

**"DOCUMENT UNCONTROLLED IF PRINTED"**

DOC #	PROCESS NAME	PAGE	REVISION	STATION	BY	DATE
<b>AR890</b>	Stand Pipe Rework	1	-	SERVICE	Brad Fisher	4/8/2024

Read process before beginning. If you do not understand any part please contact: Brad Fisher, Service Manager at 1-866-953-5555 or by e-mail at bfisher@ARBOCsv.com

Good Mechanics safety practice must be followed on any repairs.

Safety practices should include but not be limited to properly supporting the chassis, axles, blocking tires, and a work area free of clutter.

**Complaint:** Coolant leak

**Cause:** Standpipes cracking due to length and weight of valves

**Correction:** Install shorter pipes and relocate valves

**Vehicles Affected:** Equess Model year 2021- 2023

**Labor Operation Code:** 524447

**Labor Time Allowance:** 3 hours per unit

**Parts Required**

- (2) 2001301: Short stand pipe 1/2" X 7" 304L STAINLESS STEEL
- (2) 2002490: FTG, HEATER HOSE ELBOW, 1/2" 90 DEGREE BRASS
- (4) 2001071: COUPLER, 1/2" NPT - 5/8" BARBED HOSE
- (12) 1401257: CLAMP, CONSTANT TENSION 15/16"ST STEEL
- (5) 1407285: CABLE TIE, DUAL CLAMP X 19" 150# BLK

**Repair Instruction**

Step 1: Remove tallest stand pipe assembly from engine. Then remove medium stand pipe assembly from engine. Both are circled below in green. Remove valves from pipes and save for later installation.

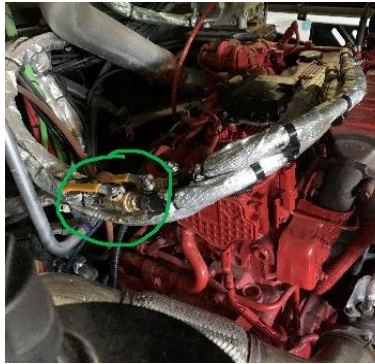


Step 2: Install two new short stand pipes with 90 degree elbows and hose couplers, use thread sealer on all pipe connections.



Step 3: Re-Connect heater hoses to new stand pipe hose couplers. Torque constant torque clamps to 45 in/lbs.

Step 4: Cut heater hoses for valve installation near end of valve cover.  
See picture.



Step 5: Install hose couplers on valves and connect hoses with new constant torque clamps, torqued to 45 in/lbs.



Step 6: Route hoses and secure with cable ties as shown in picture below.

Step 7: Fill cooling system to correct level. Run engine to operating temperature. Verify heater operation and refill as needed.