


Title:	Arrow XT Air Conditioning Gravity Drains			
Number:	PB_618	Release Date:	6/16/2023	
Revision Number:	Not Applicable	Revision Date:	Not Applicable	
Chassis Type:	Arrow XT			
Component Description:	Gravity Drain for Arrow XT A/C system			
Warranty:	Not Applicable			
Parts:	See chart below			
Tools:	Not Applicable			

Subject:

This bulletin provides the parts needed and reference work instructions for installing the gravity drains on 2010 or newer Arrow XT's with the following air conditioning system sales options:

Sales Option Code	Sales Option Description
0603353	Air Conditioning, Arrow-XT 2010
0789344	Air Conditioning, Arrow-XT 2010, EZ-Clip

Purpose:

In Arrow XT custom chassis, the A/C condensation pan may overflow and drip on driver and occupants. Previously, an engineering review was required before modifying the cabin. This bulletin streamlines the process and an engineering review is no longer required.

PARTS BULLETIN 618

Description/Procedure:

Order the following piece parts individually:

NOTE: Parts in this table are listed in the order of installation.

Quantity	Unit of Measure	Part Number	Component Description	Find No.
1	EA	2888526	EVAPORATOR ASSY,LOW PROFILE	47
1	EA	2841440	LINER,SIDE WALL,FRT,RH	49
1	EA	2044885	LINER,BACKING,SIDE WALL,RR,RH	49
1	EA	3180099	LINER,SIDE WALL,FRT,BOTTOM,RH	49
1	EA	3180252	LINER,BLISTER,BOTTOM,RH	49
2	EA	82-0257-0002	INSERT,THREADED,.25-20,STEEL	49
11	EA	1735660-0002	INSERT,THREADED,.25-20,STEEL	49
10	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN	49
10	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK	49
6	EA	82-0386-0025	NUT,CAGE,LONG,PLN,SNGLE THD	50
11	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK	52
11	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN	53
1	EA	2044876	LINER,BACKING,SIDE WALL,RR,LH	54
1	EA	2841118	LINER,SIDE WALL,FRT,LH	54
6	EA	1735660-0002	INSERT,THREADED,.25-20,STEEL	54
3	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN	54
3	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK	54
6	EA	82-0386-0025	NUT,CAGE,LONG,PLN,SNGLE THD	55
9	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK	57
9	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN	58
16	FT	2504490	HOSE,GRAVITY DRAIN KIT	59
2	EA	59-0793	ELBOW,90 DEG,A/C DRAIN HOSE	60
1	EA	2087909	DIVERTER ASSY,EVAP COVER,AC	62
1	EA	2076675	KIT,INSULATION,EVAP COVER	62
1	EA	2845733	COVER,EVAPORATOR,WLDMT	62
2	EA	2515854	FILTER,AIR INTAKE,EVAPORATOR	62
1	EA	2845421	COVER ASSY,GRAV DRAIN,FRT,LH	63
1	EA	2845423	COVER ASSY,GRAV DRAIN,FRT,RH	N/A
1	EA	2846480	COVER,GRAVITY DRAIN,RR,LH	67
1	EA	2846479	COVER,GRAVITY DRAIN,RR,RH	N/A

Arrow XT A/C Gravity Drain

NOTE: The instructions below are for reference only. Dimensions and changes required for your specific application may vary from the information below. Please read instructions thoroughly before attempting this change in the field. Pierce is not responsible for damage or modifications to the unit cause by improper installation.

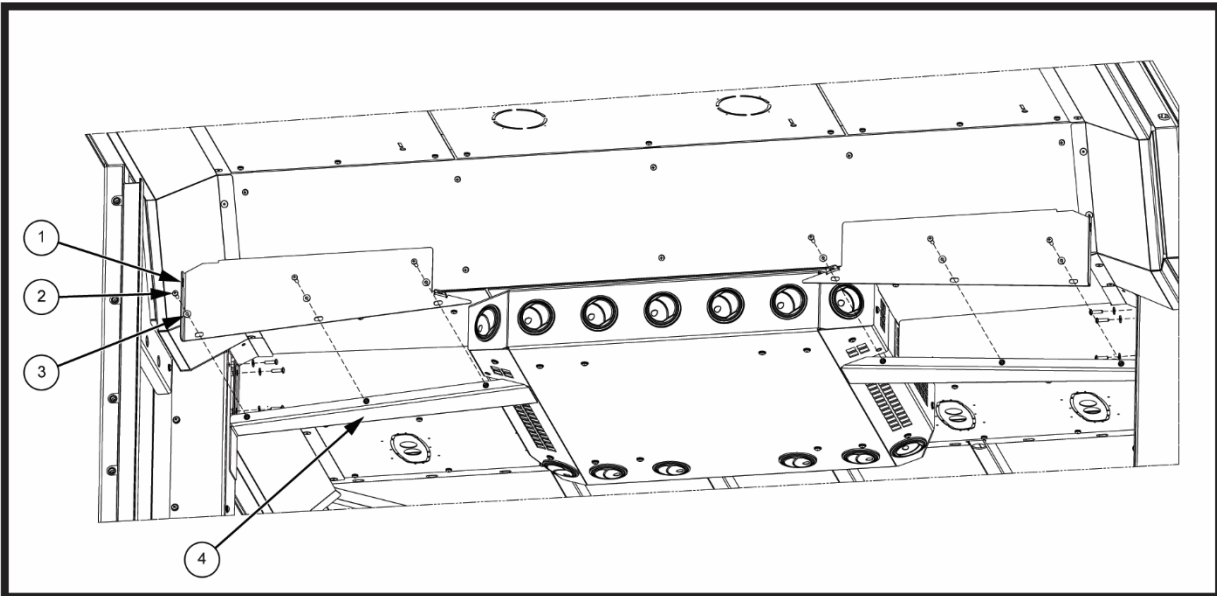
 WARNING

- Use only refrigerants approved by Pierce Manufacturing for your air conditioning system. Some unapproved refrigerants are flammable and can explode, causing injury to personnel. Other unapproved refrigerant can cause the system to fail, requiring costly repairs.
- The air conditioning system contains refrigerant under high pressure. To avoid risk of personal injury or damage to the system, adding refrigerant or any repair requiring lines to be disconnected should be done by a certified repairman.

CAUTION

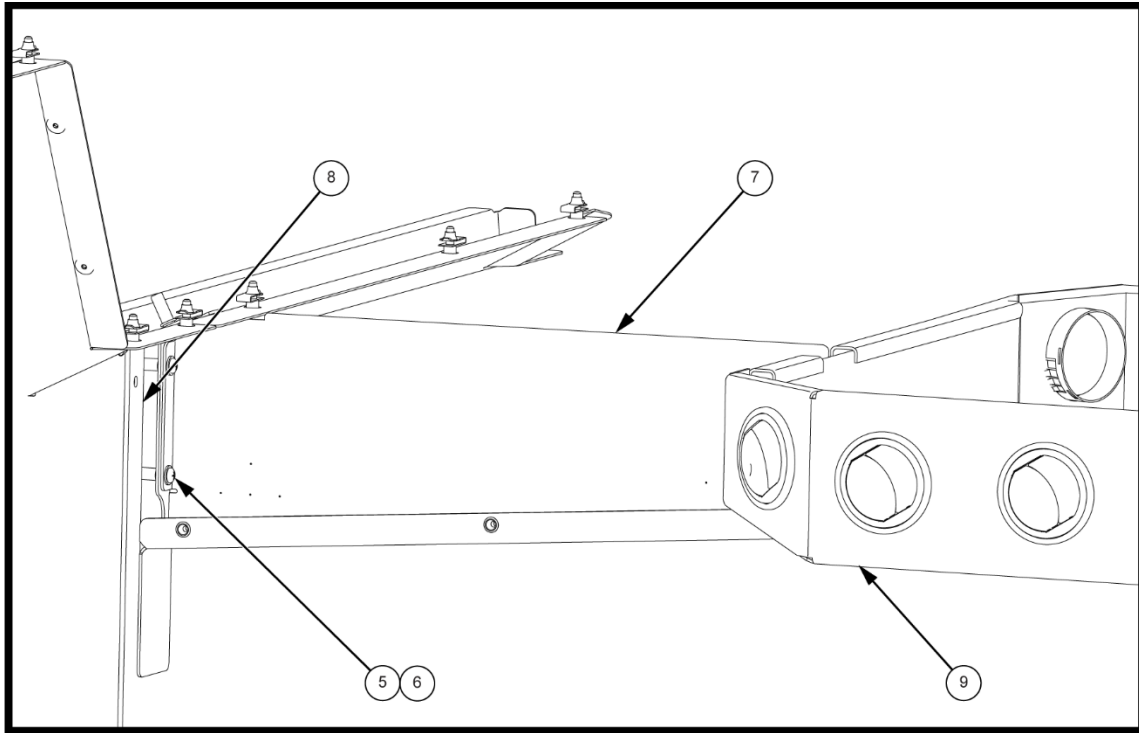
- **Air conditioning system contains R134A:**
 - **Avoid breathing refrigerant and lubricant vapor or mist;**
 - **Exposure may irritate eyes, nose and throat;**
 - **To remove R134A from air conditioning system, use equipment certified to meet SAE J2210;**
 - **If R134A discharge occurs, ventilate work area before resuming service;**
 - **Additional health and safety information may be obtained from refrigerant and lubricant manufacturers.**

1. Attach “DO NOT START” tag to vehicle ignition switch.
2. Turn battery switches OFF (if equipped) or disconnect batteries. Refer to “*Battery Connect/Disconnect*,” Group 0925-P-001.
3. Evacuate refrigerant. Refer to “*Operator’s Manual and Service Manual*.”

