 <b>HYUNDAI</b> <b>Technical Service Bulletin</b>	<b>GROUP</b> <b>ENGINE MECHANICAL</b>	<b>NUMBER</b> <b>25-EM-001H</b>
	<b>DATE</b> <b>JANUARY 2025</b>	<b>MODEL(S)</b> <b>TUCSON (LM)</b>
<b>SUBJECT:</b> CENTER MUFFLER ASSEMBLY REPLACEMENT (WARRANTY EXTENSION TXXZ)		

**Description:** Certain Tucson (LM) vehicles may have a weakened weld at the zone where the center muffler is attached to the exhaust pipe. This condition may cause the center muffler to detach from the exhaust pipe.

Hyundai is extending warranty coverage for the center muffler assembly under this condition to 15 years/150,000 miles from the date of original retail delivery or date of first use (whichever occurs first) and is valid for original and subsequent owners.

Follow the procedure outlined in this bulletin to replace the center muffler assembly to correct this condition.

**Applicable Vehicles (Certain):**

- 2014-2015MY Tucson (LM) 2.0L and 2.4L vehicles produced from 07/01/2014 to 05/15/2015.

**Parts Information:**

Part Name	Part Number	Application
Center Muffler (QTY 1)	 (Center pipe length varies by P/N*)	28650-2S910QQH <b>THETA- II 2.4L GDI (ULEV)</b> (*Refer to the NOTE below.)
	28650-2S950QQH <b>THETA- II 2.4L GDI (SULEV)</b> (*Refer to the NOTE below.)	
	28650-2S840QQH <b>NU 2.0L GDI (ULEV)</b>	
Clamp (QTY 1)		28641-C8540QQH Use for attaching replacement center muffler pipe to catalyst
<b>GASKET</b> (QTY: Front 1) (QTY: Rear 1)		Front: 28751-2S000 Rear: 28751-2B200 Replace the gasket at the front and rear flanges.

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**\*NOTE:** (2.4L Only) Use the correct campaign part number based on the emission specification. Refer to the pipe length measurement below to distinguish the emission specs with the part numbers.

THETA-II 2.4L GDI	LENGTH (From rear weld of catalyst to front dent mark of center pipe)
<p><b>(ULEV)</b> 28650-2S910QQH (Campaign) Reference: 28600-2S910 (OE Part)</p>	<p>241mm (approx 9.5 inches)</p>
<p><b>(SULEV)</b> 28650-2S950QQH (Campaign) Reference: 28600-2S950 (OE Part)</p>	<p>194mm (approx 7.5 inches)</p>

**Warranty Information:**

Model	Op Code	Operation	Causal Part	Op Time	Nature	Cause
Tucson (LM)	40D032R0	Center Muffler Replacement (Theta-II 2.4L GDI - ULEV)	28600-2S910	0.5 M/H	L31	ZZ1
	40D032R1	Center Muffler Replacement (Theta-II 2.4L GDI - SULEV)	28600-2S950			
	40D032R2	Center Muffler Replacement (Nu 2.0L GDI - ULEV)	28600-2S840			

**NOTE 1:** If the affected parts are still under factory warranty, submit as normal warranty. If the affected parts are out of factory warranty and within the extended warranty period, submit as a campaign claim type using the op codes listed above.

**NOTE 2:** If a part that is not covered by this TSB is found in need of replacement while performing TXXZ and the affected part is still under warranty, submit a separate claim using the same repair order. If the affected part is out of warranty, submit a Prior Approval request for goodwill consideration prior to performing the work.

**NOTE 3:** Take a picture of the warrantable defect. Op times include VIN, Mileage, and Repair validation photo(s) as outlined in the Digital Documentation Policy.

**NOTE 4:** The incident parts are subject to callback through the normal Warranty Technical Center (WTC) parts return process. **Claim is subject to debit if the part is not returned.**

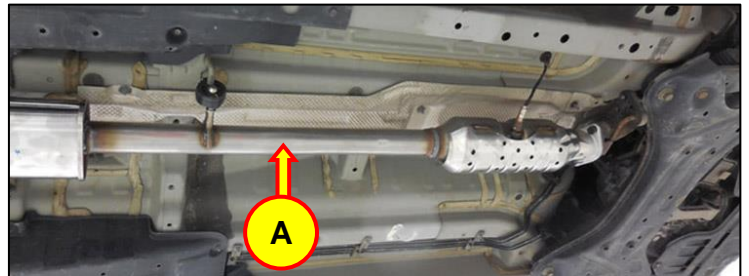
**Service Procedure:**

**STUI**



This TSB includes repair justification photos. Refer to the latest Warranty Digital Documentation Policy for requirements.

