

SERVICE INSTRUCTIONS

REFERENCE: FSA202120

DATE: 25.10.2021

SUBJECT: Retrofit of DPF for EU6 Vehicles

FSA TYPE: Customer Notification

Introduction

FSA202120: Steps to be performed in any deformation on the clamps and gaskets on the DPF filter available inside the muffler on EU 6 vehicles.

Labour:

Labour	Labour Name	Duration
25C107A	Replacement of DPF Clamps and Gaskets	3 hours

Parts:

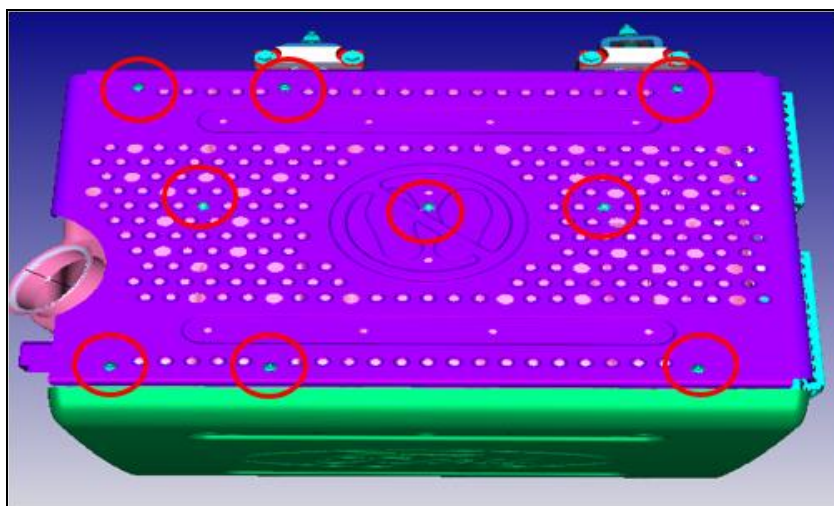
Part No	Part Description	Usage
GC46-9451-BA	GASKET	1
MC46 9451 AA	GASKET	1
MC46 9451 BA	GASKET	1
GC46-9N435-AA	CLAMP	1
GC46-9N435-BA	CLAMP	1
MC46-9N435-AA	CLAMP	1
MC46-190K54-BA	MASTIC SEALANT	0,2 (62 ml per vehicle) – (1 tube is used for 5 vehicles)

Following procedures shall be performed to replace DPF clamps and gaskets inside the muffler on vehicles brought to the service with the problems of excessive gas leak from the muffler or burning of differential pressure sensor on EU6 vehicles.

Note: **Initial Orders** were placed from the headquarters for part/stock management. Parts are expected to be in Poland Warehouse on **01.11.2021**.

Service Application

1- Remove 9 bolts (**W505541 S437**) on the upper heat shield of the muffler (**GC46-5K277-BA**) using a 6" allen wrench and take it out of the heat shield.



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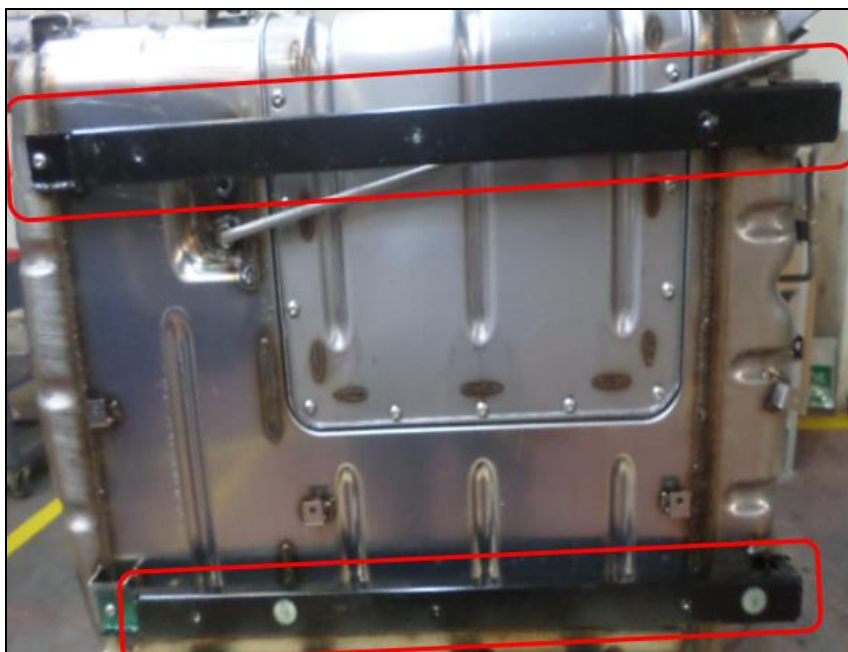
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2- Remove 6 bolts (**W505541 S437**) on the side heat shield (**GC46-5K277-AA**) using a 6" allen wrench and take it out of the heat shield.



