Information

## WORK INSTRUCTIONS

**WARNING!** To prevent, personal injury, and / or death, or damage to property, park vehicle on hard flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in both directions.

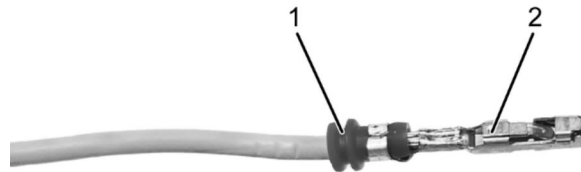
**WARNING!** To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

**WARNING!** To prevent personal injury and / or death, or damage to property, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

**WARNING!** To prevent personal injury and / or death, or damage to property, remove the ground cable from the negative terminal of the battery before disconnecting any electrical components. Always connect the ground cable last.

1. Park vehicle on level surface.
2. Shift transmission to Park or Neutral and set parking brake.
3. Turn ignition to Key OFF position.
4. Install wheel chocks.
5. Disconnect and isolate negative cable on main vehicle battery. Discard battery terminal nut.
6. Obtain and cut wire harness for procedure:
  - A 30-inch (762 mm) length of 19 strand twisted pair harness wire
  - A 32-inch (812.8 mm) length of 19 strand twisted pair harness wire

7. Using a cutting box blade, carefully remove approximately 2 in (50.8 mm) of harness insulation at each end of the 19 strand twisted pair harness.
8. Using wire stripped, remove approximately ¼ in (6.4 mm) of insulation at each end of the precut pair harness.

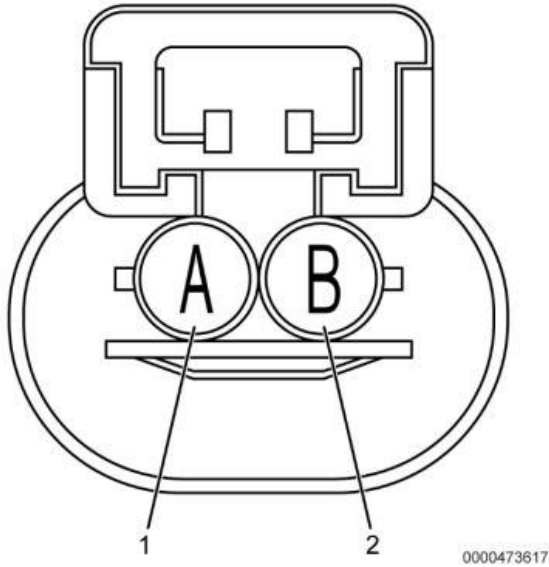


0000476514

**Figure 1. Connector Terminal Seal Assembly**

1. Terminal seal 2519455C1
2. Terminal 3683464C1

9. Using the recently cut 30-inch (762 mm) length of 19 strand twisted pair harness wire, insert electronic connector terminal seal (Figure 1, Item 1) over YELLOW wire.
10. Insert exposed portion of YELLOW wire into the barrel of the terminal (Figure 2, Item 1).
11. Using crimping tool, crimp terminal by placing the barrel of the terminal into the appropriate crimper slot, then crimp and secure electronic connector terminal seal.
12. Repeat Steps 7 through 9 for GREEN wire.
13. Using the recently cut 32-inch (812.8 mm) length of wire, repeat Steps 7 through 9 for GREEN and YELLOW wire.

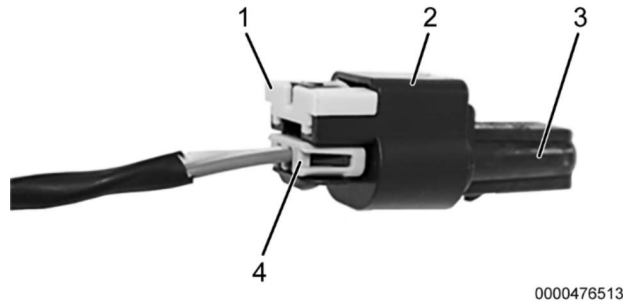


**Figure 2. Connector – 2-Way**

1. Cavity A
2. Cavity B

**NOTE: Ensure that terminals are completely inserted into the connector.**

14. Populate YELLOW wire into connector Cavity A (Figure 2, Item 1) of 2-way connector.
15. Populate GREEN wire into connector Cavity B (Figure 2, Item 2) of 2-way connector.



