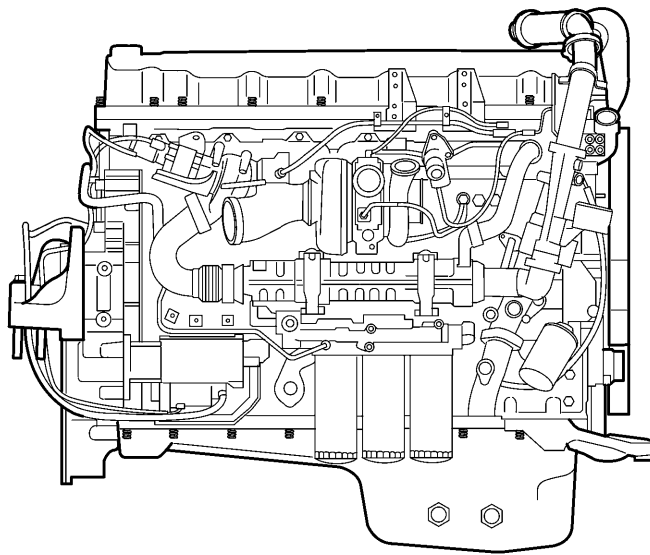


This Service Bulletin replaces SB 254–32, “EGR Cool-Side Pipes, Replace, D13F” (5.2007), publication no. PV776–20180153.

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## EGR Pipe Replacement D13F

### EGR Pipe, Replacement



W2005779

This information covers the procedures for replacing the EGR valve exhaust pipes on a Volvo D13F engine.

### Contents

- “EGR Pipe, Replacement” page 2

**Note:** Information is subject to change without notice. Illustrations are used for reference only and can differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

# **Service Procedures**

**2934-03-02-02**

## **EGR Pipe, Replacement**

You must read and understand the precautions and guidelines in Service Information, group 20, "General Safety Practices, Engine" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.

### **Mixer Inlet Pipe**

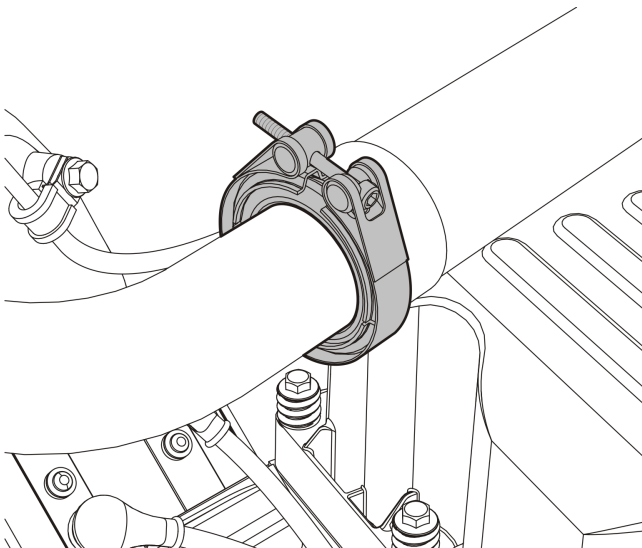
#### **Removal**

**1**

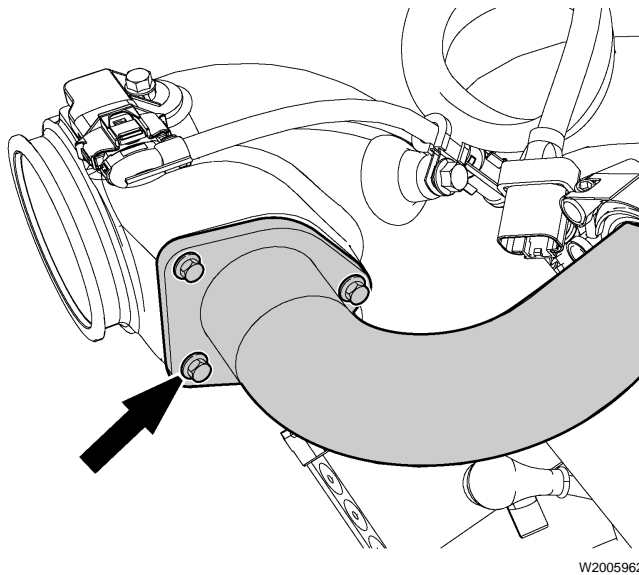
Apply the parking brake and place the shift lever in neutral.