3- Remove 2 suspension brackets (**GC46-5A277-AA**) where the heat shield is installed and 4 bolts (**W505541 S437**) on it using a 6" allen wrench and take the brackets out of the muffler.



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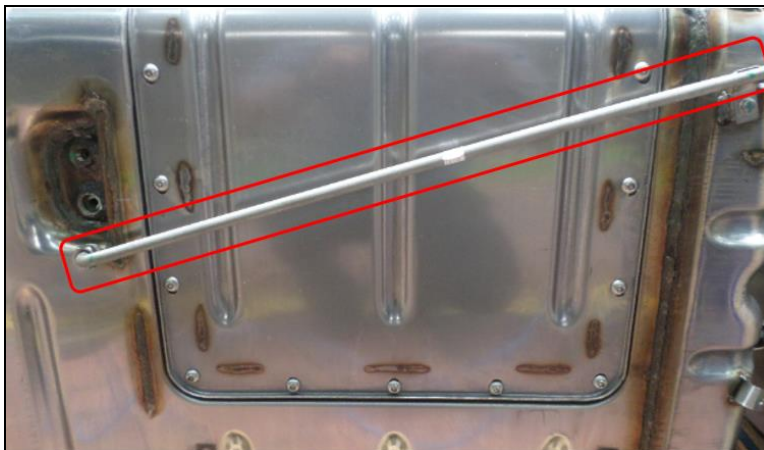
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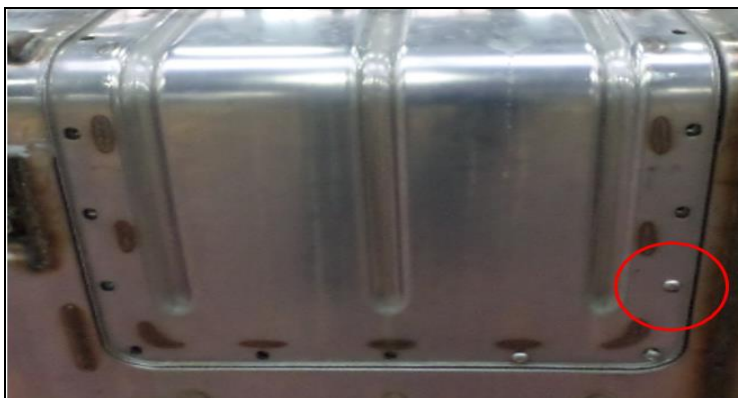
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4- Remove the bushing securing the pressure pipe with a 19" wrench



5- Remove 20 bolts on the DPF cover with a 5" allen wrench.



6- Take the DPF out by removing DPF V- clamp (**GC46-9N435-AA**) and gasket (**GC46-9451-BA**) and the Tape Clamp (**GC46-9N435-B**) and gasket (**GC46-9451-CA**) with a 6" allen wrench.



