



CNG Exhaust Pipe Modification

Service Category Service Department

Section Function Group 252

Technician Skill Level C

Market North America

Applicability

Mack

Model Years	Models
2022-2023	AN

Introduction

Mack trucks has determined that certain model year 2022-2023 AN models built with the Cummins C12 CNG engine could experience a lower flex pipe breakage. To correct this issue a new double pipe design as been developed. Follow the instructions below to remove the old flex piping, install support bracket, and install the new designed pipes.

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
Mack	CU12	EM-USA21	8-September-2022	04-January-2023

Warranty Information

This repair may be eligible for reimbursement if a product failure was experienced with in time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.		
Claim Type (used only when uploading from the Dealer Bus. Sys.)		B
Main Labor Code	Description	Hours
2529-03-02-01	Flexible exhaust pipe & leak check	0.3
2522-03-02-05	Exhaust pipe, replace (Flex pipe to DPF)	0.8
2522-03-02-02	Exhaust pipe, replace (turbo to flex pipe)	0.4
1720-16-09-01	Campaign, General x3	0.3
Causal Part	22480488	
SCC Authorization Code	S3102	

Expiration Date	September 30, 2024
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Claiming Note:

To account for the missed opportunity on part sale markup, dealers will be allowed to claim \$658 in “other costs” tab.

Parts Information

UPS will package the kits and bring them when they deliver the truck to the dealer. Please verify all parts listed below are supplied. If not, please order any parts missing through normal ordering process.

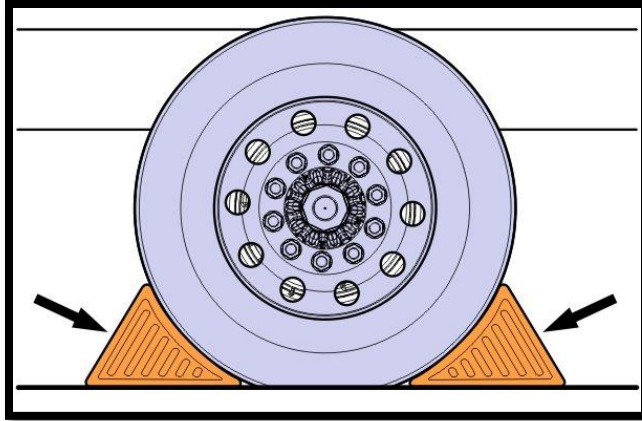
Part Numbers	Part Names	Quantity
24473235	Exhaust Tube, Rear	1
24476500	Exhaust Tube, Front	1
984855	Flange Screw	2
994522	Flange Lock Nut	2
24471673	Bracket	1
22368183	Bracket	1
984755	Flange Screw	1

