

# *Service Letter*

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**Service Letter No. 407**  
**October, 1994**

**SUBJECT: New Hold-down Bolt Torque Specification**

**MODELS AFFECTED: Models 750/760/760A/765**

Effective immediately, Jacobs has changed the torque specification for Jake Brake® Models 750/760/760A/765 hold-down bolts. The new torque specification is 100 lbft. (136 N•m) **lubricated with engine oil**. This new torque specification replaces the old torque specification of 80 lbft (110 N•m).

Effective immediately, Jacobs recommends the following procedures be followed when installing housing hold-down bolts:

1. Blow out the hold-down bolt holes with pressurized air.
2. **Lubricate the hold down bolts with clean engine oil prior to installation.**
3. Install one washer on each bolt and loosely install into brake housing (three bolts per housing).
4. Before tightening the hold-down bolts, move the housing from side to side and then locate the housing in the center position of the movement.
5. Tighten the engine brake hold-down bolts using the following sequence:
  - a. Tighten the three bolts on the camshaft side to 40 lbft (41 N•m).
  - b. Tighten the six bolts on the exhaust manifold side to 40 lbft (41 N•m).
  - c. Repeat the tightening sequence by torquing each bolt to 100 lbft. (136 N•m).

**NOTE:**

THE NEW HOLD-DOWN BOLT TORQUE APPLIES TO THE MODEL 760 (TWO 120 MM BOLTS AND ONE 110 MM BOLT) AND THE MODELS 750/760A/765 (THREE 110 MM BOLTS). THERE IS NO CHANGE TO ANY BOLT PART NUMBERS.

This is a Jacobs product improvement and not subject to campaign.