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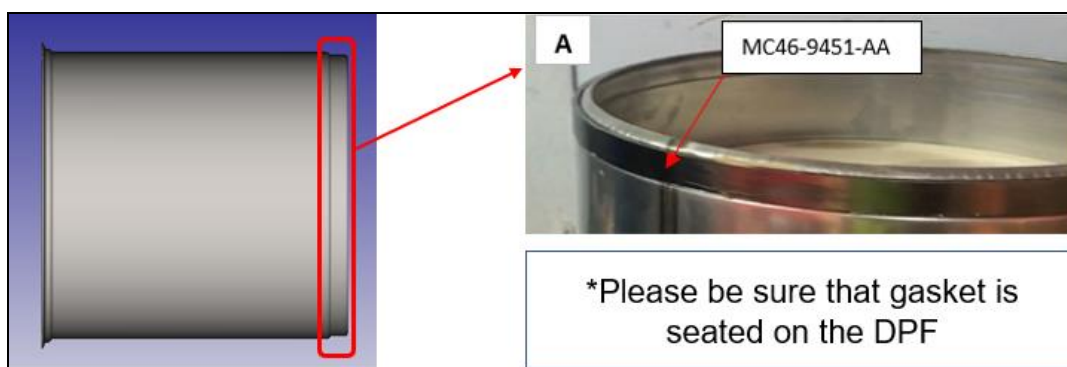
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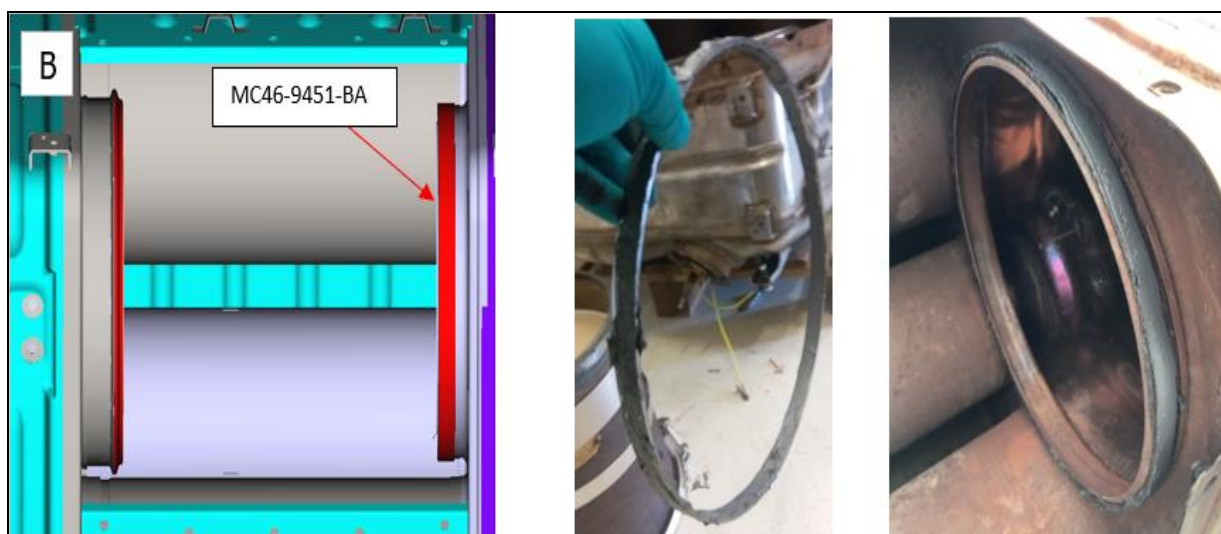
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7- a. Apply mastic sealant (**MC46-190K54-BA**) to gasket (**GC46 9451 CA**) and place it on the DPF as shown in **figure A**.



7- b. Apply mastic sealant to gasket (**MC46 9451 BA**) and insert it against the DPF on the muffler as shown in **figure B**



