



## BODY

**MODEL:** CONVENTIONAL, FS65, EF, EFX, ER/HD, HDX

**SUBJECT:** FLOOR CROSS TUBE CRACK REPAIR

**DATE:** AUGUST 29, 2014

**INDEX:** 3

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**BULLETIN:** 13R

This bulletin has been revised to include the models listed above. It provides instructions for repairs to stress cracks found in a cross tube fore and aft of the rear wheel housing, starting with body #9625059 on 3/11/96. For body #9625058 ending 3/11/96 and before, refer to [PSB Index 3, Bulletin 1R3A2](#) for repair procedure.

### Wheelhouse Crack Repair Procedure:

1. Clean-up area as needed for placement of new parts.
2. Remove the bolts from the seat feet that may interfere with the installation of reinforcement, if applicable.
3. Remove dirt, mud, and undercoating from the cross tube and floor panel in the area where the reinforcements will be installed.
4. Weld any visible crack in the cross tube. (Repair any cracks that may exist in the wheelhouse flange per [PSB Index 3, Bulletin 3.](#))



**Before performing any electric welding on a vehicle, disconnect the battery power, ground cables and any electric control units (ECU) installed on the vehicle.**

5. Prior to installation of Cross Tubes, part #TBB 136586, drill holes as indicated into support plates, as shown in **Figure 1**.
6. Insert Cross Tubes part #TBB 136586 and Union Bracket, part #TBB 136585 as indicated in **Figure 2**.
7. Weld Cross Tubes as instructed. (Note that the welds for the 1.00" dia. holes also applies for Union Bracket. **Only weld where indicated.**) See **Figures 1 and 3**.
8. Drill through new Cross Tubes, part #TBB 136586 with a "P" drill bit as required if tubes are in the way of re-installing seat bolts.
9. Re-install bolts on the seat feet, if removed in step 1.
10. Re-apply undercoating to all effected areas of the repair.