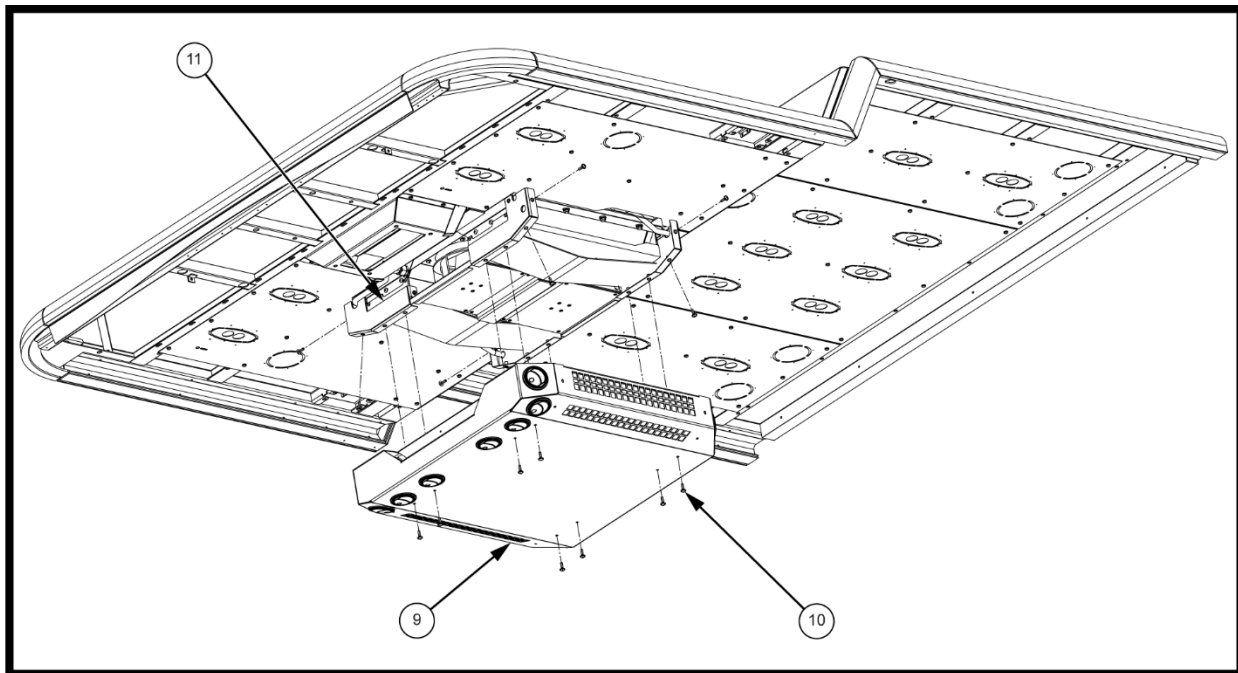


4. Remove five screws (2), washers (3), and cover (1) from cover (4).
5. Repeat step 2 for passenger side.

PARTS BULLETIN 618

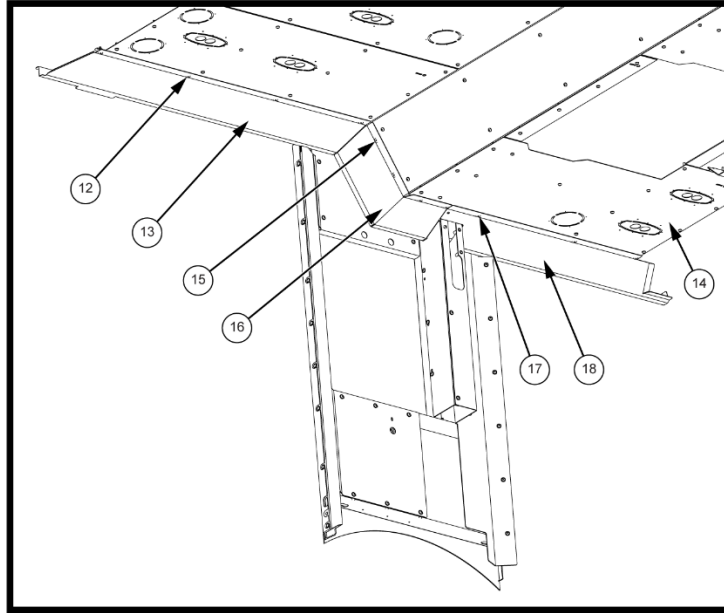


- 6. Remove three screws (5), washers (6), and cover (7) from wireway (8) and evaporator cover (9).
- 7. Repeat step 4 for passenger side.

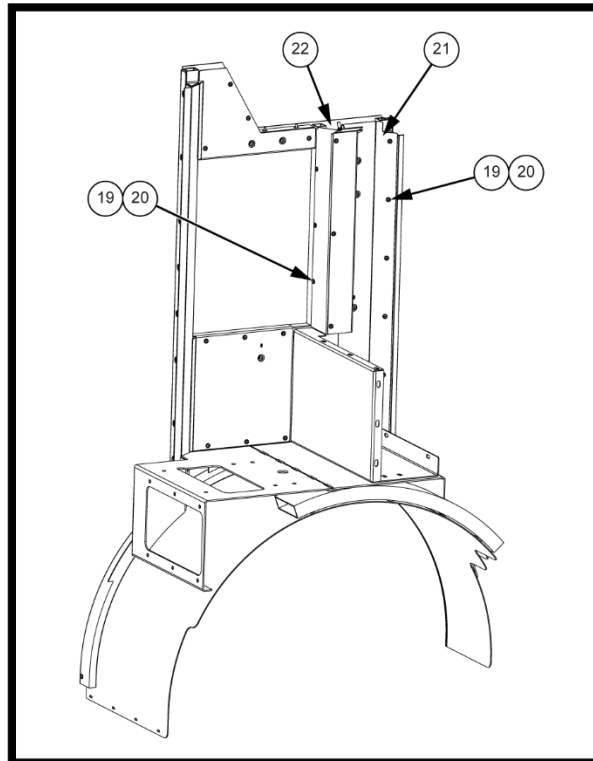


- 8. Remove 16 screws (10) and evaporator cover (9) from evaporator (11).

PARTS BULLETIN 618

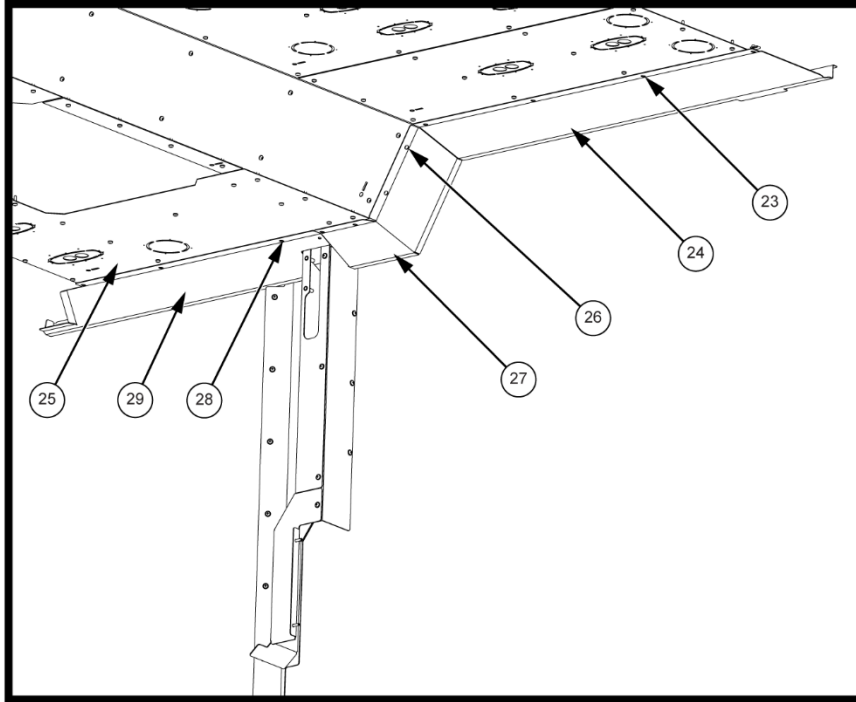


- 9. Remove four screws (12) and cover (13) from roof (14).
- 10. Remove four screws (15) and cover (16) from roof (14).
- 11. Remove three screws (17) and cover (18) from roof (14).

