

R2405 - Cummins X15N Retrofit

4/18/2025

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R2405

Subject

Cummins X15N Retrofit

Whats New Abstract

Due to parts availability issues, this bulletin will be divided into 2 phases. Phase 1 will enable these chassis to be brought 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 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.

Campaign start date: 04/18/25

Condition

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be out of compliance with emissions regulations and **illegal to operate**.

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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.

Campaign start date: 04/18/2025

Chassis Affected

8 (7 U.S. and 1 Canada) Model Year 2025, 520, 567, and 579 chassis manufactured with pre-production parts, software, and an exempt Engine Data Plate.

Action

Campaign

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

- Review the attached chassis list for your dealer code and schedule your customer(s) for service if their chassis is on the list.
- **Make sure you have all necessary parts on hand prior to scheduling your customer for service.**
- 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

needed.

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

Vehicle Emission Control Information Labels:

- There is a **2 to 4-week** processing time for label requests.

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

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

Warranty

Starting on **04/18/2025**, there is no time or mileage limit to this campaign. Peterbilt 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, it 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.

ENGINE REPLACEMENT CLAIM FILING		
PETERBILT VIN NUMBER	WHO PAYS FOR ENGINE	WHO PAYS FOR ENGINE R&R LABOR COST
1NPBDB9X6SD691189	PETERBILT	PETERBILT
1NPBDB9X9SD696418	CUSTOMER	PETERBILT
3BPDLB0XXSF693861	PETERBILT	PETERBILT

- File the claim within 7 days in accordance with warranty policy.

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:	R2405	Campaign Type:	Retrofit
Claim Category:	Truck	Repair Type:	Proactive
Customer Concern Code:	173 - Other	Causal Code:	A1-Campaign
Corrective Action Code:	12- Repair Recall/Campaign	Responsibility Code:	ENGR
Failure Location:	053-005-021	Causal Part:	S53-6198
Supplier Code:	N/A	SRT Code:	B25-12A - (Editable) Bulletin R2405 Cummins X15N Engine Retrofit - Editable Claim - Use SRT code for entire retrofit work.

Parts

Make sure you have all necessary parts on hand prior to scheduling your customer for service.



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

Cummins X15N Replacement Engine:

- There is a **15-day lead time** on engine orders.
- Refer to PB Parts Breakdown by Chassis spreadsheet in Links section to determine if a replacement engine is needed.

Vehicle Emission Control Information Labels:

- There is a **2 to 4-week processing time** for label requests.


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 – PB Parts Breakdown by Chassis in Links section 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 [R2405A - PB Parts Breakout by Chassis - PHASE 1](#) 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 label ordering procedures:**
 - Be aware that this label request requires from 2 to 4 weeks of processing time so plan accordingly.**
 - 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.pdf](#)
 - 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.



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Cummins X15N Replacement Engine:

- There is a **15-day lead time** on engine orders.
- Refer to PB Parts Breakdown by Chassis spreadsheet in Links section to determine if a replacement engine is needed.

Vehicle Emission Control Information Labels:

- There is a **2 to 4-week processing time** for label requests.

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 [R2405A - PB Parts Breakout by Chassis - PHASE 1](#) spreadsheet to determine if your chassis requires an engine replacement.
- If engine replacement is required, reference [R2405 – Engine Replacement Procedure](#).

PRE-PRODUCTION PARTS RETROFIT

- Refer to the [R2405A - PB Parts Breakout by Chassis - PHASE 1](#) 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 PB Parts Breakdown by Chassis spreadsheet.


- 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 PB ServiceNet.
 - Drawings that are not currently available in PB 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.
 - Contact your local CSSNA branch to request a new Engine Data Plate.
 - **Typical processing time for this label is 10 days.**
 - 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 **5544020** or newer.
 - If you need assistance with this, refer to [Eaton ServiceRanger Software Version Check Procedure](#).

- If software is not **5544020** 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 **2-4 weeks 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 Data Plate 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:
 - Vehicle Identification Number
 - Engine Serial Number
- Attach pictures of:
 - New Vehicle Emission Control Information label as it is installed.
 - New, compliant Engine Data Plate as it is installed.