Required Tools & Equipment

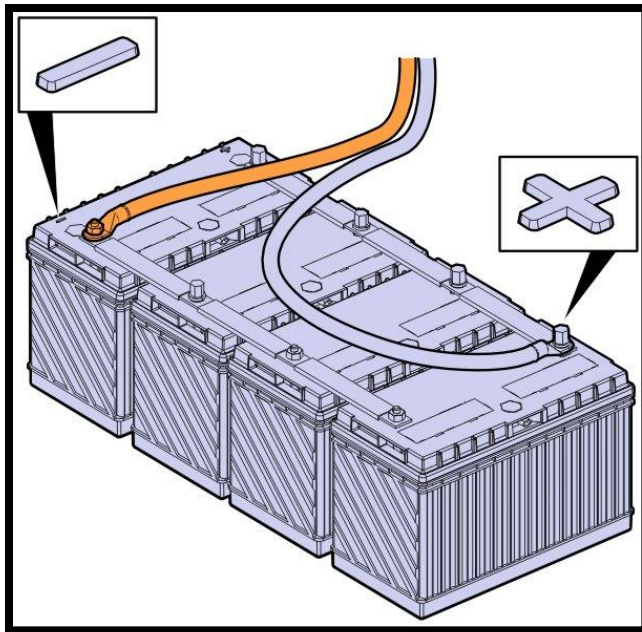
N/A

Repair Procedure

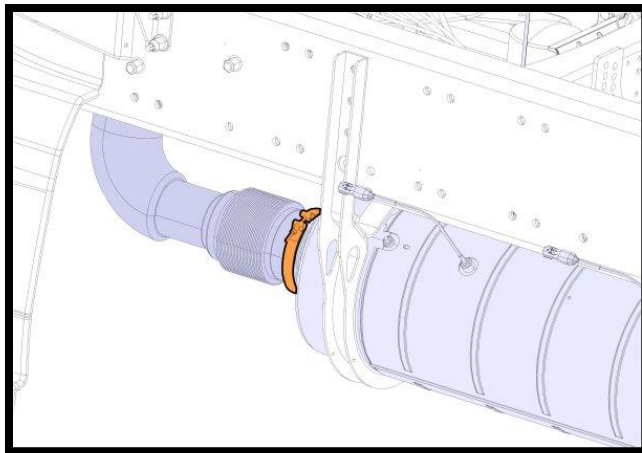
1. Park the vehicle on a level surface.
2. Apply the parking brake.
3. Place the gear lever in neutral.
4. Install the wheel chocks.



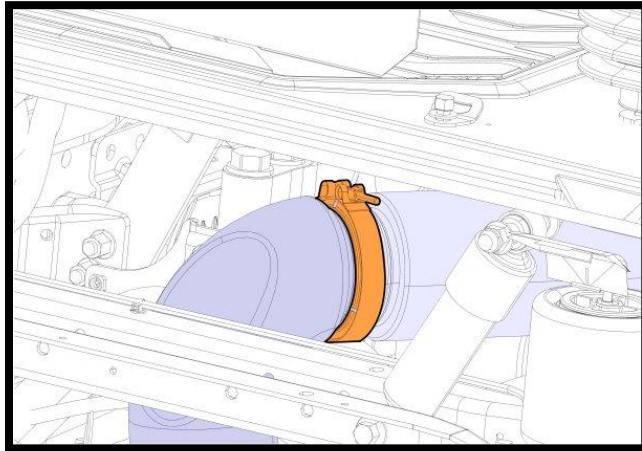
5. Disconnect the cable from the negative terminal.



6. Loosen the clamp.

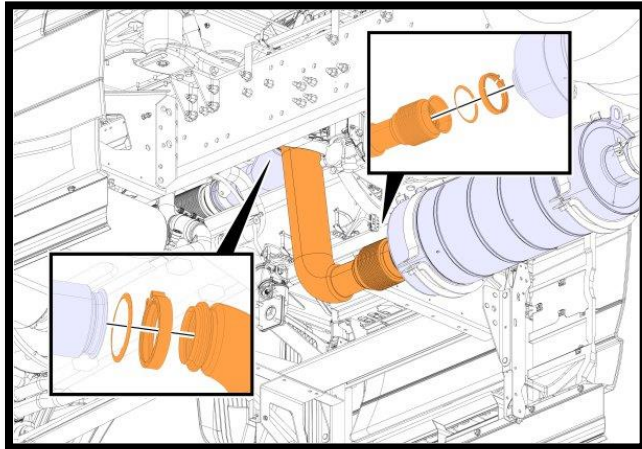


7. Loosen the clamp.



8. Remove the pipe and the clamps.

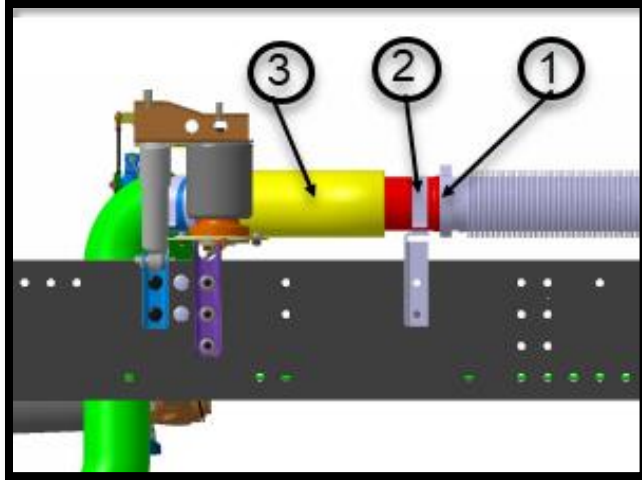
9. Remove and discard the gaskets.



