

R2405: Cummins X15N Retrofit

4/22/2025

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R2405

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Subject

Cummins X15N Retrofit

Whats New Abstract

Due to parts availability, this bulletin will be divided into 2 phases. Phase 1 will bring affected chassis into emissions compliance before 06/30/2025 to avoid fines and penalties. Phase 2 will include all parts that are not currently available but are necessary to bring chassis up to production level. This bulletin will be updated once all Phase 2 parts become available.

The emissions exemption for all chassis involved in this retrofit expires on 06/30/2025. After that date, all chassis that have not received this Phase 1 Retrofit will be out of compliance with emissions regulations and illegal to operate.



NOTE

If emissions exemptions are allowed to expire, vehicle owners could receive civil fines per regulation 40 CFR 19.4 up to \$5,911 per engine. In addition, owners may be required to discontinue operation of the vehicle until the retrofit is completed.

Condition

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that are not currently available but are necessary to bring chassis up to production level. This bulletin will be updated once all Phase 2 parts become available.

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Chassis Affected

10 US Vehicle Model Year 2025 T680/T880 chassis built from 1/15/2024 through 5/16/2024 equipped with

Action

Campaign

Service all chassis affected that enter your dealership, even if the customer has no issue with the chassis.



NOTE

Be aware that the following parts have significant lead times that must be considered when scheduling vehicles for service:

1. Cummins X15N Replacement Engine:

- Refer to [R2405 – PH1 KW Parts by Chassis - tabbed](#) to determine if a replacement engine is needed.
- There is a 15-day lead time on engine orders.

2. Vehicle Emission Control Information Labels:

- There is a 14-28 day processing time for label requests.

3. Engine Data Plate: (Only for chassis not receiving Engine Replacements)

- There is a 10-day processing time for label requests.

- Review the attached chassis list for your dealer code. Verify that you will be the repairing location and order Phase 1 Parts necessary for your customer(s) as shown in [R2405 – PH1 KW Parts by Chassis - tabbed](#).
- Order all parts necessary for the chassis. Some parts have significant lead times and special ordering procedures. Refer to [R2405 – PH1 KW Parts by Chassis - tabbed](#) and parts section for full information.
- Make sure you have all necessary parts on hand prior to scheduling your customer for service.
- Campaign **R2405A** is for Phase 1 – Emissions Compliance. R2405B will be for Phase 2 – Production Level Parts when all parts become available.
- In Service Management, select Campaign **R2405A** to add it to the case. If the unit is released back into service without performing the repair, make sure to also release the campaign in Service Management.
- If you are not using Service Management to start repair orders, review SIR for “Complete” next to the **R2405A** campaign code prior to performing this repair.
- Follow the appropriate procedures in the Links section, Cummins QuickServe, and installation drawings in ServiceNet to remove and replace any Retrofit parts listed for your specific chassis in the [R2405 – PH1](#)

[KW Parts by Chassis - tabbed](#) found in the Links section below.

The emissions exemption for all chassis involved in this retrofit expires on 06/30/2025.



NOTE

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Warranty

Warranty

There is no time or mileage limit to this campaign. Kenworth will pay for parts at dealer net plus applicable mark-up and labor except as noted in "Engine Replacement Claim Filing" table below.

The emissions exemption for affected vehicles expires on **06/30/2025**. To avoid possible fines, Phase 1 must be completed immediately.

- For all repairs relating to the **R2405 Phase 1** retrofit, file an editable claim using code **R2405A** and input all parts and labor used. If chassis requires an engine replacement, please refer to the "Engine Replacement Claim Filing" table below.
- For all retrofit related parts replacements, use editable, non-time SRT code B25-12A to report all hours involved in performing repairs.
- Attach a time sheet detailing labor time used for this retrofit.

FOR ALL CHASSIS THAT REQUIRE AN ENGINE REPLACEMENT, SEE TABLE BELOW TO DETERMINE HOW TO FILE WARRANTY CLAIM FOR ENGINE COST AND ENGINE R&R LABOR COST.