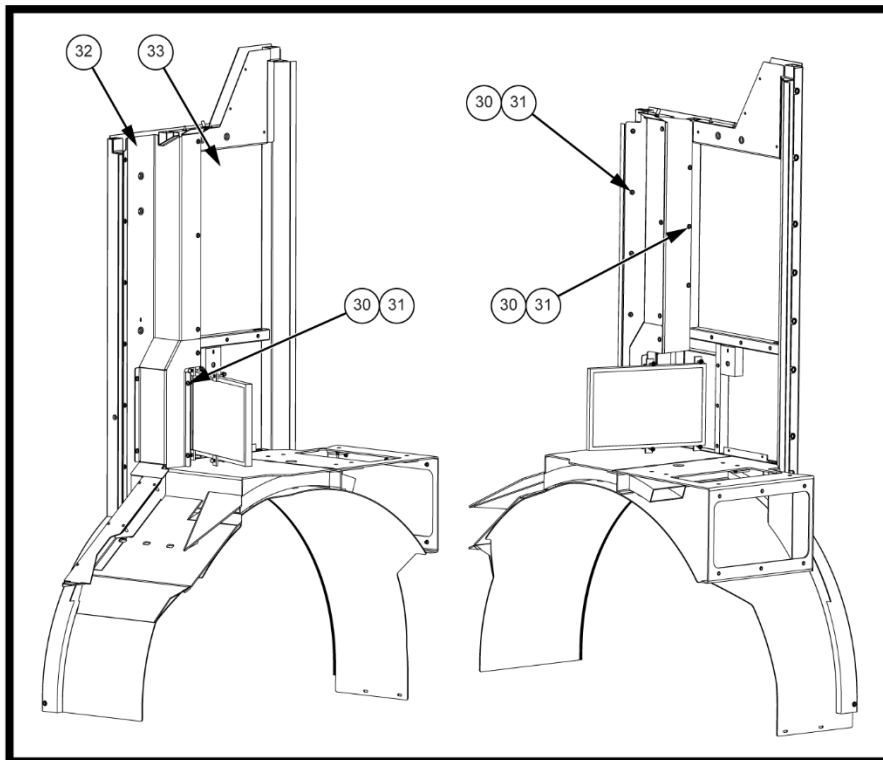


- 12. Remove nine screws (19), washers (20), and front LH wireway (21) from sidewall (22).

PARTS BULLETIN 618

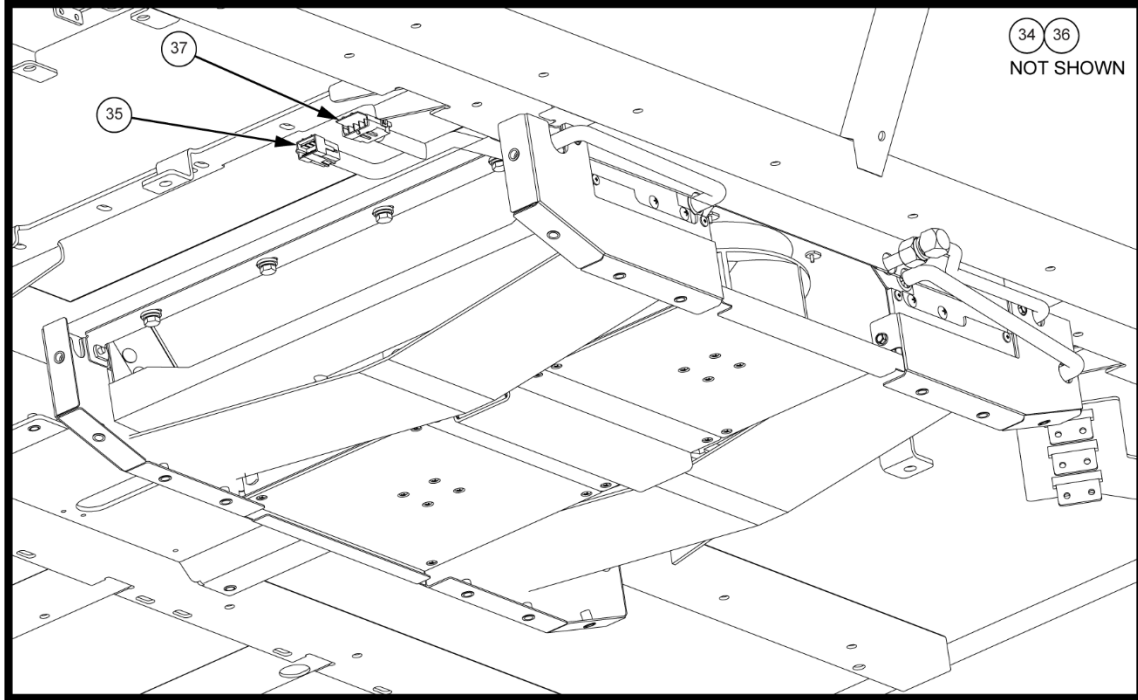


- 13. Remove four screws (23) and cover (24) from roof (25).
- 14. Remove four screws (26) and cover (27) from roof (25).
- 15. Remove three screws (28) and cover (29) from roof (25).

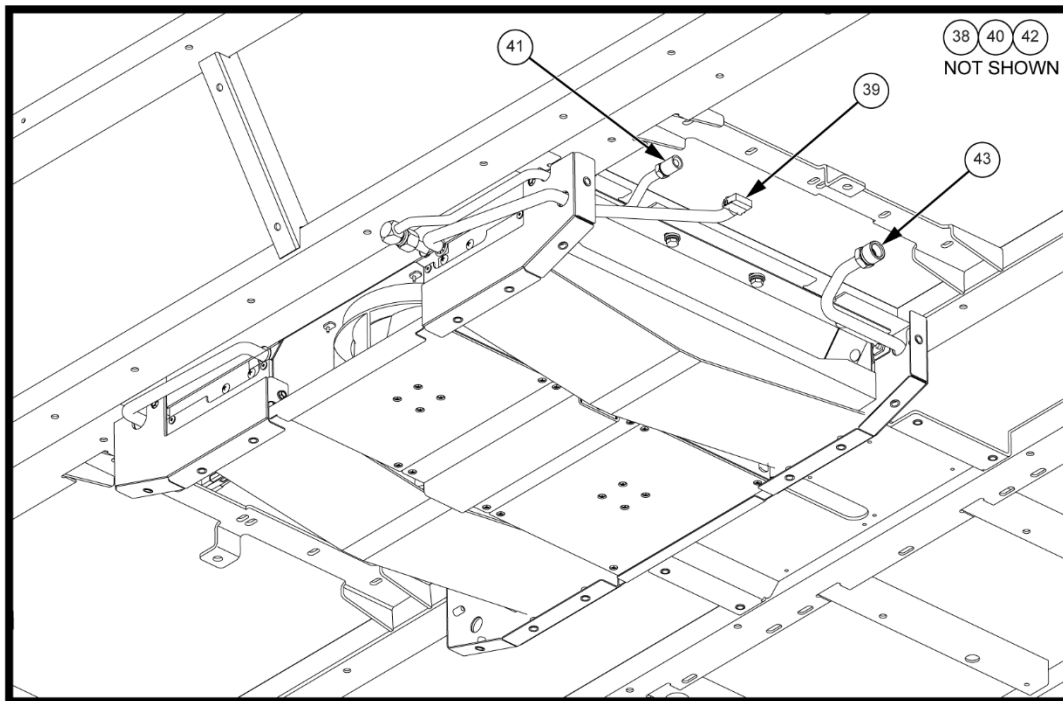


- 16. Remove eleven screws (30), washers (31), and front RH wireway (32) from sidewall (33).