**2**

Loosen and remove the V-clamp connecting the crossover pipe to the mixer inlet pipe.



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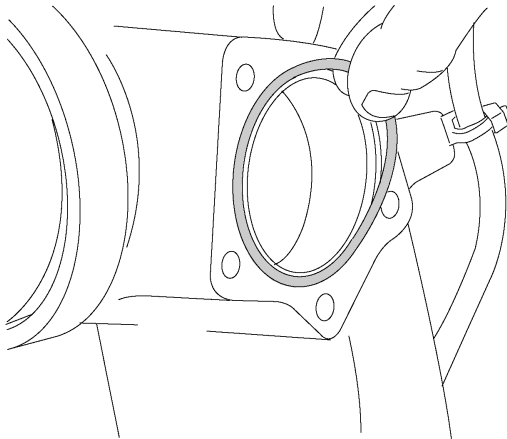
**3**

Remove the bolts attaching the EGR inlet pipe to the mixer and remove the pipe. Discard the O-rings.

## Installation

**1**

Install a new O-ring at the EGR mixer inlet and a new O-ring on the crossover pipe clamp flange.



**2**

Place the EGR inlet pipe in position on the mixer inlet mounting pad and install the mounting bolts. Tighten the bolts to specification.

**3**

Check to ensure that the O-ring is properly positioned on the crossover pipe flange and install the V-clamp connecting the crossover pipe to the mixer inlet pipe. Tighten the clamp to specification.

## Crossover Pipe

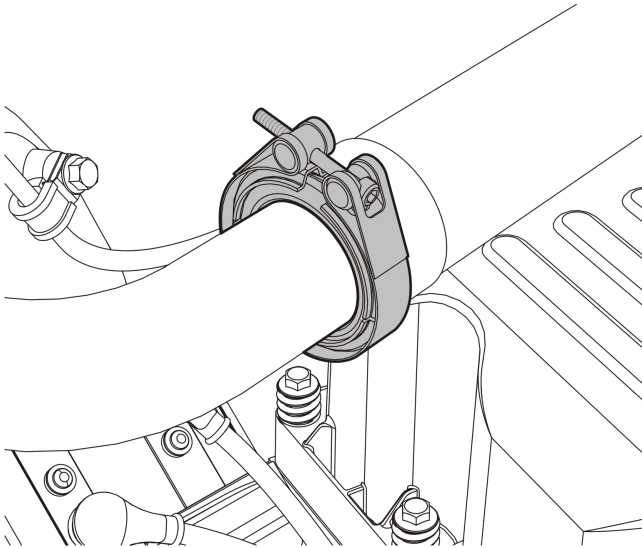
### Removal

**1**

Apply the parking brakes and place the shift lever in neutral.

**2**

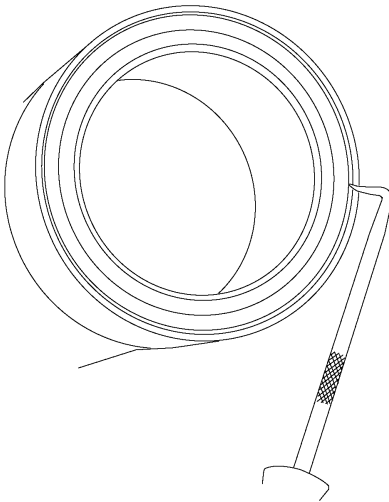
Loosen and remove the V-clamps at each end of the crossover pipe inlet and outlet.



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**3**

Remove the crossover pipe. Discard the O-rings.

