



# Service Bulletin

File in Section: -


Bulletin No.: 18-NA-107

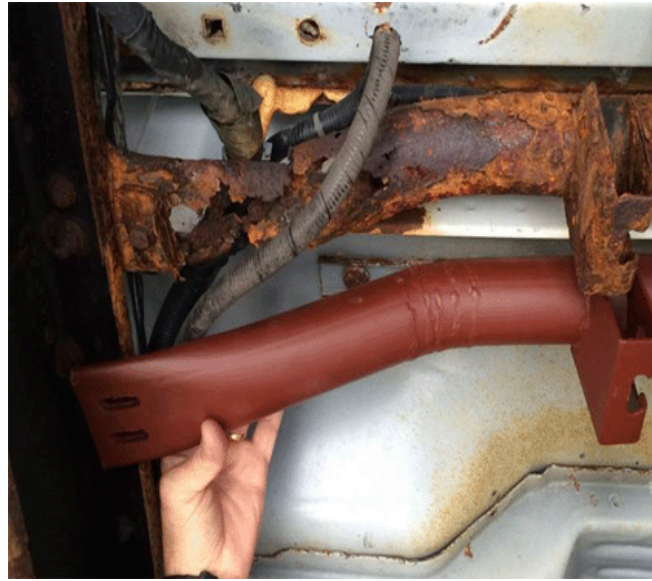
Date: April, 2018

## TECHNICAL

**Subject:** Information on Gas Tank Crossmember Available as Service Part, Original Crossmember Rusted

Brand:	Model:	Model Year:		VIN:		Engine:	Transmission:
		from	to	from	to		
Chevrolet	Silverado HD	2007	2010			All	All
GMC	Sierra HD						

<b>Involved Region or Country</b>	North America
<b>Condition</b>	Some customers may comment on finding rust or corrosion damage to the gas tank crossmember on the vehicle's frame.
<b>Cause</b>	This may be caused by the vehicle being operated in an extremely corrosive environment or may have been exposed to corrosive materials, such as salt in the truck box.
<b>Correction</b>	 <p style="text-align: right;">4994068</p>



5034454

A new crossmember service part has been released to correct this condition.

**Note:** The color of the new service crossmember may not be the same as pictured above.

## Service Procedure

1. Remove the pickup box from the vehicle. Refer to *Pickup Box Replacement* in SI.
2. Remove the rusted crossmember by drilling out the two rivets and removing the two fastening bolts.

**Note:** The current outside diameter of the frame holes is 11 mm.

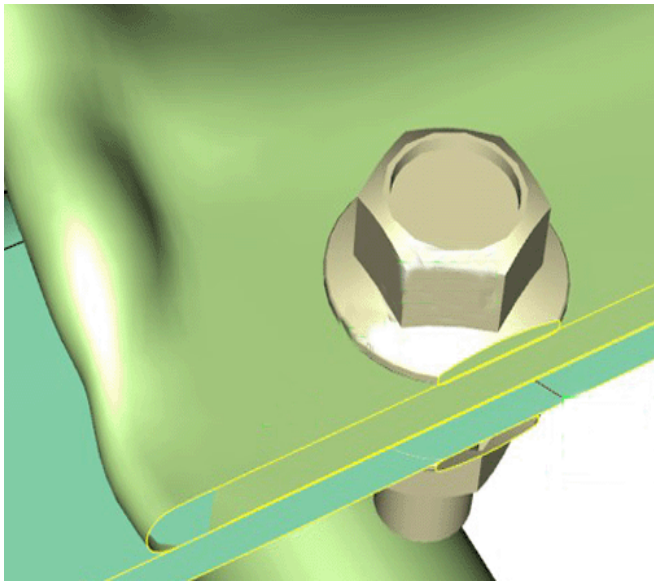
3. Using a 12 mm drill bit, enlarge the frame holes (2 on each side) to 12 mm outside diameter.



4994069

4. Using a rag and wax/grease removing solvent, remove the wax coating and any grease, oil, or undercoating from the truck frame in the affected repair area.

