

# Service Letter

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**Bulletin:** 40002  
**Date:** 18 February 2009 Revised (10-12)  
**Product:** Compressors  
**Subject:** 7/20 New exhaust design

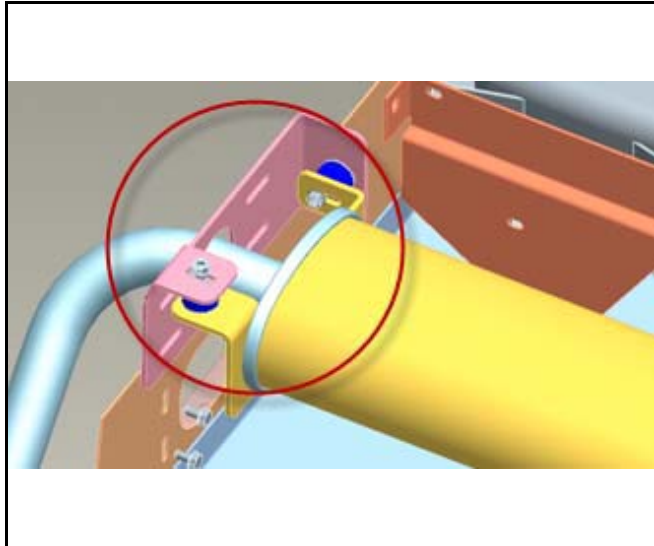
## MODELS AFFECTED BY THIS FIELD MODIFICATION CAMPAIGN:

MODELS	SERIAL NUMBER
7/20	120001 → March 2009
P65	120001 → March 2009

## LIMITATIONS:

Units produced prior to 03/2004 do not have the cooler wall bracket and rubber dampers needed to mount this silencer. [Figure 1]

Figure 1



These machines will therefore have to be fitted with those components to allow new silencer install. Instruction can be found in this TSB.

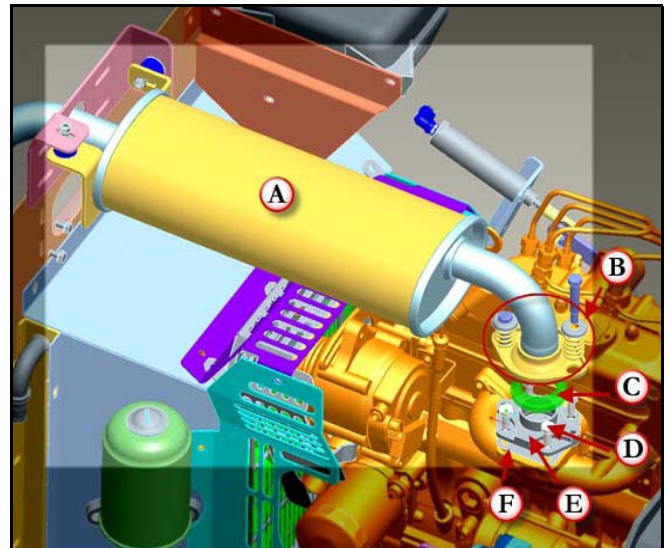
## DESIGN CHANGE:

The standard silencer will be replaced by one with a spring tension clamping system on the engine exhaust header.

While effectively sealing the flange connection it will still allow for a certain amount of movement between engine and silencer.

This flexibility will allow the exhaust to remain rigid while engine assembly vibrates.

Figure 2



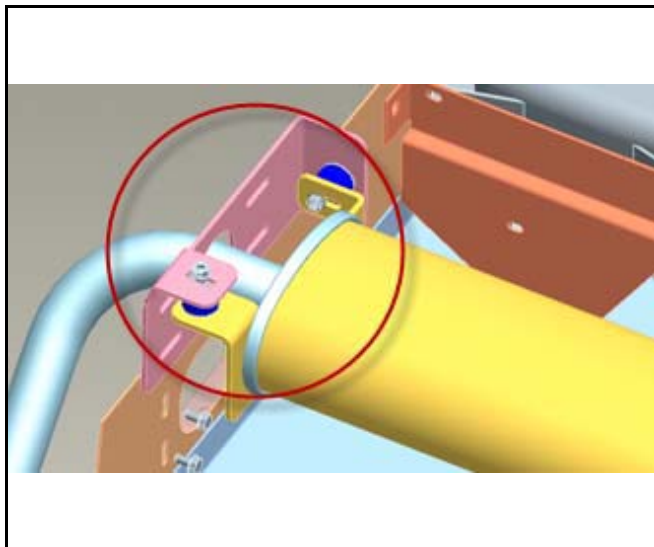
## RETROFIT KIT COMPONENTS: [Figure 2]

