

- **PCM (POWERTRAIN CONTROL MODULE)—REPLACEMENT PCM ALLOWS FOR SELECTABLE RPM CONTROL—7.3L DI (TURBO) DIESEL—VEHICLES BUILT FROM 2/9/94 THROUGH 8/29/94**
- **STALLS—7.3L DI (TURBO) DIESEL—WHEN OPERATING PTO AT IDLE—VEHICLES BUILT FROM 2/9/94 THROUGH 8/29/94**

**Article No.  
94-19-18**

**LIGHT TRUCK:** 1994 F SUPER DUTY, F-250, F-350

**ISSUE:** Some PTO-equipped vehicles may stall during PTO operation. The cause is idle RPM that is too low to support operation of external equipment.

**ACTION:** This is a customer paid repair. It is offered as an "Enhancement" option. Reprogram the powertrain control module using normal service bay diagnostics system procedures (when using the SBDS Reprogramming Kit). If there is a need to use the Powertrain Control Module (PCM) Kit, remove the production powertrain control module and replace with PCM provided in kit that allows for selectable RPM control along with all normal functions. Refer to the following procedures for details.

**NOTE:**

● **LABELS MUST BE INSTALLED IN VEHICLE BEFORE RELEASING TO CUSTOMER REGARDLESS OF WHICH KIT IS USED.**

● **RECOMMEND THE SBDS KIT TO THE CUSTOMER AS IT IS THE PREFERRED KIT SINCE IT IS LESS EXPENSIVE AND FUNCTIONS THE SAME.**

● **THIS IS FOR CUSTOMER MODIFICATION ONLY AND IS NOT REIMBURSABLE.**

**SUMMARY OF INSTRUCTIONS TO ENGAGE SELECTABLE RPM CONTROL**

1. The operator must use the detailed instructions provided on the labels to engage the selectable RPM control.
2. The operator must keep the RPM of the vehicle steady by depressing the accelerator pedal to the desired speed.

3. The operator then depresses the service brake with the left foot while holding the accelerator pedal steady.
4. The "WAIT TO START" light will begin flashing and the operator can release the brake while keeping the accelerator pedal steady.
5. When the "WAIT TO START" light flashes slowly the operator can release the accelerator pedal and the RPM will remain at a constant speed.

**DETAILED SERVICE PROCEDURE FOR SBDS KIT**

1. **Reprogram PCM** (with SBDS Kit F5TA-12B647-AA), using the September 1994 Calibration Update CD or after, performing normal Service Bay Diagnostic System (SBDS) procedures.

**NOTE: THE SEPTEMBER 1994 CALIBRATION UPDATE CD WILL INCLUDE TEN (10) SBDS REPROGRAMMING KITS. ADDITIONAL KITS CAN BE ORDERED (SEE PART BLOCK AT END OF THIS ARTICLE).**

2. Apply each label to the respective locations specified in the instruction sheets provided with each kit.
3. After all the labels are affixed in their proper locations, check for correct operation of selectable RPM control using instructions provided on the labels and/or the instruction sheets.

**DETAILED SERVICE PROCEDURE FOR POWERTRAIN CONTROL MODULE (PCM) KIT**

**NOTE: DEALER SHOULD REFER TO INSTRUCTION SHEET INCLUDED IN PACKAGE TO IMMEDIATELY RETURN CORES TO FORD ELECTRONICS VIA FEDERAL EXPRESS AWB/SHIPPER ENCLOSED.**

**Article No.  
94-19-18  
Cont'd.**

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REPLACEMENT PCM ALLOWS FOR SELECTABLE RPM  
CONTROL—7.3L DI (TURBO) DIESEL—VEHICLES BUILT  
FROM 2/9/94 THROUGH 8/29/94**
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PTO AT IDLE—VEHICLES BUILT FROM 2/9/94  
THROUGH 8/29/94**

1. **Remove and replace the PCM with the PCM provided in the PCM Kit (F5TZ-12A650-A). Remove and replace information is provided in the 1994 7.3L DI Turbo Diesel Service Manual Supplement on page 03-14-5.**
2. **Apply each label to the respective locations specified in the instruction sheets provided with each kit.**
3. **After all the labels are affixed in their proper locations, check for correct operation of selectable RPM control using instructions provided on the labels and/or the instruction sheets.**

The PCM kit (F5TZ-12A650-A) consists of:

- 1 (one) Powertrain Control Module
- 1 (one) Label Sel RPM Control Indicator
- 1 (one) Label Sel Control Engage
- 1 (one) Label Sel Control Disengage
- 1 (one) Label No Authorized Modifications
- 1 (one) Instruction Sheet
- 1 (one) Federal Express Shipper Form

The SBDS kit (F5TA-12B647-AA) consists of:

- 1 (one) Label Sel RPM Control Indicator
- 1 (one) Label Sel Control Engage
- 1 (one) Label Sel Control Disengage
- 1 (one) Label No Authorized Modifications
- 1 (one) Instruction Sheet

(to order additional SBDS kits, call 1-800-ROTUNDA, Monday through Friday 8AM - 5PM EST)

Obtain an Authorized Modifications Decal and list the date, dealer number, and summary of alterations performed. Select a prominent place adjacent to the Vehicle Emission Control Information Decal suitable for installing the Authorized Modifications Decal. Clean the area, install the decal, and cover it with a clear plastic decal shield.

	<b>AUTHORIZED MODIFICATIONS</b>
THE FOLLOWING MODIFICATIONS HAVE BEEN MADE:	
Replaced PCM per TSB 94-19-18	
THESE MODIFICATIONS HAVE BEEN APPROVED, AS APPROPRIATE, BY EPA AND CARB.	
DEALER NUMBER:	DATE:
CHANGE AUTHORITY:	
FPS 8262 978	FORD MOTOR COMPANY
	PRINTED IN U.S.A.

PART NUMBER	PART NAME	CLASS
F5TZ-12A650-A	PCM Kit	V
F5TA-12B647-AA	Kit - SBDS Reprogramming For Additional SBDS Kits, Call 1-800-ROTUNDA	-

**OTHER APPLICABLE ARTICLES: NONE**  
**WARRANTY STATUS: INFORMATION ONLY**  
**OASIS CODES: 607000**