

E323 - PACCAR MX EPA24 Phinia Fuel Injector Replacement

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Number

E323

Description

PACCAR MX EPA24 Phinia Fuel Injector Replacement

Subject

PACCAR MX EPA24 Phinia Fuel Injector Replacement

Supplier

Phinia

Date

11/1/2024

Revision

07/01/2025: Bulletin has been updated with new procedures that include the use of the recently released spacer tool set as defined in [98-031](#). Warranty section has been updated to remove infrequently used Recommended Repairs and to include new Recommended Repair codes for repairs that use the new Spacer Tool Set.

03/05/2025: 222 chassis added to chassis list. Total population is now 1,226 chassis.

01/17/2025: 263 chassis added to chassis list. Total population is now 1,004 chassis.

11/08/2024: PACCAR MX-11 EPA24 engines included in campaign. Warranty section has been updated with MX-11 specific recommended repair codes. MX-11 specific fuel injector R&R procedure has been added to the Links section.

Condition

Affected EPA24 compliant PACCAR MX engines identified by PACCAR.

Certain chassis equipped with PACCAR MX-11 or MX-13, EPA24 engines are equipped with fuel injectors that may have been manufactured incorrectly.

Affected injectors are at risk of tips fracturing and causing consequential engine damage.

Campaign Start Date: **11/01/2024**

Chassis Affected

1,226 (1,106 US and 120 Canada) Specific model year 2025 520, 567, 579, and 589 chassis built from 05/24/2024 to 11/08/2024 and equipped with a PACCAR MX-13 or MX-11, EPA24 engine.

Action

Campaign

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

1. Review the attached chassis list for your dealer code and schedule your customer(s) for service if their chassis is on the list.
2. Confirm with the customer that your dealership will be the repairing location before ordering parts.
3. Ensure all parts have arrived before scheduling the customer for installation.
4. In Service Management, select Campaign **E323** 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.
5. If you are not using Service Management to start repair orders, review SIR for "Complete" or "In Process" next to the **E323** campaign code prior to performing this repair.
6. Reference the appropriate repair procedure in the Links section below for directions on removing and replacing fuel injectors.

Warranty

Starting from **11/01/2024**, through **12/01/2025**, Peterbilt will pay for parts at dealer net plus applicable mark-up and labor:

- A required spacer tool set is now available to streamline the injector replacement process. The spacer tool set allows certain fuel system components to be loosened instead of removed to provide access to the injectors. See Bulletin [98-031](#) for details. Tools are not reimbursable through this Bulletin.

If a Fuel Injector part number other than those specifically listed in Recommended Repairs G, H, J, K, or L (2461236PEX or 2461235PEX) is used, file claim using editable Recommended Repair E323.

USE THE FOLLOWING RECOMMENDED REPAIRS WHEN NOT USING THE NEW SPACER TOOL SET:

- **5.8 hours** to replace 6 injectors on **PACCAR MX-13 engines in 579 chassis**. Use Recommended Repair code **E323G**. (2461236PEX)
- **5.4 hours** to replace 6 injectors on **PACCAR MX-13 engines in 567 and 589 chassis**. Use Recommended Repair code **E323H**. (2461236PEX)
- **4.0 hours** to replace 6 injectors on **PACCAR MX-11 engines**. Use Recommended Repair code **E323J**. (2461235PEX)

USE THE FOLLOWING RECOMMENDED REPAIRS WHEN USING THE NEW SPACER TOOL SET:

- **3.9 hours** to replace 6 injectors on **PACCAR MX-13 engines in 579 chassis**. Use Recommended Repair code **E323K**. (2461236PEX)
- **3.5 hours** to replace 6 injectors on **PACCAR MX-13 engines in 567 and 589 chassis**. Use Recommended Repair code **E323L**. (2461236PEX)
- For supplemental claims, file a long form claim and use **E323** in the “Campaign Code” field.
- File the claim within 7 days in accordance with Warranty Policy.
- Peterbilt dealers may perform E323 repairs on Kenworth chassis, but Recommended Repairs do not apply. For engine repairs on Kenworth chassis,

use long form claim and enter E323 in the "Campaign Code" field.

Take-Off Parts Disposition: Return removed injector cores through EZTrac.

PRWS CLAIM CODING			
Campaign Code:	E323	Campaign Type:	Field Repair
Claim Category:	Engine	Repair Type:	Proactive
Customer Concern Code:	007	Causal Code:	A1
Corrective Action Code:	12	Responsibility Code:	SUP
Failure Location:	044-014-001	Causal Part:	2426856PEX
Supplier Code:	77009	SRT Code:	B24-52A 5.8 hours Replace 6 injectors on MX-13 per bulletin procedure E323. (model 579 Without Spacer Tool Set.) B24-52B 5.4 hours Replace 6 injectors on MX-13 per

bulletin
procedure
E323.
**(models
567 and 589
Without
Spacer Tool
Set.)**

B24-52C
4.0 hours
Replace 6
injectors on
MX-11 per
bulletin
procedure
E323.