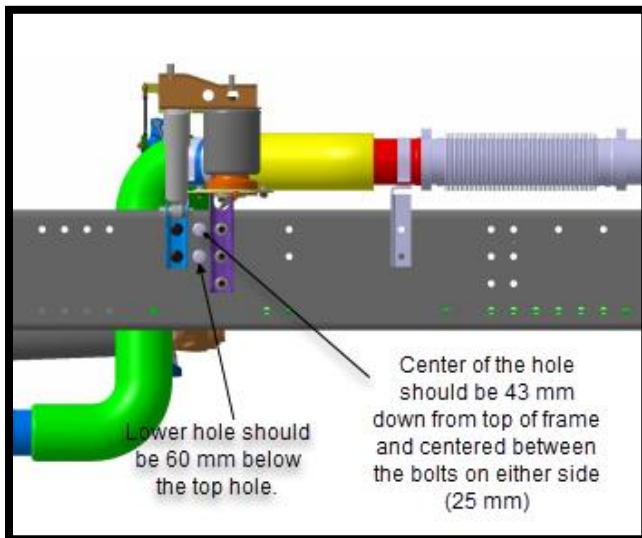
10. Remove the bolt holding bracket #2.

11. Remove the clamp #1.

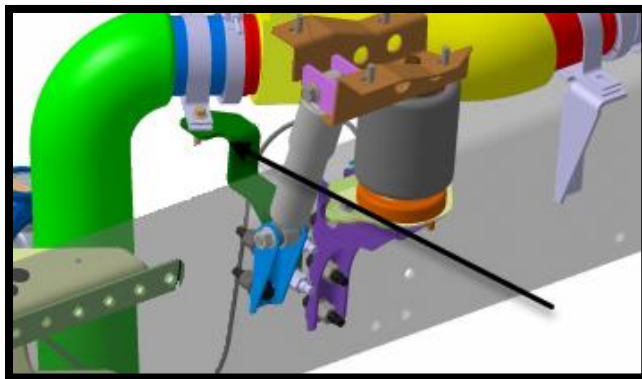
12. Remove pipe #3.



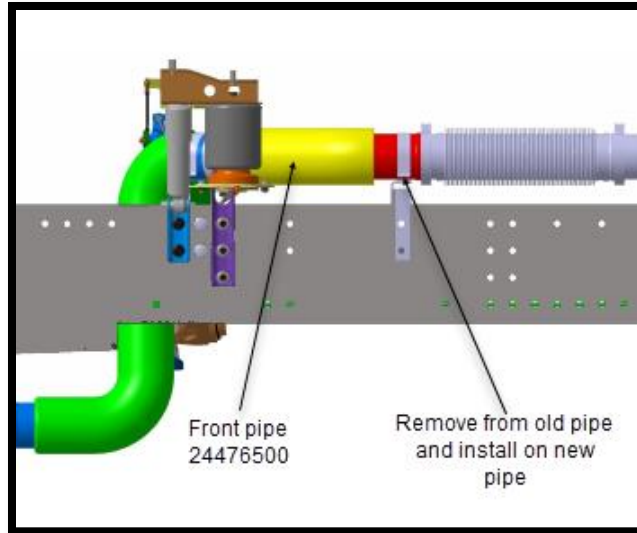
13. Drill two 15.5 mm holes following the image below.



