



# Service Bulletin

**Date:** December 29, 2003

**Product Line:** Snowmobile

**Bulletin No:** 2004-1-10

**Subject:** Coolant Hose (Engine-to-Front Heat Exchanger)

**Affected Models / VIN:**

All 2004 Firecat and Sabercat Models

**Condition:** It has been determined that the coolant hose (engine-to-front heat exchanger) may come into contact with the lower bulkhead and engine housing. If this condition exists, the hose will wear through resulting in the loss of coolant and engine failure.

**Solution:** It is highly recommended that a section of affected Coolant Hose (p/n 0610-572) be removed to prevent the hose from coming into contact with the bulkhead and engine housing.

■ **NOTE:** Retain the removed section of the hose for warranty purposes. The section of hose needs to be returned to Arctic Cat to receive credit for the service work. You must hold the affected part for 90 days. Within the 90 day holding period, Arctic Cat will send you a parts return notice.

**Parts:** Not Applicable (No Parts Needed)

**Warranty:** A labor allowance of 0.4 hr will be paid per affected snowmobile.  
Cat Tracker Claim: Enter BS200410 in the Complaint section.  
Manual Claim: Enter 0410 in the Complaint section.

■ **NOTE:** Please remember that when submitting a claim, make sure to always enter the current mileage of each affected snowmobile. In order for Arctic Cat to accurately assess warranty claims, an accurate recording of mileage on snowmobiles with warranty claims is important.

## ATTENTION

This service bulletin expires December 29, 2004. To ensure that the necessary service work is completed in a timely manner and that this issue can be resolved, Arctic Cat is requesting that all service work be completed prior to December 29, 2004. All warranty claims directly related to this issue will not be honored after December 29, 2004.



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## Instructions

■ **NOTE:** It is not necessary to drain the cooling system to complete these instructions.

1. Temporarily remove the coolant tank cap to reduce the pressure in the cooling system; then install the cap.
2. Place a protective covering on the floor to prevent the snowmobile from being damaged; then place the snowmobile on the PTO side and remove the skid plate.
3. Using a pair of long-handled needle-nose pliers, loosen the hose clamp securing the coolant hose to the front heat exchanger. Pull the clamp forward on the hose approximately 64 mm (2 1/2 in.).

■ **NOTE:** Prior to removing the hose, it is advisable to place a cloth or suitable substitute under the hose since a small amount of coolant will drain from the cooling system. Remove the hose from the heat exchanger fitting.

4. Remove the hose from the heat exchanger fitting, then using a hose cutter, remove a 38 mm (1 1/2 in.) section from the end of the hose (600 & 700 models) or a 19 mm (3/4 in.) section from the end of the hose (500 models).

### CAUTION

**Make sure to use a ruler to measure the amount of hose to be removed. Do not estimate. Also, make sure that the correct amount of hose is removed depending upon the model of the snowmobile. Be sure that a 38 mm (1 1/2 in.) section is removed for the 600 & 700 models and that a 19 mm (3/4 in.) section is removed for the 500 models.**

5. Install the shortened hose onto the front heat exchanger fitting making sure the hose is completely seated onto the fitting; then secure with existing clamp.
6. Install the skid plate; then place the snowmobile in an upright position.
7. Fill the coolant tank; then start the engine and run until the coolant is circulating and no air is in the heat exchanger system.

■ **NOTE:** It is vital that there is an adequate amount of coolant in the cooling system and that the system is purged. When the right-side heat exchanger is warm to the touch, the cooling system should be adequately purged. Add additional coolant if necessary.