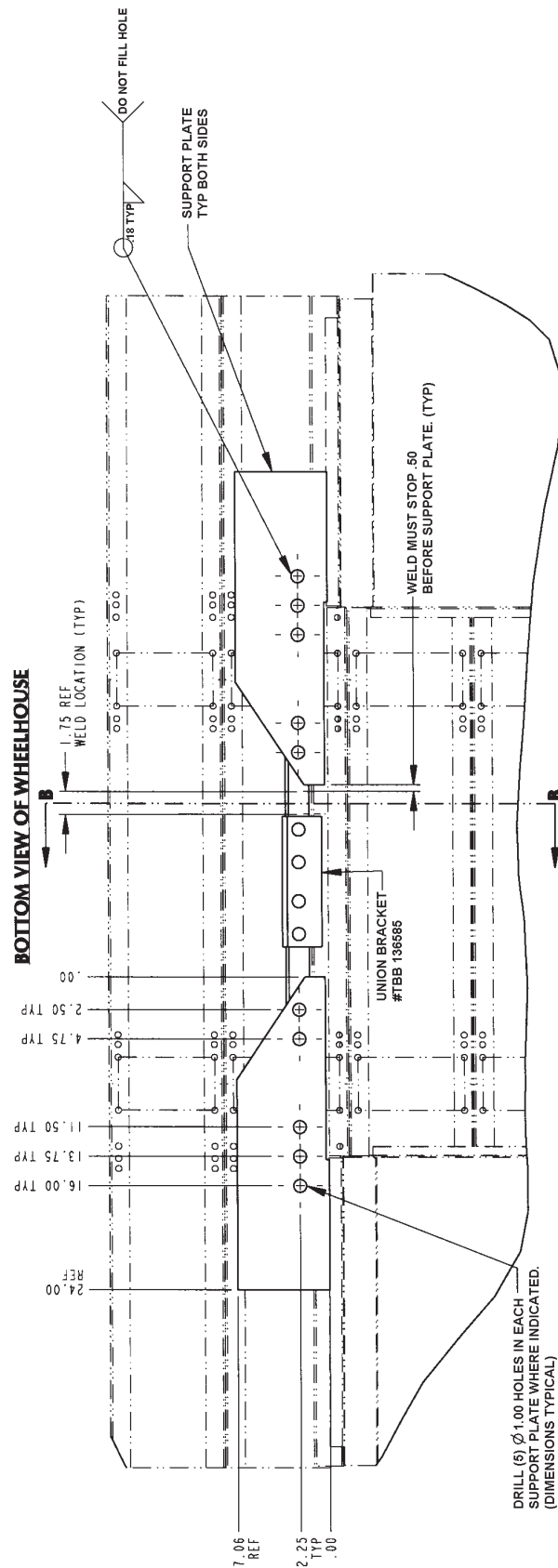
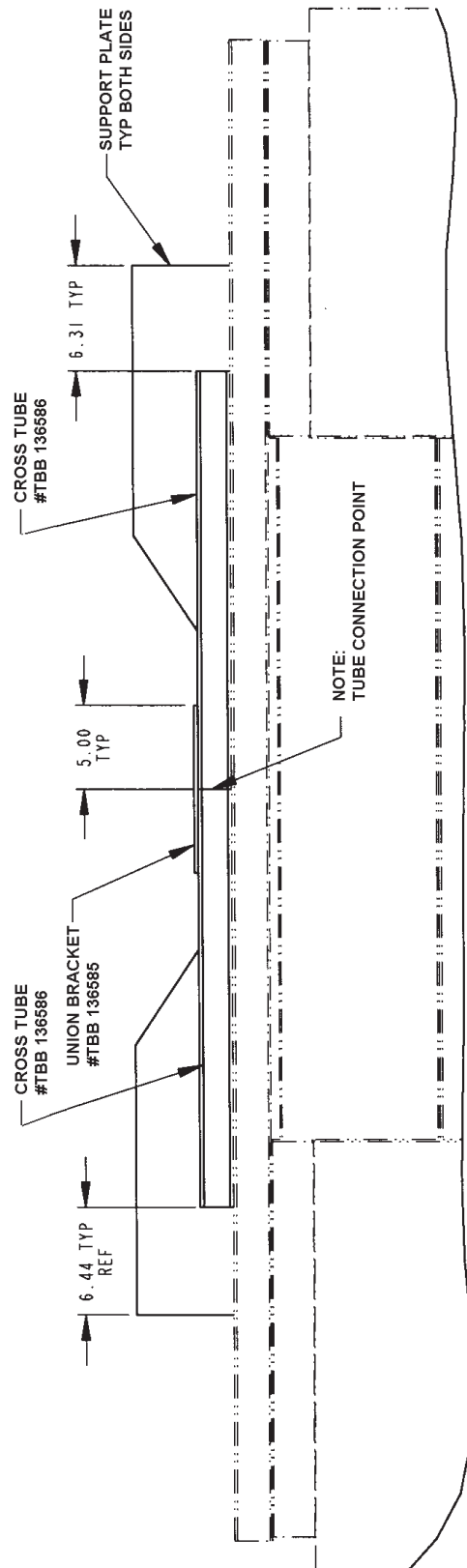