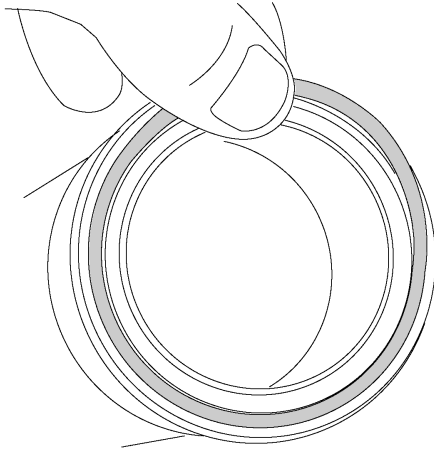


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## Installation

**1**

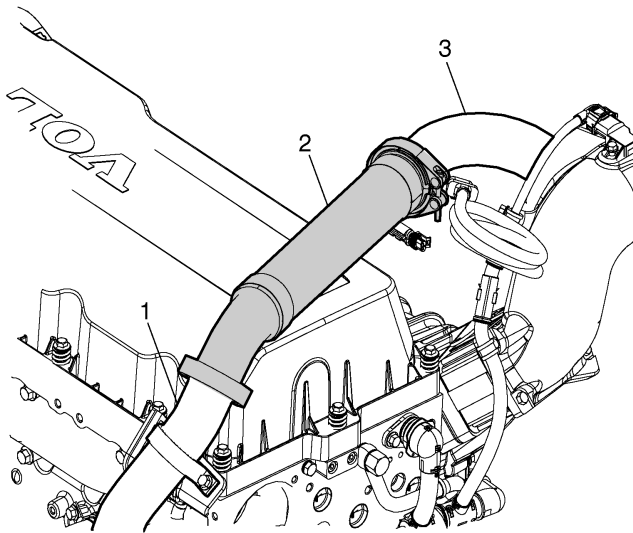
Place a new O-ring in position on the flange at each end of the crossover pipe.



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**2**

Place the crossover pipe in position between the venturi outlet and the mixer inlet pipes.

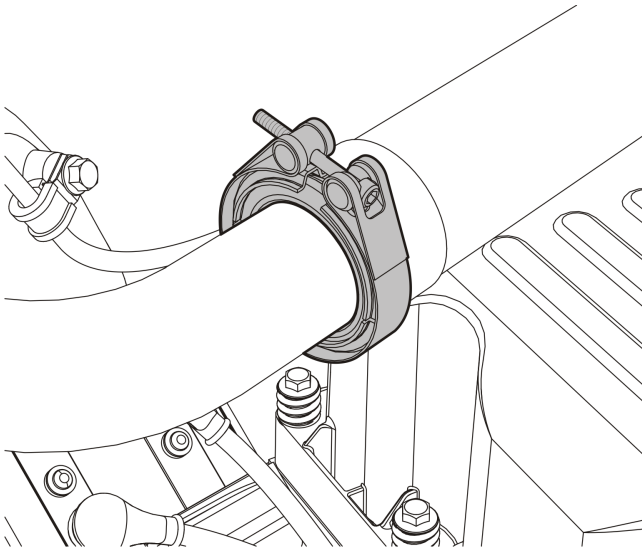


W2005960

- 1 Venturi Outlet Pipe
- 2 Crossover Pipe
- 3 Mixer Inlet Pipe

**3**

Check that the O-rings are in place and install the V-clamps at the inlet and outlet ends of the crossover pipe. Tighten the clamps to specification.