### Parts

COMPLETE MUFFLER INSTALL KIT 22512917			
QTY.	P/N	DESCRIPTION	KIT CONTENT
1	46502076	Spring Assy Kit	B
1	46501789	Muffler	A
1	46501797	Sealing Ring	C
2	96702055	HexHeadScrew	D
1	46501805	Flange	E
1	22307409	Gasket	F

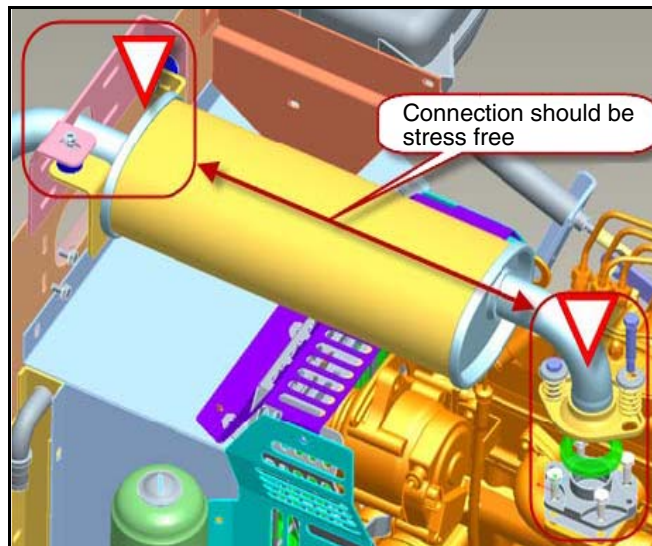
**MOUNTING INSTRUCTION WITH BRACKET SETUP  
AS BELOW: UNITS AFTER 03-2004**

**Figure 3**



1. Place gasket (F) on the engine manifold flange. **[Figure 3]**
2. Place Flange (E) on top of the gasket and fixate using Screw (D) at 23Nm.
3. Assemble muffler (A) with vibration dampers and bracket. Nuts on dampers should be hand tight only at this point.
4. Place Sealing ring (C) on flange (E) with conical side pointing upwards.
5. Install kit (B) on the muffler
6. Align and fit the pre assembled muffler on the cooler wall and exhaust manifold. Handtight only. **[Figure 4]**
7. Torque the two spring bolts to 23Nm.
8. Tighten the vibration dampers to the cooler wall bracket. Take care not to deform the dampers.
9. Install bracket to cooler wall and torque.

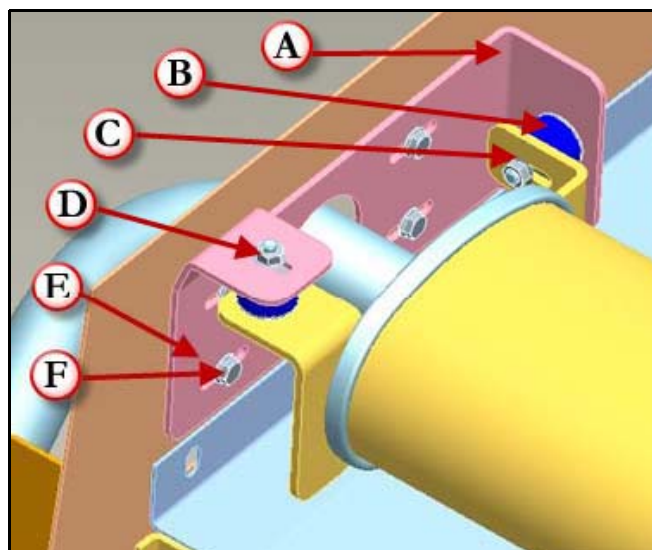
**Figure 4**



**MOUNTING INSTRUCTION WITHOUT BRACKET &  
DAMPERS: UNITS BEFORE 03-2004:**

Compressors produced prior to 03-2004 are not fitted with the bracket and dampers setup as show in **[Figure 5]**. Please order 22512917 + items A-B-C-D-E-F.

