

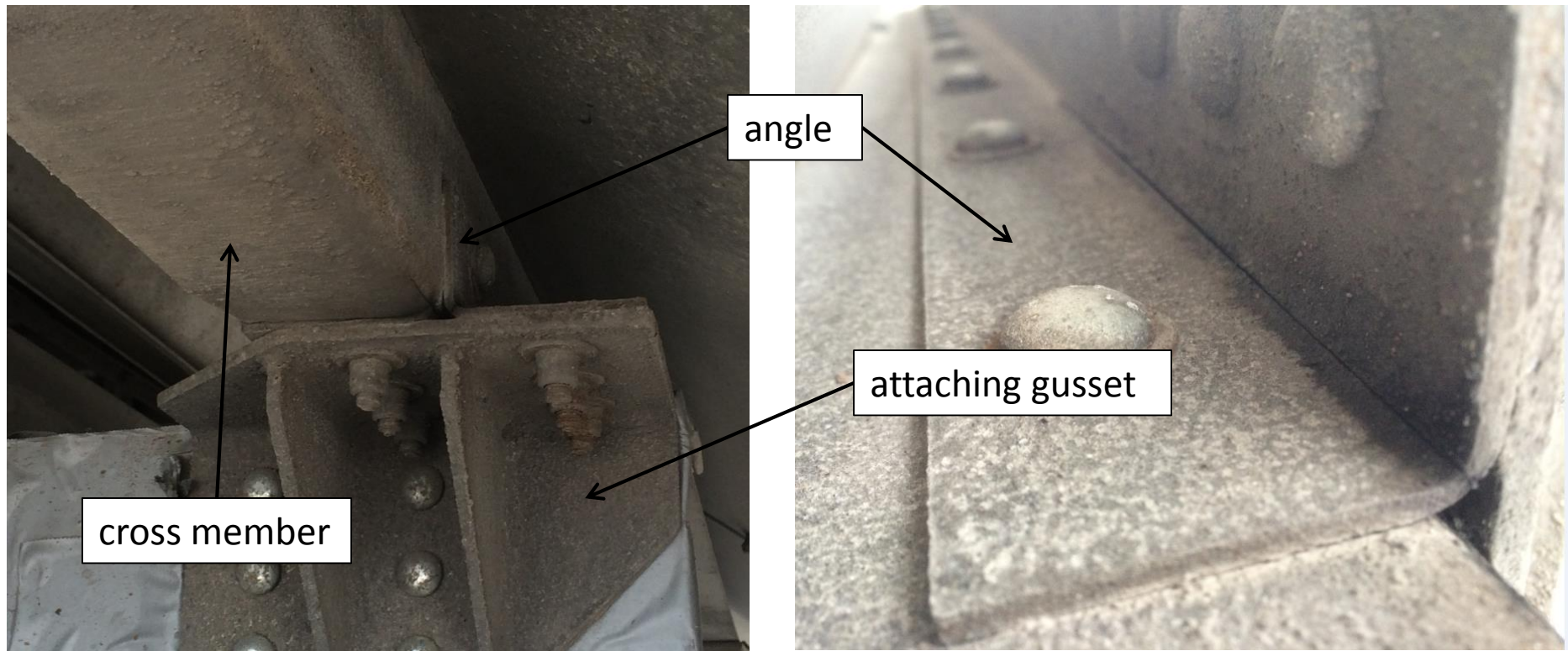
RD-00049

Subframe Front Cross Member Repair

06/09/15

Description of reported problem.

- Cracking found along the front crossmember of the subframe.
- Cracking also found in the angle attached to the front of the crossmember.