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## Venturi Outlet Pipe

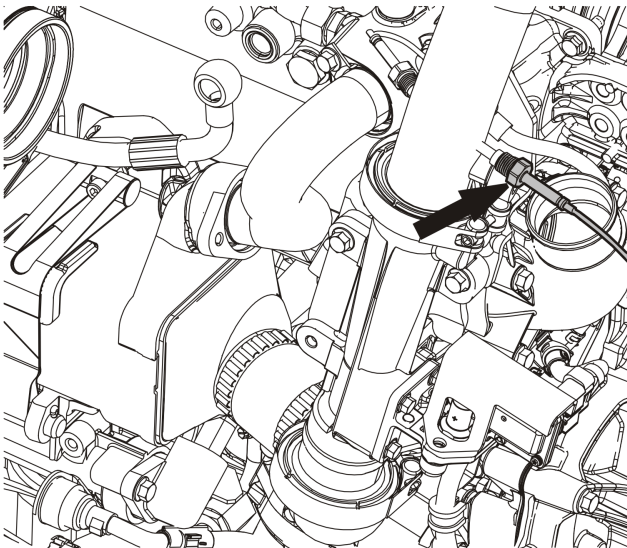
### Removal

**1**

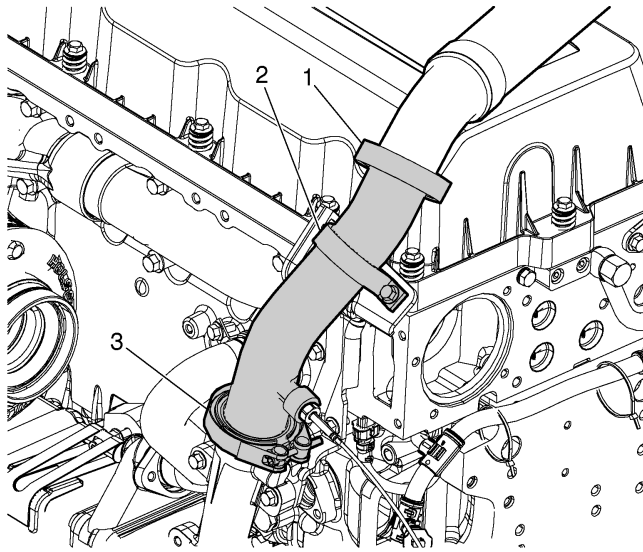
Apply the parking brake and place the shift lever in neutral.

**2**

Loosen the collar nut and remove the EGR temperature sensor from the venturi tube outlet pipe.



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W2005961

- 1 V-Clamp
- 2 Retainer Strap
- 3 V-Clamp

**3**

Loosen and remove the V-clamp connecting the outlet pipe at the top end of the venturi tube.

**4**

Loosen and remove the V-clamp connecting the venturi outlet pipe to the crossover pipe.

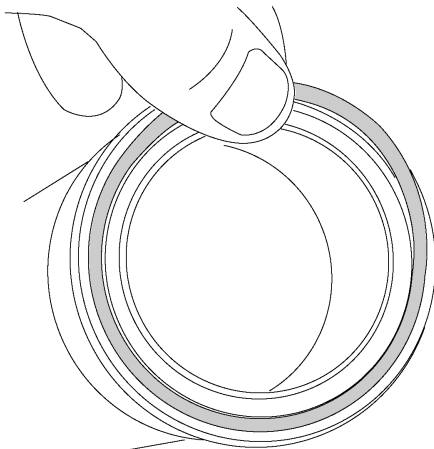
**5**

Remove all fasteners at the retainer strap securing the venturi outlet pipe to the venturi tube mounting bracket and remove the pipe from the engine.

## Installation

**1**

Place new O-rings in position on the venturi tube outlet flange and the inlet flange of the crossover pipe.



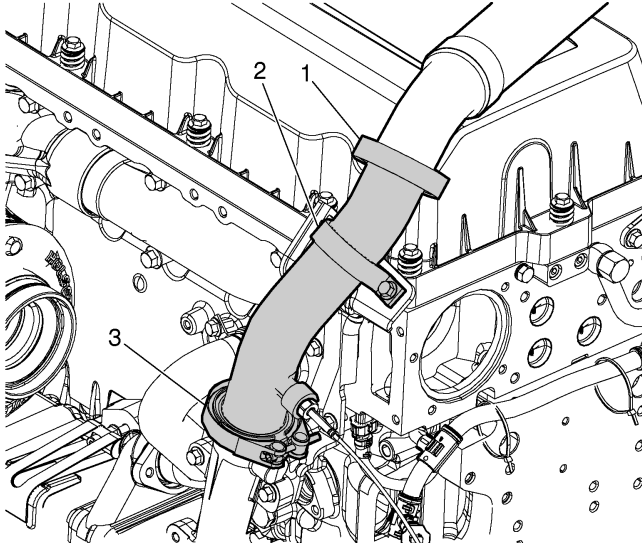
W2005959

**2**

Place the venturi outlet pipe in position between the venturi tube and the crossover pipe.

**3**

Check to ensure that the O-rings are properly positioned in the pipe flanges and install the V-clamps. Tighten the clamps to specification.



W2005961

- 1 V-Clamp
- 2 Retainer Strap
- 3 V-Clamp

**4**

Install the retainer strap to secure the venturi outlet pipe to the venturi mounting bracket. Tighten the clamp fasteners to specification.

**5**

Due to the Engine Electronic Control Unit (EECU) self learning capability, it is necessary to reset learned EECU parameters after servicing some engine related components. This allows the EECU to learn the new components behavior. After servicing is complete, perform the "Learned Data Reset" using the PC tool. This is located in the Function Group 1 menu.