1. Lift the vehicle on a hoist and refer to the Shop Manual to remove the center muffler (A) from the vehicle.
  - **Engine Mechanical System > Intake and Exhaust System > Muffler > Repair Procedures**



**NOTICE**

Some engine and emission types may require the removal of the rear O2 sensor from the catalyst.

- Take a STUI photo of the detached or weakened muffler section of the assembly.

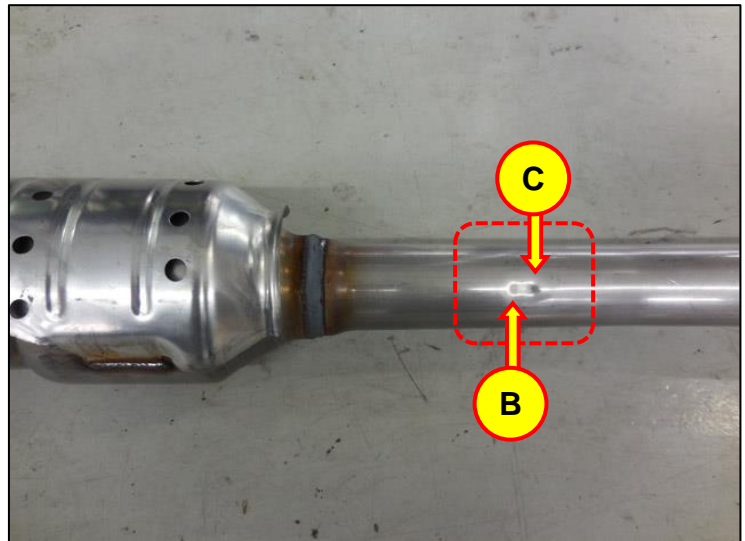
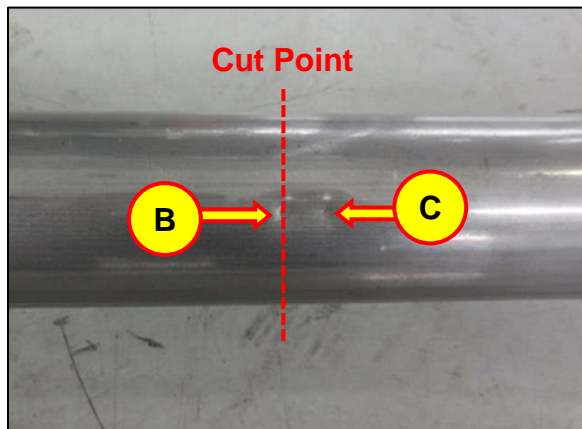
**STUI**



Using STUI, take a photo of the weakened welding area where the center muffler is attached to the exhaust pipe along with the last 6 digits of the VIN and date of repair on a piece of paper. Upload the photo to STUI.



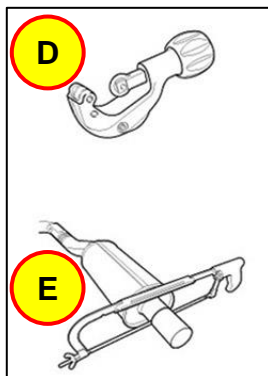
2. Locate the front dent (B) and rear dent (C) of the center muffler pipe for cutting at point (B).



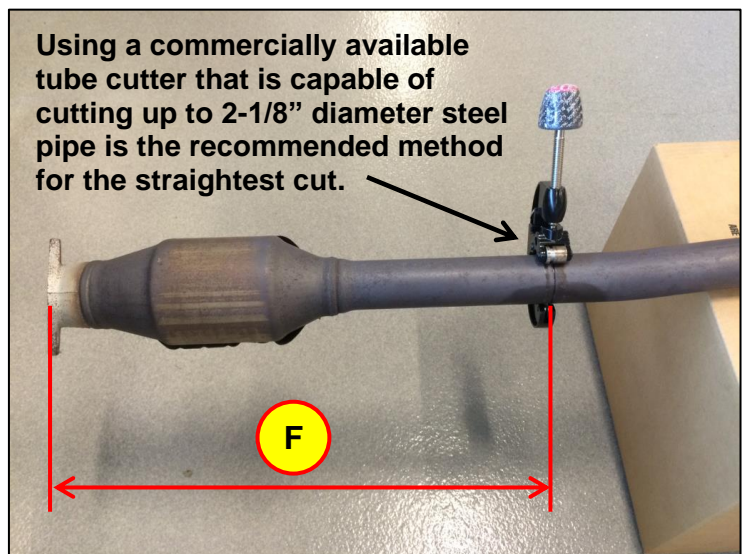
3. Cut the center muffler pipe perpendicular to the front dent (B) cutting point.
- Retain the cut portion with the catalyst (F) to be reused with the new center muffler.

