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Coding Information

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Title: HX Rear Crossmember Cracking

Applies To: HX Series Vehicles

DESCRIPTION

This document will guide the user through replacing the crossmember with the newly designed crossmember.

SYMPTOMS

DTC/Light	Description
N/A	N/A

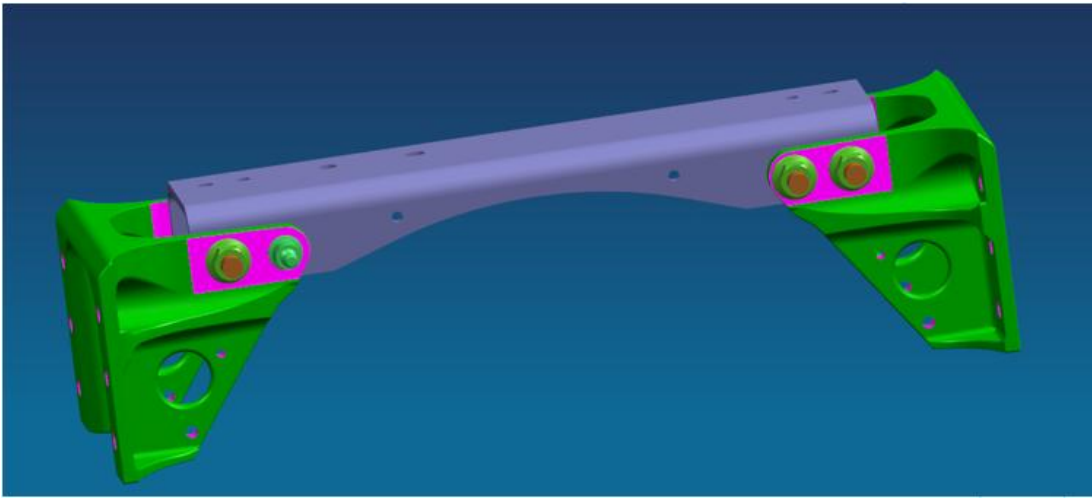
SPECIAL TOOLS / SOFTWARE

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

SERVICE PARTS INFORMATION

Kit Description	Part Number	Qty. Required	Notes
CROSSMEMBER , CAB	4232322C91	1	
BOLT M16 X 60MM PHC FLG CLASS	30753R2	12	
NUT HEX M16 PRVTRQ	30756R1	14	
BOLT M16 X 40MM PHC FLG CLASS	30750R2	2	
BOLT M12 X 35 HEX FLG HD	30745R2	4	
NUT HEX M12 FLANGED	30755R1	4	

NOTE: Picture shows what the crossmember will look like when repairs are completed.



DIAGNOSTIC STEPS

N/A

REPAIR STEPS

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.

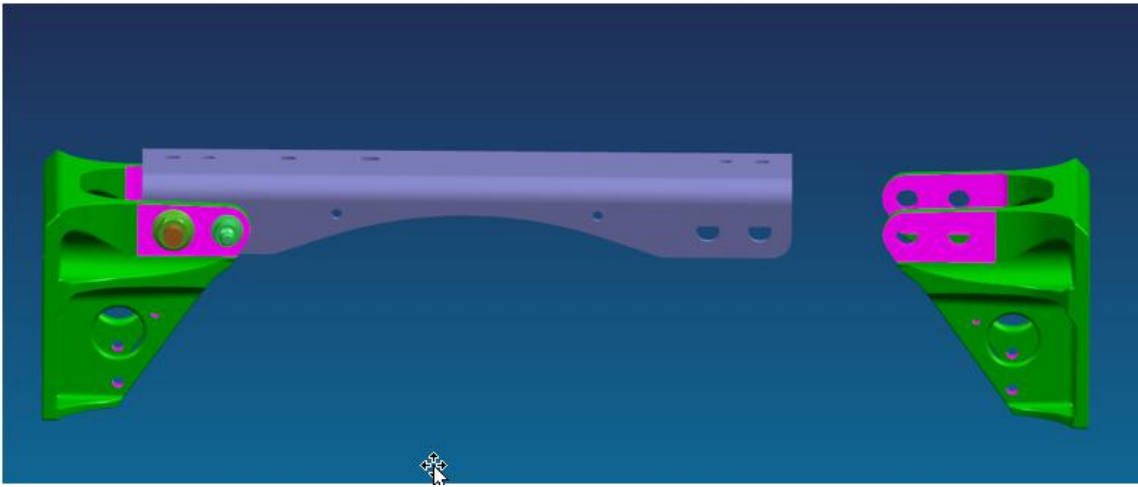
WARNING! To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

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.

