

Subject: DETROIT™ Reman Built HDEP Engines - Incorrect Gear Train Bolt Torque
Models Affected: Certain DETROIT™ Reman Built HDEP Engines

General Information

Daimler Trucks North America LLC, on behalf of its DETROIT™ Powertrain Division, is initiating Field Service Campaign D20M6 to modify the vehicles mentioned above.

Certain DETROIT™ Reman built HDEP will need the following repairs completed:

- The gear train mounting bolts need to be checked for proper torque and adjusted as needed.

There are approximately 11 engines affected by this Field Service Campaign.

Work Instructions

Please refer to the attached work instructions. **Prior to performing the campaign, check the vehicle for a completion sticker (Form WAR261).**

Labor Allowance

Table 1 – Labor Allowance for D20M6

Procedure	Time Allowed (hours)	SRT Number	Corrective Action
D20M6			
Gear Train – Torque Check and Adjust	13.1 - 16.6 Hours	996-F076A	12 – Repair Recall/Campaign

Claim Reimbursement

You will be reimbursed for your parts, labor, and handling (landed cost for Export Distributors) by submitting your claim through the Warranty system within 30 days of completing this campaign. Please reference the following information in OWL:

Table 2 – Claim Reimbursement

Claim Type	Field Service Campaign
Campaign	D20M6
Component Code	045-008-010
Cause Code	A1 – Campaign
Primary Failed Part	DDE A4729900200
Procedure A¹	
Labor Number	996-F076A Gear Train – Torque Check and Adjust Group A
Labor Hours	13.1 - 16.6 Hours
Part Number	DDE A4729900200
Parts Return	NONE
¹ Administrative time (SRT 939-6010A) for 0.3 hours is automatically added to the claim. Hours may vary based on the chassis model.	

This Field Service Campaign will terminate on **August 12, 2021**. Dealers will be notified of any changes.

IMPORTANT: OWL must be viewed prior to beginning work to ensure the vehicle is involved and the campaign has not previously been completed.

All claims must be submitted within 30 days of the repair and within 30 days of the termination date of the campaign.

For questions, U.S. and Canadian dealers, contact the Warranty Campaigns Department via Web inquiry at DTNAConnect.com / WSC, or the Customer Assistance Center at (800) 385-4357. Export distributors submit a Web inquiry or contact your International Service Manager.

****Copy of Notice to Owner****

Subject: **Field Service Campaign D20M6**

DETROIT™ Reman Built HDEP Engines - Incorrect Gear Train Bolt Torque

Daimler Trucks North America LLC, on behalf of its DETROIT™ Powertrain Division, is initiating Field Service Campaign D20M6 to modify the vehicles mentioned above.

Certain Detroit Reman built HDEP engines had the gear train bolts torqued to the wrong specification. Records available to us indicate that your vehicle has one of the eligible engines.

Instructions for this Field Service Campaign have been sent to your local Detroit Diesel Authorized Repair Facility and the labor time required to perform this update may take up to approximately **16.6** hours.

Please contact a Detroit Diesel Authorized Repair Facility to arrange to have the Field Service Campaign performed. To locate an authorized facility, search online at <https://demanddetroit.com/find-a-dealer/>

This service will be completed for you at no charge, prior to **August 12 2021**, under the provisions of this notice.

We are sorry to cause you this inconvenience; however, we have taken this action in the interest of your continued satisfaction with our products.

DETROIT WARRANTY CAMPAIGNS DEPARTMENT

Enclosure

Work Instructions

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Models Affected: Certain DETROIT™ Reman Built HDEP Engines

Corrective Procedure

Service Tools Used in the Procedure

Tool Number	Tool Name	Engine
J-47487	Cantilever For Idler #3 Tool	DD Platform
J-48630	Crankshaft TDC Locating Tool	DD Platform



WARNING:

PERSONAL INJURY

To avoid injury, never remove any engine component while the engine is running.

Remove as follows:

1. Shut off the engine, apply the parking brake, chock the wheels, and perform any other applicable safety steps.

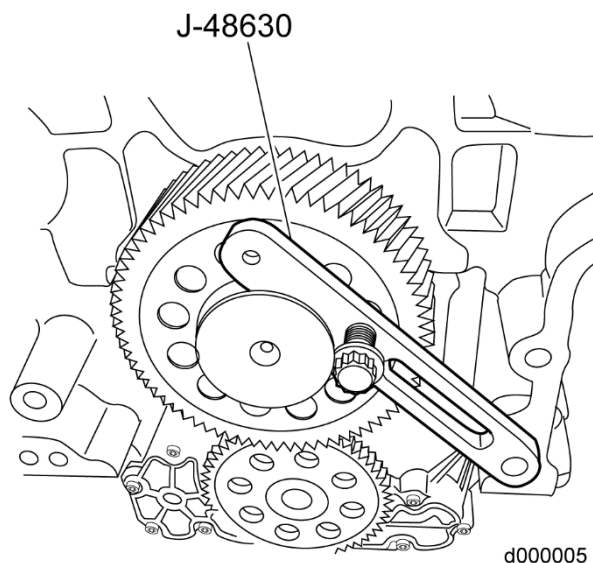


CAUTION:

