

Isolator Radiator Mounting, Behr/Mahle

TSB-20-092-FTL

Creation Date: 2026-05-12

Engine or Vehicle Affected:

- Business Class M2-Plus
- Business Class M2

This is an informational bulletin only. The described condition is a product improvement and is not warrantable.

Described Condition

This bulletin applies to Business Class M2 106 vehicles and Business Class M2 Plus vehicles equipped with Cummins L9 engines and Mahle radiators. In some vehicles, the current radiator mounting configuration can allow chassis and engine vibration to transfer directly to the radiator, which may result in gradual, progressive radiator leaks over time. To address this condition, follow the instructions in this bulletin to update the lower engine leg/radiator mount and the upper bullhorn bracket to include isolation components. This update will improve vibration control and help prevent future radiator leaks, enhancing overall radiator durability.

Radiator Removal

1. ☐ Park the vehicle on a level surface, shut down the engine, and set the parking brakes. Chock the tires.

2. ☐ Disconnect the batteries at the negative post.

⚠ Warning: Do not attempt to drain the cooling system until the coolant and engine are cool. Draining the cooling system prior to system cooling could cause severe personal injury due to scalding.

3. ☐ Drain the coolant.

4. ☐ Remove the lower coolant hose assembly between the radiator and the engine.

5. ☐ Disconnect the wiring harness from the hood.

6. ☐ Remove the hood. See **Group 88** of the applicable Workshop Manual.

7. ☐ Remove the charge air cooler (CAC) inlet and outlet hoses.

8. ☐ Remove the upper coolant hose.

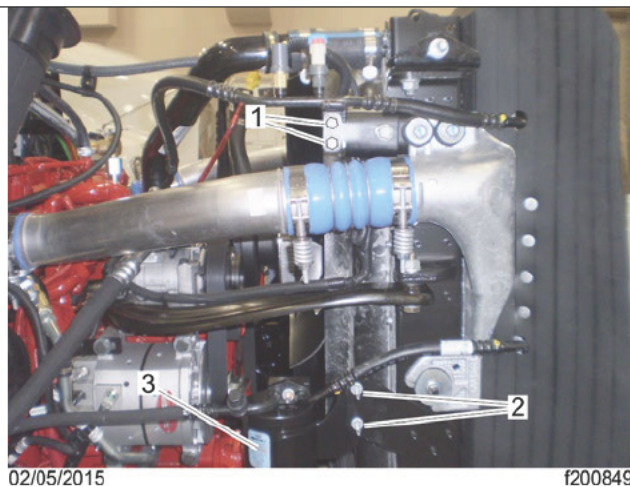
9. ☐ Disconnect the surge tank vent line from the radiator, and free the retaining clips.

10. ☐ Remove the grille from the radiator.

11. ☐ Remove the radiator support brackets. Discard the brackets, spacers, and fasteners.

12. ☐ Loosen the A/C condenser and move it out of the way as follows.