**Figure 5**



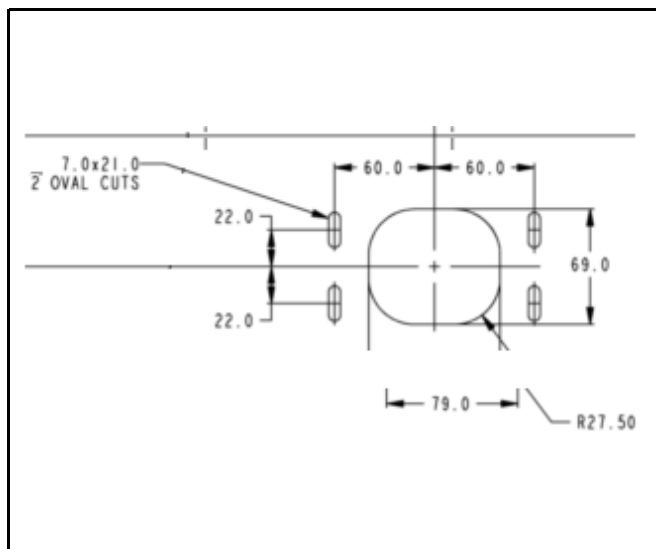
**Parts [Figure 5]**

COMPLETE MUFFLER INSTALL KIT 22512917 +			
QTY.	P/N	DESCRIPTION	LOCATION
1	22415582	Bracket	A
2	22431704	Rubber Damper	B
4	92341981	Washer	C
4	22307656	Locknut	D
4	96704176	Nut	E
4	92184811	Screw, flanged	F

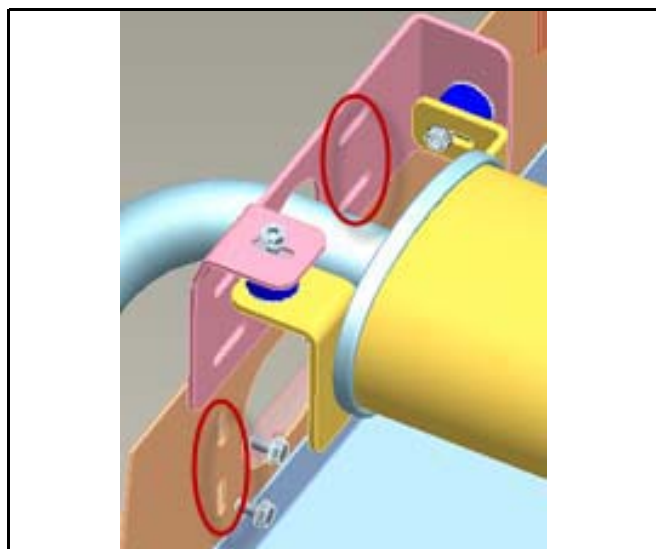
Follow previous instruction up to and including line 6 in the previous assembly section, from then on proceed as described below.

1. Align the muffler-bracket assembly on the cooler wall.
2. Torque spring tension bolts to 23Nm while making sure muffler bracket is parallel to cooler wall.
3. Mark position of bracket slot holes on cooler wall.  
**[Figure 7]** Take care to ensure the hole position is correct in order to create a stress free mount.  
**[Figure 6]**

**Figure 6**



**Figure 7**



4. Move muffler assembly to gain access to cooler wall for drilling.
5. Drill bracket mounting holes according to drawing **[Figure 6]**

6. Align and fit the pre assembled muffler on the cooler wall and exhaust manifold.
7. Torque spring tension bolts to 23Nm while making sure muffler bracket is parallel to cooler wall.
8. Install bracket to cooler wall and torque.
9. Test run compressor and check for exhaust leaks or loose components.

**Note:**

**[Figure 7]** shows the bracket and cooler wall slot holes, this setup allows for increased mounting flexibility and a stress free assembly.

**Important Information:**

Standard warranty conditions apply.