

R2405: Cummins X15N Retrofit

10/6/2025

 [Edit](#)  [Clone](#)

R2405

Cummins X15N Retrofit

Subject

Cummins X15N Retrofit

Whats New Abstract

All parts necessary to complete Phase 2 of this bulletin are now available.

This retrofit provides certain chassis equipped with Cummins X15N (Natural Gas) engines with production level parts to replace pre-production parts installed at the time of manufacture.

Revision

10/06/2025: Bulletin has been updated to show the release of Phase 2.

09/22/2025: Warranty section has been updated with new verbiage about labor hour reporting using the Non-Standard Time Labor Worksheet.

Condition

All parts necessary to complete Phase 2 of this bulletin are now available.

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 the chassis up to production level.

The emissions exemption for all chassis involved in this retrofit expired on 06/30/2025. After that date, all chassis that have not received

Phase 1 of this retrofit will be out of compliance with emissions regulations and **illegal to operate**.

i 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.

Chassis Affected

10 (9 U.S. and 1 Canada) vehicle model year 2024-2025 model 520, 567, and 579 chassis manufactured from 04/10/2023 through 05/17/2024 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 and it shows R2405A and/or R2405B open in SIR or Service Management.
- **Make sure you have all necessary parts on hand prior to scheduling your customer for service.**
- In Service Management, select campaign **R2405A** and/or **R2405B** to add it to the case. Both campaigns must be closed out to complete this retrofit campaign. If the unit is released back into service without performing the repair, make sure to also release the campaign(s)

in Service Management.

- If you are not using Service Management to start repair orders, review SIR for “Complete” next to the **R2405A** and/or **R2405B** campaign codes 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 parts listed for your specific chassis in the “Parts Breakdown by Chassis” lists found in the Links section below.

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

i 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.

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 the “Engine Replacement Claim Filing” table below.

The emissions exemption for affected vehicles expired 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 the chassis requires an engine replacement, please refer to the “Engine Replacement Claim Filing” table below.
 - For **Phase 1** retrofit related parts replacements, use editable, non-time SRT code **B25-12A** to report all hours involved in performing the repairs.
 - Any labor in excess of 19 hours must have a detailed justification on the [Non-Standard Time Labor Worksheet](#) found in the warranty procedure manual.

- You will need to download the “Non-Standard Time Labor Worksheet” by clicking on “File”, “Create a Copy”, and “Download a Copy.”
- For all repairs relating to the **R2405 Phase 2** retrofit, file an editable claim using code **R2405B** and input all parts and labor used. If the chassis requires an engine replacement, please refer to the “Engine Replacement Claim Filing” table below.
 - For **Phase 2** retrofit related parts replacements, use editable, non-time SRT code **B25-12B** to report all hours needed to perform the repairs.
 - Any labor in excess of 5 hours must have a detailed justification on the [Non-Standard Time Labor Worksheet](#) found in the warranty procedure manual.
 - Attach a time sheet detailing labor time used for this retrofit.
 - File the claim within 14 days in accordance with the warranty policy.
 - Cross-division repairs are not allowed for this campaign.

FOR ALL CHASSIS THAT REQUIRE AN ENGINE REPLACEMENT, SEE THE BELOW TABLE TO DETERMINE HOW TO FILE A 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
1NPBDB0X8RD686678	CUSTOMER	PETERBILT
1NPCDH9X6RD894939	CUSTOMER	PETERBILT

Take-Off Parts Disposition: Except for engines, destroy take-off parts 30 days after the claim is paid. Engines will be returned per

the instructions in the [R2405 – Engine Replacement Procedure](#).

PRWS CLAIM CODING			
Campaign Code:	R2405A - Phase 1 R2405B - Phase 2	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:	CAMP
Failure Location:	053-005-021	Causal Part:	S53-6198
Supplier Code:	N/A	SRT Code:	B25-12A Editable, non-time SRT code for Phase 1 repairs B25-12B Editable, non-time SRT code for Phase 2 repairs.

Parts

 NOTE

If Safety Recall 25PACF has been completed for the chassis you are working on, be sure that you DO NOT order or replace any of the parts on the [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) list that have been marked as included in 25PACF. Parts that are included in 25PACF will be highlighted blue and will have “(25PACF)” in the Part Description field.

i NOTE


If R2405A (Phase 1) has already been completed for the chassis you are working on, be sure you only order and replace the parts listed in the [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) list.

i NOTE

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 the [R2405 - PB Parts Breakdown by Chassis – PHASE 1](#) and [R2405 - PB Parts Breakdown](#)

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

- **Vehicle Emissions Control Information 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 “Label”, and then select "Convert Exempt Vehicle to Compliant Vehicle."
- 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.

CUMMINS X15N ENGINE REPLACEMENT

- Refer to the [R2405A - PB Parts Breakout by Chassis - PHASE 1](#) and [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) lists to determine if your chassis requires an engine replacement.
- If an engine replacement is required, reference the [R2405 – Engine Replacement Procedure](#).

