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**Author:** David Horner

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Coding Information

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**Title: Rear S Cam Tube/ Bracket Part Update**

**Applies To: Prostar, CAT, LoneStar, Durastar, WorkStar, TranStar**

## **CHANGE LOG**

Please refer to the change log text box below for recent changes to this article:

02/26/2025 - Additional LT Part Numbers Added to Table
02/10/2025 - Parts Table Update for LT Gusset Option
04/05/2018 - Author Updated for Feedback Purposes
07/02/2013 - Initial Article Release

## **DESCRIPTION**

Part update for cast and stamped Rear S Cam Brackets. Revised parts will include an additional gusset for the rear wing bracket and/ or longer gussets and wrap-around weld on the flange side of the tube.

Parts information below is based off the previous part number and crossed to the new number. **If the part number for your VIN is not listed below DO NOT SUBSTITUTE to the new numbers. Brackets are specific in length and clocking to each vehicle application.**

## **PARTS INFORMATION**

**Typical For Cast Spider (New)**

**Typical for Stamped Spider (New)**

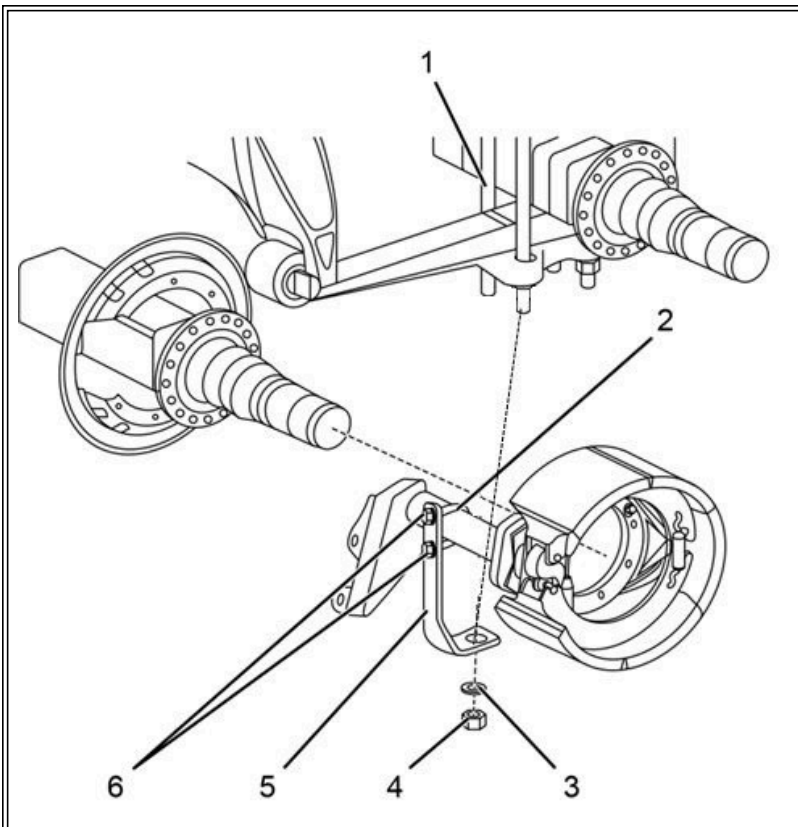


OLD Meritor Part Number		OLD Navistar Part Number		NEW Meritor Part Number		NEW Navistar Part Number	
G9 3299P6256	G9 3299Q6257	1698379C91	1698390C91	T68 3299P6256	T68 3299Q6257	2511737C91	2511738C91
M5 3299P6256	M5 3299Q6257	2509758C91	2509760C91	T67 3299P6256	T67 3299Q6257	2511739C91	2511740C91
M10 3299P6256	M10 3299Q6257	2508938C91	2508941C91	T69 3299P6256	T69 3299Q6257	2511741C91	2511742C91
F38 3299P6256	F38 3299Q6257	2596616C91	2596618C91	U23 3299P6256	U23 3299Q6257	2512102C91	2512103C91
M43 3299P6256	M43 3299Q6257	2585527C91	2585528C91	T50 3299P6256	T50 3299Q6257	2512124C91	2512075C91
F89 3299P6256	F89 3299Q6257	1698120C91	1698122C91	U21 3299P6256	U21 3299Q6257	2512122C91	2512123C91
M22 3299P6256	M22 3299Q6257	2509295C91	2509296C91	U20 3299P6256	U20 3299Q6257	2512118C91	2512119C91
K88 3299P6256	K88 3299Q6257	2505794C91	2505800C91	U24 3299P6256	U24 3299Q6257	2512120C91	2512121C91
E82 3299P6256	E82 3299Q6257	1694330C91	1694332C91	U25 3299P6256	U25 3299Q6257	2512076C91	2512077C91
D11 3299P6256	D11 3299Q6257	584922C91	584923C91	U26 3299P6256	U26 3299Q6257	2512078C91	2512079C91
R45 3299P6256	R45 3299Q6257	2611610C91	2611611C91	V85 3299P6256	V85 3299Q6257	N/A	N/A
P81 3299P6256	P81 3299Q6257	2597625C91	2597627C91	U56 3299P6256	U56 3299Q6257	N/A	N/A