**NOTICE**

Mark the circumference of the pipe and cut the pipe by using a pipe cutter (D), a hack saw (E), or equivalent.



Using a commercially available tube cutter that is capable of cutting up to 2-1/8" diameter steel pipe is the recommended method for the straightest cut.



4. Deburr the cut edge of the pipe at the rear portion of the catalyst (F) using a metal file.

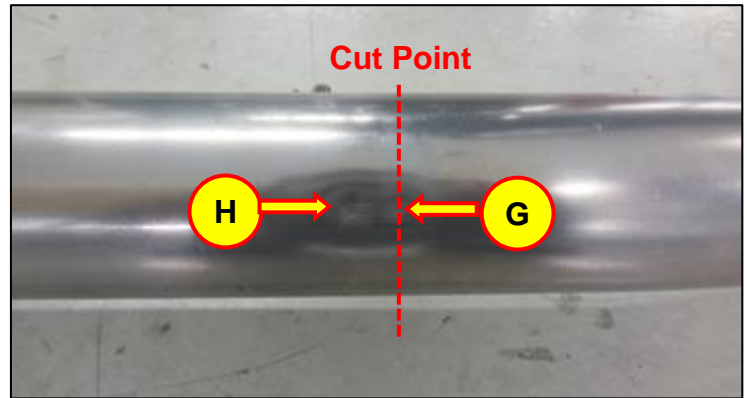
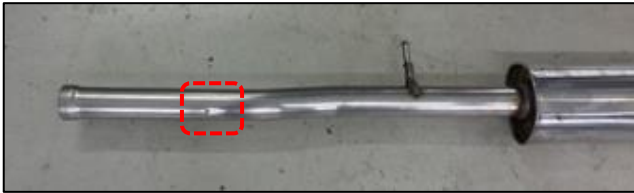


**NOTICE**

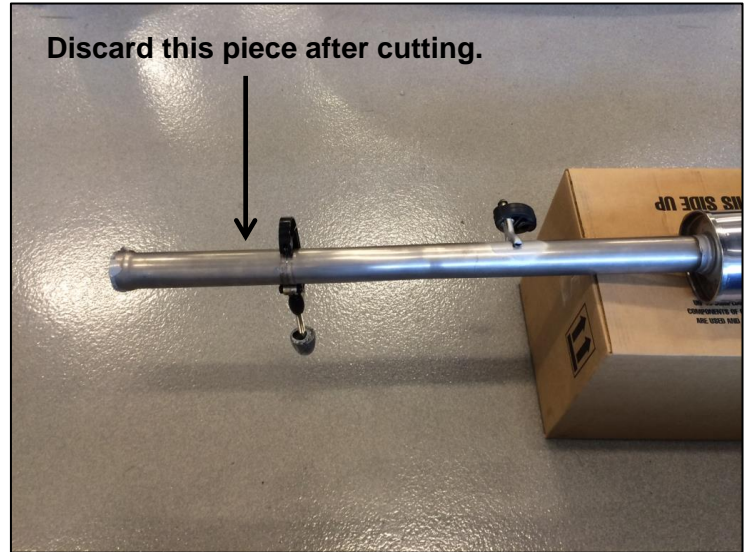
Do not allow any foreign material to enter inside the catalyst pipe.



5. Locate the front dent (H) and rear dent (G) of the new replacement campaign center muffler pipe for cutting at rear dent point (G).



6. Cut the new replacement center muffler pipe perpendicular to the rear dent (G) cutting point.
- Discard the short cut off portion of the new center muffler.
  - Deburr the cut edge of the pipe at the front portion of the replacement center muffler pipe.



Layout of the catalyst (F), shortened new replacement center muffler assembly (I), and clamp (J).