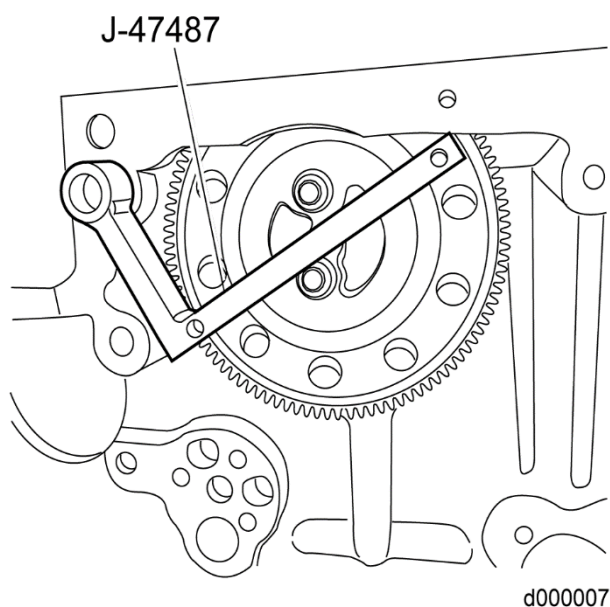
ELECTRICAL SHOCK

To avoid injury from electrical shock, use care when connecting battery cables. The magnetic switch studs are at battery voltage.

2. Disconnect the batteries. Refer to the Original Equipment Manufacturer (OEM) procedure.
3. Open the hood.
4. Remove the flywheel housing. Refer to section "Removal of the Flywheel Housing"
5. Rotate the crankshaft so the pistons in cylinders 1 and 6 are at Top Dead Center (TDC), if not already positioned. The locating pin for the crankshaft gear should be at the 12 o'clock position.
6. Install and lock crankshaft TDC locating tool (J-48630) into place with a flywheel mounting bolt. See figure below.



7. Remove the access cover for the idler gear No. 5 mounting bolts.
8. Check torque on the two idler gear No. 5 mounting bolts and if necessary re-torque between 60 and 65 N·m (44 and 48 lb·ft).
9. Install the cantilever tool (J-47487) onto idler gear No. 3, as shown below. The tool should slide on and off with ease and if it does not it indicates idler get No. 3 is incorrectly timed or the tool is damaged. Correct as necessary.



10. Remove the cantilever tool from idler gear No. 3.
11. Check torque on the two idler gear No. 3 mounting bolts and if necessary re-torque between 60 and 65 N·m (44 and 48 lb·ft).
12. Break loose idler gear No. 2 mounting bolts and re-torque to 40 N·m (30 lb·ft) + 90° torque turn.

13. Break loose idler gear No. 1 mounting bolts and re-torque to 40 N·m (30 lb·ft) + 90° torque turn.
14. For DD16 engines, break loose idler gear No. 4 mounting bolts and re-torque to 40 N·m (30 lb·ft) + 90° torque turn.
15. For engines without a No. 4 idler gear, break loose the cover plate mounting bolts and re-torque to 40 N·m (30 lb·ft) + 90° torque turn.
16. Install idler gear No. 5 access cover. Torque the bolts to 30 N·m (22 lb·ft).
17. Remove the crankshaft TDC locating tool.
18. Install the flywheel housing. Refer to section "Installation of the Flywheel Housing" .
19. Connect the batteries.



CAUTION:

PERSONAL INJURY

Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.

- Always start and operate an engine in a well ventilated area.
- If operating an engine in an enclosed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system or emission control system



CAUTION:

PERSONAL INJURY

To avoid injury before starting and running the engine, ensure the vehicle is parked on a level surface, parking brake is set, and the wheels are blocked.



CAUTION:

ENGINE EXHAUST

To avoid injury from inhaling engine exhaust, always operate the engine in a well-ventilated area. Engine exhaust is toxic.

20. Start the engine and inspect for leaks.
21. If removed, install the bumper. Refer to the Original Equipment Manufacturer (OEM) procedure.
22. Close the hood.