

**NO: 11-07-98 Rev. A**

**SUBJECT: Outer Exhaust Manifold Studs Breaking**

**DATE: Dec. 11, 1998**

**THIS BULLETIN SUPERSEDES TECHNICAL SERVICE BULLETIN 11-07-98, DATED JUL. 31, 1998, WHICH SHOULD BE REMOVED FROM YOUR FILES. ALL REVISIONS ARE HIGHLIGHTED WITH \*\*ASTERISKS\*\* AND INCLUDE THE ADDITION OF MODEL YEARS, CLEAN POINTS, AND NEW PARTS.**

**NOTE: THIS INFORMATION APPLIES TO VEHICLES EQUIPPED WITH A 2.5L ENGINE \*(SALES CODE EPE)\* BUILT PRIOR TO DEC. 7, 1998 (MDH 1207XX).**

**SYMPTOM/CONDITION:**

The outer exhaust manifold studs may fatigue and break ([Figure 1](#)).

**DIAGNOSIS:**

Inspect either manifold stud for breakage. If breakage is noted, perform the Repair Procedure.

**PARTS REQUIRED:**

Qty	Part No.	Description
**2	06036193AA	Stud, Exhaust Manifold**
**2	06036221AA	Washer, Flat**
**2	06036171AA	Nut & Washer**
2	33003332	Spacer
1	53020112	Gasket, Intake

**REPAIR PROCEDURE:**

This bulletin involves replacing both outer mounting studs, clamps, and nuts \*\*with new parts\*\* and tightening the outer studs to a reduced torque of \*\*20 Nm (180 in. lbs.)\*\*.

1. Remove the intake/exhaust manifold per service manual procedures to gain access to the broken stud(s).
2. Remove the outer studs from the cylinder head. Use a stud removal tool if possible or drill the broken stud from the head.
3. Install two new outer studs p/n 06036193AA into the cylinder block. \*\*Torque the studs to 14 Nm (126 in. lbs.)\*\*.
4. Clean any carbon deposits or debris from the exhaust manifold.
5. Reinstall the exhaust manifold. \*\*Use only the new parts listed above to attach the outer ends ([Figure 2](#)).
6. Torque the bolts in the order and specification as listed in [Figure 2](#).

**\*\*NOTE: THE TORQUE SPECIFICATION FOR THE OUTER EXHAUST MANIFOLD STUDS HAVE BEEN REDUCED TO 20 NM (180 IN. LBS.)\*\*.**

**POLICY:**

Reimbursable within the provisions of the warranty.

**TIME ALLOWANCE:**

Labor Op. No.	Time
09-45-01-92	2.0 Hrs.

**FAILURE CODE:**

Code	Description
P8	New Part