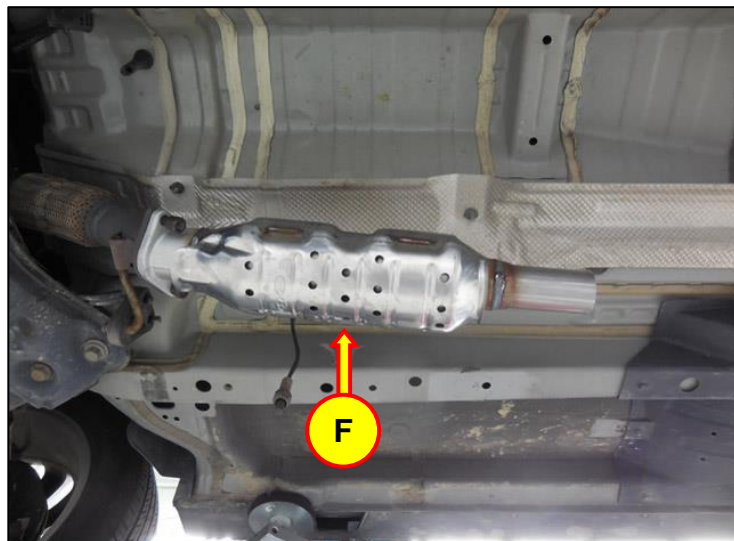


**NOTICE**

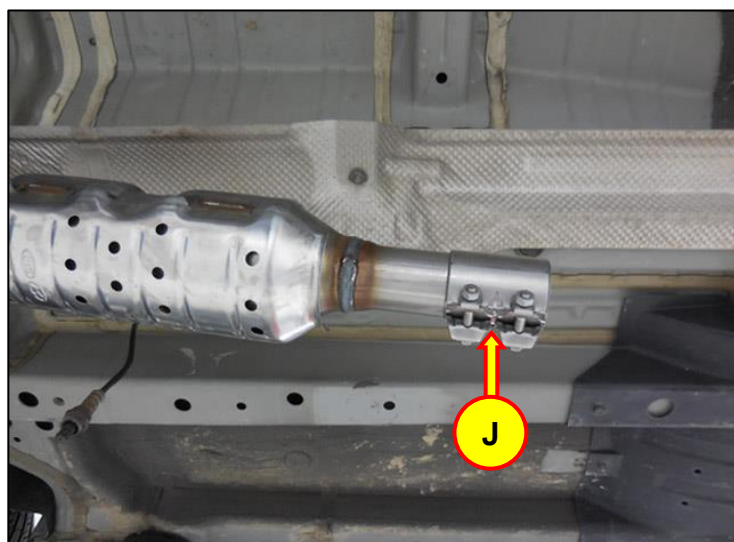
Remove any sticker labels and protective covering tape from the new replacement center muffler assembly prior to installation.



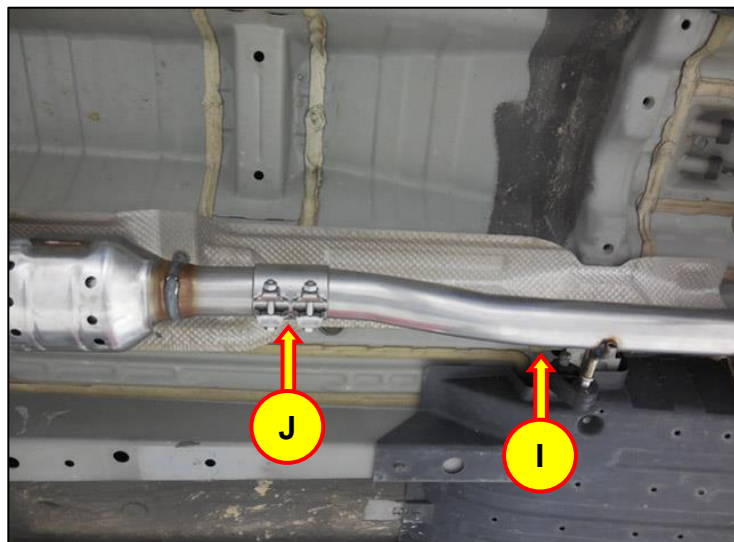
7. Replace the front flange gasket and install the catalyst (F), then temporarily hand tighten the flange nuts.



