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Major System: FRAME AND BUMPER **Created:** 2/26/2018
Current Language: English **Last Modified:** 2/27/2018
Other Languages: NONE **Author:** Allan Hertko
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Coding Information

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Title: HX SBA Frame Tie Relocation**Applies To:** HX Series (SBA); Applies ONLY to listed (30) VIN's within this IK Document

CHANGE LOG

Please refer to the change log text box below for recent changes to this article:

02/27/2018 - Initial Article Release

DESCRIPTION

Some HX series will require the frame tie bracket to be relocated, see VIN list.

[HX SBA VIN List Located Here](#)

SPECIAL TOOL(s) or SOFTWARE

Tool Description	Tool Number	Comments	Instructions
N/A	N/A	N/A	N/A

SERVICE PART(s) INFORMATION

Kit Description	Part Number	Quantity Required
Flanged Hex Bolt M20-2.5 X 50, CL10.9	31086R1	4
Flanged Hex Nut M20-2.5, CL 10.9	31094R1	4

REPAIR STEP(s)

WARNING! To prevent property damage, personal injury, and / or death, park vehicle on a hard, flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in either direction.

WARNING! To prevent property damage, personal injury, and / or death, if the vehicle must be raised, do not work under the vehicle supported only by jacks. Jacks can slip or fall over.

WARNING! To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

WARNING! To prevent property damage, personal injury, and / or death, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

WARNING! To prevent property damage, personal injury, and / or death, remove the ground cable from the negative terminal of the battery box before disconnecting any electrical components. Always connect the ground cable last.



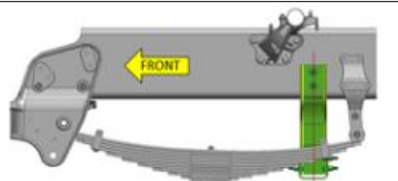
WARNING:

DO NOT use an oxygen/acetylene torch to cut the huck/collars from the bracket.



Figure 1: Location of Frame Tie

BEFORE



AFTER

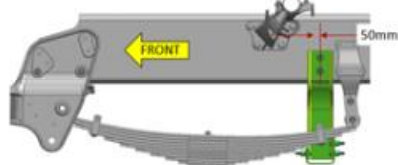
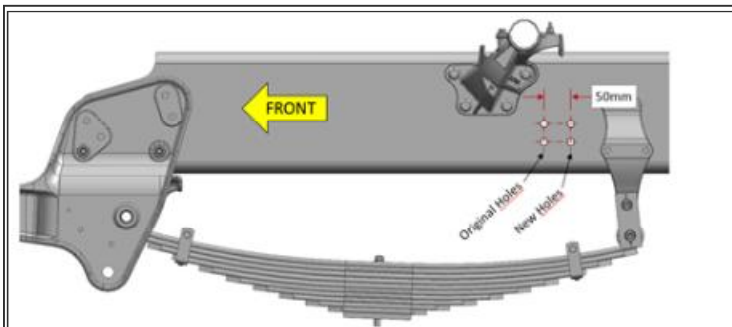


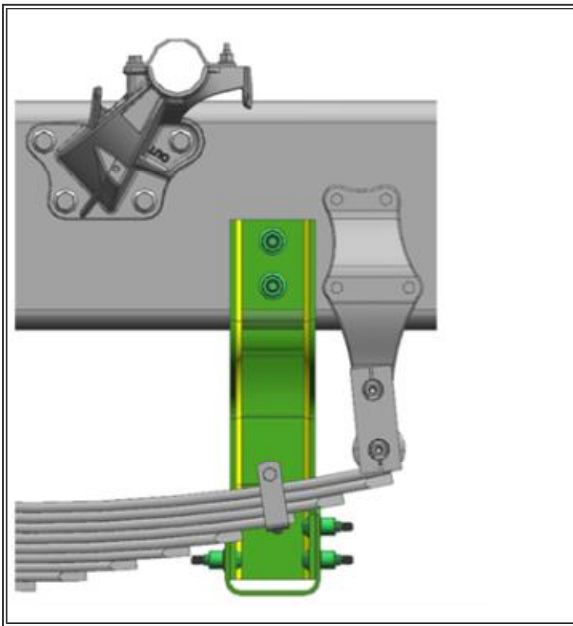
Figure 2: Frame Tie Relocation**CAUTION:**

Prior to drilling and removal of huck/collars, inspect/position wiring harnesses and air lines away from the affected area.

- 1) Install rear wheel chocks, open hood and turn the wheel to access the frame tie bracket.
- 2) Support the frame tie bracket assembly and remove (2) huck/collars.
- 3) Measure and mark the frame from the center line of the original bolt hole 50 mm rearward.

**Figure 3: New mounting location measurements**

- 4) Drill both sides of the frame using a 13/16" bit.
- 5) Position and install frame tie bracket assembly with new hardware and torque: 368-461 ft/lbs (500-625 N/m).

**Figure 4: Frame Tie Mounted with New Bolts/Nuts**

- 6) To prevent rusting spray paint the frame with appropriate color.
- 7) Repeat steps for the other side of the truck.

8) Close hood assembly.

WARRANTY INFORMATION

Warranty Claim Coding:

Refer to the [Warranty Coding Manual](#) for Group and Noun Codes.

Standard Repair Time(s):

Description	SRT	Hours
Frame rail or reinforcement channel drill	A01-110	1.2
Miscellaneous cross-members, brackets, support replace	A01-150	0.5

OTHER RESOURCES

[Master Service Information Site](#)

HX SBA VIN List

3HTDTAPT7HN691497
3HTDTAPT9HN691498
3HTDTAPT0HN691499
3HTDTAPT5HN706529
3HTDTAPT7HN706824
3HTDTAPT6HN706670
3HTDTAPT0HN751202
3HTDTAPT5HN036447
3HTDTAPT5HN761283
3HTDTAPT5HN044791
3HTDTAPT2HN446056
3HTDTAPT3HN470477
3HTDTAPT7HN472796
3HTDTAPT5HN489558
3HSDTAPT5JN490624
3HSDTAPT6JN553914
3HTDTAPT9JN537945
3HTDTAPT0JN537946
3HTDTAPT8JN471145
3HTDTAPT4JN566723
3HTDTAPT6JN566724
3HTDTAPT1JN549765
3HTDTAPT5JN549798
3HTDTAPT1JN695373
3HTDTAPT3JN695374
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