



WARRANTY BULLETIN

Warranty Campaign

CAUTION: All involved customers must be notified, all involved units must be corrected as per instruction herein.

Campaign no.: 2018-0004

November 3, 2017 Subject: **850 E-TEC® - Driven Pulley Bearing Support Bolts Out of Specifications** No. **2018-4**

MODEL YEAR	MODEL	SERIAL NUMBERS
2018	850 E-TEC®	Refer to campaign monitoring
<p>IMPORTANT</p> <ul style="list-style-type: none"> – When a vehicle comes in for service, always type the VIN in Knowledge Center to check for pending campaigns or alerts. – When performing any work on a vehicle, it is good practice to connect it to BUDS2 to ensure that all needed updates are done. 		

PROBLEM

Due to a problem during the manufacture process, the bolts securing the driven pulley bearing support to the engine module could break.

SOLUTION

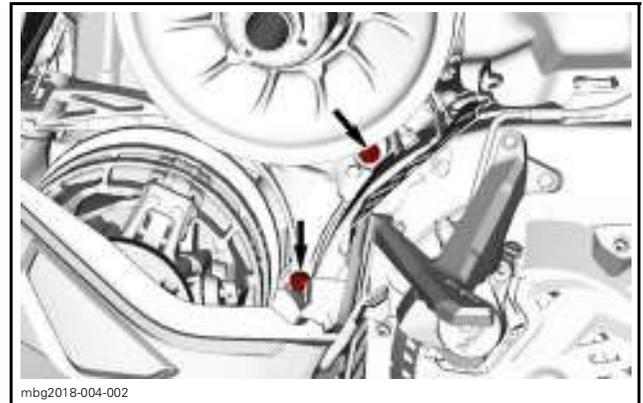
Validate the strength of the bolts by torquing them to the specification indicated in the *STRENGTH VERIFICATION* section.

PROCEDURE

Strength Verification

- Remove:
 - LH side panel
 - Belt guard.
- Using a torque wrench, verify the bolts strength by applying the following torque.

NOTICE Use only a torque wrench to validate the tightening torque.



TORQUE VERIFICATION	
Driven pulley bearing support bolt	33 N•m ± 1 N•m (24 lbf•ft ± 1 lbf•ft)

- Reinstall removed parts.

If Bolts Broke or Threads Stripped During Verification

Required Parts

Order parts through regular channel.

DESCRIPTION	PART NUMBER	QTY
M8 x 40 hexagonal flanged bolt	207684044	2
M8 nylon flanged nut	233281414	2

Bolts Replacement

NOTICE If one bolt broke or stripped, replace both.

A video showing the procedure is available on Knowledge Center.

– Driven Pulley Bearing Support Bolts Replacement

1. Refer to the appropriate shop manual, remove:
 - LH side bottom pan
 - Drive and driven pulleys.
2. Remove the broken portion of the bolt from the bearing support
3. Screw a M8 x 30 self-tapping screw or a M8 x 30 full thread (grade 8.8 minimum) in the hole and spin it a few times. This will remove the leftover threads.

NOTICE Do not use a drill bit to remove leftover threads to avoid damaging the positive cable of the electric starter located behind the support.

4. Remove aluminum chips with compressed air.
5. Install the new M8 x 40 hexagonal flanged bolt in the hole and move it back and forth to be sure that it is loose.
6. Pull the bottom bolt back some then install a new M8 nut by hand, once started snug it up.
7. To install the top nut use a flex head 13mm wrench and a piece of tape. Once started snug it up.



8. Tighten bolts to specified torque.

TIGHTENING TORQUE	
Driven pulley bearing support bolts	33 N•m ± 1 N•m (24 lbf•ft ± 1 lbf•ft)

9. Reinstall all removed parts.

WARRANTY

Submit a warranty claim using the following information:

For claiming procedure, refer to the *DEALER/DISTRIBUTOR WARRANTY GUIDE*.

Strength Verification

Product Line	Ski-Doo
Unit Model Year	2018
Campaign/Bulletin/Description	4 / 2018-4 / Gen4 - QRS support bolts
*Action	
Inspect <input checked="" type="checkbox"/>	Repair <input type="checkbox"/>
Total Labor time paid	0.3 hour
Expiration date	November 30, 2020

Bolt Replacement

Product Line	Ski-Doo
Unit Model Year	2018
Campaign/Bulletin/Description	4 / 2018-4 / Gen4 - QRS support bolts
*Action	
Inspect <input checked="" type="checkbox"/>	Repair <input checked="" type="checkbox"/>
Total Labor time paid	0.6 hour
Expiration date	November 30, 2020