5. Any loose rust or loose flakes should be scraped, wire brushed or ground off.
6. Remove any residual wax, oil or rust by wiping the frame down with a towel or Scotch-Brite™ (3M) pad soaked with wax/grease remover.
7. Using Lloyd's Pure Prep™ Metal Surface Preparation P/N 25418 (10 fluid ounce bottle), or equivalent, saturate a towel or Scotch-Brite™ (3M) pad with the pre-diluted solution and scrub the area well, rendering a foaming of the Pure Prep.™ This will greatly improve adhesion and corrosion resistance in the repair areas.
8. Using a water dampened clean towel, remove any residue and dry the affected area. Dry the repair area completely using an air hose to blow dry the frame.
9. Check the repair area for phosphate treatment by wiping it to see if any corrosion residue can be picked up. Correctly treated areas will not have any residue on the surface.
10. Apply a light flash-coat of Lloyds Kryptonite Metal Treatment P/N 36502 Life Long Rust Protection (14 ounce aerosol), or equivalent, to all rusted and bare areas of the frame where the wax coating was removed. This first coat should flash in approximately 3-5 minutes.
11. Apply a second coat of Lloyds Kryptonite. This can be a heavy coat; double and triple passes with this product, over a light first coat, are not a problem.
12. We suggest top coating the Lloyds Kryptonite with Daubert Nox-Rust® P/N X-121B "One Coat Rust Preventative Coating" (aerosol), or equivalent.
13. Allow the final coat to dry as recommended by the manufacturer.



4994073

**Important:** The captured washer bolt direction is down, meaning the bolt with washer is touching the cross member and the nut is making contact with frame rail from bottom

14. Position the crossmember to frame and install the bolts at the four locations.
15. Holding the bolt head from top side, torque the washer nut to 75 Nm +60 deg (one flat) from the frame side.

**Parts Information**

Dealers should obtain 25418 and 36502 by contacting Lloyds by e-mail at sales@lloydslaboratories.com, or by calling 1-800-361-6766.

U.S. Dealers can obtain the X-121B topcoat by contacting the Daubert website at www.daubertchemical.com or inside the U.S. only, by calling 1-800-914-0034.

Canadian dealers must contact the Daubert distributor in Canada, Corrosion Control Coatings Ltd, by faxing the form below to 1-800-563-8078.

**Important:** ONLY Canadian Dealers should use this form.

Description	Part Number	Qty
CROSSMEMBER ASM-RR	84162982	1
NUT	11546443	4
BOLT ASM - HX HD W/CON WASHER	11519538	4

**Warranty Information**

For vehicles repaired under the Corrosion coverage, use the following labor operation. Reference the Applicable Warranties section of Investigate Vehicle History (IVH) for coverage information.

Labor Operation	Description	Labor Time
1481048*	Crossmember Installation Due to Corrosion	1.4 hr
*This is a unique Labor Operation for Bulletin use only.		

<b>Version</b>	1
<b>Modified</b>	Released April 06, 2018



## GENERAL MOTORS DEALERSHIP ORDER FORM FOR CANADIAN DEALERS ONLY

U.S. Dealers can obtain the X-121B topcoat by contacting the Daubert website at [www.daubertchemical.com](http://www.daubertchemical.com) or inside the U.S. only, by calling 1-800-914-0034.

**Fax Orders to: 1-800-563-8078**

<b>Address</b>	<b>Bill To:</b> _____ _____ _____	<b>Ship To:</b> _____ _____ _____	<b>Dealer #:</b> _____  _____ _____ _____  <b>Contact Name:</b> _____
<b>Phone:</b>	<b>Fax:</b>	<b>Phone:</b>	<b>Fax:</b>
<b>Nox Rust X121B Aerosol Rust Preventive Coating</b> Case (12 cans per case)  # _____ of cases # _____ of cans		<b>Cost per Case</b> <b>\$ 195.00 + shipping &amp; applicable tax</b>  <b>Cost per Can</b> <b>\$16.25 + shipping &amp; applicable tax</b>	
<b>Order Desk Information:</b> Corrosion Control Coatings Ltd. 106 Colborne Street Walkerton, Ontario N0G 2V0  Phone: 519-881-1594 or 800-934-7771 Fax: 800-563-8078 E-Mail: <a href="mailto:lpegelo@cc-coatings.com">lpegelo@cc-coatings.com</a>		<b>Payment Information:</b>  All orders require payment by Credit Card. Please include credit card information.  Credit Card # -----  Expiry Date: -----  <i>Only Visa or MasterCard Accepted</i>	
<b>Special Notes:</b>			
<b>Confirmation:</b> (CC Use only)	<b>Ship Date:</b> _____  <b>Rec'd By:</b> _____		

GM bulletins are intended for use by professional technicians, NOT a "do-it-yourselfer". They are written to inform these technicians of conditions that may occur on some vehicles, or to provide information that could assist in the proper service of a vehicle. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do a job properly and safely. If a condition is described, **DO NOT** assume that the bulletin applies to your vehicle, or that your vehicle will have that condition. See your GM dealer for information on whether your vehicle may benefit from the information.



WE SUPPORT VOLUNTARY  
TECHNICIAN  
CERTIFICATION