**Figure 3. Connector – 2-Way**

1. Connector body lock 2507598C1
2. Connector – 2-way 3683465C1
3. 120 ohm terminating resistor 3769112C91
4. Connector body lock 3683466C1

**NOTE: Ensure that terminals are completely inserted into the connector.**

16. Install 120 ohm terminating resistor (Figure 3, Item 3) into 2-way connector (Figure 3, Item 2).
17. Insert connector body lock (Figure 3, Item 1) into male 2-way connector (Figure 3, Item 2).
18. Insert connector body lock (Figure 3, Item 4) into male 2-way connector (Figure 3, Item 2).
19. Repeat Steps 15 through 18 for 32-inch (812.8 mm) length of 19 strand twisted pair harness wire.



0000476515

**Figure 4. Connector Terminal Seal Assembly**

1. Terminal 3549418C1

20. At opposite end of 30-inch (762 mm) length of 19 strand twisted pair harness wire, insert end of wire into barrel of cable terminal (Figure 4, Item 1).

21. Using crimping tool, crimp terminal to wire end.



0000476516

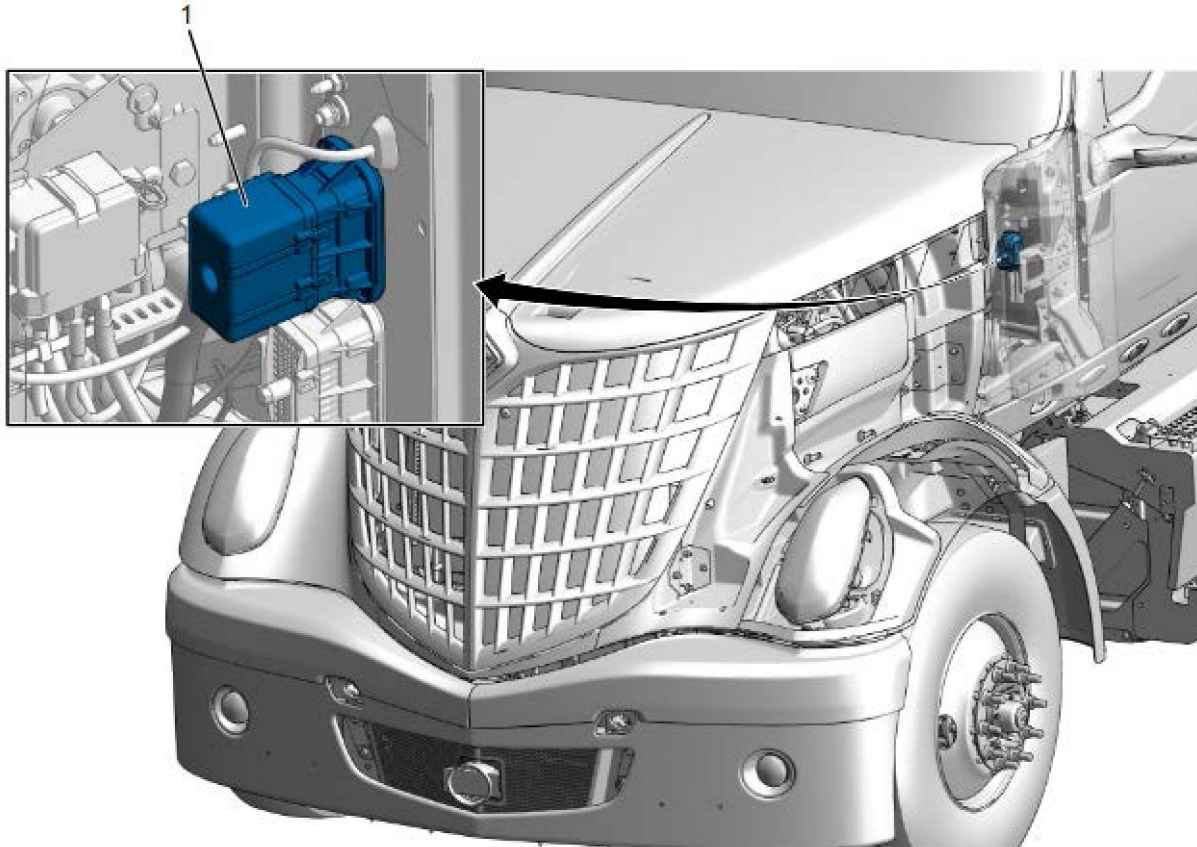
**Figure 5. Connector Terminal Seal Assembly**