**NOTE: On certain wide base axle applications the new SCAM gusseted bracket will come into contact with the old support brackets. It will be necessary to order and relocate new s-cam Support bracket to the out board side of the U-bolt (Bolt closest the wheel).**

If replacing the passenger side (right side) s-cam bracket you will need a new s-cam support bracket part # 3668032C1  
 If replacing the Driver Side (left side) s-cam bracket you will need a new s-cam support bracket part # 3668033C1

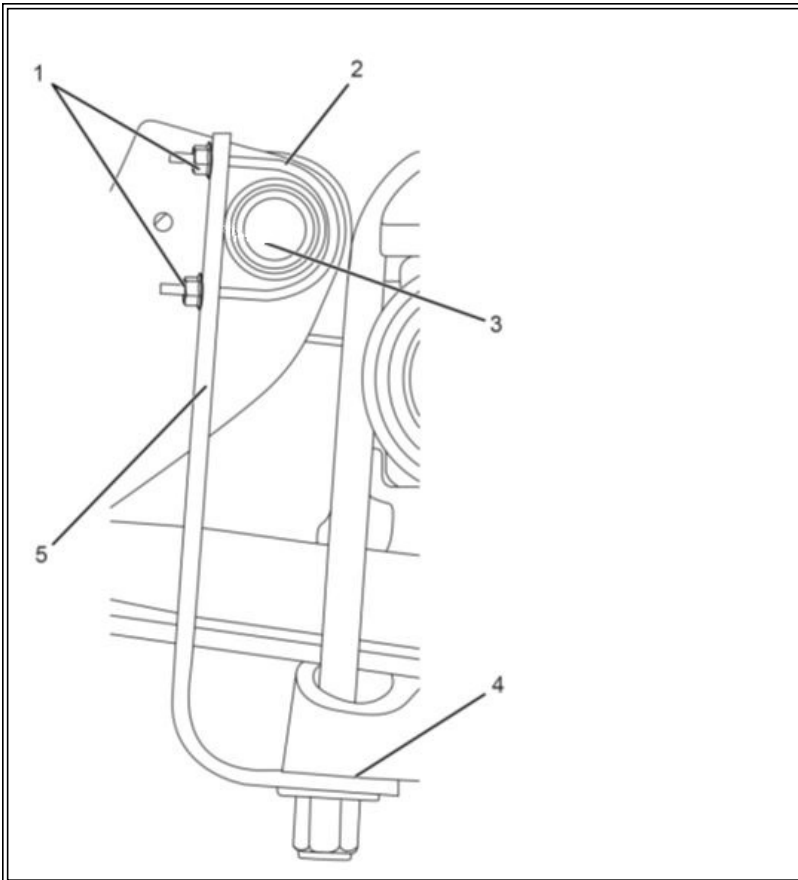
Service Procedure



**Figure #1: Cam Tube**

1. U-bolt
2. Exhaust pipe clamp
3. Washer (U-bolt)
4. Nut (U-bolt)
5. Cam tube support bracket
6. Nut and washer

1. Remove and discard the old support bracket
2. Remove Out Board U-Bolt Nut
3. To ensure proper installation of the cam tube support bracket, perform the following:
  - a. Slide the new cam tube support bracket (Figure 1, Item 5) over the outboard U-bolt (Figure 1, Item 1)
  - b. Position the exhaust pipe clamp (Figure 2, Item 2) on the cam tube support bracket (Figure 2, Item 5) and through cam tube support bracket slots with two washers and nuts (Figure 2, Item 1) hand tight.
  - c. Ensure the cam tube support bracket (Figure 2, Item 5) is contacting the cam tube (Figure 2, Item 3) and is sitting flush against the rear U-bolt spring plate (Figure 2, Item 4).
  - d. Using a torque wrench, tighten two nuts (Figure 2, Item 1) to 60 - 72 lb-in (6.8 - 8.1 N•m).