Repair

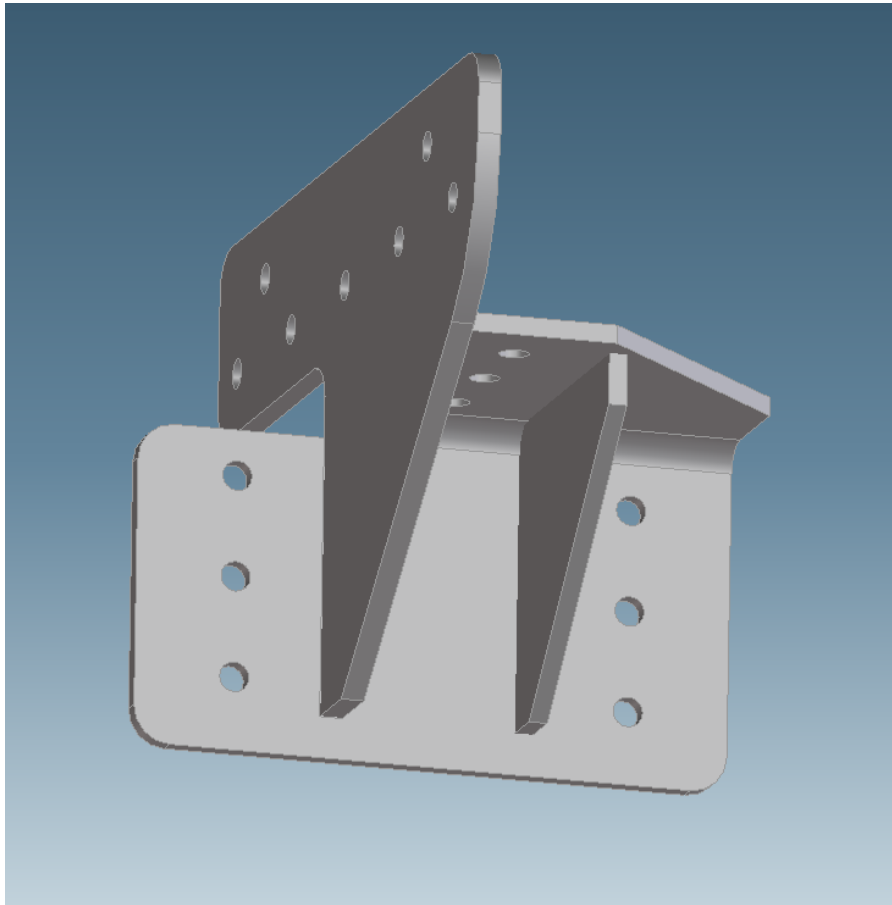
- Remove angle and the attaching gusset from each side.
- Clean cracked area in cross member and flatten any distortion that exists.
- Stop drill the ends of the cracks with a #10 drill bit.
- Grind a groove in the crack for a full penetration weld, weld crack.
- Seal welded areas with a corrosion preventer, i.e. primer and/or undercoating.
- Install the new attaching gusset and sleeve the cross member at each gusset.

Bill of Material

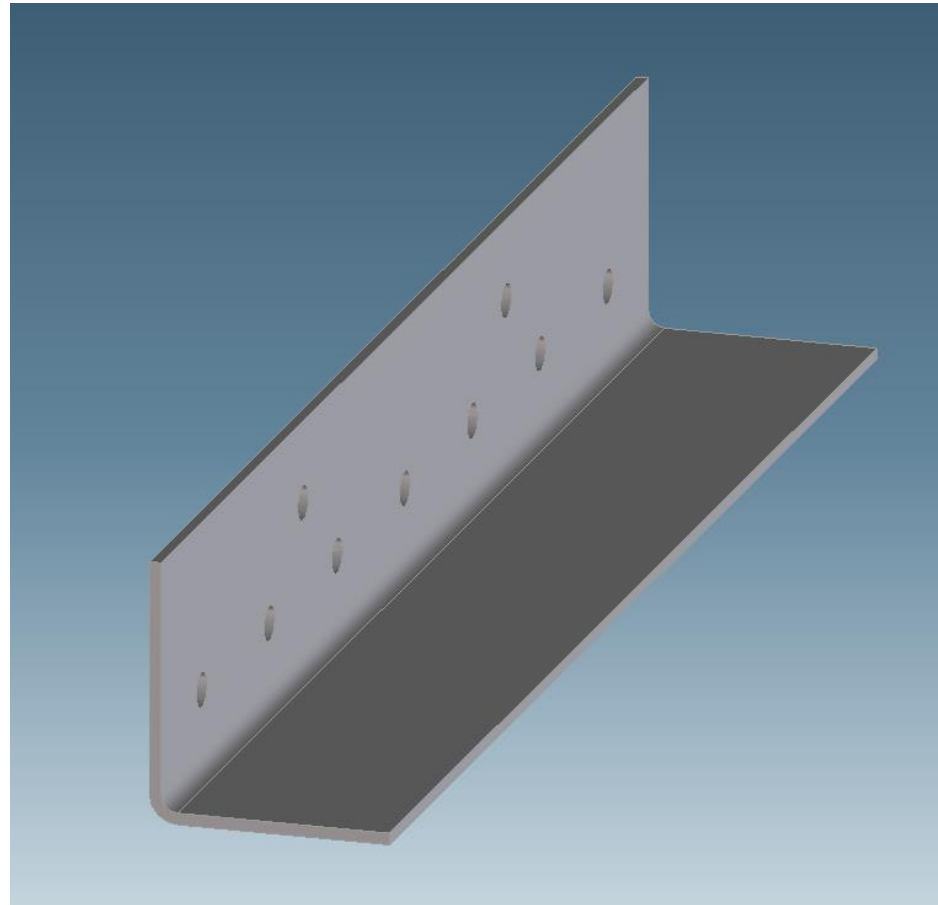
ITEM	QTY	PART #	DESCRIPTION
1	1	17-05279-100	Bracket Assy – LH
2	1	17-05279-200	Bracket Assy – RH
3	2	01-28051	Angle,Reinf
4	36	04-97121	Pin,Huckbolt,C6L,3/8Dia
5	36	04-97119	Collar,C6L