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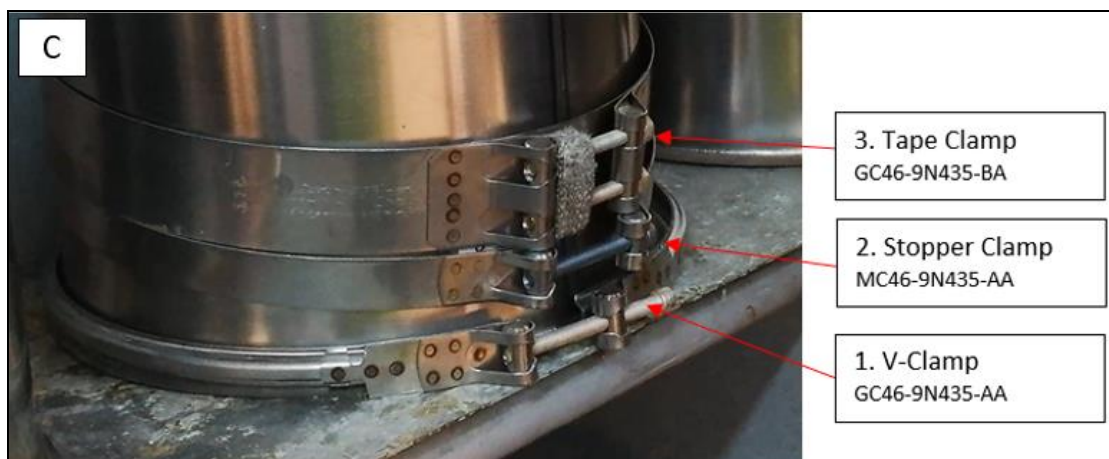
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7- c. Apply mastic sealant inside of the Tape Clamp as below picture.



8- Engage the clamps to the DPF with the V-Clamp first, then the stopper clamp and finally the Tape Clamp as shown in **Figure C** respectively.



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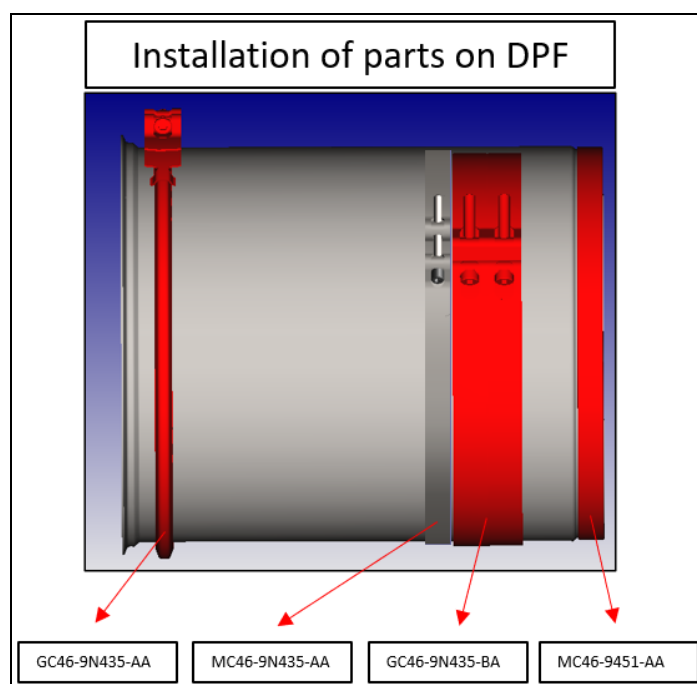
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9- Apply mastic sealant to all over the gasket surface after all clamps are assembled. Inside of gasket was already applied with mastic sealant in the previous step. **Figure D**