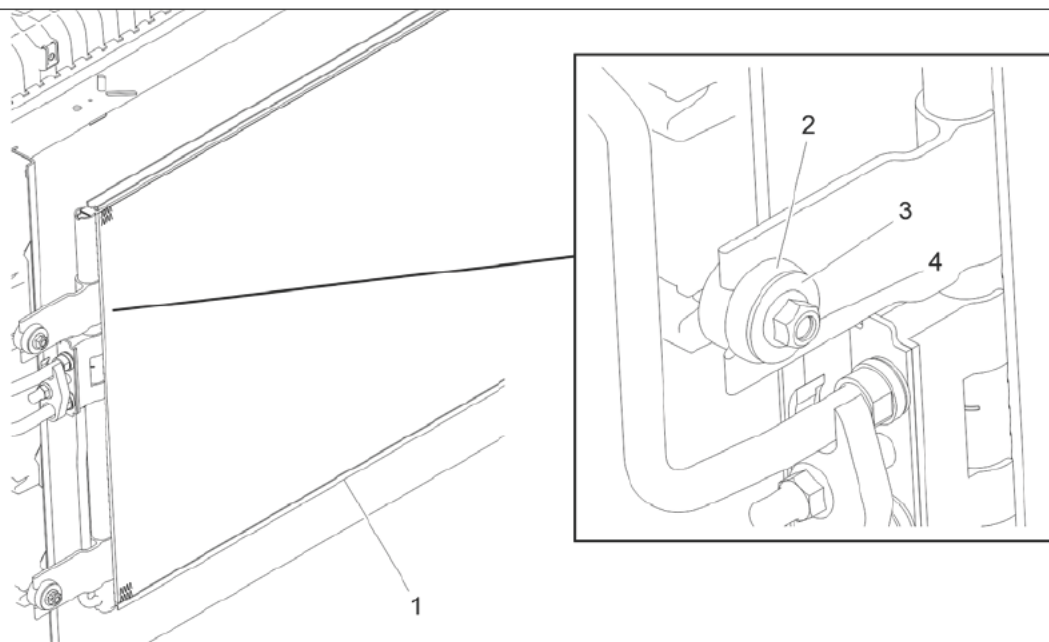
a. ☐ Remove the receiver-drier and upper condenser line mounting nuts, then free the receiver-drier. See Fig. 1.



1. Upper Condenser Line Mounting Nuts 2. Receiver-Drier Mounting Nuts
Fig. 1, Receiver-Drier Installation (typical)

b. ☐ Loosen the radiator baffle at the top right corner of the radiator.

c. ☐ Unbolt the A/C condenser from the CAC. 2.

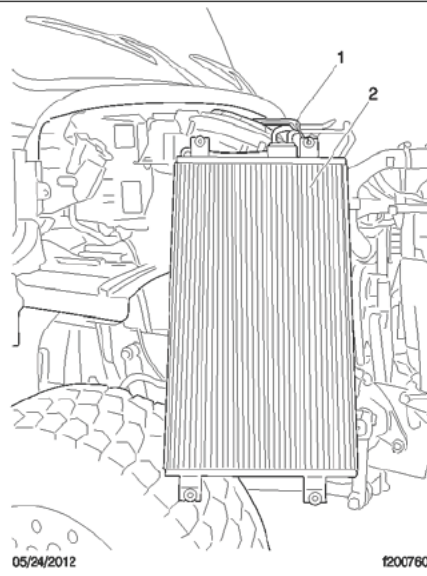


1. A/C Condenser
2. Isolator

3. Washer
4. Nut

Fig. 2, A/C Condenser Installation (typical)

d. ☐ Carefully move the condenser around and set it on the right front tire or on top of the engine. Secure it as needed. See Fig. 3.



1. Bungee Cord

2. Condenser

Fig. 3, Securing the A/C Condenser

13. ☐ Disconnect the transmission cooler lines.

14. ☐ Attach an appropriate lifting device to the radiator, then remove the fasteners that connect the radiator to the radiator mounting bracket.

15. ☐ Remove the radiator assembly and driveline from the vehicle.

Note: Save all of the parts removed from the radiator assembly to install on the new radiator.

16. ☐ Remove the driveline from the radiator.

17. ☐ Remove the baffles from the radiator.

