

SVE BULLETIN

SPECIAL VEHICLE ENGINEERING – BODY BUILDERS ADVISORY SERVICE

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QVM BULLETIN: Q-308R1
Revision date

DATE: 03 / APR / 2020
20 / Apr / 2020

2021 E-Series DRW Tailpipe Kit – Cutaway / Stripped Chassis

REVISION	UPDATE	REVISION DATE
Q-308	INITIAL RELEASE	03 / APR / 2020
Q-308R1	Add build date restriction	20 / APR / 2020

MODEL(S) AFFECTED:

All 2021MY E-Series DRW Cutaway / Stripped Chassis – BUILT PRIOR TO 20MAY2020

ISSUE / DESCRIPTION:

The tailpipe extension kit included in the dunnage box for all incomplete vehicles with gas engines may be too short for some final stage manufacturers applications. A design change is in process to increase the length of the tailpipe to the same length as 2019MY. This bulletin will be updated with the date of when the longer pipe goes into production. This bulletin gives guidance for extending the tailpipe to meet the final stage manufacturers application.

If the straight tailpipe extension pipe included with the vehicle is not long enough for the application a tailpipe provided by the final stage manufacturer may be used. Recommend using the following material:

Pipe Material: ASTM S40900 (AL409) A240, A480, COAT T1-25 A463, 82.55 mm diameter, 1.2 mm wall thickness. Note that a larger diameter pipe may be used, but 82.55 mm diameter is the minimum diameter that can be used.

Per Figure 1, the end of the straight pipe, which attaches to the tailpipe, should be swaged to 90.65 +/- 0.4mm ID to a depth of 60 +/- 2.5 mm. **The extension pipe can be secured with a clamp, F5TZ-5A231-B, which is available through Ford Service or similar type of U-bolt exhaust clamp with a 94 mm I.D.. DO NOT use clamp included with the tailpipe extension kit that came with the vehicle seen in Figure 2. The clamp included with tailpipe extension requires two Z-slots to be machined into the swaged end of the pipe 180 degrees apart for proper retention.**

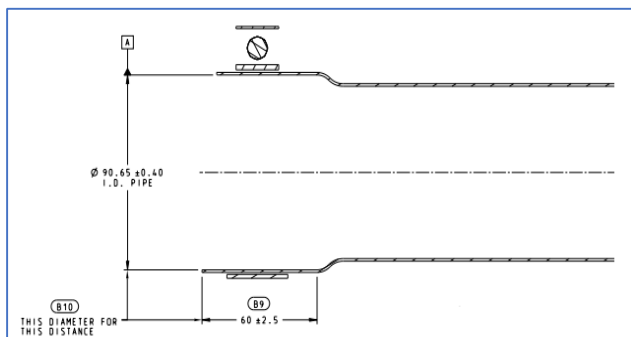


Figure1: Swage Dimension

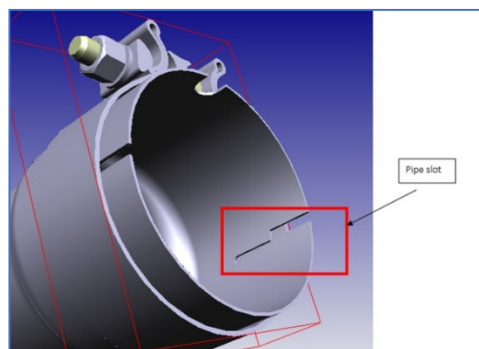


Figure 2: Use of this clamp without the Z-slots is not recommended.

Refer to the Body Builder Layout Book for additional guidelines and recommendations. If you have any questions, please contact the [Ford Body Builders Advisory Service](http://www.FordBodyBuildersAdvisoryService.com) as shown in the header of this bulletin.