Attachments

PARTS LIST AND CHASSIS LIST

[R2405A - PB Parts Breakout by Chassis - Phase 1](#)

[R2405A - PB Chassis List](#)

RETROFIT PROCEDURES

[R2405 - Engine Replacement Procedure](#)

INSTALLATION DRAWINGS

[S53-1383-000](#)

[F97-2403-000](#)

[F97-2373-000](#)

[F97-2399-000](#)

[F97-2342-000](#)

[F97-2355-000](#)

[D95-6279](#)

[F95-1314-000](#)

[F97-6514](#)

REFERENCE GUIDES

[Green House Gas Aftermarket Change Request Guide](#)

[Eaton Service Ranger Software Version Check](#)

CUSTOMER LETTERS

[R2405 - Customer Letter - English](#)

[R2405 - Customer Letter - French](#)

Date à être déterminée

Objet : R2405 – Mise à niveau de Cummins X15N
DATE D'EXPIRATION : N'a pas d'expiration

Cher client Peterbilt,

Peterbilt vous écrit afin de vous informer des mesures que vous êtes légalement tenu de prendre à l'égard de votre (vos) véhicule(s) listé(s) à la présente et qui sont équipés de composants de préproduction, lesquelles comprennent des composantes relatives aux émissions. **Les exemptions relatives aux émissions pour les châssis équipés d'un moteur Cummins X15N expireront le 30 juin 2025.**

Les châssis soumis à l'expiration de l'exemption relative aux émissions doivent être mis en conformité avec les réglementations sur les émissions en recevant des pièces relatives aux émissions de niveau production, des logiciels, une plaque signalétique du moteur conforme et, pour certains châssis, un nouveau moteur de niveau production.

Toutes les pièces nécessaires afin de rendre votre châssis conforme aux normes d'émissions sont actuellement disponibles. Cependant, certaines pièces nécessaires afin d'amener votre châssis au statut de niveau production ne sont pas disponibles actuellement. Une fois que ces pièces seront disponibles, vous recevrez une autre lettre vous informant qu'elles sont disponibles.

Qu'est-ce que Peterbilt améliore ?	Votre véhicule de préproduction est approuvé afin de recevoir des composants de niveau production, des logiciels et une plaque signalétique du moteur.
Quel effet aura cette amélioration ?	Mettre à jour les pièces de préproduction afin de les remplacer par les pièces de production actuelles, mettre à jour le logiciel et installer la plaque signalétique du moteur conforme.
Que devez-vous faire ?	Communiquer avec votre concessionnaire Peterbilt afin de prendre rendez-vous pour cette mise à niveau.

Cette mise à niveau des pièces de préproduction et la mise à jour du logiciel doivent être effectuées afin d'éviter le risque d'une éventuelle mesure d'application de la loi. Veuillez communiquer avec un concessionnaire Peterbilt afin de prendre rendez-vous pour ce travail. Vous pouvez trouver votre concessionnaire Peterbilt le plus près en consultant le localisateur de concessionnaires sur le site Web www.Peterbilt.com ou en balayant le code QR au bas de la présente. Au moment de communiquer avec le concessionnaire Peterbilt de votre choix, vous référer à la **mise à niveau R2405** ainsi qu'au(x) NIV(s) listé(s) à la présente. Le travail peut nécessiter jusqu'à **2 jours**, selon la configuration du véhicule et la disponibilité du concessionnaire.

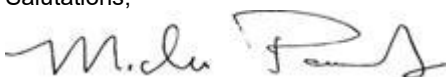
Si cette mise à niveau n'est pas complétée avant la date d'expiration de l'exemption d'émissions (30/06/25), les propriétaires de véhicules pourraient recevoir des amendes civiles pouvant aller jusqu'à 5 911 \$ par moteur en vertu du règlement 40 CFR 19.4. De plus, les propriétaires peuvent être tenus de cesser d'utiliser le véhicule jusqu'à ce que la mise à niveau soit complétée.

