

> FLA COE  
> FLB COE  
> FLD Conventional  
> Business Class

FLC 112 Conventional  
> Century Class Conventional  
Argosy COE  
Cargo

> Columbia  
> Coronado  
> Business Class M2  
> Cascadia

**Freightliner  
Service Bulletin**

**Description of Revisions:** *This service bulletin replaces the previous version dated April 2010. The warranty information has been revised.*

## General Information

Five-piece bolted crossmembers are available for field replacement of the five-piece welded crossmembers used with steel frame rails. The bolted crossmember makes replacement easier, since it can be installed without spreading the frame rails (as is required with a welded crossmember). In the event that a five-piece welded crossmember fails, use the instructions below for replacement with a five-piece bolted crossmember.

## Crossmember Replacement Procedure

**NOTE:** On the FLD Conventional, the five-piece welded back-of-cab crossmember on sleeper cabs cannot be replaced with a bolted five-piece crossmember. Replace it with a bolted alligator crossmember instead. Adjust the cab air suspension leveling valve, following the instructions in **Group 60** of the applicable workshop manual or service manual.

1. Apply the parking brakes, then chock the tires on both the front and rear axles.
2. If any air brake valve is attached to the crossmember, drain the air reservoirs, then remove the valve(s) from the crossmember. Remove any clamps that attach air lines or wiring to the crossmember. Secure the lines or wires away from the crossmember.
3. If rear suspension brackets are attached to the frame rails with the same fasteners that attach the crossmember, support the rear of the frame at its normal ride height, using safety stands.
4. Note whether the crossmember open channel faces the front or rear of the vehicle.
5. Using a cutting torch, cut the crossmember channel in two. A 3-inch (76 mm) sectional cut will make removal easier.
6. Remove the fasteners that attach the crossmember halves to the frame rails, and remove the crossmember. If threaded fasteners are used, save them to use with the new crossmember. If huckbolts are used, refer to **Group 31** of the applicable workshop manual or service manual for instructions on removing and replacing them with threaded fasteners.

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## NOTICE

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**Never attempt to reuse a huck fastener that has been removed. Even though HUCK-FIT fasteners can be removed with a socket wrench, they cannot be correctly installed again. Reusing any huck frame fastener can result in damage to the vehicle frame or components attached to the frame.**

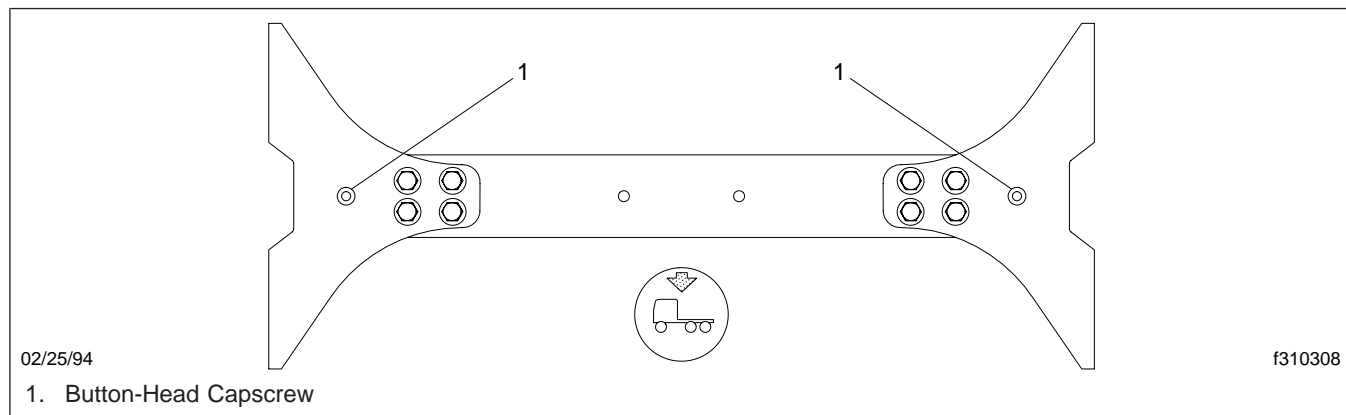
7. Attach one new upper gusset to the crossmember channel. Tighten the fasteners snugly, but not to their final torque value.
8. Place the crossmember channel and gusset in the frame rails with its open channel facing the same direction that was noted during removal. Position the crossmember so the channel is supported on the lower flanges of both frame rails.
9. Slide the other upper gusset into position and attach it to the crossmember channel. Tighten the fasteners snugly, but not to their final torque value.
10. Tighten the locknuts on the button-head capscrews at the outboard end of both upper gussets 68 lbf·ft (92 N·m). See [Fig. 1](#).

