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Coding Information

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**Title:** Cummins B6.7 Air Compressor Discharge Update

**Applies To:** Cummins B6.7 with feature code 0004VLE AIR DRYER LOCATION Mounted Inside Engine Compartment, Right Side

## CHANGE LOG

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

03/11/2025 - Corrected typo on 971645R1 to 971645R91  
03/10/2025 - Initial Article Release

## DESCRIPTION

The copper air compressor discharge line with air dryer feature code on Cummins B6.7 Series engines may crack and leak air due to engine vibration. This document will guide the user through the repair strategy to replace the hard copper line with a flexible version.

## SYMPTOM(s)

**Diagnostic Trouble Code(s) & Dashboard Indicator Light(s):**

DTC/Light	Description
n/a	

**Customer Observations or Concerns May Include:**

- Low air pressure warning or audible air leak
- Increased time to build air pressure
- Increased compressor duty cycle

## SPECIAL TOOL(s) / SOFTWARE

Tool Description	Tool Number	Comments	Instructions
n/a			

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**SERVICE PARTS INFORMATION**

Kit Description	Part Number	Quantity Required	Notes
Hose, Air Teflon, 29"	3994400C91	1	
Elbow, Air Compressor Fitting (45°)	971645R91	1	
Clamp, Pipe Tee, Single, Cushion (5/8")	3564290C1		If Needed
Bolt, 1/4" X 1"	25483R1		If Needed
Nut, Hexagon Type 8 1/4" Unc	25519R1		If Needed

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**DIAGNOSTIC STEP(s).**

n/a

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**REPAIR STEP(s).**

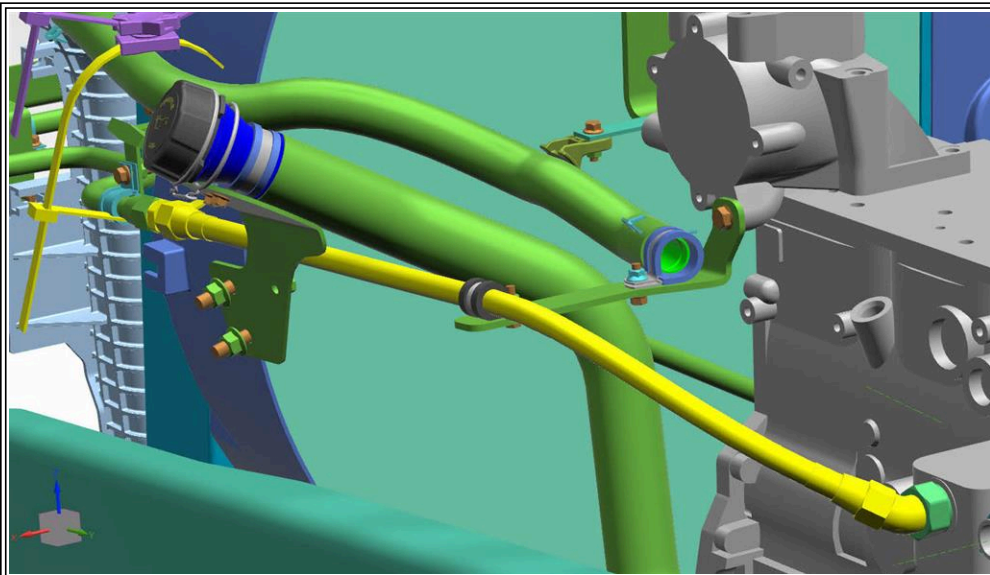
**WARNING!** To prevent property damage, personal injury, and / or death, park vehicle on a hard, flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in either direction.

**WARNING!** To prevent property damage, personal injury, and / or death, if the vehicle must be raised, do not work under the vehicle supported only by jacks. Jacks can slip or fall over.

**WARNING!** To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

**WARNING!** To prevent property damage, personal injury, and / or death, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

**WARNING!** To prevent property damage, personal injury, and / or death, remove the ground cable from the negative terminal of the battery box before disconnecting any electrical components. Always connect the ground cable last.