Repair Parts

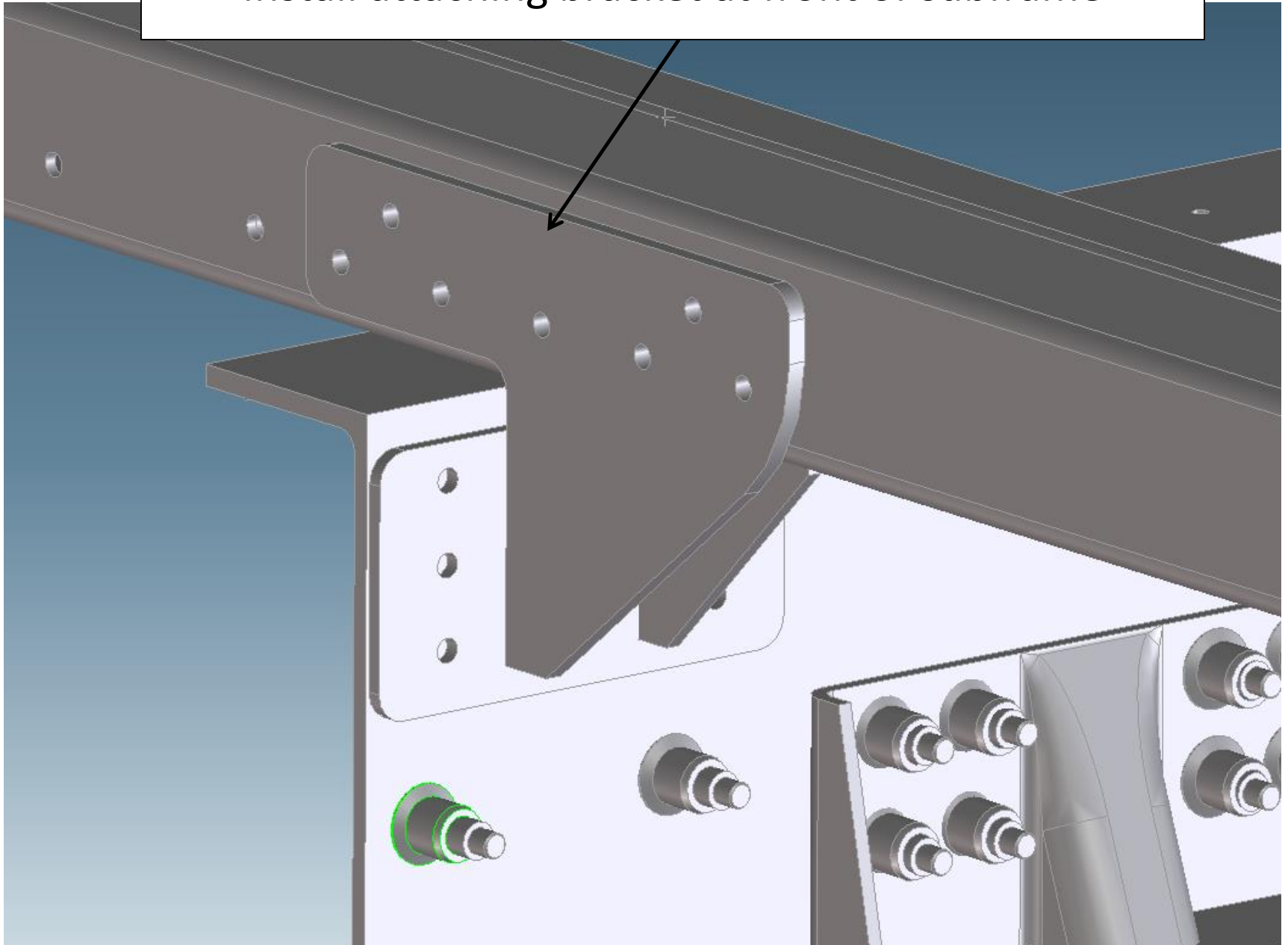
Attaching Gusset #17-05279-100 and -200



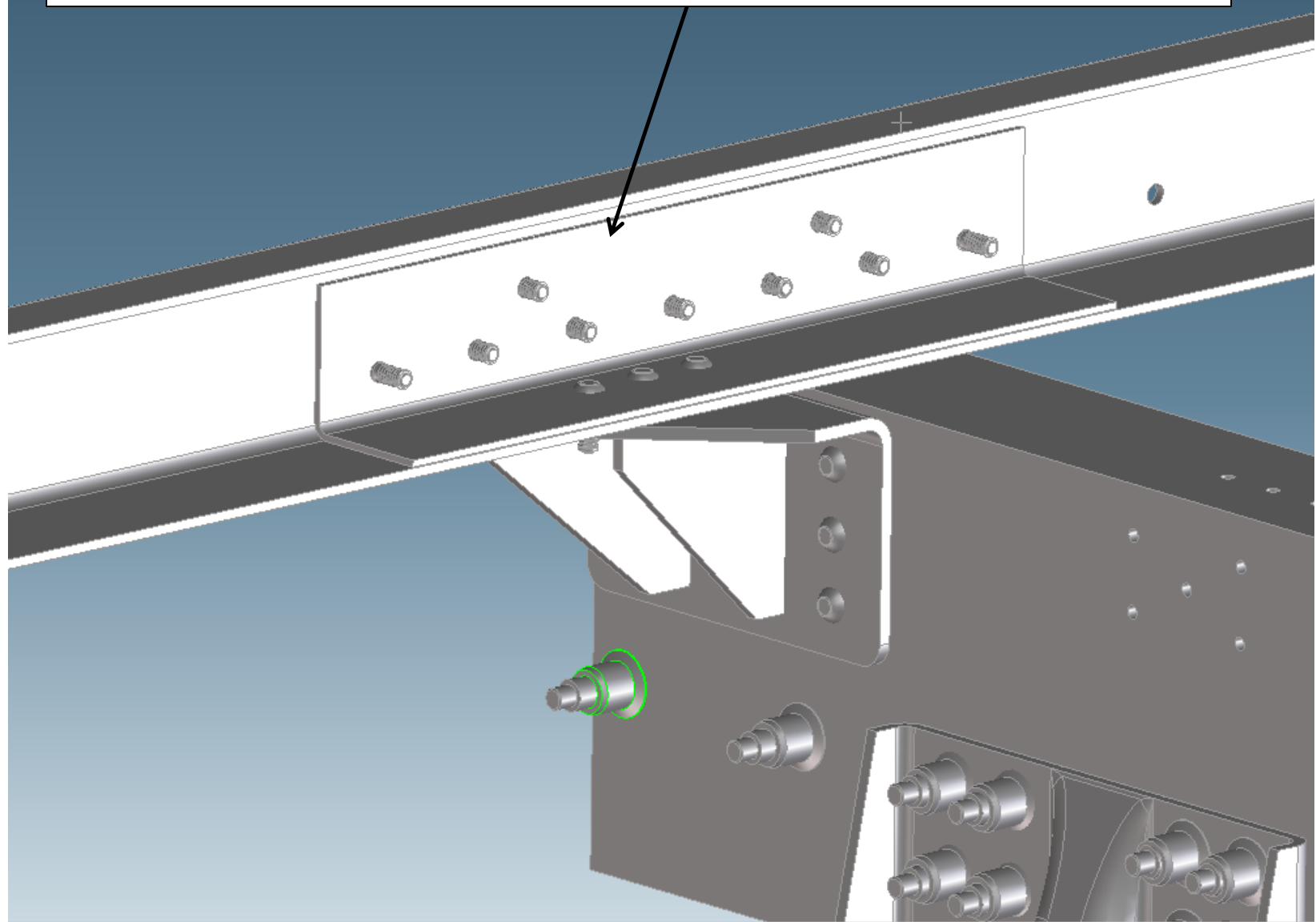
Angle #01-28051



Install attaching bracket at front of subframe



Install reinforcement sleeve on inside of front crossmember, above each bracket



Install install fasteners, 18 each side