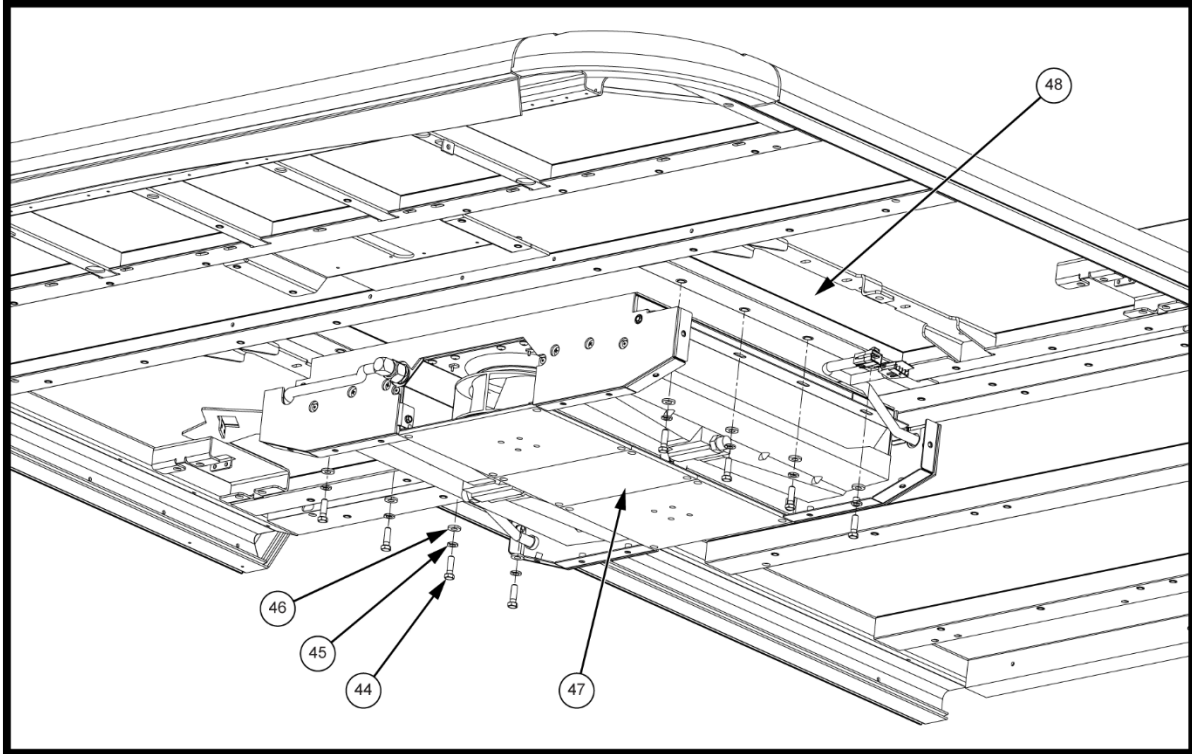
PARTS BULLETIN 618



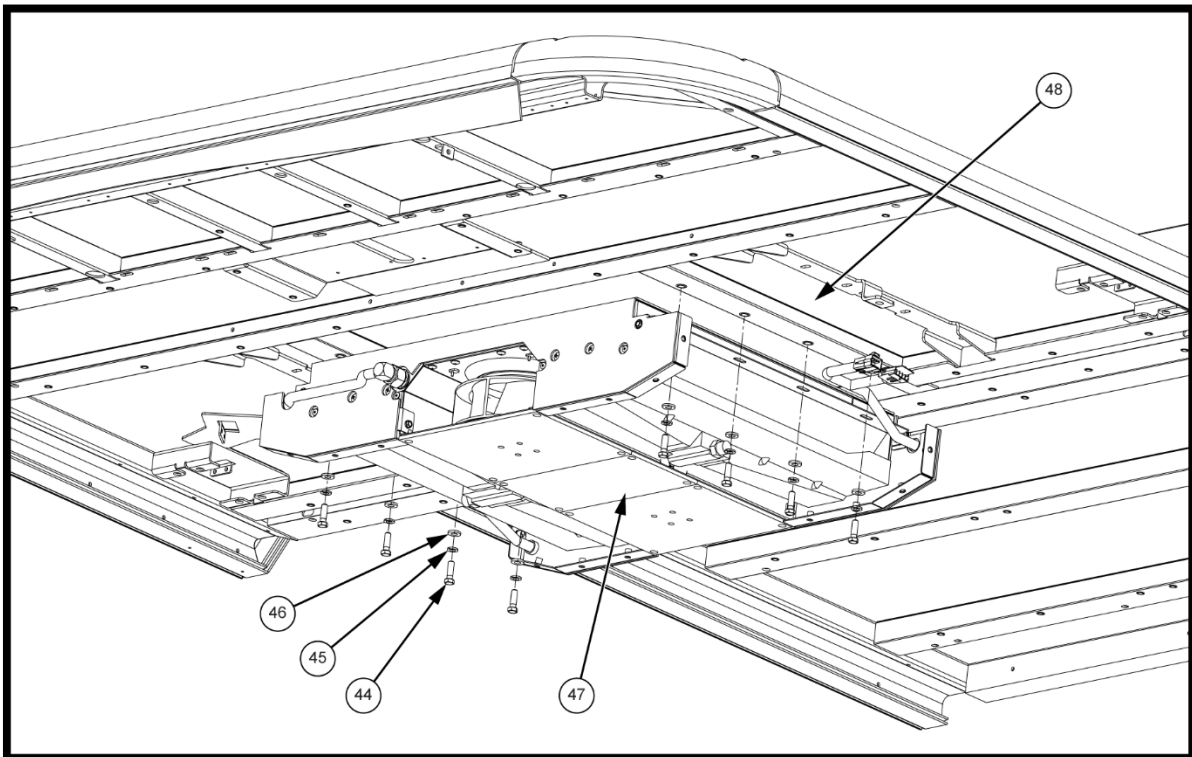
- 17. Disconnect connector (34) from connector (35).
- 18. Disconnect connector (36) from connector (37).



- 19. Disconnect connector (38) from connector (39).
- 20. Disconnect A/C line (40) from A/C line (41).
- 21. Disconnect A/C line (42) from A/C line (43).