14. Install bracket **24471673** inside the frame using mounting hardware **984855** and **994522**.

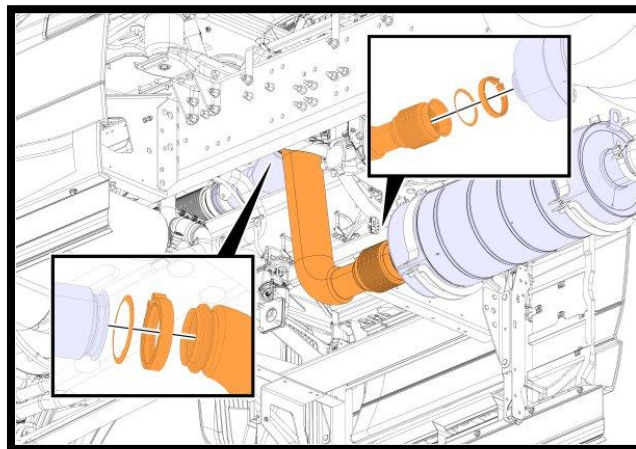


15. Install new front pipe **24476500** with new gasket.



16. Transfer the support clamp from the old pipe to the new pipe.

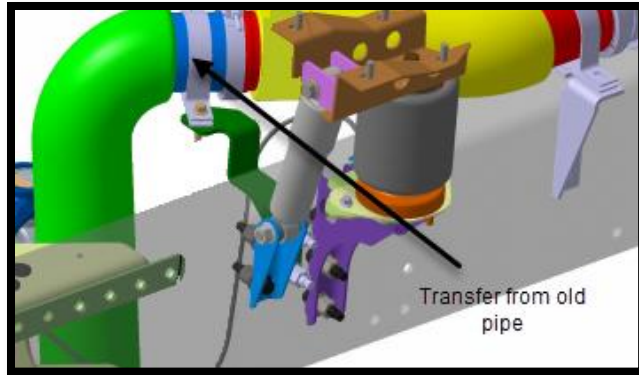
17. Install the rear pipe **24473235** with new gaskets.



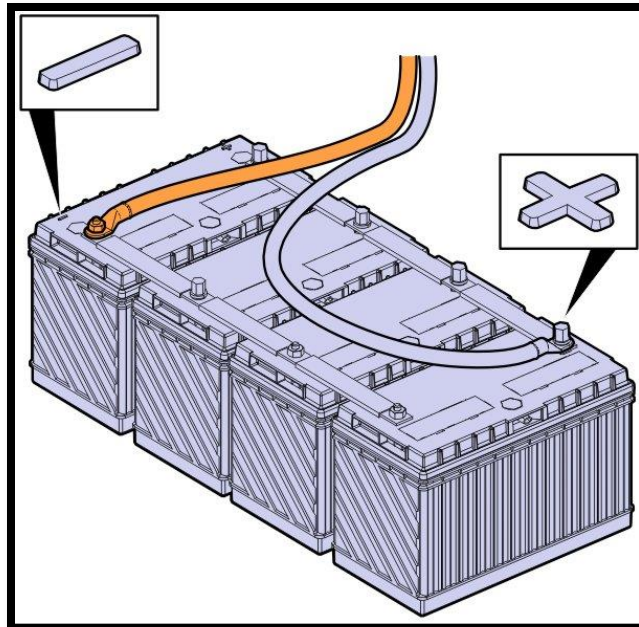
18. Tighten all the pipe clamps

Tightening torque	
Exhaust pipe, clamps	8 Nm (6 lb _r .ft)

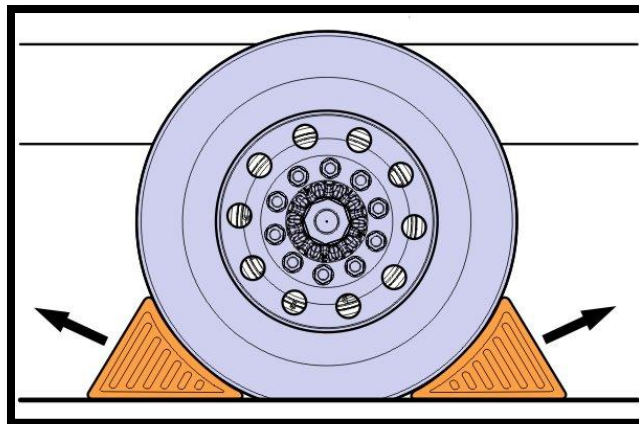
19. Transfer support clamp from old pipe to new pipe and secure to the new mounting bracket using flange screw **984755**.



20. Connect the cable to the negative terminal.



21. Remove wheel chocks.



22. Release vehicle to service.