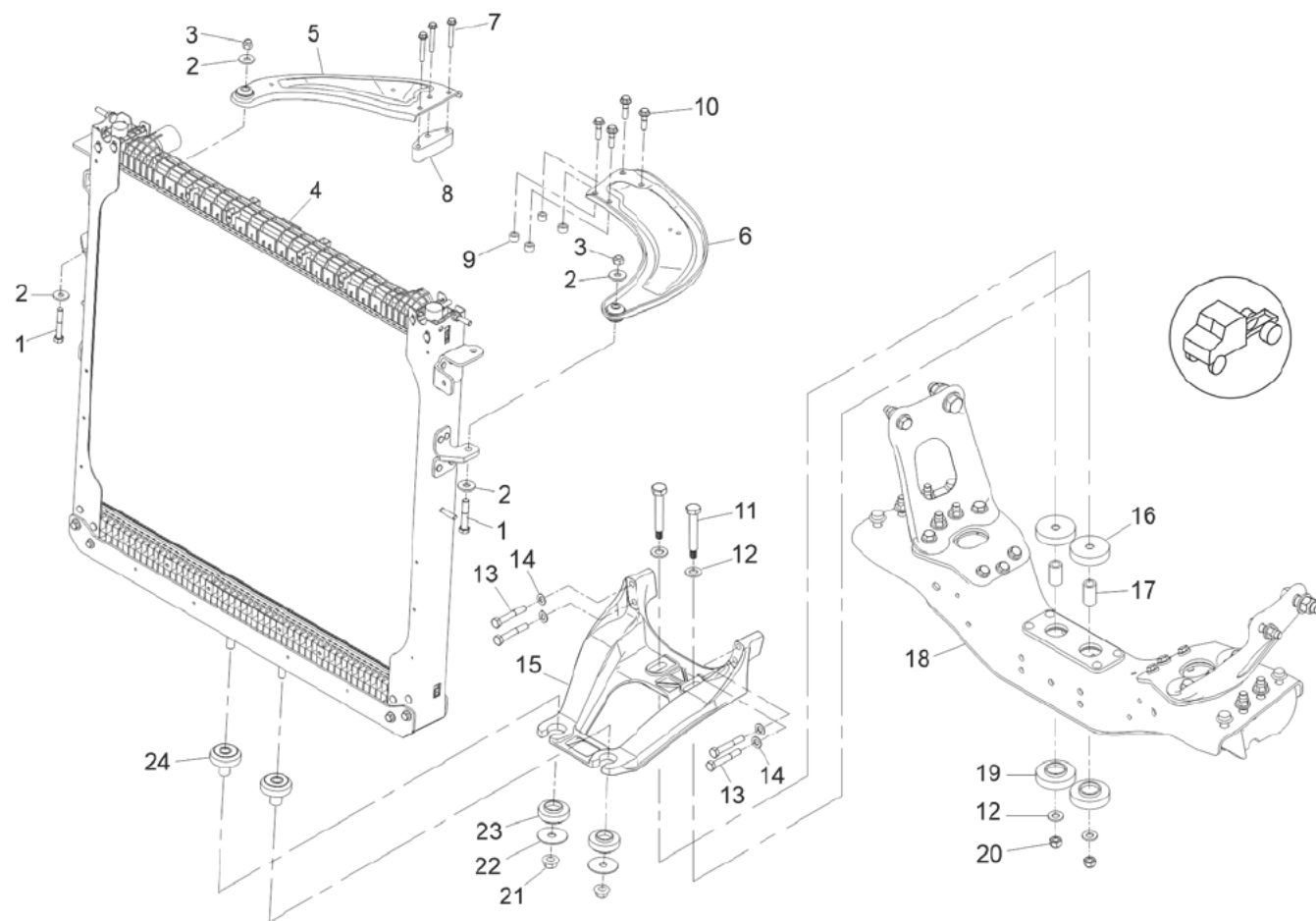
18. ☐ Remove the CAC from the radiator.

19. ☐ Remove the fan shroud from the radiator.

20. ☐ Remove the side and lower channels from the radiator. Discard the lower channel. Save all other parts for the new radiator.

Front Engine Mount Replacement

Refer to [4](#) for this procedure.



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- | | |
|--------------------------------|-----------------------------------|
| 1. Bolt | 13. Capscrew |
| 2. Washer | 14. Washer |
| 3. Nut | 15. Front Engine Mount |
| 4. Radiator | 16. Upper Engine Mount Isolator |
| 5. Right Upper Support Bracket | 17. Engine Mount Bushing |
| 6. Left Upper Support Bracket | 18. Front Crossmember |
| 7. Capscrew | 19. Lower Engine Mount Isolator |
| 8. Spacer | 20. Nut |
| 9. Spacer | 21. Nut |
| 10. Capscrew | 22. Washer |
| 11. Bolt | 23. Lower Radiator Mount Isolator |
| 12. Washer | 24. Upper Radiator Mount Isolator |