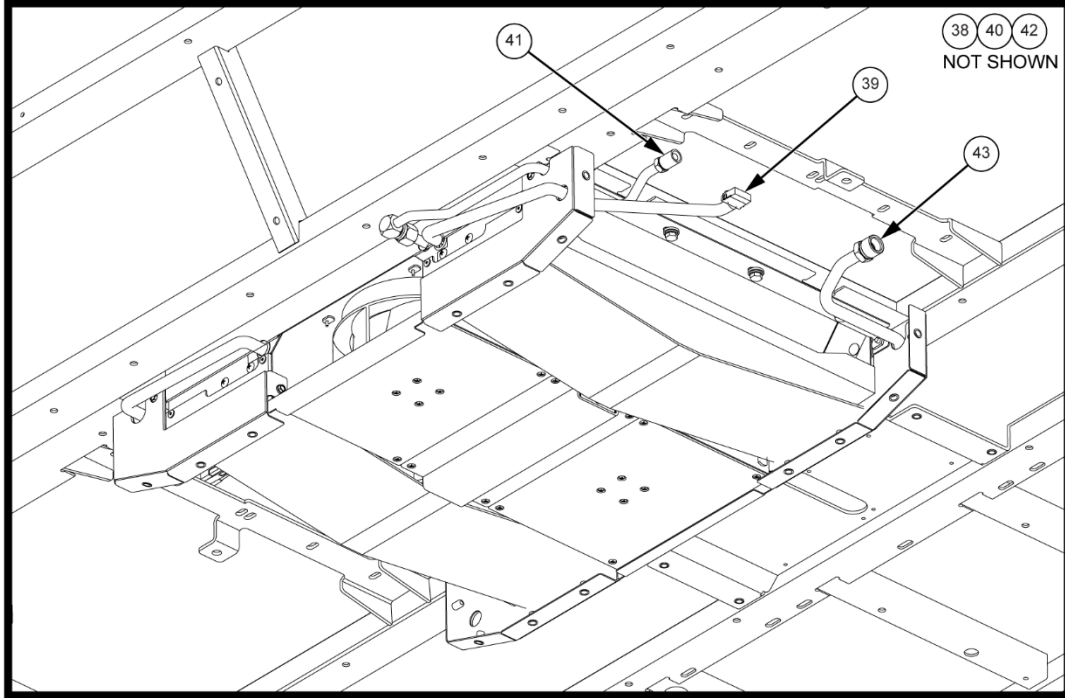


22. Remove eight screws (44), lockwashers (45), washers (46), and evaporator (47) from roof (48).

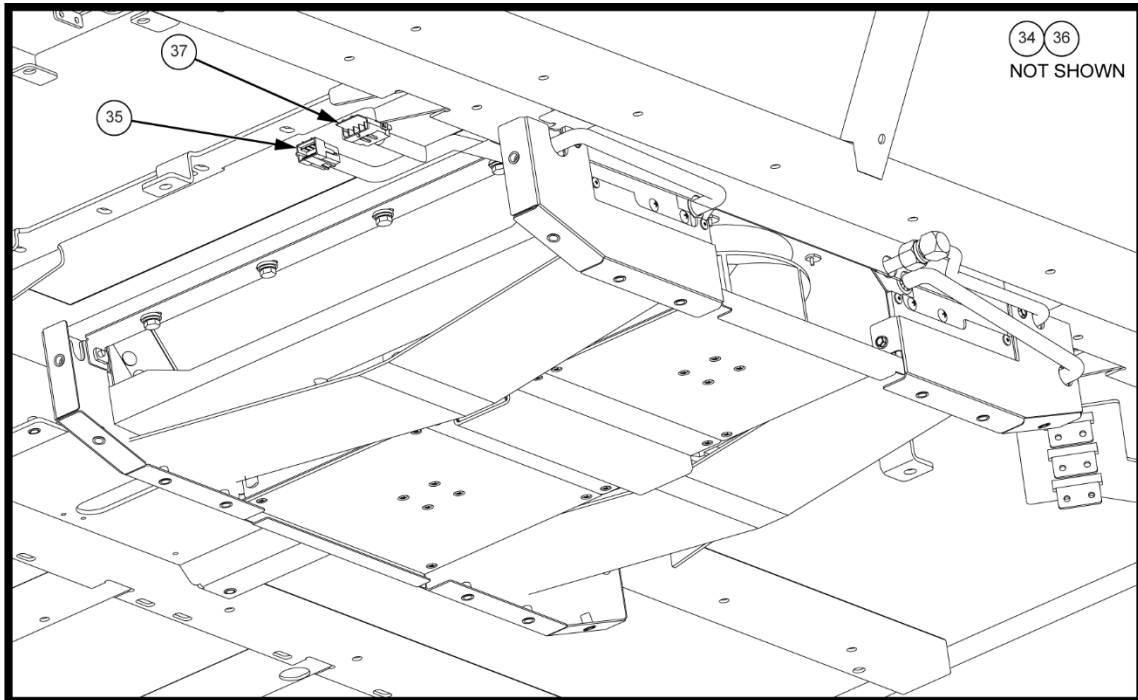


23. Install evaporator (47) (Pierce P/N 2888526) on roof (48) with eight washers (46), lockwashers (45), and screws (44).

PARTS BULLETIN 618

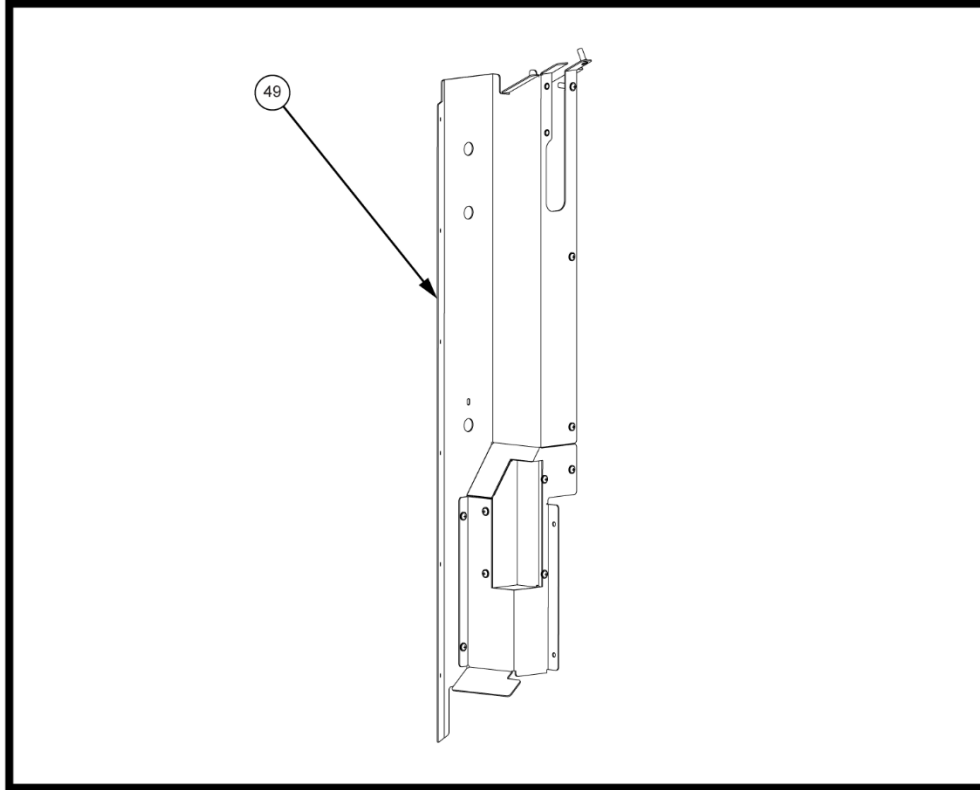


- 24. Connect A/C line (42) to A/C line (43).
- 25. Connect A/C line (40) to A/C line (41).
- 26. Connect connector (38) to connector (39).



- 27. Connect connector (36) to connector (37).
- 28. Connect connector (34) to connector (35).