8. Install the clamp (J) to the catalyst pipe with the clamp bolts facing horizontally.

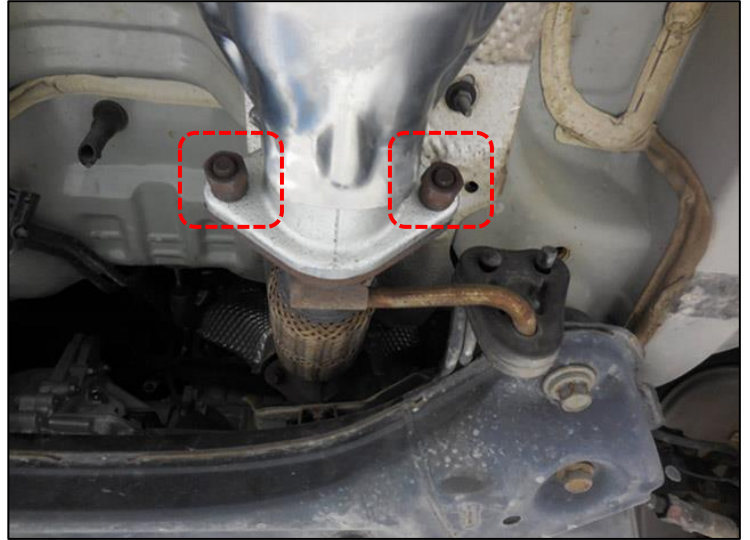


9. Replace the rear flange gasket and install the new replacement center muffler (I) to the clamp (J), then temporarily hand tighten the flange nuts.



10. Tighten the front flange mounting fasteners of the center muffler catalyst.

- **Tightening torque: 49 Nm (36 lb-ft)**



11. Tighten the rear flange mounting fasteners of the center muffler pipe.

- **Tightening torque: 49 Nm (36 lb-ft)**



12. After making sure that the two cut ends of the pipes are butted together inside the clamp:
- a) Slide and hold the clamp (J) towards the catalyst (F) while initially tightening the front clamp fastener.
  - b) Slide and hold the center muffler pipe (I) towards the clamp (J) while initially tightening the rear clamp fastener.

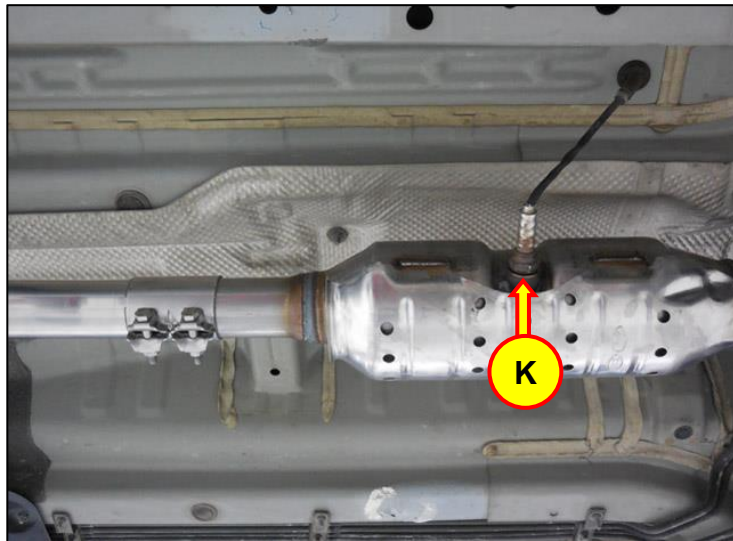
- **Final tightening torque: 22 Nm (16 lb-ft)**

### **NOTICE**

**This clamp forms a crush type seal to the pipes and therefore it cannot be reused after tightening.**

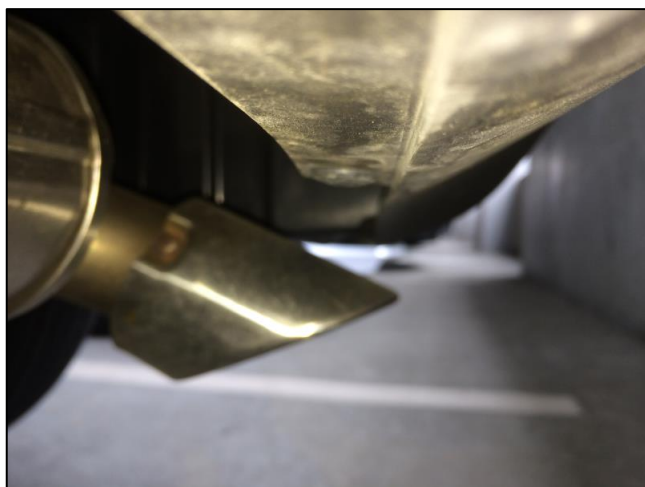
13. Reinstall the rear O2 sensor (K) to the catalyst (if applicable depending on engine and emission type).

- **Tightening torque: 22 Nm (16 lb-ft)**



14. Verify repair.

- Check that there are at least 30mm of clearance between the rear bumper cover and the exhaust tip finisher.
- Operate the engine briefly to confirm that there is no exhaust leak and noise from the clamped pipe areas.



15. Service procedure is now complete.