

Tool Instruction DEF Tank Cutting Tool

4328516R1

Tool Number: 18-637-01



0000419494

Figure 1. 18-637-01 DEF Tank Cutting Tool

Purpose

The Diesel Exhaust Fluid (DEF) Tank Cutting Tool widens the DEF tank opening to accommodate a new DEF sending unit.

Application(s)

2012 - Current Model Year Selective Catalyst Reduction (SCR) Equipped International[®] Vehicles

Application(s) (cont.)



GOVERNMENT REGULATION: Engine fluids (oil, fuel, and coolant) may be a hazard to human health and the environment. Handle all fluids and other contaminated materials (such as filters or rags) in accordance with applicable regulations. Recycle or dispose of engine fluids, filters, and other contaminated materials according to applicable regulations.



WARNING: To prevent personal injury and / or death, read all safety instructions in the “Safety Information” section of the *Engine Service Manual* or *Engine Diagnostic Manual* .



WARNING: To prevent property damage, personal injury, and / or death, park vehicle on hard flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in either direction.



WARNING: To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.



WARNING: To prevent property damage, personal injury, and / or death, inspect tool for wear / damage prior to use. Replace any worn or damaged components as necessary.





CAUTION: To prevent property damage, NEVER use power / impact tools when using the DEF tank cutting tool. The use of excessive force will cause the forcing screw to strip.



CAUTION: To prevent vehicle / property damage, NEVER install DEF tank with debris present inside the tank.

Tool Contents

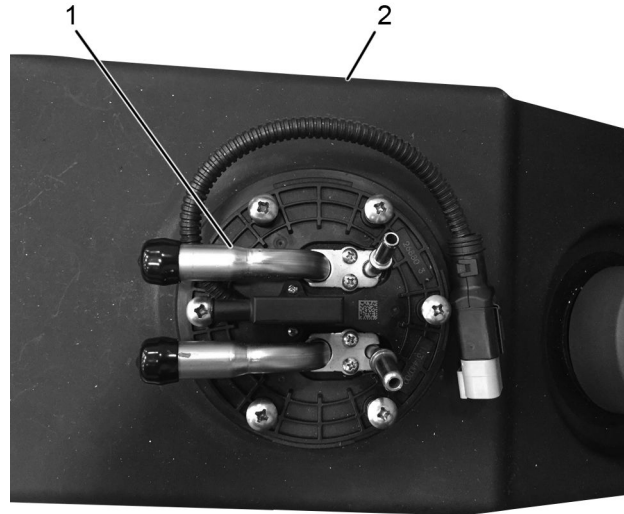
Table 1 Tool Information

Image	Tool Number	Qty	Description
 <p>0000419493</p>	18-637-01	1	DEF Tank Cutting Tool (Includes Three Mounting Bolts)
 <p>0000160075</p>	4328516R1	1	Tool Instruction

Instructions

IMPORTANT: Please reference International® Service PortalSM regarding any possible revisions to this document.

NOTE: To perform this procedure, the DEF tank must be empty and removed from vehicle.

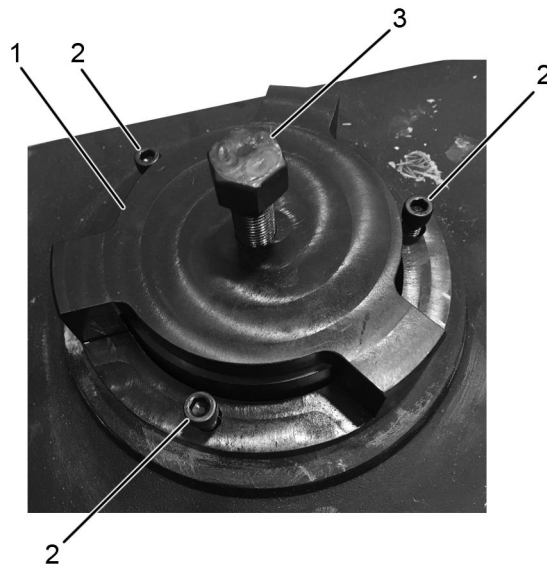


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Figure 2. DEF Tank and Sending Unit Assembly

1. DEF sending unit assembly
 2. DEF tank
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1. Park vehicle on flat surface.
 2. Shift transmission to Park or Neutral and set parking brake.
 3. Install wheel chocks.
 4. Remove DEF tank from vehicle. Refer to appropriate service manual for detailed instructions.
 5. Remove DEF sending unit assembly (Figure 2, Item 1) from DEF tank (Figure 2, Item 2). Do not discard. Save mounting fasteners for reuse.
 6. Using fresh water, rinse any residual DEF fluid from tank.

Instructions (cont.)



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Figure 3. Mounting Location - DEF Tank Cutting Tool

1. DEF Tank Cutting Tool
2. Mounting screw (3)
3. Forcing screw

NOTE: The carbide insert / bit installed on this tool has four total cutting surfaces, only two surfaces are used in this application.

7. Prior to installation, inspect cutting surfaces located on carbide insert / bit:
 - A. If cutting surfaces appear worn or chipped, the carbide insert / bit can be clocked / rotated to expose unused / new cutting surfaces.
 - B. If all cutting surfaces appear worn or chipped, replace damaged part with 18-637-01-02 Carbide Insert with Screw.
8. Using three cutting tool mounting screws (Figure 3, Item 2) and existing tank mounting holes, install DEF Tank Cutting tool (Figure 3, Item 1) onto tank. Tighten screws securely.

⚠ CAUTION: To prevent property damage, NEVER use power / impact tools when using the DEF tank cutting tool. The use of excessive force will cause the forcing screw to strip.

9. Using ratchet and socket / open-end wrench, tighten forcing screw (Figure 3, Item 3) to enlarge opening in tank.
10. Remove DEF tank cutter tool.
11. If necessary, remove any shavings attached to recently cut opening in tank.

Instructions (cont.)



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Figure 4. DEF Tank with Vacuum Hose

1. Vacuum hose



CAUTION: To prevent vehicle / property damage, NEVER install DEF tank with debris present inside the tank.

12. Using vacuum with hose (Figure 4, Item 1), remove any debris from inside DEF tank.
13. Rinse DEF tank with fresh water to remove any remaining debris. Verify no debris is present.
14. Install DEF sending unit assembly. Refer to appropriate service manual for detailed instruction.
15. Install DEF tank on vehicle. Refer to appropriate service manual for detailed instruction.
16. Flush DEF tank cutting tool with water and spray with rust inhibitor / water displacement lubricant before storing.
17. Remove wheel chocks.

Care and Maintenance

- Keep tools clean and free of contaminants
- Worn or damaged cutter bits can be re-locked to use other cutting surfaces. If all cutting surfaces appear worn or chipped, replace damaged part with 18-637-01-02 Carbide Insert with Screw.
- Replace any damaged components

Contact Information

If you would like to order additional tools or need replacement parts, please refer to the Navistar Service Tool Catalog. If you have questions, concerns, or feedback, please contact Navistar Service Tool Support Center:

- Submit a Service Tool iKNow Case File.
- Phone: 800-365-0088 (toll free).