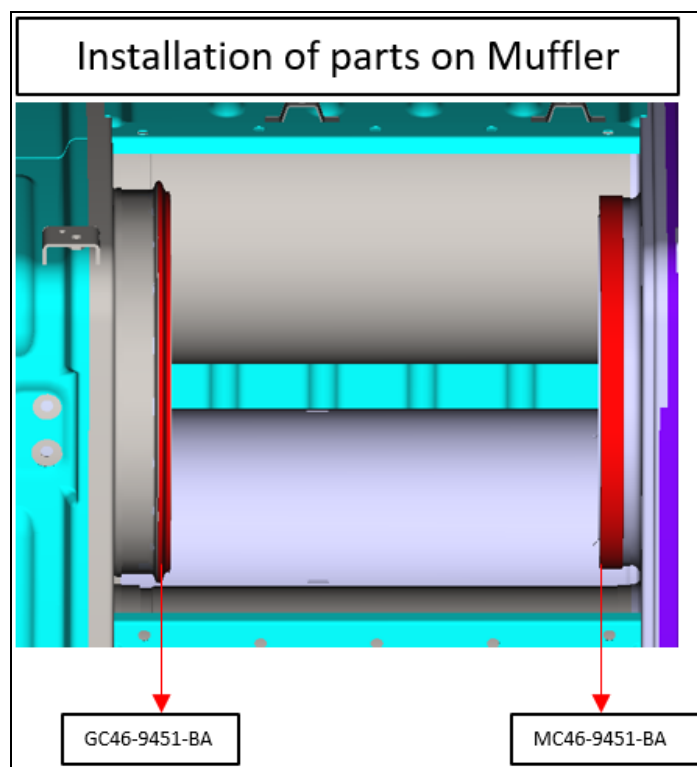
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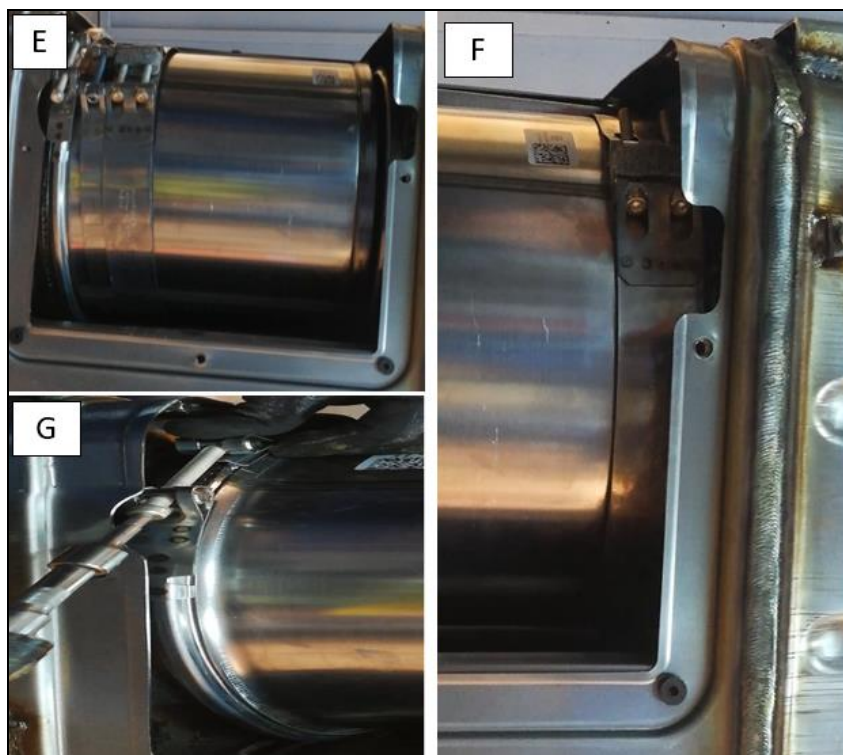
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10- Align DPF inside the muffler as **figure E**. While placing the Tape Clamp, the gasket of the tape clamp (**MC46-9451-BA**) shall not protrude more than **3mm** under the clamp. Align V-clamp on its seat as shown in **figure F** and take out its play.



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11- After Placing Clamps;

- Tighten the Tape clamp (**GC46-9N435-BA**) in **Figure F** to **10Nm**.
- Tighten the V-clamp (**GC46-9N435- AA**) in **Figure G** to **10Nm**.

12- After tightening to **10Nm**:

