

Fuel Tank Strap Top Bolt, Tightening VN, VHD,VT, VAH

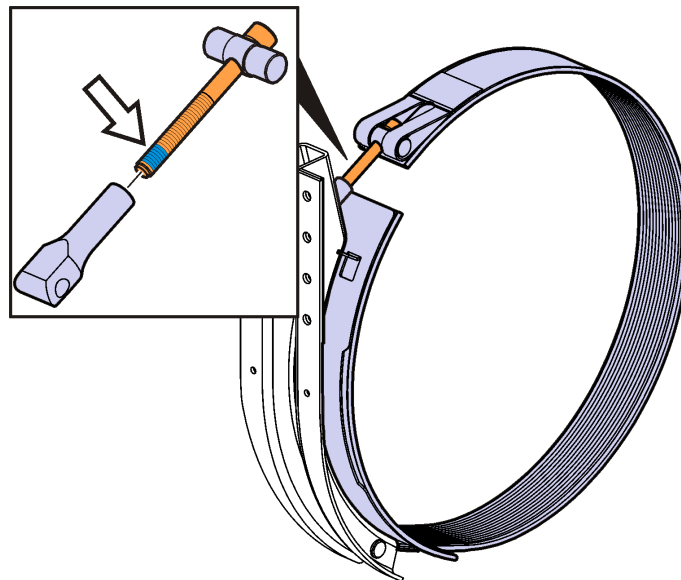
FSB 234-015, Fuel Tank Strap Top Bolt, Tightening

(January 2012)

VOLVO Trucks is introducing new fuel tank strap top bolt tightening procedures for VN, VHD, VT and VAH truck models. Over-tightening the tank strap top bolts may cause the D-shaped and round fuel tanks to collapse. To prevent this condition, all top tightening fuel tank strap top bolts have patch lock applied to address the concern of low strap torque. Blue patch lock may be visible where the bolt enters the "T" fitting. Re-torque or checking of torque will be inaccurate and interfere with the operation of the patch lock. The new bolt, part number 995673 (with blue patch lock) replaces the old bolt part number 995253.

Note: The new bolt must be used in combination with new T-slug (21589047), which replaces existing T-slug (21500314). A new bolt (995673) and new T-slug (21589047) must be installed any time the new bolt (995673) is removed or patch lock is broken free.

Note: Fuel tank straps do not require re-torquing or checking of torque on trucks built after January 11, 2011.



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Strap Installation and Handling

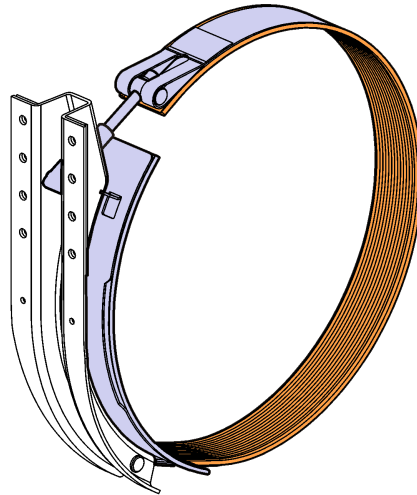
Kinking or bending of the fuel tank strap should be avoided during assembly.