Kenworth VIN	Who Pays For ENGINE	Who pays for engine R&R LABOR
1NKYDB9X5SJ100688	KENWORTH	KENWORTH
1NKYDB9X4SJ130426	KENWORTH	KENWORTH
1NKYDB9X8SJ380705	KENWORTH	KENWORTH
1NKZDB9X1SJ383384	KENWORTH	KENWORTH
1NKYDB9X4SJ396674	KENWORTH	KENWORTH
3BKYD40X7SF549149	CUSTOMER	KENWORTH

- File the claim within 14 days in accordance with Warranty Policy [CA009](#).

Take off parts disposition: Except for engines, destroy take-off parts 30 days after claim is paid. Engines will be

returned per instructions in Engine Replacement Procedure in Links section.

PRWS CLAIM CODING			
Campaign Code:	R2405A	Campaign Type	Retrofit
Claim Category:	Truck	Repair Type	Proactive
Customer Concern Code	173	Causal Code	A1
Corrective Action Code	12	Responsibility Code:	Engineering
Failure Location	053-005-021	Causal Part	S53-6198 (VECI Label)
Supplier Code	N/A	SRT Code	B25-12A Editable, non-time SRT code

Parts

Please ensure ALL required parts are on hand before scheduling the customer for service.



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- There is a 15-day lead time on engine

orders.

2. Vehicle Emission Control Information Labels:

- There is a 14-28 day processing time for label requests.

3. Engine Data Plate: (Only for chassis not receiving Engine Replacements)

- There is a 10-day processing time for label requests.

Parts for this retrofit are available from PACCAR Parts except as noted below.

- Cummins Fan Drive Bracket 6552457 must be sourced directly from Cummins per instructions below. Reference [R2405 – PH1 KW Parts by Chassis - tabbed](#) to determine if this part is needed for your chassis.
- To source part number 6552457, you must contact David King at Cummins via email: David.j.king@cummins.com.
- For engine ordering instructions, refer to [R2405 – Engine Replacement Procedure](#).
- Refer to the [R2405 – PH1 KW Parts by Chassis - tabbed](#) to determine parts required for your chassis.
- You must order a new “Vehicle Emissions Control Information” label (p/n S53-6198) that is updated to show MY25 compliance.

PACCAR	VEHICLE EMISSION CONTROL INFORMATION	
VIN: 1XKYD49XXSJ123456	FAMILY NAME: SPCR2TRACCG3	
EMISSIONS CONTROLS: AES,ARF,ATS,IRT5,IRTE,LRRR,LRRD,LRRS,TGR,TPMS,VSL,VSLE,WR		
THIS VEHICLE COMPLIES WITH U.S. EPA REGULATIONS FOR 2025 HEAVY-DUTY VEHICLES		
THIS VEHICLE COMPLIES WITH CALIFORNIA REGULATIONS FOR 2025 HEAVY-DUTY VEHICLES		
REGULATORY SUBCAT: Class 8 High Roof Sleeper Tractor, C I Eng	01/02/2025	

Vehicle Emissions Control Information (VECI) Label ordering procedures:

- Login to PACCAR.net.
 - Open the following link: [Aftermarket Change Request](#)
 - For instructions on how to submit a GHG Aftermarket Change Request, refer to the [GHG Aftermarket Change Request User Guide](#)
 - Be sure to specify in the submission that the vehicle is an X15N Pilot Vehicle that is being upfit to a certified configuration.
 - For the “Regulated Modification”, select “Engine Replacement.”
- “Engine Replacement” will be selected even if the chassis is not receiving a replacement engine.**
- The new label will be mailed to you UPS Red – Next Day Air.

Procedure

Please follow your dealership's safety procedures and precautions to ensure the vehicle can be safely repaired and maintained. Read all steps before beginning.

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- There is a 15-day lead time on engine orders.

2. Vehicle Emission Control Information Labels:

- There is a 14-28 Day processing time for label requests.

3. Engine Data Plate: (Only for chassis not receiving Engine Replacements)

- There is a 10-day processing time for label requests.

CUMMINS X15N ENGINE REPLACEMENT

- Refer to the [R2405 – PH1 KW Parts by Chassis - tabbed](#) spreadsheet to determine if your chassis requires an engine replacement.
- If engine replacement is required, reference [R2405 – Engine Replacement Procedure](#).

