

Linear EATS Mixer Replacement

Revision: 1

Technician Skill Level: A

Revision Note: 09/2025 Initial Release

Market: North America

Service Category: Service Department

Applicability: Please refer to VDA+

Section: Function Group 250

Description:

EATS mixer section may have a 2-inch section that was not welded correctly.

Concern:

This defect could cause an internal leak, reducing efficiency of the aftertreatment system.

Action:

Use the instructions referenced in this document to remove and replace the mixer section.

Warranty Information

This repair is covered by an authorized Service Program. Reimbursement is obtained through the normal claim handling process.			
Claim Type (used only when uploading from the Dealer Bus. Sys.)			B
Labor Code		Description	Hours
Main Code	2500-03-02-03	EXHUAUST MIXER, EXHAUST AFTERTREATMENT, REPLACE	2.2
Causal Part		24654875	
SCC Authorization Code		S4566	
Expiration Date		September 30, 2026	

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Parts Information

Order using the normal DFS process.

Part Numbers	Part Names	Quantity
24877332	Muffler Mixer Kit	1
21021850	V-Clamp	1
948211	Cable Tie (Black)	5
990073	Cable Tie (Gray)	23
980464	Cable Tie (Black)	5
21095726	Gasket 5 inch	1
60111689	Hex Socket Screw, M6*20	3
21376801	Sealing Plate, Urea Dosing System	1

Repair Procedure

1. Follow impact operation 2500-03-02-03 Exhaust Mixer, Exhaust Aftertreatment, Replace.
2. Return truck to service.