



Ford 6.8L Exhaust Manifold Studs

Propane Service Notice #17-01-PP



Broken Exhaust Manifold Studs

New York Bus Sales has been seeing some exhaust manifold studs breaking (generally at the rear of the manifolds) on the Ford 6.8L engines. This was an issue with some of the earlier units. After working with Ford, Blue Bird implemented a Service Information Letter, SI 35-300-136 (attached). Measurements of the Y-pipe installation, torque specs and torquing sequences were to be taken. This would ensure it was aligned properly and not add undue stress on the rear manifold bolts. It is thought that if this repair had not been done soon enough that studs were already partially fractured and we are seeing those studs breaking now.

PLEASE NOTE- We have contacted DOT and a cracked manifold stud is not a failure unless it causes an exhaust leak.

At your earliest convenience, please schedule ALL units which have broken studs through our shops for repair. This repair does take some time as ALL studs are replaced with stainless steel on whichever side has a broken stud. If you have a unit where the manifold is leaking, we will of course make it a priority. New York Bus Sales appreciates your patience as we work on this issue.

ALL of our Service Updates can be found on the [New York Bus Sales website](#)
Or at the [New York Head Mechanic website](#)



SI 35-300-136 Vision Propane 6.8L Y-Pipe/Catalyst Inspection

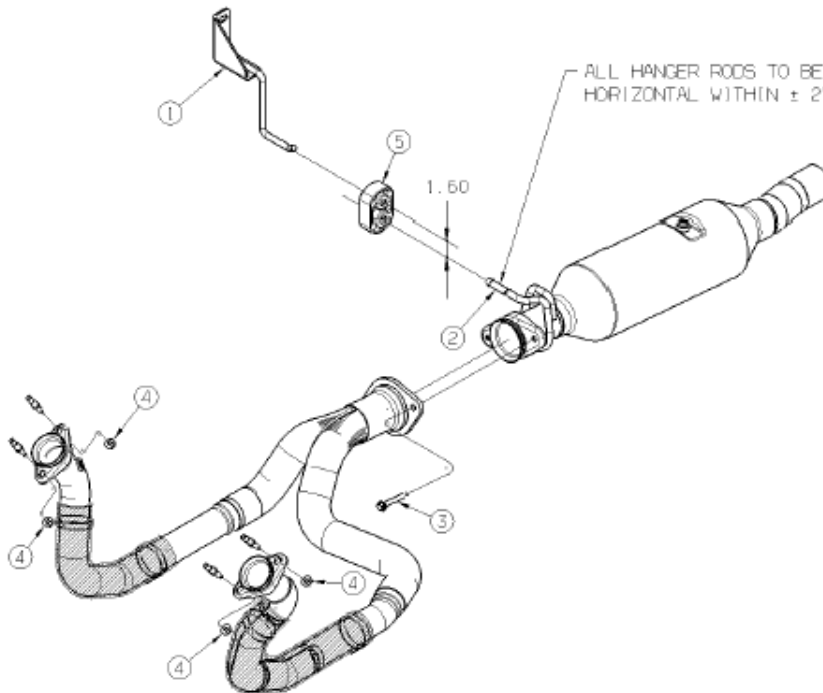
WARNING: Always follow all Federal, State, Local and Shop safety standards and use proper safety equipment when performing these procedures. Observe all safety precautions to secure the bus from rolling. Allow the exhaust to cool before inspection.

Note: Warranty claims for repairs made during the vehicle warranty period shall be submitted using component '35-300-136', cause 'Misaligned/Not Aligned', and only one of the 2 following corrective actions: 1) 'Inspect', if no defect is found or 2) 'Adjust' if making adjustments and/or replacing isolator.

To insure proper installation position of the 6.8L Y-Pipe and Catalyst, perform the following inspection.

Measure from the center rod of the exhaust mount bracket assembly (Item 1) to the center rod of the catalyst muffler (item 2). The dimension should be $1.60 \pm .125$

If the measurement is not $1.60 \pm .125$, support the catalyst muffler (item 2), loosen the collectors and manifold flanges fasteners (items 3 & 4) and raise or lower the catalyst muffler as necessary to obtain the $1.6 \pm .125$ dimension. Re-tighten and torque flanges and collector fasteners per torque sequence 1 and 2, then install new isolator 10034251 (item 5).



S E R V I C E I N S T R U C T I O N





SI 35-300-136

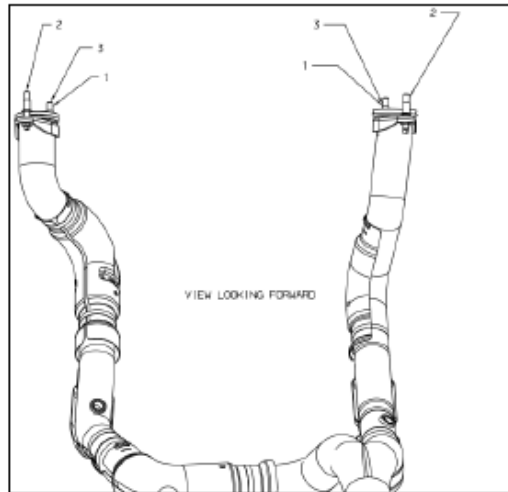
Vision Propane 6.8L

Y-Pipe/Catalyst Inspection

Torque Sequence 1

Perform the tightening sequence on the left and right pipes simultaneously as shown below

1. Run down until the loose flange seats
2. Run down to full torque (29 +/- 5 FT-LBS)
3. Tighten to full torque (29 +/- 5 FT-LBS)

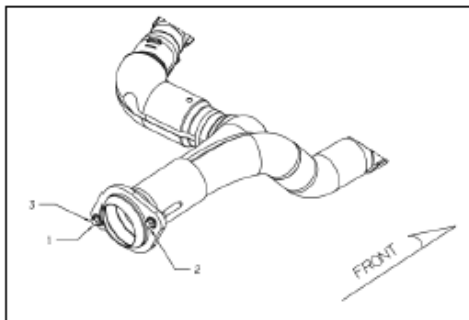


Torque Sequence 1

Torque Sequence 2

Perform the tightening sequence below

1. Run down until the loose flange seats
2. Run down to full torque (29 +/- 5 FT-LBS)
3. Tighten to full torque (29 +/- 5 FT-LBS)



Torque Sequence 2

S E R V I C E I N S T R U C T I O N

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