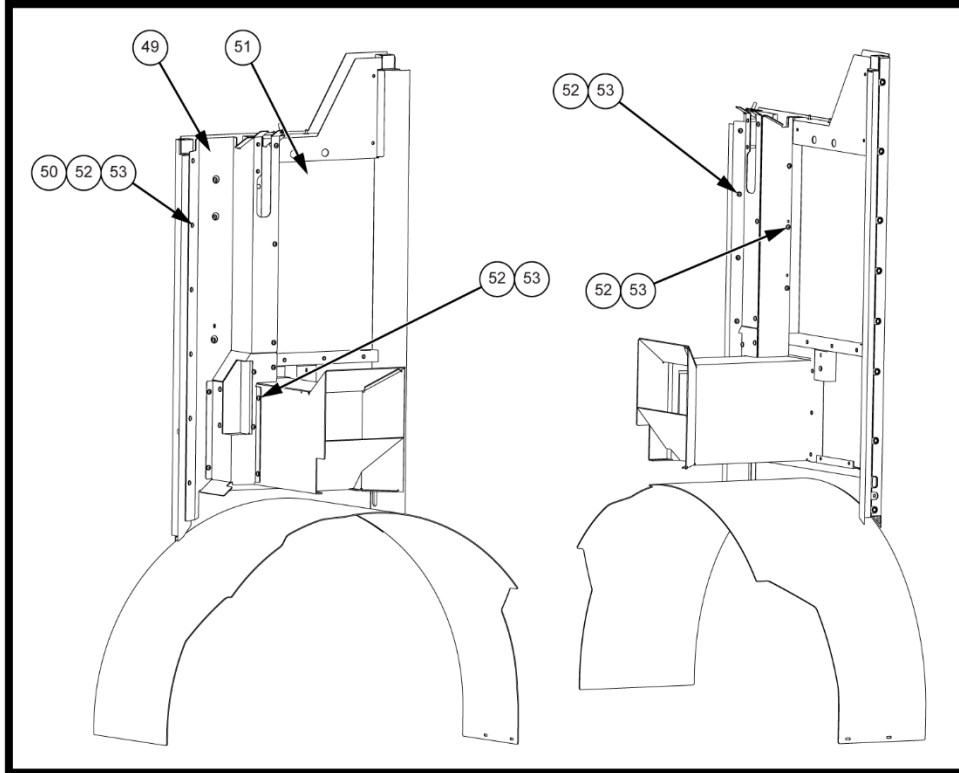
PARTS BULLETIN 618



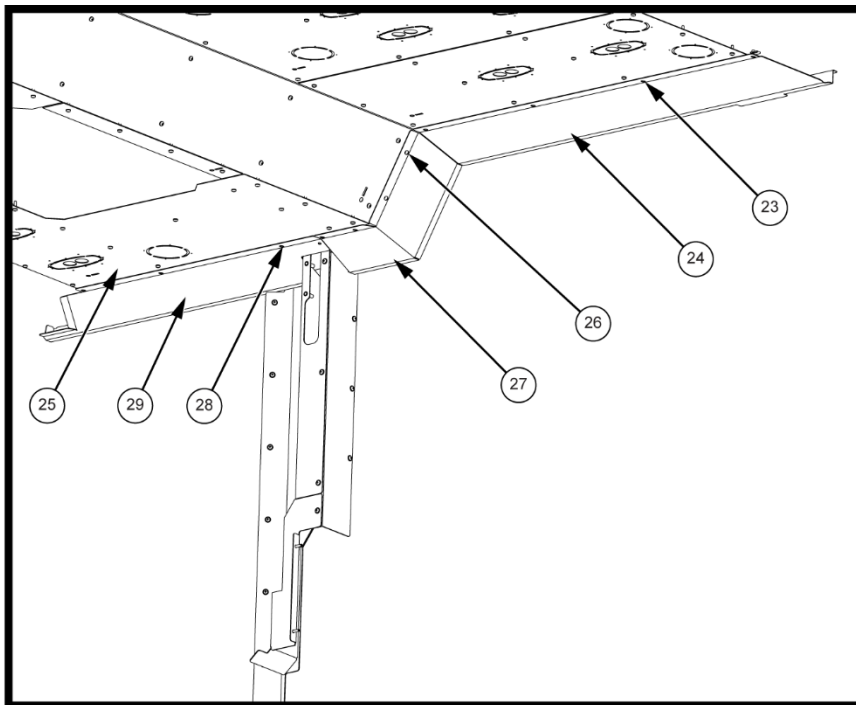
29. Assemble front RH wireway (49) with the following parts:

Quantity	Unit of Measure	Part Number	Component Description
1	EA	2841440	LINER,SIDE WALL,FRT,RH
1	EA	2044885	LINER,BACKING,SIDE WALL,RR,RH
1	EA	3180099	LINER,SIDE WALL,FRT,BOTTOM,RH
1	EA	3180252	LINER,BLISTER,BOTTOM,RH
2	EA	82-0257-0002	INSERT,THREADED,.25-20,STEEL
11	EA	1735660-0002	INSERT,THREADED,.25-20,STEEL
10	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN
10	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK

PARTS BULLETIN 618

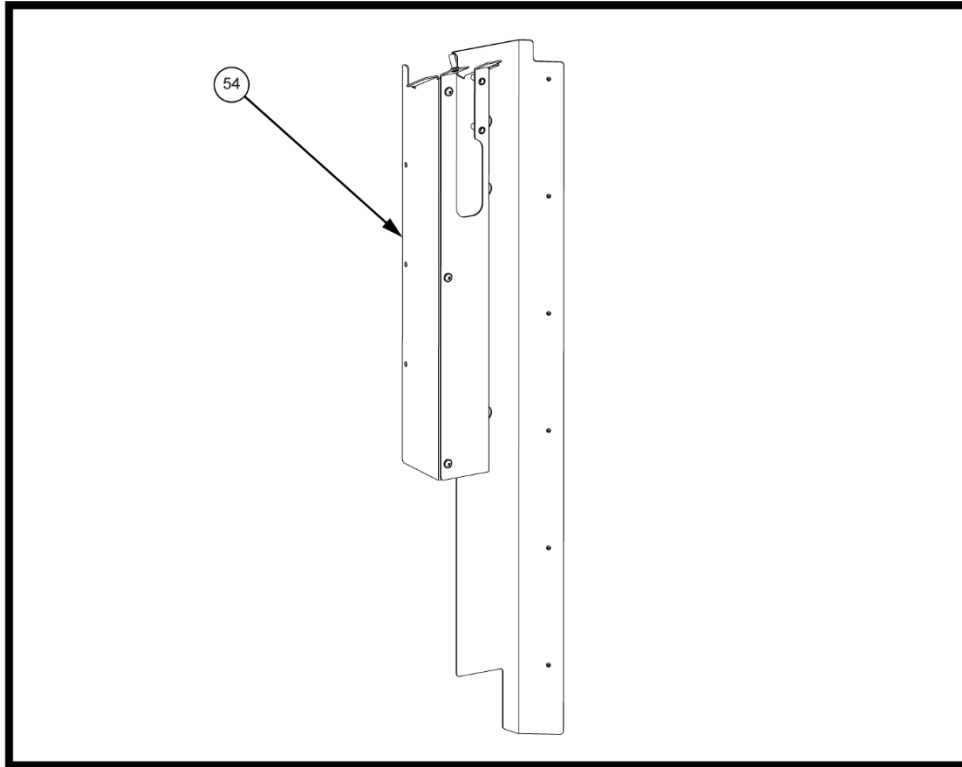


- 30. Install six cage nuts (50) (Pierce P/N 82-0386-0025) on sidewall (51).
- 31. Install front RH wireway (49) on sidewall (51) with eleven washers (52) (Pierce P/N 82-0418-0002) and screws (53) (Pierce P/N 82-0429-0100).



- 32. Install cover (29) on roof (25) with three screws (28).
- 33. Install cover (27) on roof (25) with four screws (26).
- 34. Install cover (24) on roof (25) with four screws (23).

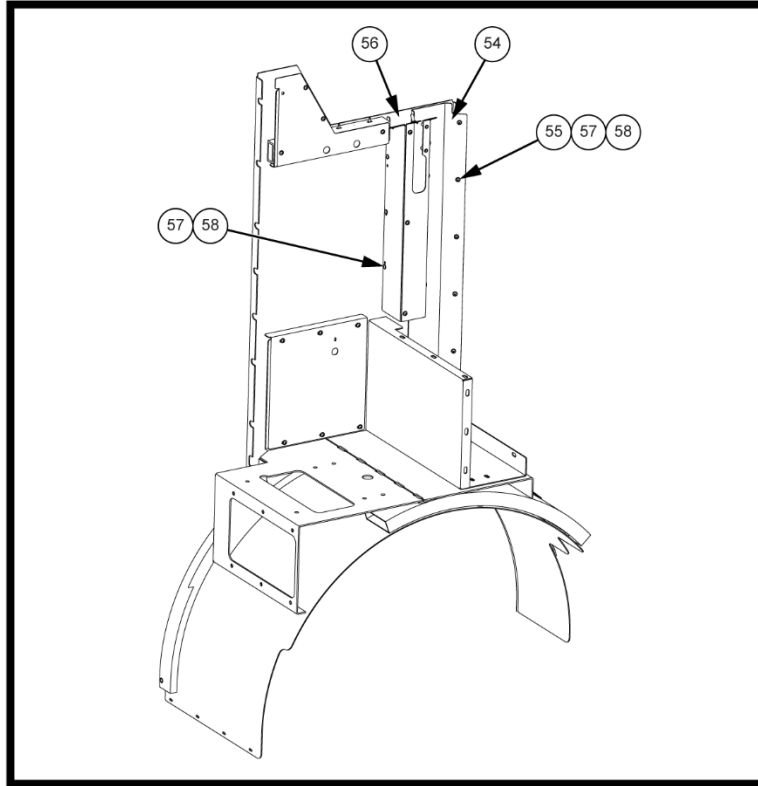
PARTS BULLETIN 618



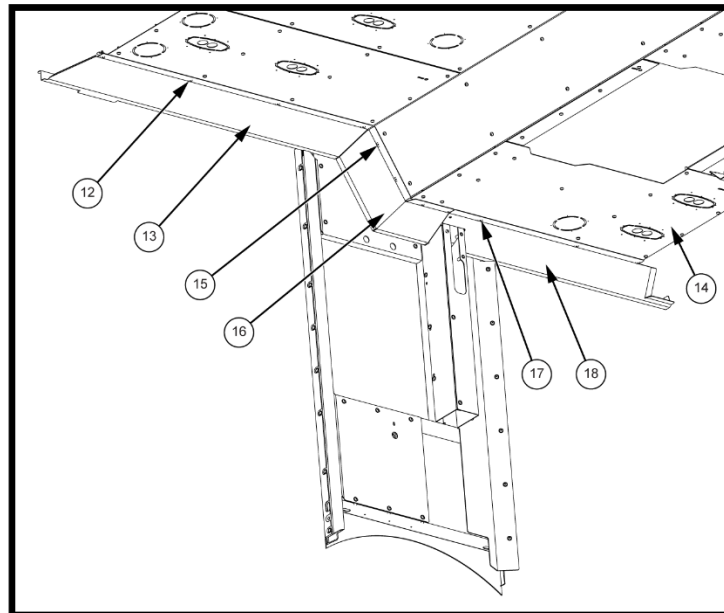
35. Assemble front LH wireway (54) with the following parts:

