

FLA COE
FLB COE
FLD Conventional
Business Class
FLC 112 Conventional

Century Class Conventional
Argosy COE
Cargo
Columbia

Coronado
Business Class M2
> Cascadia
108SD/114SD

Freightliner
Service Bulletin

General Information

A set of reinforcement plates have been developed to repair a Cascadia cab back wall damaged by a shock mount bracket that has torn loose ([Fig. 1](#)) or started to separate. Follow the procedure in this bulletin to repair the cab back wall.



Fig. 1, Torn-Out Shock Mount Bracket, Back Wall of Cab

Parts

Parts are available through the PDCs. Sikaflex®-252 adhesive may be acquired locally. See [Table 1](#).

Parts for Installing Cab Shock Bracket Reinforcement Plates, Both Sides		
Part Number	Description	Qty.
18-65754-000	Reinforcement Plate, Cab Shock	2
18-65755-000	Inner Reinforcement Plate, Cab Mount	2
A18-65392-000	Nutplate, Rear Sill	2
—	Sikaflex-252	as needed

Table 1, Parts for Installing Cab Shock Bracket Reinforcement Plates, Both Sides

Procedure

1. Park the vehicle on a level surface, shut down the engine, and set the parking brake. Chock the tires.
2. Remove the under-bunk panels as follows:
 - 2.1 Tilt the lower bunk up.
 - 2.2 Remove the two dividers in the baggage compartment; see [Fig. 2](#). The forward ends of the dividers are attached to the bunk forward support with two screws.
 - 2.3 Remove the screws that attach the baggage door sill(s) to the cab floor. Remove the sill(s).

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- 2.4 Remove the two screws and the two Christmas-tree fasteners that secure the baggage compartment right-hand side panel (if equipped). Remove the side panel. See [Fig. 3](#).
- 2.5 Remove the screws that secure each lower bunk side support to the cabinet base or HVAC cover and to the cab side wall. The side-wall screws are hidden behind the lower edge of the side-wall upholstery panel. Remove the bunk support.
- 2.6 Remove the Christmas-tree fasteners that secure the baggage compartment back-wall panel. Four of the fasteners are hidden behind the lower edge of the back-wall upholstery panel. If necessary, loosen the lower bunk hinge screws.