PRE-PRODUCTION PARTS RETROFIT

Some non-emissions related parts are listed in Phase 1 to prevent excess work in phase 2 - For example, engine mounts (non-emissions) are best replaced during an engine replacement (emissions-related)

- Refer to the [R2405 – PH1 KW Parts by Chassis - tabbed](#) spreadsheet to determine parts required for your chassis.
 - For directions on replacing the components listed for the chassis you are working on, reference the "Part Description and Special Instructions" column in the [R2405 – PH1 KW Parts by Chassis -](#)

[tabbed](#). Here you will find installation drawing numbers to help you determine routing of harnesses, placement of brackets and clamps, etc.

- Most drawing numbers can be accessed through KW ServiceNet.
- Drawings that are not currently available in KW ServiceNet are attached in PDF format in the Links section of this bulletin.
- There is an additional column in the spreadsheet that shows whether the installation of the new part is similar to or different from the part being removed.
 - If the new part installation is different, you will want to review the installation drawing carefully to see how it differs from the current part installation.
 - If the new part installation is similar, you will want to observe how the current part is installed and install the new part in a similar manner. You will still want to reference the drawing to determine where any minor differences in the installation may be.

FOR CHASSIS NOT RECEIVING A REPLACEMENT ENGINE

For all trucks not receiving a replacement engine, you must perform all of the following in addition to any applicable part retrofits listed above:

- Replace the existing, exempt Engine Data Plate with a new, compliant Engine Data Plate.
- Send photo of exempt Data Plate removed from engine, and engine with new Data Plate installed to: David.j.king@cummins.com.
- Update engine calibration to latest production calibration using Cummins Insite.

If chassis is equipped with an Eaton Endurant transmission:

- Use Eaton ServiceRanger to verify Transmission Control Module software is version **5543661** or newer following steps in the [Eaton Software Programming Document](#).
- If software is not **5543661** or newer, use Eaton ServiceRanger to update software to latest version.

If chassis is not equipped with an Eaton Endurant transmission, leave transmission calibration as-is .

VEHICLE EMISSION CONTROL INFORMATION (VECI) LABEL

PACCAR		VEHICLE EMISSION CONTROL INFORMATION		
VIN:	1XKYD49XXSJ123456	FAMILY NAME:	SPCR2TRACCG3	
EMISSIONS CONTROLS:		AES,ARF,ATS,IRT5,IRTE,LRRA,LRRD,LRRS,TGR,TPMS,VSL,VSLE,WR		
THIS VEHICLE COMPLIES WITH U.S. EPA REGULATIONS FOR 2025 HEAVY-DUTY VEHICLES				
THIS VEHICLE COMPLIES WITH CALIFORNIA REGULATIONS FOR 2025 HEAVY-DUTY VEHICLES				
REGULATORY SUBCAT:		Class 8 High Roof Sleeper Tractor, C I Eng		01/02/2025

- Be sure to order a new VECI label following the instructions in the Parts section.
 - Be aware of the **14-28 day processing time**.
 - *All chassis* require a new VECI label whether they are receiving a replacement engine or not.
- Remove the old VECI label from the driver's side door jamb and replace it with the new label.
- Take a picture of the new label as it is installed and attach the picture to the warranty claim.

EMISSIONS LABELS

You must take pictures of both the new Engine Emissions Label and Vehicle Emission Control

Information Label as they are installed and email to Vince.Davis@paccar.com.

- Type the following in the subject line of the email: *R2405 Emissions Retrofit Labels*
- In the body of the email, input the following: 17-digit Vehicle Identification Number AND Engine serial number.
- Attach pictures of: New, compliant Engine Emissions label as it is installed AND New Vehicle Emission Control Information (VECI) label as it is installed.

Attachments

[R2405 – PH1 KW Parts by Chassis - tabbed](#) (Chassis on individual tabs at bottom)

[R2405 - KW Chassis List](#)

[Customer Letter](#)

PROCEDURES DOCUMENTS

[R2405 – Engine Replacement Procedure](#)

[Eaton Software Check](#)

INSTALLATION DRAWINGS

[F95-1314-000](#)

[F97-2342-000](#)

[F97-2355-000](#)

[F97-2403-000](#)

[A97-1383-000](#)

[F97-2208-001](#)