B24-52D
3.9 hours
Replace 6
injectors on
MX-13 per
bulletin
procedure
E323
**(model 579
With Spacer
Tool Set.)**

B24-52E
3.5 hours
Replace 6
injectors on
MX-13 per
bulletin
procedure
E323
(models

			567 and 589 With Spacer Tool Set.)
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Parts

Parts are available from PACCAR Parts.

Parts Required - MX-13		
Quantity	Part Number	Description
1	2461236PEX	Injector, MX-13, EPA21/24 (Package of 6)
Only use fuel injector part numbers below if 2461236PEX is not available.		
1	2434417PEX	INJECTOR, MX-13, EPA21/24 (Package of 6)
OR		
6	2426856PEX	INJECTOR, MX-13, EPA21/24 (Package of 1)
6	1313120PE	Flange Bolt, 10.9
1	2105834	Valve Cover Gasket
1	2105835	Valve train casing gasket
1	1858035	Usit Ring
As Needed	EC3501 (US) EC7501 (Canada)	Coolant
As	Source	Cable Ties

Parts Required - MX-13		
Quantity	Part Number	Description
Needed	Locally	
Partial Container Needed	Source Locally	Electrical Contact Cleaner
Partial Container Needed	Source Locally	Loctite 242 Thread Locker or equivalent
The following parts are used ONLY when performing this repair WITHOUT SPACER TOOL SET.		
Injector Replacement Parts – MX-13		
Quantity	Part Number	Description
1	2272926	Fuel Filter Element Set (With O-Rings)
1	2138144	Gasket, Oil Fill Pipe
1	2253166	O-ring (Fuel Filtration Module mounting)
1	2253167	Sealing Ring (Fuel Filtration Module mounting)
1	F37-1022-100	Dryer-Receiver with Dye
Partial Container Needed (Max 8oz)	D14858530	Refrigerant, R134a
Partial	LM1020	Oil-PAG, 250cc (A/C)

Parts Required - MX-13		
Quantity	Part Number	Description
Container Needed (Max 2oz)		oil, SP15)

Parts Required - MX-11		
Quantity	Part Number	Description
1	2461235PEX	Injector, MX-11, EPA21/24 (Package of 6)
Only use fuel injector part numbers below if 2461235PEX is not available.		
6	2426855PEX	INJECTOR, MX-11, EPA21/24 (Package of 1)
OR		
1	2434418PEX	INJECTOR, MX-11, EPA21/24 (Package of 6)
6	1313120PE	Flange bolt 10.9
1	2272926PE	Fuel Filter Element Set (With O-Rings)
1	1900010PE	Valve cover gasket
1	1917012PE	Flange gasket (inlet manifold)

Parts Required - MX-11		
Quantity	Part Number	Description
1	1876805PE	O-ring (EGR pipe to venturi)
1	2235755PE	Sealing Ring (Inlet horn to venturi)
1	2015102PE	O-ring (non-return valve)
1	2004292PE	O-Ring (injector leak pipe)
Partial Container Needed	Source Locally Available at Primo Supply	P-80 Lubricant or equivalent (EGR pipe O-ring)
As Needed	EC3501 (US) EC7501 (Canada)	Coolant
As Needed	Source Locally	Cable Ties
Partial Container Needed	Source Locally	Electrical Contact Cleaner
Partial Container Needed	Source Locally	Loctite 242 Thread Locker or equivalent

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.

Ensure that DAVIE4 is updated to the latest version before connecting to any vehicle for diagnostics or software updates.

1. Order parts **as shown in Parts section (above)** for engine type.
 - Ensure all parts have arrived before beginning installation.
2. Replace all 6 injectors with new injectors. Follow the attached procedures document for engine and chassis type.
3. A required spacer tool set is now available to streamline the injector replacement process. The spacer tool set allows certain fuel system components to be loosened instead of removed to provide access to the injectors. See Bulletin [98-031](#) for details. Tools are not reimbursable through this Bulletin.

 NOTE

On warranty claim, use injector part numbers *stamped on the injectors*. Other part numbers (from ECAT or RMI) may not be the actual installed injectors and could result in delayed or denied claims.

