

01/18/2019
CAL WS 32-001

Subject: Transverse Track Rod Tower Bracket

Models Affected: Specific Western Star 4700SF Model Year 2014 through 2017 vehicles manufactured from April 29 to September 16, 2016.

Our records indicate that you are the owner of certain Western Star vehicles, and DTNA has decided to share the following documentation with you.

Trucks equipped with Meritor MT axles and Hendrickson Haulmax suspensions may use an incorrect track rod axle tower. Certain 4700SF trucks were shipped from the Portland or Cleveland truck manufacturing plant possibly without correct track rod axle tower brackets.

Normal warranty applies for those vehicles where this letter is applicable. See following pages for specific serial numbers. When submitting warranty claims for battery cable routing, refer to Customer Advisory Letter CAL WS 32-001 in the repair description field on the claim.

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Work Instructions

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Procedure

1. Park the vehicle, apply the parking brakes, and shut down the engine. Chock the tires.
2. Disconnect the batteries.
3. Use grinding cloths to cover up components that need to be protected from sparks, such as air springs, electrical connections, hoses, air lines, etc.
4. Using a disc grinder, grind out the weld and remove the tower bracket from the axle housing. Discard the bracket.
5. Remove any weld residue, ridges, or ripples from the surface of the housing. All areas must be level with the housing wall and bracket. Do not gouge or leave sharp edges on any surface.
6. Verify that the forward drive axle and rear drive axle pinion angles are within specifications as listed below. Pinion angles should be measured relative to the frame rail. See *Western Star Workshop Manual, Section 41.01* for more information.
 - Forward Drive Axle Pinion Angle: 3.0 degrees
 - Rear Drive Axle Pinion Angle: 10.9 degrees
7. Grind off the outer coating on the surfaces of the new tower bracket that will be welded.
8. Install the transverse track rod to the frame bracket. Tighten the fasteners only enough to remove play.
9. Attach the tower bracket to the transverse track rod. Tighten the fasteners only enough to remove play. Do not apply the final torque at this time. See [Fig. 1](#) for the bracket orientation.

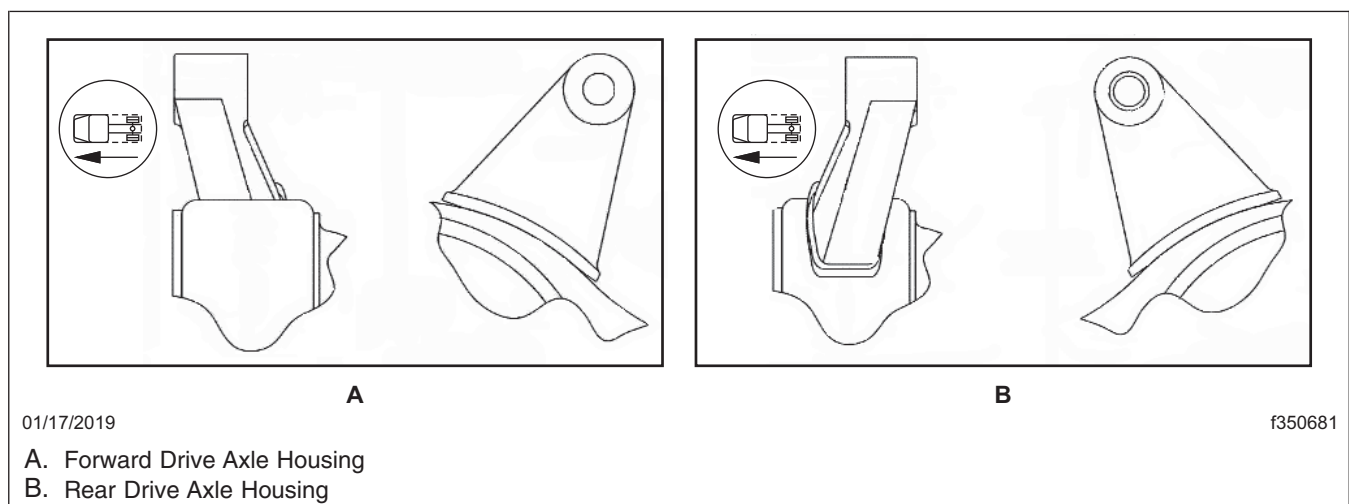


Fig. 1, Track Rod Tower Bracket Orientation

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10. Using the tower bracket attached to the track rod, establish the position of the tower bracket on the axle housing in preparation for welding. Make sure the transverse track rod is as perpendicular to the frame rail as possible.
11. Press the bracket tight against the axle housing to reduce gaps, tack-weld the tower bracket into place.
12. Remove the track rod from the tower bracket.

IMPORTANT: The welding must be done by a certified welder.

13. Weld the tower bracket onto the axle housing. Lay a full-length 3/8 to 1/2 inch (9.5 to 12.7 mm) fillet in a single pass on each side.

NOTE: For reference, see *Meritor Maintenance Manual*, Chapter 8, "Drive Axle Housing Welding and Repair Procedures". The upper torque rod brackets are covered on pages 10 and 11.

Parts

Parts are available at the PDCs. See [Table 1](#) for required parts. [Table 2](#) lists existing parts to be reused.

Parts Required		
Part Number	Description	Qty.
TDA 3150P1628	BRKT-TRACK ROD TOWER	2

Table 1, Parts Required

Existing Parts		
Part Number	Description	Qty.
HDR62350 635	CTRL ROD-TRNSV,635MM,TAPER PIN	2
16-12324-000	BRKT,TORQUE ROD SUSP	2

Table 2, Existing Parts