**Figure # 2: Support Bracket**

1. Nut and washer
2. Exhaust pipe clamp
3. Cam tube
4. Rear U-bolt spring plate
5. Cam tube support bracket

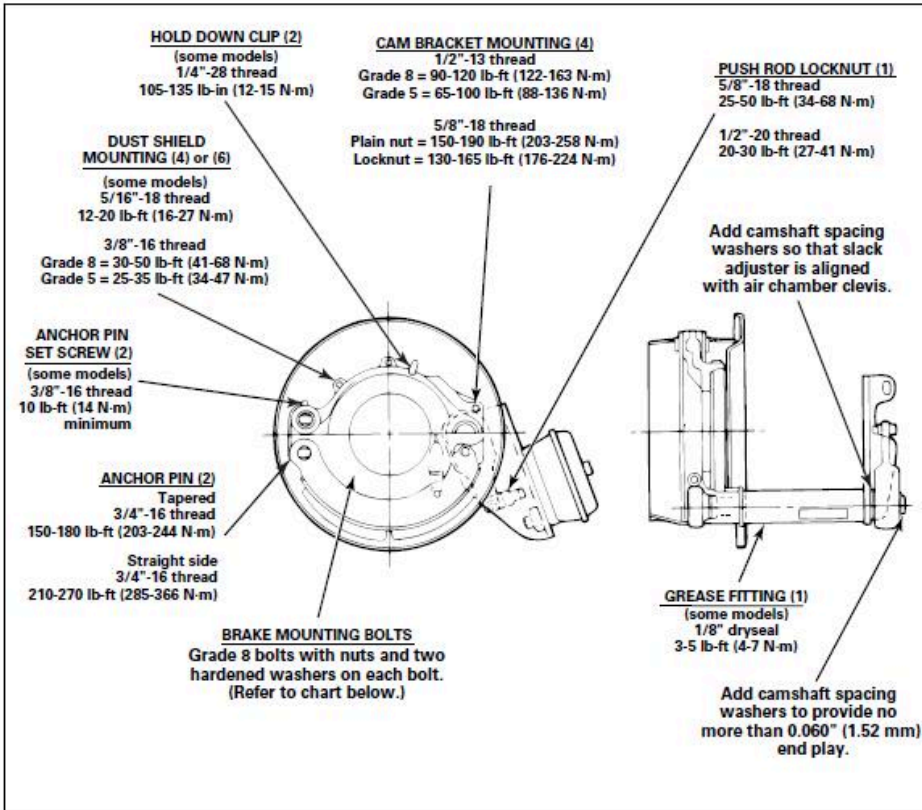
**Note: If you loosen one u bolt it is necessary to re-torque all bolts in that set.**

4. Install the washer U-bolt using a torque wrench, and tighten the nut to 200 lb-ft (271 N•m)
5. Using a torque wrench, re-tighten four bolts in a diagonal pattern to 300 lb-ft (405 N•m)
6. Using a torque wrench, re-tighten four bolts in a diagonal pattern to a final torque of 375 lb-ft (508 N•m)
7. If torque is not achieved, replace the U-bolt.

**Refer to the Meritor Cam Brake maintenance manual for removal and installation instructions on S-CAM brackets**

## Torque Specifications

### Cam Brakes



Brake Mounting Bolts

Bolt Size, Grade 8	Torque, lb-ft (N-m)
7/16"-20	60-75 (81-102)
1/2"-20	85-115 (115-156)
9/16"-18	130-165 (176-224)
5/8"-18	180-230 (244-312)

## WARRANTY INFORMATION

### Warranty Claim Coding:

Refer to the [Warranty Coding Manual](#) for Group and Noun Codes.

### Standard Repair Time(s):

Refer to the [SRT Manual](#) for Repair Times

## OTHER RESOURCES

[Master Service Information Site](#)

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