PRE-PRODUCTION PARTS RETROFIT

- Refer to the [R2405 - PB Parts Breakdown by Chassis – PHASE 1](#) and/or [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) lists to determine parts required for your chassis.
- Check SIR or Service Management to determine if R2405A (Phase 1) has already been completed.
- If R2405A has been completed but R2405B is still open, only order parts and perform repairs for R2405B (Phase 2).
- Only order parts and perform repairs for both R2405A (Phase 1) and R2405B (Phase 2) if they both show open in SIR or Service Management.
- 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" lists.
 - 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" lists.
 - Installation drawing numbers located in this column will help you route harnesses, place brackets and complete all steps.
 - 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.
 - A column in the spreadsheet 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, review the installation drawing carefully to see how it differs from the current part installation.
 - If the new part installation is similar, 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.

EMUX JUMPER HARNESS

NOTE

If Safety Recall **25PACF** has been completed for the chassis you are working on, be sure that you DO NOT order or replace any of the parts on the [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) list that have been marked as included in **25PACF**. Parts that are included in **25PACF** will be highlighted blue and will have “(25PACF)” in the Part Description field.

- Reference [R2405 - PB Parts Breakdown by Chassis – PHASE 2](#) to determine if the EMUX jumper harness is required for the chassis

you are working on.

 CAUTION

You **MUST** perform repair steps in the exact order they are listed in the procedure document! Failure to do so may result in the inability to program the CSG2 and/or Digital Display.

 CAUTION

DAVIE4 **MUST** be updated to the latest version before attempting to perform software updates relating to this EMUX procedure!

- Reference the procedure appropriate to the chassis model you are working on below.
 - [R2405 – Cummins X15N Retrofit 2.1m HD Procedure](#)
 - [R2405 – Cummins X15N Retrofit Model 520 Procedure](#)


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 Engine Data Plate is 10 days.**
 - Send a photo of the exempt Engine Data Plate removed from the engine, and the engine with the new Engine Data Plate

installed to: david.j.king@cummins.com.

- Update the engine calibration to the latest production calibration using Cummins Insite.
- If the 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 the [Eaton ServiceRanger Software Version Check Procedure](#).
 - If the software is not **5544020** or newer, use Eaton ServiceRanger to update the software to the latest version.
- If the chassis is not equipped with an Eaton Endurant transmission:
 - Leave the 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,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

- Be sure to order a new VECI label following the instructions in the Parts section.
 - Be aware of the **2 to 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

- Take pictures of both the new Engine Data Plate and the 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:
 - The new Vehicle Emission Control Information label as it is installed.
 - The new, compliant Engine Data Plate as it is installed.

Attachments

PARTS LISTS AND CHASSIS LISTS

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

[R2405B - PB Parts Breakdown by Chassis - Phase 2](#)

[R2405A - PB Chassis List - Phase 1](#)

[R2405B - PB Chassis List - Phase 2](#)

RETROFIT PROCEDURES

[R2405 - Engine Replacement Procedure](#)

[R2405 PB Cummins X15N Retrofit 2.1m HD Procedure](#)

[R2405 PB Cummins X15N Retrofit Model 520 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 - Phase 1 Customer Letter - English](#)

[R2405 - Phase 1 Customer Letter - French](#)

[R2405 - Phase 2 Customer Letter - English](#)



Peterbilt Motors Company
Customer Service Department
C/O PACCAR Parts
750 Houser Way North
Renton, WA 98057
(425) 828-5888

10/06/25
Subject: R2405: Cummins X15N Retrofit
Expiration Date: None



FIELD SERVICE CAMPAIGN

This notice applies to your vehicle; Your VIN(s) can be found on the front or back of this page.

Dear Peterbilt Customer,

Peterbilt Motors Company has determined that all parts necessary to bring your pre-production chassis, listed in this letter, up to production level, are now available.

Model Year: **2024 - 2025**

Manufactured: **04/10/2023 - 05/17/2024**

Model: **Peterbilt 520, 567, and 579**

What is the problem?	Your pre-production vehicle requires production level parts.
What will your dealer do?	Update pre-production parts to current production parts.
What you should do ...	Contact your Peterbilt dealer to schedule a repair appointment.

If you have already had this work performed, please disregard this letter. You can find your nearest Peterbilt dealer using Find a Dealer on www.Peterbilt.com or by scanning the QR code at the top of this letter.

When contacting your selected Peterbilt dealer, refer to campaign **R2405: Cummins X15N Retrofit**, and the VIN(s) listed on this letter. The work will take approximately **2 days**, depending on repair scope, vehicle configuration, and dealer scheduling. There will be no charge to you for this retrofit.

If you require further information about this campaign, please contact Peterbilt Customer Service at ServiceBulletins@PACCAR.com with the bulletin number in the subject line.

If you no longer own this vehicle, please email the 17 digit VIN and the new owner's name and address to ServiceBulletins@PACCAR.com so we can update our records.

Thank you,
Peterbilt Customer Service