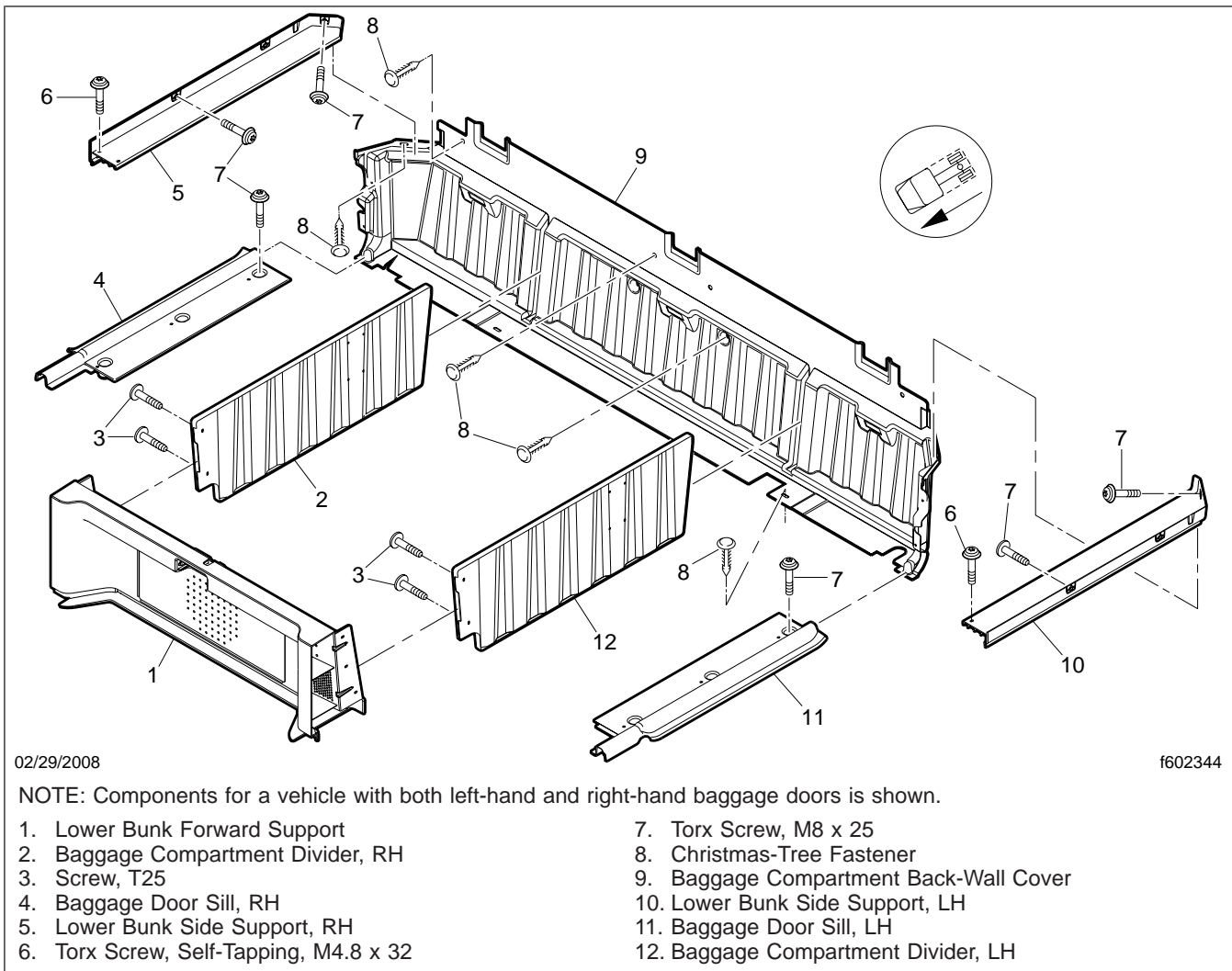


Fig. 2, Baggage Compartment Panels and Lower Bunk Support

3. Remove the floor mat.
4. At the angle of the cab deck and back wall, remove the two rivets surrounding the hole formed by the torn-out shock bracket fastener.

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5. Remove the two rivets on each side of the shock bracket, at the bottom edge of the cab back wall. See [Fig.4](#).
6. Straighten damaged areas of the cab, and weld any torn pieces back in place. Grind the welds smooth so that the new plates will lay flat.
7. Clean and scuff one side of the shock reinforcement plate ([Fig. 4](#), item 5) and the area of contact on the cab back wall.
8. Apply a thin layer of Sikaflex-252 adhesive to the scuffed side of the shock reinforcement plate.
9. Position the shock reinforcement plate in place, then using two rivets, install it and the inner nut plate (item 4) to the cab back wall. See [Fig. 5](#) for the inner nut plate installation.