1. Terminal 3574277C1

22. At opposite end of the 32-inch (812.8 mm) length of 19 strand twisted pair harness wire, insert end of wire into barrel of cable terminal (Figure 5, Item 1).

23. Using crimping tool, crimp terminal to wire end.

24. Unlatch and open hood.

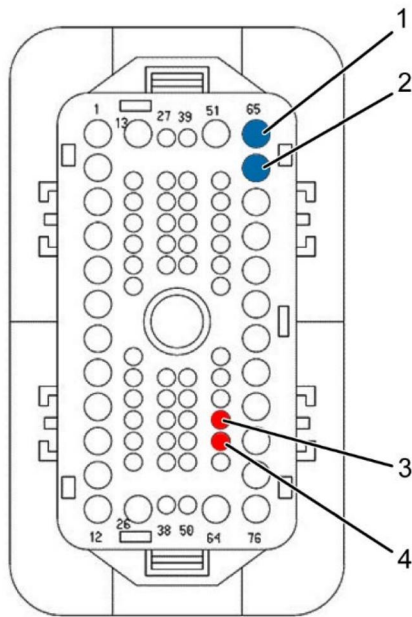


0000476033

### **Figure 6. Forward Chassis Connector**

1. 1700F forward chassis connector

25. Disconnect 1700F forward chassis connector (Figure 6, Item 1) located in the driver-side under-hood compartment. Save fastener for reuse.
26. Remove 1700F forward chassis cover. Save cover for reuse.
27. Remove 1700F forward chassis terminal lock. Save lock for reuse.



0000476517

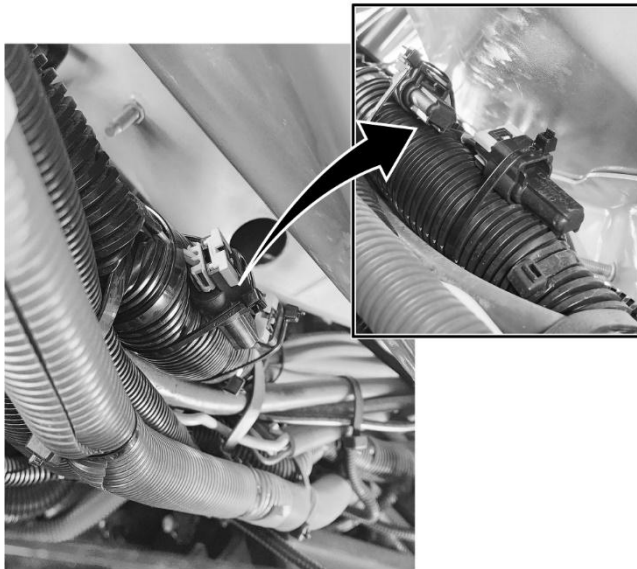
**Figure 7. Forward Chassis Connector**

1. Cavity 65
2. Cavity 66
3. Cavity 61
4. Cavity 62

**NOTE: Ensure terminal is completely inserted into connector.**

28. Populate opposite end of the pre-assembled of the 32-inch (812.8 mm) length of 19 strand wire YELLOW wire into cavity 65 (Figure 7, Item 1).
29. Populate GREEN wire into cavity 66 (Figure 7, Item 2).
30. Populate the opposite end of the pre-assembled of 19 strand twisted pair harness 30-inch length (762 mm) YELLOW wire into cavity 61 (Figure 7, Item 3).
31. Populate GREEN wire into cavity 62 (Figure 7, Item 4).
32. Insert terminal lock into 1700F forward chassis connector.
33. Install 1700F forward chassis connector. Using torque wrench, tighten bolt to 44 lb-in (5 N·m)

