

Transmission Bolt Replacement

Service Category Service

Section Function Group 431

Technician Skill Level A

Market North America

Applicability

VOLVO

Years	Models
2019-2022	VN

Introduction

Volvo has received reports of certain VN chassis, with Allison transmissions, 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 and replacing the flange screws with new ones.

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	CU9	EM-USA17, EM-USA21	03-October-2018	28-June-2021

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
9000-06-09-01	Miscellaneous, Inspection	1.0
Causal Part	22936956	
SCC Authorization Code	S3174	
Expiration Date	May 31, 2024	

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Parts Information

Part Numbers	Part Names	Quantity
984754	Flange Screw (M10X35)	12
*	Threaded insert	As needed

Required Tools & Equipment

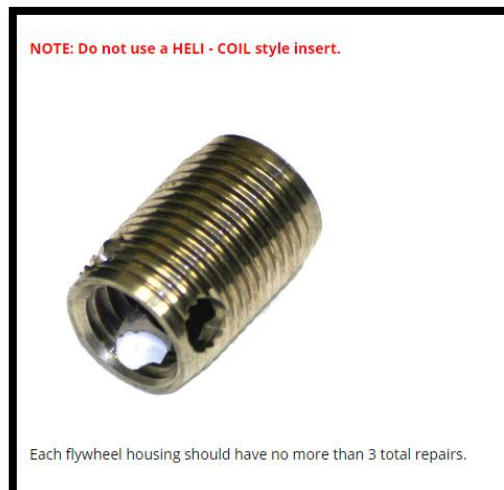
- None

Calibration Information

- None

Repair Procedure

1. Secure truck for service.
2. Properly support transmission during procedure.
3. Remove **one** bell housing flange screw and spacer.
4. Inspect the flange screw for damage.
5. Inspect the flywheel housing threads for any damage.
6. If damage threads are found to the flywheel housing threads, Repair damaged threads.
Only three repairs are allowed on the flywheel housing. If more than three holes are damaged replace the flywheel housing.
7. When repairing the flywheel housing, use only threaded inserts not Heli-Coils.



8. Install a new flange screw part number **984754** without the spacer, torque to 51-61Nm (38-45lbf-ft).

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9. Continue above procedure (one at a time) on the remaining 11 bell housing flange screws.
10. Once all bell housing flange screws have been replaced and torqued, the truck is ready to be released for service.