Fig. 4, Radiator and Front Engine Mount Installation

1. ☐ Attach an appropriate lifting device to the engine.
2. ☐ Remove the front engine mount fasteners at the crossmember.
3. ☐ Lift the engine enough to remove the weight from the front engine mount.
4. ☐ Remove the front engine-mount-to-block fasteners, then remove the engine mount. Discard the engine mount.
5. ☐ Attach the new front engine mount to the engine. Tighten the fasteners 74 to 92 lbf·ft (100 to 125 N·m)
6. ☐ Position the upper engine mount isolators on top of the frame cross member.
7. ☐ Lower the engine onto the cross member and isolators.
8. ☐ Install the lower isolators and the engine-mount-to-cross member fasteners. Tighten 122 to 149 lbf·ft (166 to 202 N·m).

Radiator Installation

1. ☐ Install the new lower channel, and the original side channels on the new radiator.

2. ☐ Install the CAC on the new radiator.

3. ☐ Install the grille. Tighten 50 to 55 lbf·in (565 to 622 N·cm).

4. ☐ Install the fan shroud on the new radiator.

5. ☐ Install the left and upper baffles on the new radiator.

6. ☐ Install the lower radiator isolators on the new front engine mount.

Note: It may be easier to install the transmission cooler lines before the radiator is completely set in the isolators.

7. ☐ Using a proper lifting device, position the radiator above the isolators.

8. ☐ Connect the transmission cooler lines.

9. ☐ Lower the radiator into the isolators and install the mounting nuts and washers. Do not tighten at this time.

10. ☐ Connect the lower radiator hose.

11. ☐ Install the A/C condenser as follows.

- a. ☐ Move the condenser into position in front of the radiator and secure it temporarily.

- b. ☐ Position the receiver-drier and upper A/C line on their respective brackets and install the mounting nuts. Tighten the nuts 14 to 16 lbf·ft (19 to 22 N·m).

- c. ☐ Install the condenser mounting bolts. Tighten 112 to 144 lbf·in (1265 to 1625 N·cm).

12. ☐ Install the lower radiator hose assembly.

13. ☐ 14. Install the new radiator support brackets, spacers, and fasteners. Tighten the fasteners at the radiator 76 to 90 lbf·ft (103 to 122 N·m), and the capscrews at the engine 43 to 53 lbf·ft (58 to 72 N·m).

14. ☐ 15. Tighten the radiator mounting nuts 140 to 170 lbf·ft (190 to 230 N·m).

15. ☐ 16. Adjust the fan shroud as needed.

16. ☐ Install the upper coolant hose.

17. ☐ Install the CAC inlet and outlet hoses. Tighten the clamps 88 to 108 lbf·in (994 to 1220 N·cm).

18. ☐ Fill the cooling system with approved coolant.

19. ☐ Connect the batteries.

20. ☐ Install the hood.

21. ☐ Connect the wiring harness to the hood.

22. ☐ Start the engine and check for leaks on all lines and hoses that were disconnected for this procedure. Tighten any leaking connections as needed.

Parts

Parts are available through the PDC. See Table [1](#) for the list of required parts.

Part Number	Description	Quantity
05-28904-010	ASSY-BOLT PLATE, LWR, M2, M14	1
23-09440-375	SCREW-CAP, HEX, GRADE 8	2
05-33125-045	ISOLATOR-RAD,LWR,45 DURO	2
23-13833-108	NUT-HEX, LKG, GR C, ZNAL	2
23-11751-275	SCREW-CAP, HEX, GR8	2
23-09114-017	WASHER-FLAT, STEEL, HARDENED	4
05-32533-000	SPACER-RAD SUPPORT, RH	1
910105 008006	CREW-HEXFLGH, PC 8.8	3
05-30707-000	STUD-M10X50.0	4
05-38086-000	SPACER-RAD SUPPORT, LH, ISO	1
23-13892-010	NUT-HEX FLANGE	4

Warranty

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Note:
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F18
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