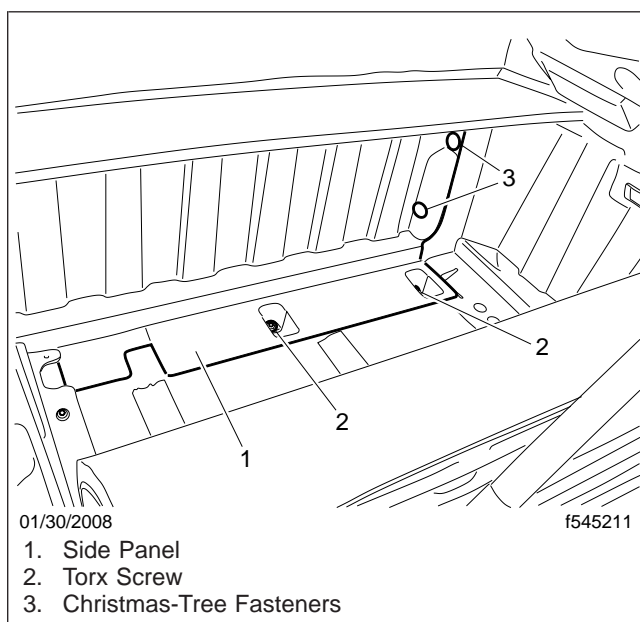


Fig. 3, Baggage Compartment Side Panel

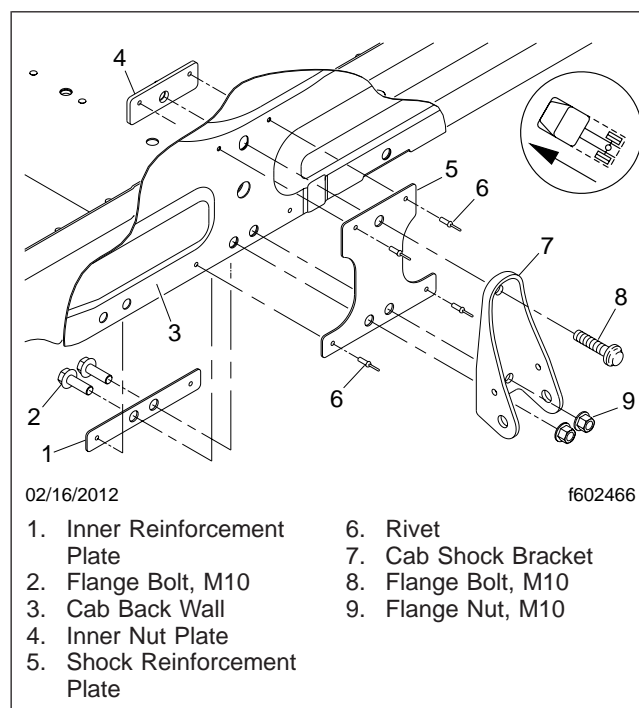


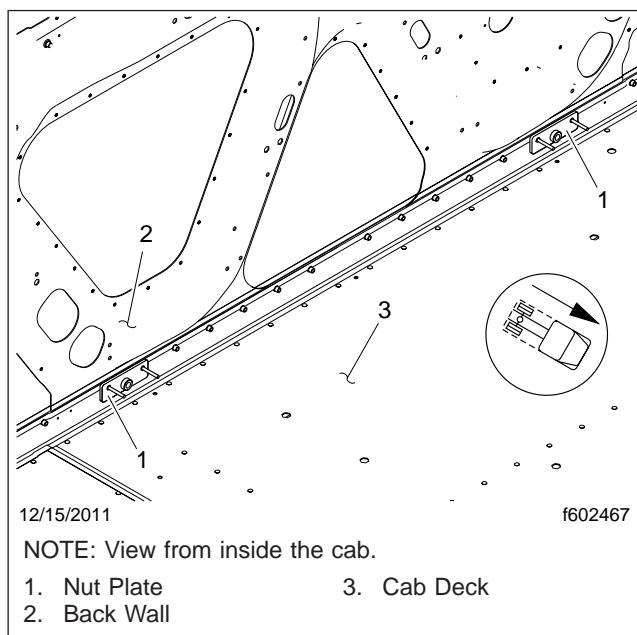
Fig. 4, Reinforcement Installation

10. Using two rivets, install the inner reinforcement plate ([Fig. 4](#), item 1) to the cab back wall and the shock bracket reinforcement plate.
11. Repeat, installing the reinforcement plates on the other side of the vehicle.
12. Using three flange bolts and two flange nuts each, install the shock brackets.
13. Install the floor mat.
14. Install the under-bunk panels as follows:
 - 14.1 Using the Christmas-tree fasteners, install the baggage compartment back-wall panel, with the bottom flange of the panel under the floor mat. If necessary, tighten the lower bunk hinge screws.
 - 14.2 Install the lower bunk side supports.
 - 14.3 Install the baggage door sill(s).
 - 14.4 Install the baggage compartment right-hand side panel, if equipped.

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Fig. 5, Inner Nut Plate Installation

14.5 Install the two baggage compartment dividers.

14.6 Lower the bunk.

15. Paint and finish the exterior reinforcement plate and surrounding area as needed.

16. Install the cab shocks.

Warranty

This procedure is warrantable only if the described condition exists and the repair is performed within the applicable base or extended coverage warranty period. If a failure is not found, this procedure is considered preventive and warranty does not apply.

Normal warranty applies. See [Table 2](#) for QuickClaim damage code and labor allowance information. Refer to this service bulletin by number at the beginning of the claim comments. See [Table 3](#) for OWL VMRS codes and labor allowance information. Enter this service bulletin number in the *Service Bulletin #:* field.

QuickClaim Damage Code and Labor Allowance			
Damage Code	SRT Code	Description	Time: Hours
650-000032130	650-5025A	MOUNT, CAB REAR, BOTH SIDES, REINFORCE/REPLACE (60-151)	6.1

Table 2, QuickClaim Damage Code and Labor Allowance

Reinforcement Plates for Cab Shock Brackets

60-151

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OWL VMRS Codes and Labor Allowance					
Primary Failed Part	Component Code	Cause Code	SRT Code	Description	Time: Hours
Z18-52508-000	002-050-254	14	650-5025A	MOUNT, CAB REAR, BOTH SIDES, REINFORCE/REPLACE (60-151)	6.1

Table 3, OWL VMRS Codes and Labor Allowance