Service personnel: Please circulate, read and initial

Service Manager	Warranty Administrator	Workshop Foreman	Service Technicians						

Tank Preparation

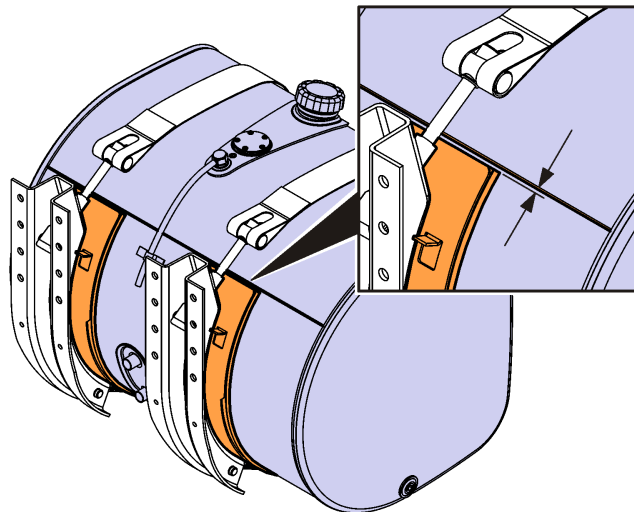
Before mounting the fuel tank, apply a thin film of soap-water solution to the rubber surface of the mounting strap assembly that contacts the fuel tank. The soap-water solution will prevent kinking or bending of the tank strap and damage to fuel tank when tightening the tank strap top bolt.



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Tank Orientation (D-Shaped Tank Shown for Reference Only)

Locate the longitudinal weld of the round or D-shaped tank casing no more than 10 mm (.39 in) above the top of the bearing plate as shown in the figure below.



W2070223

Fuel Tank Strap Top Bolt Torque Sequence (D-Shaped Tanks Shown for Reference)

Tighten the fuel tank strap top bolts in sequence as shown in figure below. The same torque sequences apply to the D-shaped and round tanks.

Note: To prevent crushing the fuel tank, do not tighten fuel tank straps to specification during the initial torque sequence. The initial torque values for the fuel tank straps are 51 ± 7 Nm (38 ± 5 ft-lb) for round tanks and 98 ± 7 Nm (72 ± 5 ft-lb) for D-shaped fuel tanks. Following the initial torque sequence, tighten the fuel tank straps to the final torque specification shown below.

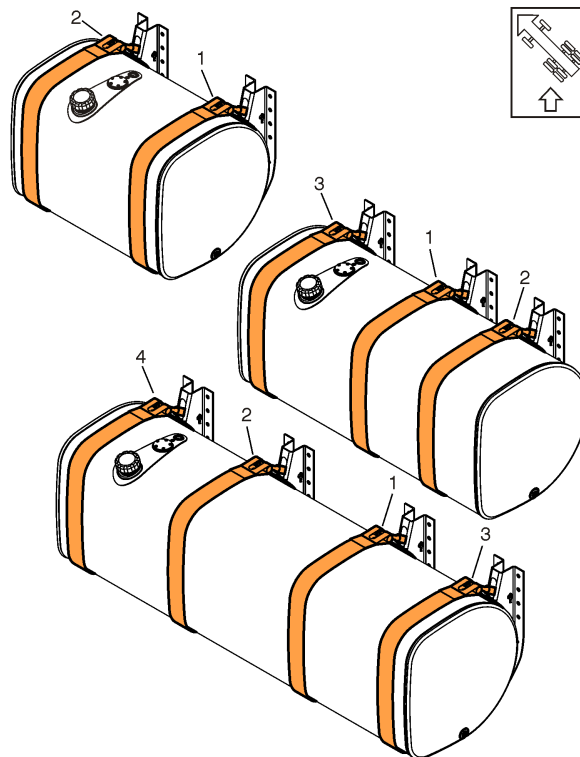
Note: When tightening two or three strap assemblies, tighten fuel tank strap number 1 to the initial torque value, followed by strap number 2, and strap number 3. Then re-tighten the fuel tank straps in sequence to specification as shown below.

Note: When tightening four fuel tank strap assemblies, tighten fuel tank strap number 1 to the initial torque value, followed by tank strap number 2, 3, and 4. Then re-tighten the fuel tank straps in sequence to the final torque specification shown below.

Fuel Tank Strap Top Bolt Final Torque Specifications

Tighten round fuel tank strap top bolts to 75 ± 7 Nm (55 ± 5 ft-lb)

Tighten D-shaped fuel tank strap top bolts to 110 ± 7 Nm (80 ± 5 ft-lb)



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