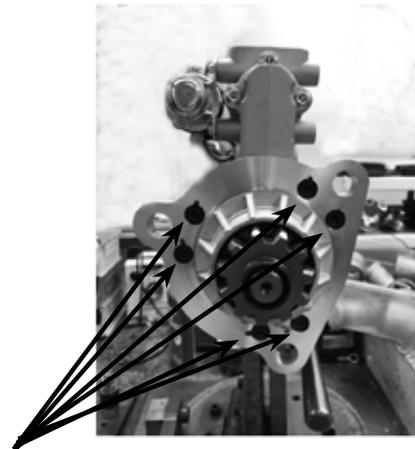


Source: Leece-Neville Heavy Duty Systems Division - Arcade, NY USA  
Date: January 23, 2020  
Bulletin No: TSB-1175  
Models: M128  
Subject: Procedure to rotate flange and IMS relay

- 1) Remove flange mounting bolts with a 7/32" allen head socket. Do not discard. (Fig 1)
- 2) Rotate flange ensuring mounting bolt holes are accessible. (Fig 2)
- 3) Apply Red 272 Loctite to flange mounting bolts removed in step 1 (Fig 3)
- 4) Install starter flange bolts and torque to 20+/-2Nm. (Fig 4)



Remove bolts

Fig. 1

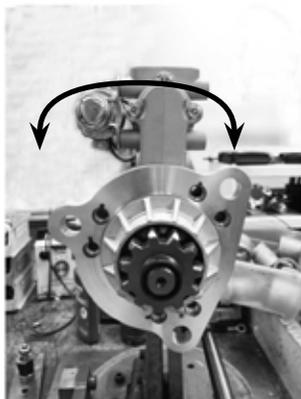
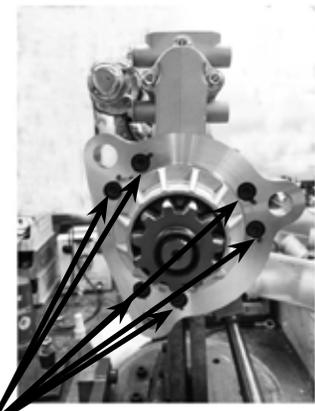


Fig. 2

Apply  
Loctite



Fig. 3



Install  
bolts

Fig. 4

Important: The information contained in this bulletin is intended for use by trained, professional technicians who have the proper tools, equipment, and training to perform the required maintenance described above. This information is NOT intended for 'do-it-yourselfers'; and you should not assume that this information applies to your equipment. If you have any questions regarding this information please visit our website at [www.prestolite.com](http://www.prestolite.com), or contact our technical service department at:

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5) Loosen B+ (Terminal 30) nut to allow the ring terminal to rotate and cut wire tie. (Fig 5)

6) Remove M5 flange nut (10mm socket) and remove solenoid wire. Do not discard nut. (Fig 6)

7) Remove relay nut and ground wire. Do not discard nut. (Fig 7)

8) Remove relay mounting screws with a T27 torx socket. (Fig 8)  
Do not discard.

9) Apply 272 Loctite to relay mounting screws. Removed in step 8. (Fig 9)

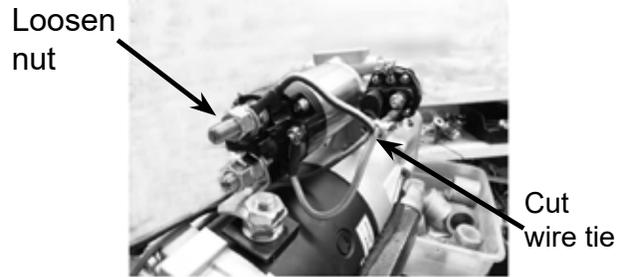
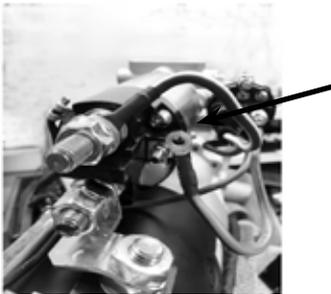


Fig. 5



Remove flange nut and ring terminal.

Fig. 6



Remove relay nut and ring terminal. Relay nut can be either 8mm or 10mm depending on model.

Fig. 7



Remove relay mounting screws

Fig 8

Apply Loctite

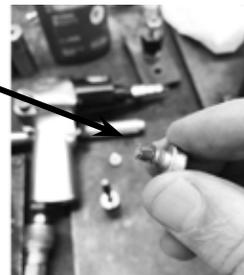


Fig. 9

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10) Relocate relay into the desired position and install the relay mounting screws. Torque to 8+/-1Nm. (Fig 10)

11) Install relay ground wire and nut (removed from step 7) on relay terminal and torque to 2-2.5 Nm. (Fig 11)

**Note:**

If both terminals is a M5 then relay is not polarity sensitive. Then either terminal can be used for the ground connection.

If terminals are M5 and M6 then the relay is polarity sensitive and the larger M6 must be use for the ground connection. (Fig 11)

12) Route solenoid wire (removed in step 6) under the solenoid. (Fig 12)

13) Install solenoid wire and M5 flange nut (10mm socket) onto solenoid terminal (removed in step 6) and torque to 3-4 Nm. (Fig 13).

**Note:**

Hold inner nut while tightening outer nut to avoid side load on terminal.



Fig. 12

Route solenoid wire under solenoid.

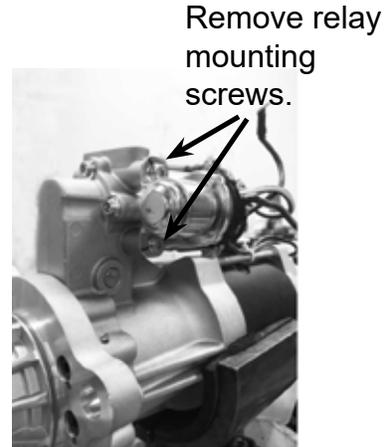


Fig. 10



Fig. 11

Install relay ground wire and nut.



Fig. 13

Install solenoid wire and M10 nut..

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14) Install new wire tie. (Fig 14)

**Note:**

Verify all wires are properly secured without stress, pinch points or against any sharp corners.

Verify wires do not come in contact with the starter yoke. (See Fig 14)

New wire tie.

Starter yoke.



Fig. 14

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