Figure 1



**VIEW FROM TOP SIDE OF FLOOR  
TO CLARIFY POSITION OF TUBES  
RELATIVE TO SUPPORT PLATES  
AND EXISTING TUBE.**

Figure 2

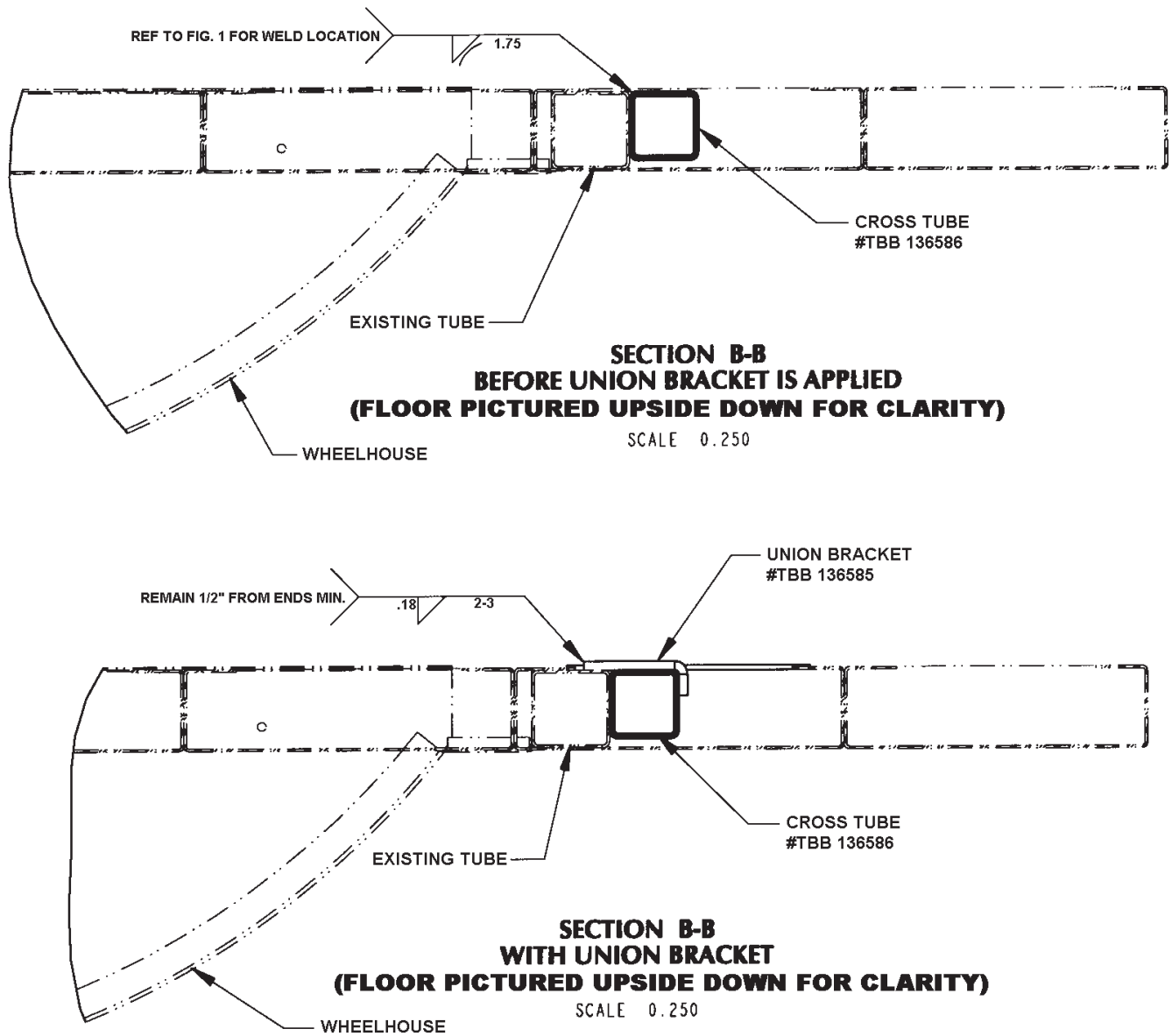


Figure 3

PARTS REQUIRED		
PART NUMBER(S)	QUANTITY	DESCRIPTION
TBB 136585	1	UNION BRACKET, WHEELHOUSE REPAIR
TBB 136586	2	CROSS TUBE, WHEELHOUSE REPAIR
	1	P DRILL BIT
	AR	1/8" #6011 WELDING RODS

**WARRANTY**

THIS PROCEDURE IS WARRANTABLE ONLY IF THE DESCRIBED CONDITION EXISTS AND THE REPAIR IS PERFORMED WITHIN THE APPLICABLE BASE OR EXTENDED COVERAGE WARRANTY PERIOD. IF A FAILURE IS NOT FOUND, THIS PROCEDURE IS CONSIDERED PREVENTIVE AND WARRANTY DOES NOT APPLY.

NORMAL WARRANTY APPLIES. SEE TABLE BELOW FOR **OWL VMRS** CODES AND LABOR ALLOWANCE INFORMATION. ENTER THIS **PSB** NUMBER IN THE **SERVICE BULLETIN #:** FIELD.

<b>OWL VMRS CODES AND LABOR ALLOWANCE</b>					
<b>PRIMARY FAILED PART</b>	<b>COMPONENT CODE</b>	<b>CAUSE CODE</b>	<b>SRT CODE</b>	<b>DESCRIPTION</b>	<b>TIME: HOURS PER SIDE</b>
TBB 136585	174-001-008		174-6137C	Repair of wheelhouse crack (per side)	1.5 HRS.