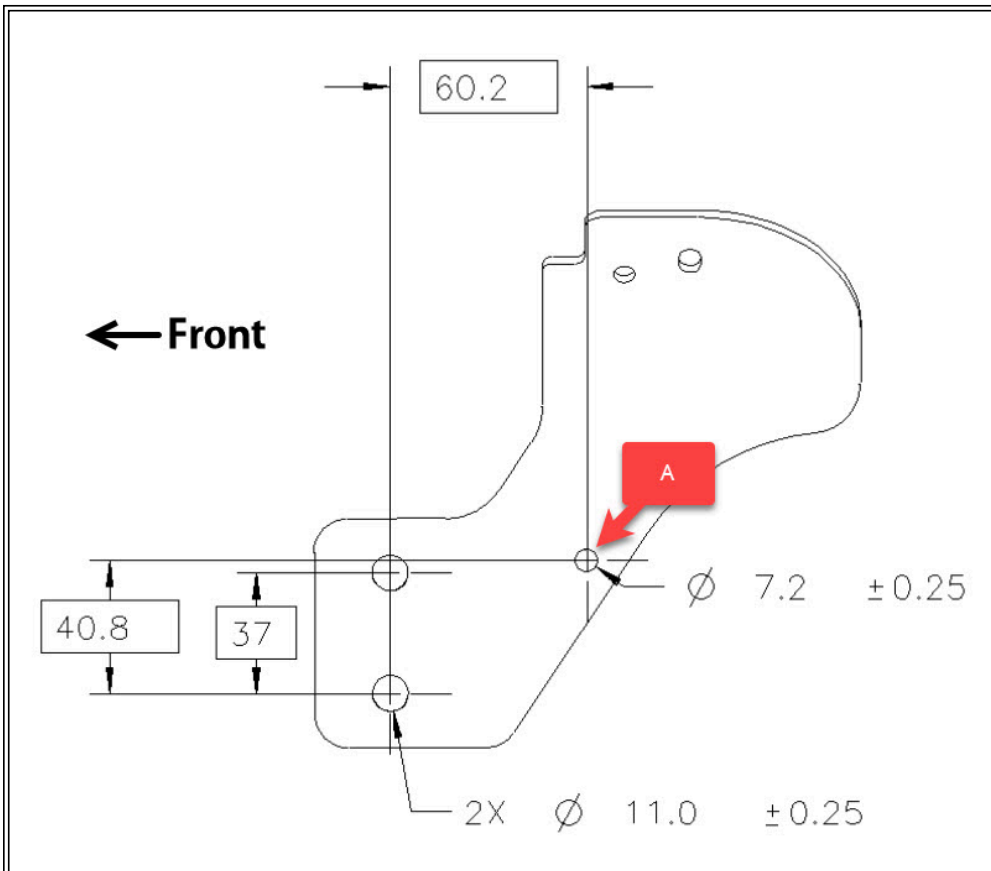


**Figure 1: Teflon Hose Overview**

#### **Vehicle Conditions:**

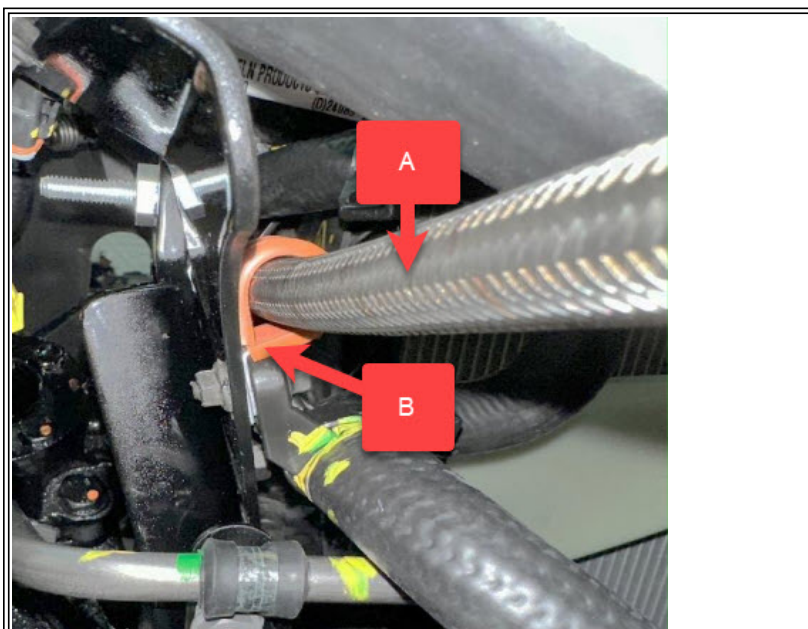
Vehicle parked on dry, level ground, parking brake set, transmission in Park or Neutral, Key OFF. Wheel chocks installed. Battery disconnected. See Battery Disconnect. Hood unlatched and open. Air pressure drained from vehicle reservoirs.

1. Remove and discard air compressor outlet discharge copper tube with forward routed flex hose & 90° adaptor on air compressor
2. Install 45° degree elbow on air compressor angled roughly 45° counter clockwise from vertical
3. Install Teflon Hose, reinstall midsupport P Clamp on stanchion support from engine, and tighten hose ends to 32 - 40 NM (Figure 1)
4. Reinstall P Clamp orientated on the top side of fastener mounted to oil fill bracket (Figure 2 & 3)
5. If needed, bend stanchion support bracket from engine downward with hand pressure to eliminate any low midpoints in newly installed Teflon Hose
6. Reconnect battery and close all reservoir drain valves.



**Figure 1: Oil Fill Bracket Overview**

A: P Clip Point on Oil Fill Bracket



**Figure 1: P Clip Reference Point**

A: Teflon Hose

B: P Clip Installation (Supporting Feature ABOVE Fastener)

# 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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