Quantity	Unit of Measure	Part Number	Component Description
1	EA	2044876	LINER,BACKING,SIDE WALL,RR,LH
1	EA	2841118	LINER,SIDE WALL,FRT,LH
6	EA	1735660-0002	INSERT,THREADED,.25-20,STEEL
3	EA	82-0429-0100	SCREW,.25-20,PH PAN HD,BLKZN
3	EA	82-0418-0002	WASHER,FLAT,NYLON,MOLDED BLACK

PARTS BULLETIN 618

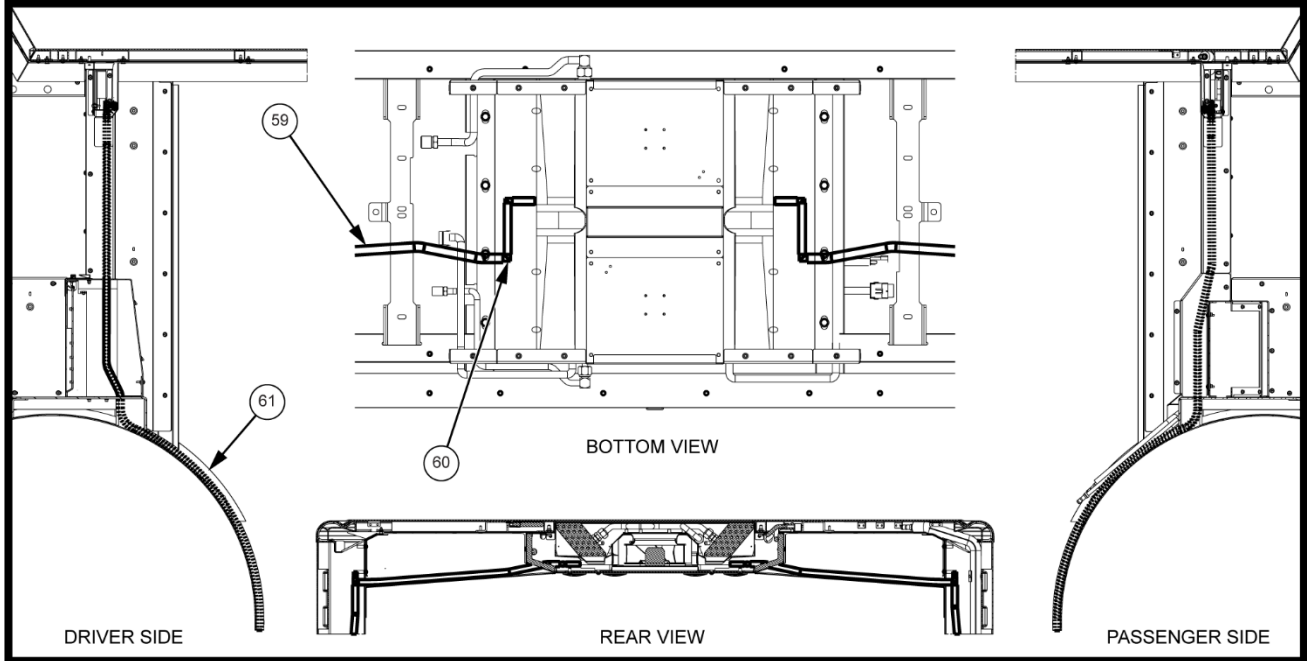


- 36. Install six cage nuts (55) (Pierce P/N 82-0386-0025) on sidewall (56).
- 37. Install front LH wireway (54) on sidewall (56) with nine washers (57) (Pierce P/N 82-0418-0002) and screws (58) (Pierce P/N 82-0429-0100).



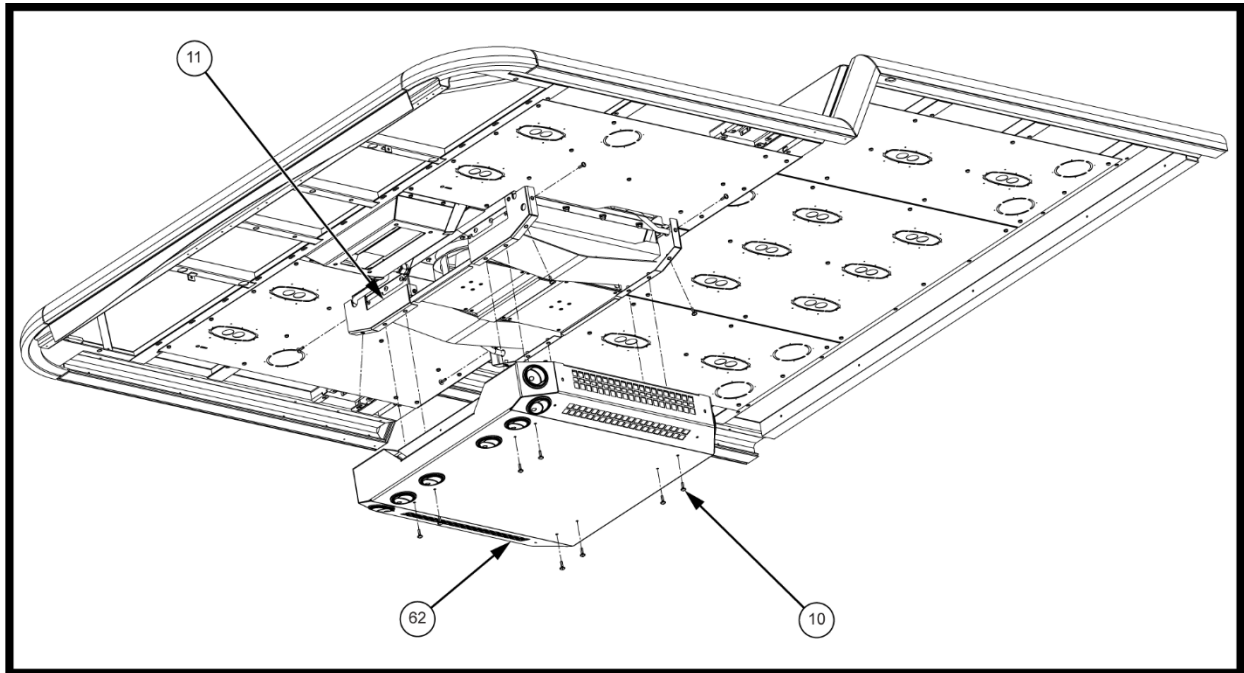
- 38. Install cover (18) on roof (14) with three screws (17).
- 39. Install cover (16) on roof (14) with four screws (15).
- 40. Install cover (13) on roof (14) with four screws (12).

PARTS BULLETIN 618



NOTE: When routing drain lines, ensure continuous downward slope with no rise blocking drainage. Once proper slope is achieved, cut drain lines flush with bottom of wheelwell on both sides.

