



# Service Bulletin

Bulletin No.: 23-NA-186

Date: February, 2024

## INFORMATION

**Subject:** Information on Gas Vacuum Pump Replacement Part Update

Brand:	Model:	Model Year:		VIN:		Engine:	Transmission:
		from	to	from	to		
Chevrolet	Medium Duty LCF 3500, 4500	2016	2023			6.0L, 6.6L	
	Low Cab Forward 3500 HG, 4500 HG, 5500 HG and 5500 XG	2024	2024				

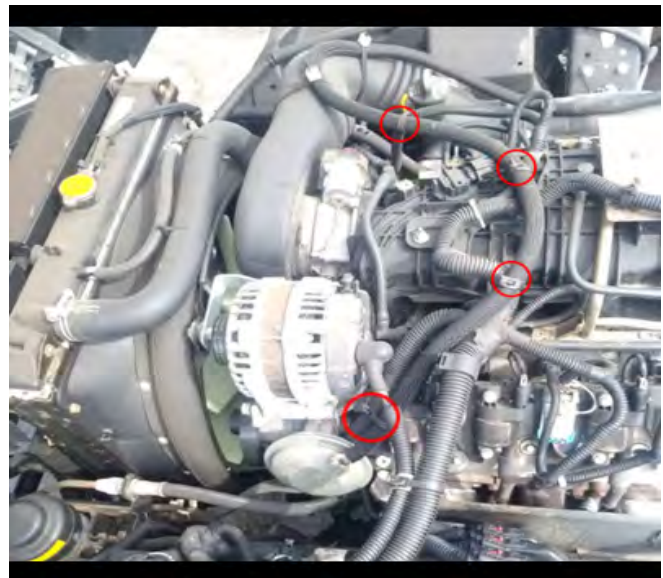
<b>Involved Region or Country</b>	North America
<b>Information</b>	<p>The vacuum pump service part for affected vehicles listed in this bulletin has been superseded and is now the same vacuum pump that is the service part for the 6.6L gas engine. The updated pump requires the outlet vacuum hose to be rerouted for proper fitment. Follow the service procedure below to install the updated replacement vacuum pump and reroute the outlet vacuum hose as set forth below.</p> <p>In order to improve the supply of these parts it has been decided to revert to making vacuum pumps available individually rather than in kits.</p> <p><b>Important:</b> It is essential that the correct pulley for the application is used. Refer to the Parts Information section.</p>

**Important:** Service agents must comply with all International, Federal, State, Provincial, and/or Local laws applicable to the activities it performs under this bulletin, including but not limited to handling, deploying, preparing, classifying, packaging, marking, labeling, and shipping dangerous goods. In the event of a conflict between the procedures set forth in this bulletin and the laws that apply to your dealership, you must follow those applicable laws.

### Service Procedure

1. Remove the drive belt from the drive pulley. Refer to *Drive Belt Replacement in SI* or *Accessory Drive Primary Belt Replacement in SI*.
2. Remove the two (2) vacuum hoses (inlet and outlet) from the vacuum pump.

**Note:** Zip tie locations for removal may vary according to model year.



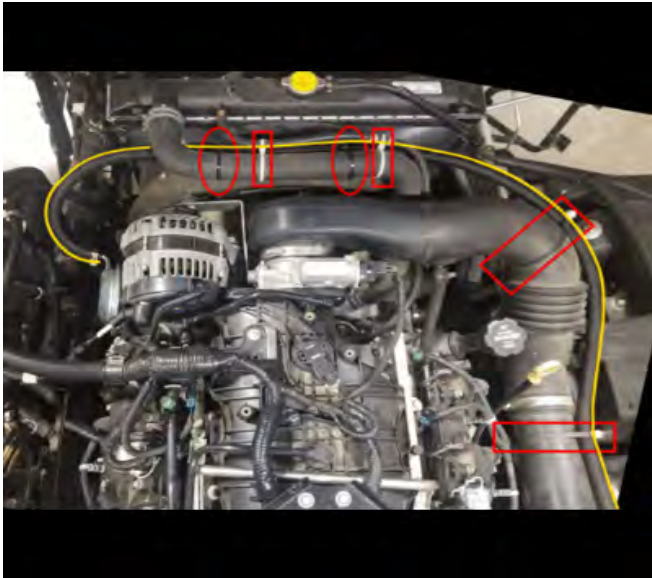
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3. Remove zip ties holding the upper vacuum line from the vacuum pump back to the curve of the Air Inlet Duct. (See Figure 1.)
4. Working through the pulley access holes, remove the three (3) vacuum pump mounting bolts. Save these bolts for reassembly.

5. Remove the vacuum pump from the accessory bracket.
6. Install a new vacuum pump pulley onto the replacement vacuum pump using special tool EN-49756 Vacuum Pump Pulley Installer.

**Note:** Pump damage may occur if proper installation procedures are not followed.

7. Ensure that the mounting surface of the engine is clean and free of debris.
8. Install the pump onto the engine and working through the access holes in the pulley, install the three mounting bolts.  
⇒ Tightening torque: 25 N·m (18 lb·ft)
9. Connect the inlet vacuum line onto the vacuum pump inlet fitting.



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10. Reroute the outlet vacuum hose along the inlet air duct, in front of the upper radiator hose, attaching the line to the hose with two (2) zip ties as shown in the graphic above. Complete the routing by connecting the end of the vacuum hose to the vacuum pump outlet fitting.
11. Install the drive belt on the drive pulley. Refer to *Drive Belt Replacement in SI* or *Accessory Drive Primary Belt Replacement in SI*.

## Parts Information

**Note:** Only select the parts that coincide with the repair performed. Replace the part with the P/N outlined in the Electronic Parts Catalog (EPC) in accordance with the vehicle VIN.

Causal Part	Description	Part Number	Pulley Part Number	Qty
N/A	PUMP, VAC	97656980	97542180 (6.0L)	1
			97657703 (6.6L)	1
N/A	CLIP, BAND (ZIP TIE)	98250712	—	As Required

**Note:** If you have a vehicle that has an additional drive belt due to an uplift such as a sweeper application, and therefore does not have clearance for the tapered design pulley, please contact Partech for part number information.

Version	1
Modified	Released February 20, 2024