Links

[E323 - PB Chassis List](#)

INJECTOR R&R PROCEDURES FOR MX-13 EPA24 WITH SPACER TOOL SET

[E323 - PB MX-13 Procedure - 579 - With Spacer Tool Set](#)

[E323 - PB MX-13 Procedure - 567_589 - With Spacer Tool Set](#)

INJECTOR R&R PROCEDURES FOR MX-13 EPA24 WITHOUT SPACER TOOL SET

[E323 - PB MX-13 Injector R&R Procedure 567/589 - Without Spacer Tool Set](#)

[E323 - PB MX-13 Injector R&R Procedure 579 - Without Spacer Tool Set](#)

INJECTOR R&R PROCEDURE FOR MX-11 EPA24

[E323 - PB MX-11 Injector R&R Procedure](#)

[E323 - PB English Customer Letter](#)

[E323 - PB French Customer Letter](#)

PSB E323: PACCAR MX EPA24 Phinia Fuel Injector Replacement

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Number

E323

Description

PACCAR MX EPA24 Phinia Fuel Injector Replacement

Subject

PACCAR MX EPA24 Phinia Fuel Injector Replacement

Supplier

Phinia

Date

11/4/2024

Revision

7/1/2025: Bulletin has been updated with new procedures that include the use of the recently released spacer tool set as defined in [98-031](#). Warranty

section has been updated to include new Quick Claim codes for repairs that use the new Spacer Tool Set.

3/4/2025: Added 163 chassis to chassis list.

1/17/2025: Added chassis to chassis list.

11/7/2024: Included MX-11 engines. Updated chassis list, procedures, and warranty claims.

Condition

Affected EPA24 compliant PACCAR MX engines identified by PACCAR.

Certain chassis equipped with PACCAR MX-11 or MX-13, EPA24 engines are equipped with fuel injectors that may have been manufactured incorrectly. Affected injectors are at risk of tips fracturing and causing consequential engine damage.

Chassis Affected

1093 (1002 US and 91 Canada) Model Year 2025 T680/T880/W990/L770 chassis built from 05/09/2024 to 09/26/2024 and equipped with EPA2024 compliant PACCAR MX-11 or MX-13 engines.

Action

Campaign

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

1. Review the attached chassis list for your dealer code and schedule your customer(s) for service if their chassis is on the list.
2. Confirm with the customer that your dealership will be the servicing location before ordering parts.
3. Ensure all parts have arrived before scheduling the customer for installation.
4. In Service Management, select Campaign **E323** 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

5. If you are not using Service Management to start repair orders, review SIR for "Complete" or "In Process" next to the **E323** campaign code prior to performing this repair.
6. Reference the appropriate repair procedure in the Links section below for directions on removing and replacing fuel injectors.

Warranty

For repairs completed by 12/01/2025, Kenworth will pay for parts at dealer net plus applicable mark-up and labor:

A required spacer tool set is now available to streamline the injector replacement process. The spacer tool set allows certain fuel system components to be loosened instead of removed to provide access to the injectors. See Bulletin TIB [98-031](#) for details. Tools are not reimbursable through this Bulletin.

- **5.8 hours** to replace 6 injectors on **PACCAR MX-13 engines in T680 chassis without spacer tool set**. Use *editable* Quick Claim code **E323A**.
- **5.4 hours** to replace 6 injectors on **PACCAR MX-13 engines in T880/W990 chassis without spacer tool set**. Use *editable* Quick Claim code **E323B**.
- **4.0 hours** to replace 6 injectors on **PACCAR MX-11 engines**. Use *editable* Quick Claim code **E323C**.
- **3.9 hours** to replace 6 injectors on **PACCAR MX-13 engines in T680 chassis with spacer tool set**. Use *editable* Quick Claim code **E323D**.
- **3.5 hours** to replace 6 injectors on **PACCAR MX-13 engines in T880/W990 chassis with spacer tool set**. Use *editable* Quick Claim code **E323E**.
- Dealers must edit Quick Claims to include injector PNs used. See Parts section for more information.
- File an additional claim for extraordinary circumstances. A quick claim for standard labor must be filed first.
- File the claim within 14 days in accordance with Warranty Policy [CA009](#).
- Kenworth dealers may perform E323 repairs on Peterbilt chassis, but Quick Claims do not apply. For Peterbilt chassis repairs, use the long claim

input form.

Take off parts disposition: Return removed injector cores through EZTrac.