**CAUTION:** To prevent damage to property, route and secure harness away from any sharp objects and / or moving parts.



0000476518

**Figure 8. 2-Way Connector Secured**

34. Using cable tie straps, secure both – 19 Strand Twisted Pair Harness to existing harness conduit and male 2-way connectors (Figure 8).
35. Close and latch hood.
36. Clean battery terminal with wire brush. After brushing terminal, clean with electrical contact cleaner and dry with ship air.
37. Apply BLUE dielectric grease to battery terminal stud, negative battery cable ring terminal, and threads of new battery stud nut.
38. Reconnect negative battery cable to negative terminal on main vehicle battery and install new battery terminal nut.
39. Using torque wrench, tighten battery stud nut to 12 - 15 lb-ft (16 - 20 N·m).
40. Remove wheel chocks.

## LABOR INFORMATION

Operation number must appear on all claims.

Operation Number	Description	Time
A40-22127-1	Fabricate Overlay and Install Resistor	0.5 hrs

**Table 3** Labor Information

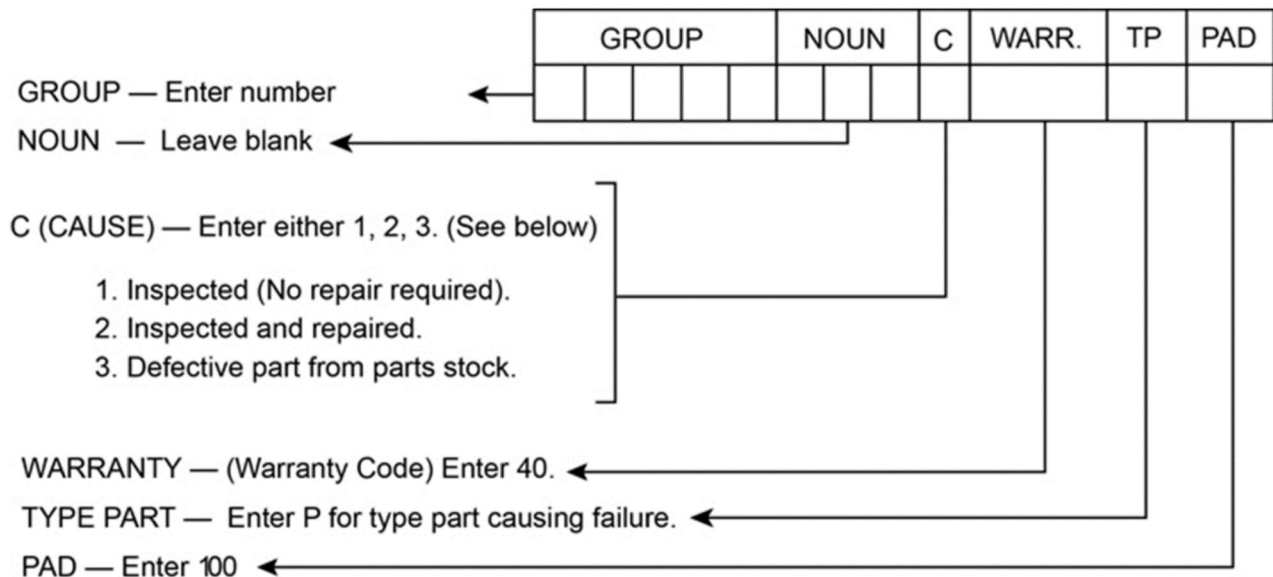
## WARRANTY CLAIMS

Warranty claim expense is to be charged to Warranty. Claims are to be submitted in the normal manner, making reference to Field Service Campaign 22127.

Section 7 of the Warranty Policy and Procedures Manual contains further information related to the submission and processing of AFC / Recall claims.

As with all claim submissions, items acquired locally must be submitted in the “Other Charges” tab. The cost of any bulk items (such as a bag of cable tie straps, roll of wire, barrel of oil, or tube of silicone) should be prorated for the cost of the individual pieces / amount used during each repair.

To make sure this important improvement is made in a timely manner, all claims for 22127 activity must be submitted by 10 January 2023 or within the normal warranty period for the component repaired, if after 10 January 2023.



0000047910