

REMOVAL AND INSTALLATION INSTRUCTIONS FOR EXHAUST TUBE BELLOWS PACKAGE

N1171752R2

PARTS INFORMATION:

EXHAUST TUBE BELLOWS/ADAPTER PACKAGE INCLUDES THE FOLLOWING ITEMS:

	PART NUMBER	DESCRIPTION
•		TURBOCHARGER EXHAUST INLET ADAPTER ASSEMBLY
•		RIGHT HAND EXHAUST TUBE ASSEMBLY
•		LEFT HAND EXHAUST TUBE ASSEMBLY
•		EXHAUST FLANGE GASKET (QTY 2)
•		TURBOCHARGER EXHAUST ADAPTER FLANGE BOLT (QTY 4)
•		EXHAUST FLANGE BOLT (TUBE TO MANIFOLD) (QTY 4)
•		PREVAILING TORQUE HEX FLANGE NUT(QTY 4)
•	1171752R2	INSTRUCTION SHEET

REMOVAL AND INSTALLATION INSTRUCTIONS:

1. Remove road draft breather tube by removing two bolts securing tube to rear of engine. If required, remove breather hose with draft tube from breather by loosening hose clamp.
2. Remove and discard lower exhaust flange bolts (4) and hex flange nuts (4).

NOTE: Support exhaust adapter and exhaust tubes before removal of turbocharger exhaust adapter clamp.

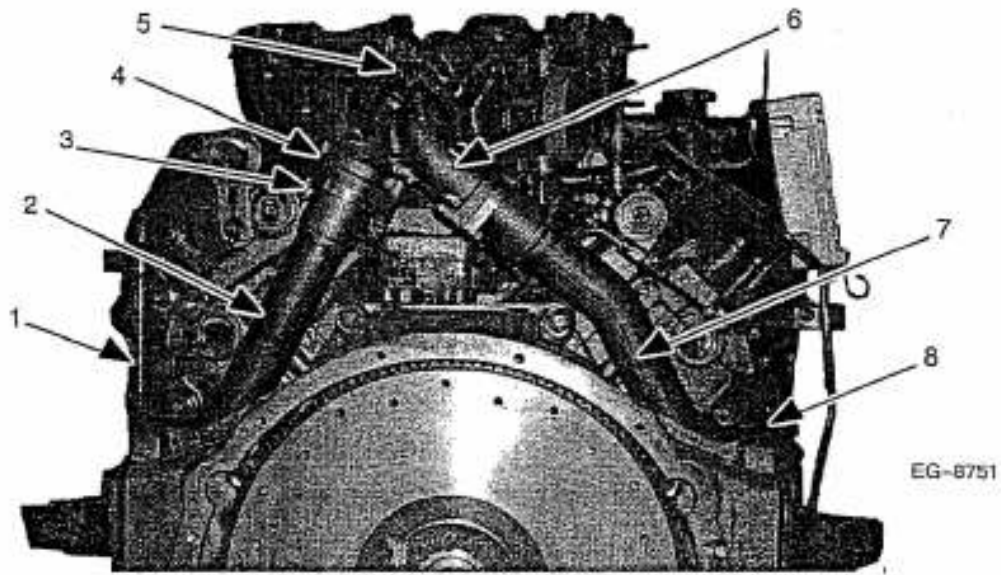
3. Remove and save turbocharger exhaust adapter V band clamp.
4. Remove and discard turbocharger exhaust inlet adapter, left and right hand exhaust tubes from engine.
5. Before mounting turbo adapter to engine, sub-assemble right-hand tube assembly to turbo adapter with stainless steel flange gasket (either side up) mounted between the flange and the adapter casting.

CAUTION: To make assembly easier, make sure that the blind tapped bolt holes in the turbo adapter casting are clean and free of all machining debris and dirt. Blind tapped bolt holes are often difficult to clean properly. The fasteners used in these holes employ a locking feature that will bind the threads before it is seated properly.

6. Snug mounting bolts, but don't final torque them until the assembly has been completed.
7. Slide adapter/tube assembly into location. Install turbocharger exhaust adapter clamp around turbocharger and adapter flange.
8. Assemble the left-hand tube assembly to the turbo adapter with the stainless steel flange gasket (either side up) mounted between the flange and the adapter casting.
9. Install exhaust flange bolts with prevailing torque nuts, making sure that flange holds the flared end of the tube firmly and evenly against exhaust manifold to seal out leaks. Torque the exhaust manifold flange bolts to 19 lbf-ft (26 Nm). Torque the adapter flange bolts that secure exhaust tube assemblies to turbocharger exhaust inlet adapter to 21 lbf-ft (29 Nm).
10. Torque lock nut on exhaust adapter V band clamp to 50 lbf-in (5.6 Nm).
11. Reinstall road draft breather tube.

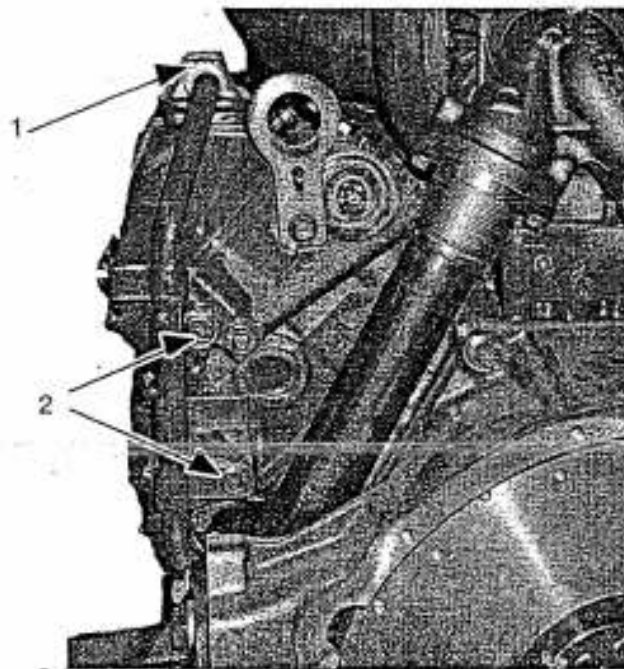
NOTE: Use anti-seize compound on the mounting bolts and on all other bolt threads used on the exhaust system to prevent high temperature corrosion that makes future service difficult.

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Exhaust Tube Bellows/Adapter Assembly Package

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|------------------------------------|---------------------------------------|
| 1. Road Draft Tube | 5. Turbocharger Exhaust Adapter Clamp |
| 2. LH Exhaust Tube Assembly | 6. Exhaust Inlet Adapter Assembly |
| 3. Exhaust Adapter Flange Bolt (4) | 7. RH Exhaust Tube Assembly |
| 4. Exhaust Pipe Flange Gasket (2) | 8. Exhaust Tube Flange Location |



Road Draft Tube Mounting Hardware

- | | |
|---------------|-------------------|
| 1. Hose Clamp | 2. Mounting Bolts |
|---------------|-------------------|