Si vous avez besoin de plus d'information au sujet de cette campagne ou rencontrez des difficultés à obtenir un rendez-vous pour cette réparation, veuillez communiquer avec le département de l'expérience-client de Peterbilt sur PB.Tech.Pubs.Dept@paccar.com.

La loi fédérale nécessite de tout bailleur de véhicules qui reçoit cette mise à niveau d'en faire parvenir une copie à toute personne ayant loué un véhicule et ce, dans un délai de dix jours. Si ce véhicule ne vous appartient plus, nous apprécierions que vous nous fassiez part du nom du nouveau propriétaire. Veuillez faire parvenir toute information relative au nouveau propriétaire et son adresse à PBDiv.Warranty.Docs@paccar.com.

Nous nous excusons pour tout inconfort causé par cette mise à niveau et vous remercions de votre participation afin d'aider Peterbilt à offrir les plus hauts niveaux de satisfaction de la clientèle et d'expertise de service. Nous apprécions votre entreprise ainsi que votre constante fidélité envers Peterbilt et son réseau de concessionnaires. Les produits Peterbilt se distinguent en étant leader de l'industrie en matière de qualité, performance et fiabilité; et nous vous remercions de faire d'un Peterbilt votre camion préféré.

Salutations,



Michelle Ponsonby
Directrice de l'expérience-client
Peterbilt Motors Company

Scan this QR code to open the
Peterbilt Dealer Locator.





A PACCAR COMPANY

Peterbilt Motors Company
Customer Experience Department
1700 Woodbrook St.
Denton, TX 76205
(940) 591-4000

Date TBD

Subject: R2405: Cummins X15N Retrofit
EXPIRATION DATE: Does not expire.

Dear Peterbilt Customer,

Peterbilt is writing to advise you of actions you are legally required to take with regard to your vehicle(s) listed on this letter that have pre-production components installed, which include emissions components. **The emissions exemptions for chassis equipped with a Cummins X15N Engine will expire on June 30, 2025.**

Chassis subject to emissions exemption expiration must be brought into compliance with emissions regulations by receiving production level emissions parts, software, a compliant Engine Data Plate, and, for some chassis, a new production level engine.

All parts necessary to bring your chassis into emissions compliance are currently available. However, there are some parts necessary to bring your chassis up to production level status that are not currently available. Once these parts become available you will receive another letter informing you that the parts are available.

What is Peterbilt improving?	Your pre-production vehicle is approved to receive production level components, software, and Engine Data Plate.
What will this improvement do?	Update pre-production parts to current production parts, update software, and install compliant Engine Data Plate.
What should you do?	Contact your Peterbilt Dealer to schedule an appointment for this retrofit.

This Pre-production Parts Retrofit and software update must be completed to avoid the risk of a potential enforcement action. Please contact a Peterbilt dealership to schedule an appointment for this work. You can find your nearest Peterbilt dealer using "Find A Dealer" on the website www.Peterbilt.com or scan the QR code at the bottom of this letter. When contacting your selected Peterbilt dealer, refer to **Retrofit R2405** and the VIN(s) listed on this letter. The work may take up to **2 days**, depending on vehicle configuration and dealer scheduling.

If this Retrofit is not completed prior to the emissions exemption expiration date (06/30/25), 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.

If you require further information about this campaign or experience any difficulty in making arrangements for this repair, please contact the Peterbilt Customer Experience Department at PB.Tech.Pubs.Dept@paccar.com.

Federal regulation requires that any vehicle lessor receiving this retrofit notice must forward a copy of this notice to the lessee within ten days. If you no longer own this vehicle, we would appreciate your advising us of the new owner. Please send all known ownership and address changes to PBDiv.Warranty.Docs@paccar.com.

We apologize for any inconvenience this retrofit may cause and thank you for your participation in helping Peterbilt provide the highest levels of customer satisfaction and service expertise. We value your business and appreciate your ongoing loyalty to Peterbilt and its dealer network. Industry-leading quality, performance and reliability are hallmarks of Peterbilt products, and we thank you for making Peterbilt your truck of choice.

Sincerely,

Michelle Ponsonby
Director of Customer Experience
Peterbilt Motors Company

Scan this QR code to open the Peterbilt Dealer Locator.