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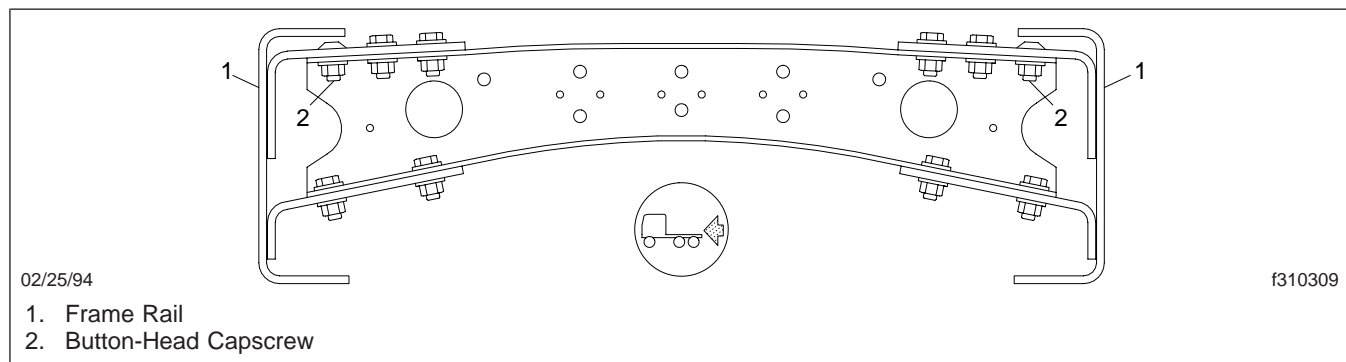
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**Fig. 1, Tighten the Locknuts on the Button-Head Capscrews**

NOTE: When the crossmember is in place, the frame rail upper flange prevents access to these button-head capscrews. See [Fig. 2](#).

11. Using a deadblow hammer, tap the crossmember up into place. Align the mounting holes of the upper gussets with the holes in the frame rails. Install the fasteners, but don't tighten them.



**Fig. 2, Crossmember Installation**

12. Position the lower gussets on the crossmember channel. Install, but don't tighten, the fasteners that hold the lower gussets to the crossmember channel. Install the fasteners that attach the lower gussets to the frame rails. If the welded crossmember was fastened to the frame rails with huckbolts, see **Group 31** of the applicable workshop manual or service manual for instructions on removing and replacing them with threaded fasteners.
13. Tighten the fasteners that attach the gussets to the frame rails 136 lbf-ft (184 N-m). Then, tighten the fasteners that attach the gussets to the crossmember channel 68 lbf-ft (92 N-m). If any air brake valve was removed from the old crossmember, install the valve(s) on the new crossmember.
14. Install any clamps that attach air lines or wiring to the crossmember.
15. Remove the chocks from the tires.

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## Parts

Complete crossmember replacement kits are available from the PDCs. For replacement kit numbers, see [Table 1](#).

Original Crossmember Part Number	Crossmember Replacement Kit		Original Crossmember Part Number	Crossmember Replacement Kit
680 310 00 37	680 310 00 K0		A15-14814-000	A15-22498-000
680 310 06 37	680 310 05 K0		A15-14814-001	A15-22498-001
680 310 07 37	680 310 01 K0		A15-14814-002	A15-22498-002
680 310 08 37	680 310 06 K0		A15-14814-003	A15-22498-003
680 310 10 37	680 310 14 K0		A15-14814-004	A15-22498-004
680 310 11 37	680 310 15 K0		A15-14814-005	A15-22498-005
680 310 14 37	680 310 16 K0		A15-14814-006	A15-22498-006
680 310 15 37	680 310 17 K0		A15-14814-007	A15-22498-007
680 310 16 37	680 310 18 K0		A15-14814-008	A15-22498-008
680 310 17 37	680 310 19 K0		A15-14814-009	A15-22498-009
680 310 22 37	A15-22497-000		A15-14814-010	A15-22498-010
680 310 23 37	A15-22497-001		A15-14814-011	A15-22498-011
680 310 24 37	A15-22497-002		A15-14814-012	A15-22498-012
680 310 25 37	A15-22497-003		A15-14814-013	A15-22498-013
680 310 30 37	A15-22497-004		A15-14814-014	A15-22498-014
680 310 31 37	A15-22497-005		A15-14814-015	A15-22498-015
680 310 32 37	A15-22497-006		A15-14814-016	A15-22498-016
680 310 33 37	A15-22497-007		A15-14814-017	A15-22498-017
680 310 34 37	A15-22497-008		680 310 35 37	A15-22497-009

**Table 1, Replacement Kit Part Numbers**

## Warranty

This is an informational bulletin only.