

## C20410 SERVICE PROCEDURE

**Subject:** C11300 Replacement Procedure  
Navistar #1893172C91

**Models Affected:** C20410  
Navistar #3006570C91

**CAUTION!** At no time should the capscrews securing the anchor bracket to the housing be loosened.

### AIR CYLINDER REMOVAL

- 1 Disconnect the supply airline.
- 2 Remove the lower e-clip (closest to the bracket) at the clevis pin.
- 3 Push the clevis pin up and out of the clevis (away from the bracket).
- 4 Remove the e-clip and flat washer at the anchor pin.
- 5 Rotate the arm of the butterfly shaft out of the clevis, remove cylinder.

### INSTALLING THE REPLACEMENT CYLINDER

- 1 Install the lock nut and clevis provided on the replacement cylinder.
- 2 Install the cylinder muffler, torque to 15 in-lbs (1.6 N•m).
- 3 Apply anti-seize to the anchor pin.
- 4 Install the air cylinder with the air port towards the notch in the anchor bracket.
- 5 Install the washer on the anchor pin (rounded side towards the cylinder) and then the new e-clip provided.

### ADJUSTING THE REPLACEMENT CYLINDER

- 1 Apply shop pressure to the 12mm port (minimum 100 PSI and maximum 150 PSI) extend the cylinder.
- 2 Install one of the new e-clips provided on the new clevis pin.

## ADJUSTING THE REPLACEMENT CYLINDER CONT'D

- 3 Apply anti-seize to the clevis pin and install through the clevis and through the butterfly arm, then install the remaining e-clip on the lower side of the clevis pin.



- 4 Using a 3/8" open end wrench on the cylinder rod, rotate the rod to extend the travel closing the butterfly. Once the butterfly becomes close to fully closed, move the clevis up and down on the butterfly arm while rotating the cylinder rod. Once the butterfly contacts the ID of the bore the clevis will no longer move freely up and down on the arm, at this point back off the adjustment slightly to achieve slight movement.
- 5 Tighten the lock nut to 25 ft-lbs (35 N•m). Re-check to ensure the adjustment is unchanged.
- 6 Install the original air inlet fitting into the assembly.

Re-install the unit on the vehicle as per Navistar service procedures.