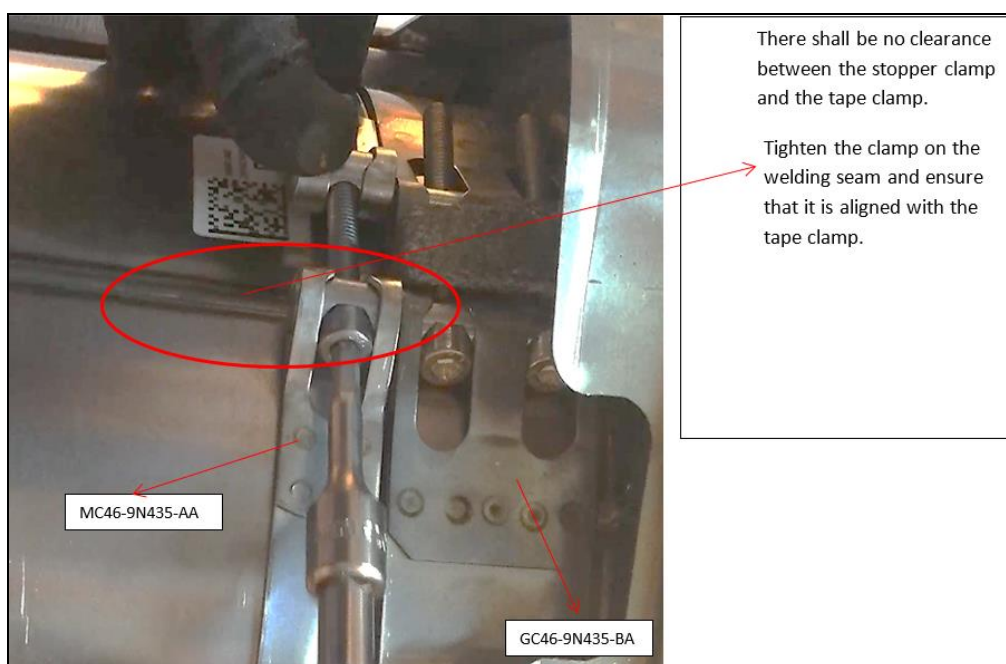
- Tighten the Tape Clamp (**GC46-9N435-BA**) in **Figure F** to **19Nm**.
- After completing the tightening process, visually inspect for the protrusion of the gasket under the clamp. The gap should be less than **3mm**.
- If the sealant protrudes after the band clamp is torqued, the overflow sealant should be spread around the clamp as below



- Tighten the V-clamp (**GC46-9N435- AA**) in **Figure F** to **19Nm**.

13-

- Place the stopper clamp (**MC46-9N435-AA**) next to the tape clamp (**GC46-9N435-BA**) and take out its free play first.
- Then, tighten it to **19Nm**.



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14- Install DPF cover to its location and tighten 20 bolts to **13Nm** with 5" allen wrench



15- Install the pressure pipe and tighten it with 19" wrench



16- Install 2 suspension brackets (**GC46-5A277-AA**) where the heat shield with Ford logo is installed and 4 bolts (**W505541 S437**) on it using a 6" allen wrench and tighten the bolts to **25+/-4 Nm**



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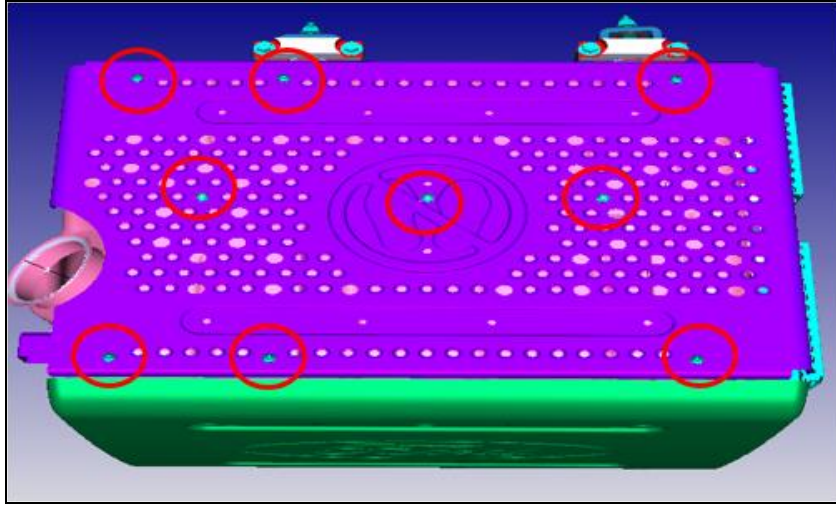
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17- Tighten 6 bolts (**W505541 S437**) on the side heat shield (**GC46-5K277-AA**) to **25+/-4 Nm** using a 6" allen wrench



18- Tighten 9 bolts (**W505541 S437**) on the upper heat shield of the muffler (**GC46-5K277-BA**) to **25+/-4 Nm** using a 6" allen wrench.



IMPORTANT NOTE: After applying mastic sealant to the DPF Gaskets and completing the DPF Gasket and clamp assembly, it is necessary to wait for at least 1 hour.

Best Regards,
Ford Trucks Service Engineering
Ford Otomotiv San. A.Ş