PRWS CLAIM CODING			
Campaign Code:	E323	Campaign Type	Field Repair
Claim Category:	Engine	Repair Type	Proactive
Customer Concern Code	007	Causal Code	A1
Corrective Action Code	12	Responsibility Code:	CampSupp
Failure Location	044-014-001	Causal Part	2426856PEX (MX-13 Injector)
Supplier Code	77009	SRT Code	<p>B24-52A 5.8 hrs Replace 6 injectors on MX-13 per bulletin procedure E323 without spacer tool set (T680)</p> <p>B24-52B 5.4 hrs Replace 6 injectors on MX-13 per bulletin procedure</p>

			<p>E323 without spacer tool set (T880/W990)</p> <p>B24-52C 4.0 hrs Replace 6 injectors on MX-11 per bulletin procedure E323.</p> <p>B24-52D 3.9 hrs Replace 6 injectors on MX-13 per bulletin procedure E323 with spacer tool set (T680)</p> <p>B24-52E 3.5 hrs Replace 6 injectors on MX-13 per bulletin procedure E323 with spacer tool set (T880/W990)</p>
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Parts

Parts are available from PACCAR Parts.

Injector Replacement Parts – MX-13		
Quantity	Part Number	Description
6	2426856PEX	Injector, MX-13, EPA21/24 (Package of 1)

Injector Replacement Parts – MX-13		
OR		
1	2434417PEX OR 2461236PEX	INJECTOR, MX-13, EPA21/24 (Package of 6)
6	1313120PE	Flange Bolt, 10.9
1	2105834	Valve Cover Gasket
1	2105835	Valve train casing gasket
2	1858035	Usit Ring
As Needed	EC3501 (US) EC7501 (Canada)	Coolant
As Needed	Source Locally	Cable Ties
Partial Container Needed	Source Locally	Electrical Contact Cleaner
Partial Container Needed	Source Locally	Loctite 242 Thread Locker or equivalent
The following parts are used ONLY when performing this repair WITHOUT SPACER TOOL SET		
1	2272926	Fuel Filter Element Set (With O-Rings)
1	2138144	Gasket, Oil Fill Pipe
1	2253166	O-ring (Fuel Filtration Module mounting)
1	2253167	Sealing Ring (Fuel Filtration Module mounting)
1	F37-1022-100	Dryer-Receiver with Dye
Partial Container Needed (Max 8oz)	D14858530	Refrigerant, R134a

Injector Replacement Parts – MX-13		
Partial Container Needed (Max 2oz)	LM1020	Oil-PAG, 250cc (A/C oil, SP15)

Injector Replacement Parts – MX-11		
Quantity	Part Number	Description
6	2426855PEX	Injector, MX-11, EPA21/24 (Package of 1)
OR		
1	2434418PEX OR 2461235PEX	INJECTOR, MX-11, EPA21/24 (Package of 6)
6	1313120PE	Flange Bolt, 10.9
1	2272926	Fuel Filter Element Set (With O-Rings)
1	1900010	Valve Cover Gasket
1	1917012	Flange gasket (inlet manifold)
1	1876805	O-ring (EGR pipe to venturi)
1	2235755	Sealing Ring (Inlet horn to venturi)
1	2015102	O-ring (non-return valve)
1	2004292	O-Ring (injector leak pipe)
Partial Container Needed	Source Locally Available at Primo Supply.	P-80 Lubricant or equivalent (EGR pipe O-ring)
As Needed	EC3501 (US) EC7501 (Canada)	Coolant
As Needed	Source Locally	Cable Ties

Injector Replacement Parts – MX-11		
Partial Container Needed	Source Locally	Electrical Contact Cleaner
Partial Container Needed	Source Locally	Loctite 242 Thread Locker or equivalent

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.

Ensure that DAVIE4 is updated to the latest version before connecting to any vehicle for diagnostics or software updates.

1. Order parts **as shown in Parts section (above)** for engine type.
 - Ensure all parts have arrived before beginning installation.
2. Replace all 6 injectors with new injectors. Follow the attached procedures document for engine and chassis type.
3. A required spacer tool set is now available to streamline the injector replacement process. The spacer tool set allows certain fuel system components to be loosened instead of removed to provide access to the injectors. See Bulletin [98-031](#) for details. Tools are not reimbursable through this Bulletin.



NOTE

On warranty claim, use injector part numbers *stamped on the injectors*. Other part numbers (from ECAT or RMI) may not be the actual installed injectors and could result in delayed or denied claims.

Links

[KW Chassis List](#)

[E323 KW MX-13 Procedure T680 Without Spacer Tool Set](#)

[E323 KW MX-13 Procedure T880/W990 Without Spacer Tool Set](#)

[E323 KW MX-13 Procedure T680 With Spacer Tool Set](#)

[E323 KW MX-13 Procedure T880/W990 With Spacer Tool Set](#)

[E323 KW Procedures – MX-11](#)

[KW Customer Letter](#)

Authored by: JB3