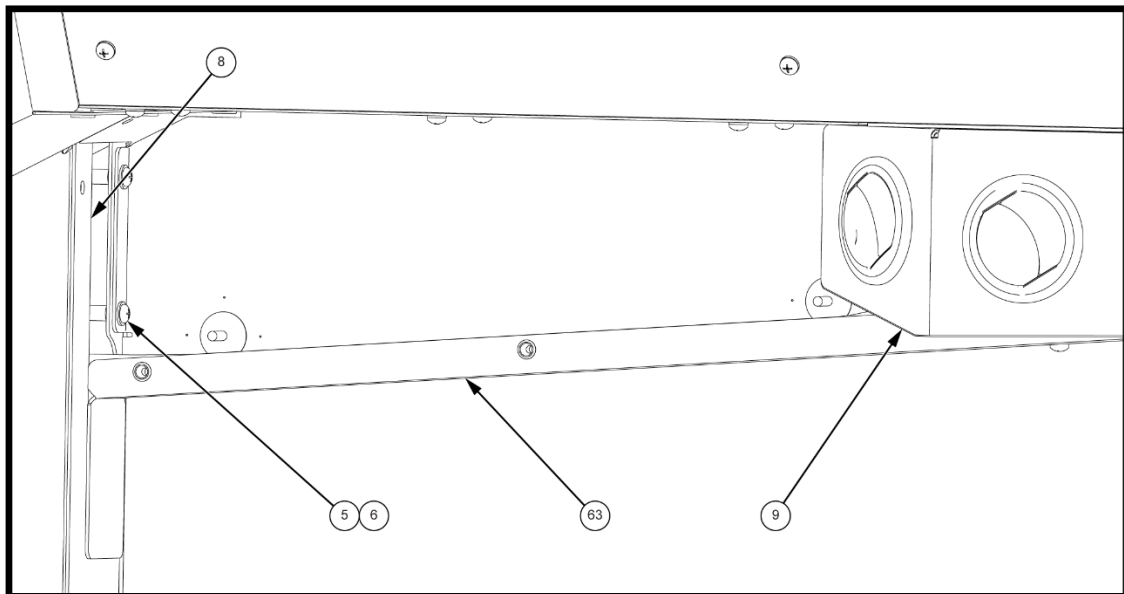
- 41. Cut hose (59) (Pierce P/N 2504490) to length and install on two fittings (60) (Pierce P/N 59-0793) as needed and route on driver side and passenger side as shown.
- 42. Cut hose (59) flush with bottom of wheelwell (61).



42. Assemble evaporator cover (62) with the following parts:

Quantity	Unit of Measure	Part Number	Component Description
1	EA	2087909	DIVERTER ASSY, EVAP COVER, AC
1	EA	2076675	KIT, INSULATION, EVAP COVER
1	EA	2845733	COVER, EVAPORATOR, WLDMT
2	EA	2515854	FILTER, AIR INTAKE, EVAPORATOR

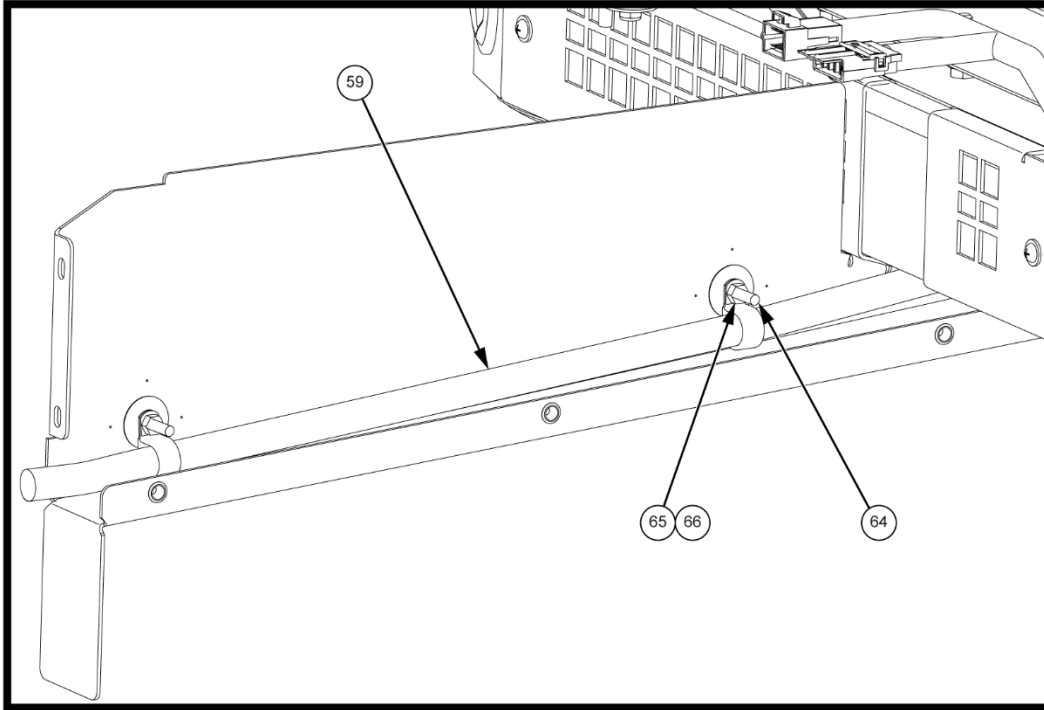
43. Install evaporator cover (62) on evaporator (11) with 16 screws (10).



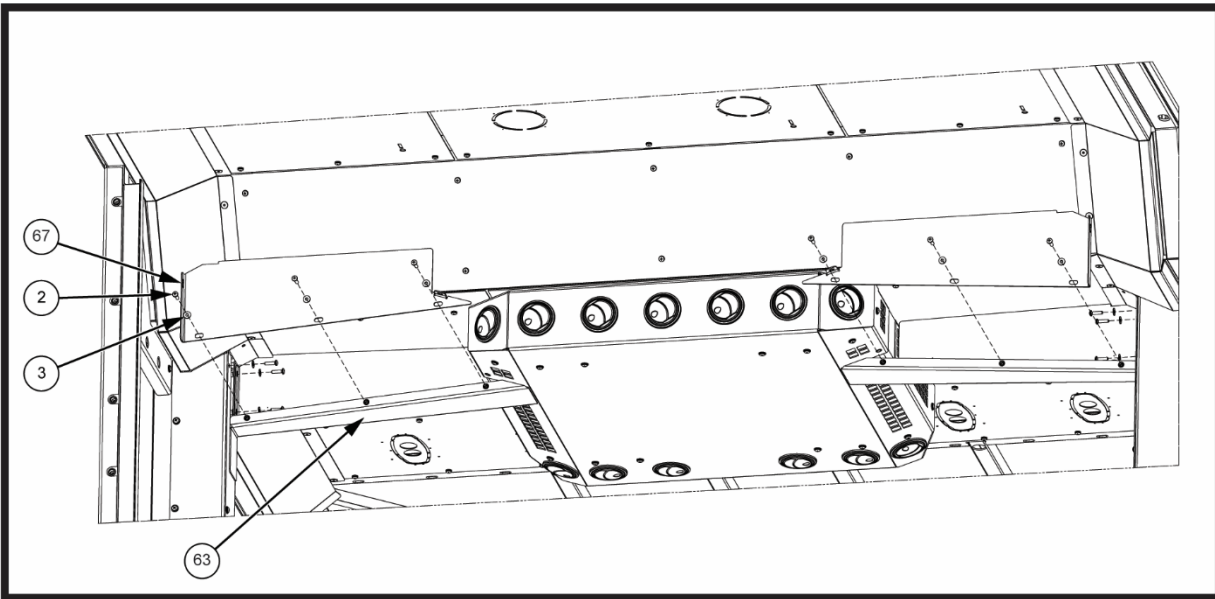
44. Install cover (63) (Pierce P/N 2845421) on wireway (8) and evaporator cover (9) with three washers (6) and screws (5).

45. Repeat step 44 for passenger side (Pierce P/N 2845423).

PARTS BULLETIN 618



- 46. Install hose (59) on two studs (64) with two cushion clips (65) and nuts (66).
- 47. Repeat step 46 for passenger side.



- 48. Install cover (67) (Pierce P/N 2846480) on cover (63) with five washers (3) and screws (2).
- 49. Repeat step 48 for passenger side (Pierce P/N 2846479).

 **WARNING**

- Use only refrigerants approved by Pierce Manufacturing for your air conditioning system. Some unapproved refrigerants are flammable and can explode, causing injury to personnel. Other unapproved refrigerant can cause the system to fail, requiring costly repairs.
- The air conditioning system contains refrigerant under high pressure. To avoid risk of personal injury or damage to the system, adding refrigerant or any repair requiring lines to be disconnected should be done by a certified repairman.

 **CAUTION**

- Air conditioning system contains R134A:
 - Avoid breathing refrigerant and lubricant vapor or mist;
 - Exposure may irritate eyes, nose and throat;
 - To remove R134A from air conditioning system, use equipment certified to meet SAE J2210;
 - If R134A discharge occurs, ventilate work area before resuming service;
 - Additional health and safety information may be obtained from refrigerant and lubricant manufacturers.

NOTE: Do not add refrigerant unless the system is checked for leaks and any leaks found are repaired.

50. Charge refrigerant. Refer to “*Operator’s Manual and Service Manual.*”

51. Turn battery switches ON (if equipped) or connect batteries. Refer to “*Battery Connect/Disconnect,*” Group 0925-P-001.

52. Remove “DO NOT START” tag from vehicle ignition switch.

If any additional support is needed, please open a technical support incident on Pierceparts.com.