1. Bring vehicle into shop and park on a flat surface
2. Shift transmission into park or neutral, set parking brake and install wheel chocks
3. Unbolt the passenger side bracket from the assembly. **The bolts and nuts will be reused for assembly.** Disassembling the end bracket allows the cross member to fit inside the rails

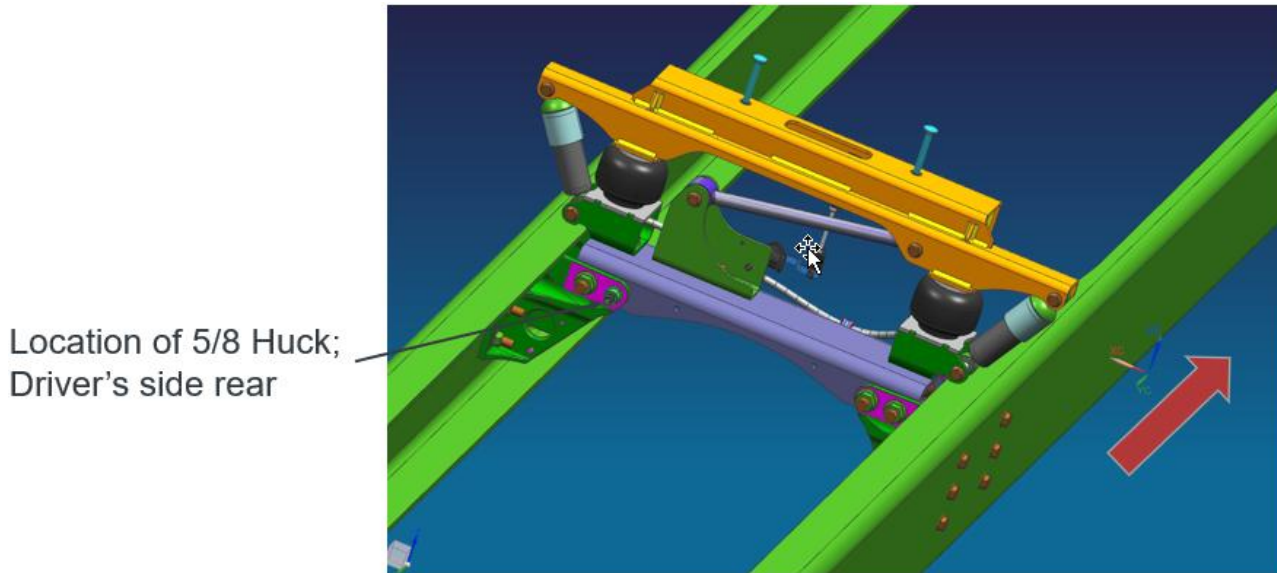
NOTE: Save the bolts and nuts as some will be reused for assembly.



4. Raise cab suspension and support the cab so that the suspension components can be unbolted from the cab cross member.

5. Unbolt the cab suspension from the cross member. Remove the old cross member from the frame.

6. The replacement cross member will come assembled. The design has maintained one 5/8 Huck which gets oriented on the driver's side rear as shown below:



Location of 5/8 Huck;
Driver's side rear

Arrow points toward front of truck

A. Slide in the disassembled cross member and fit the end brackets to frame connection with new M16 frame bolts/nuts – 30753R1/30756R1.

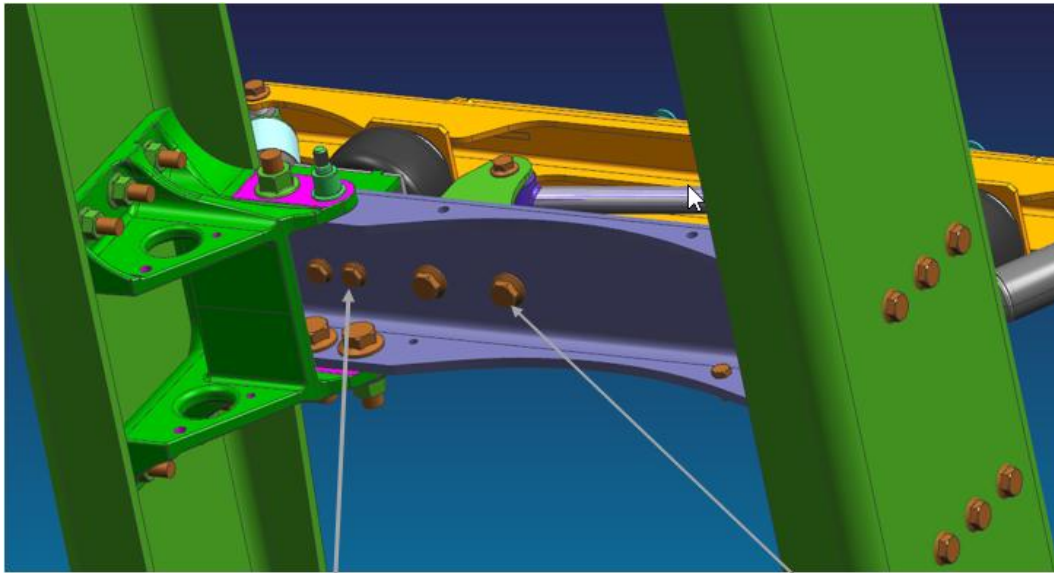
Do not tighten until all the bolts being replaced have been fitted.

B. Assembly the M20 bolt/nuts on the passenger end bracket in the orientation as shown in slide 2.

Do not tighten yet.

C. Assembly all the bolt cab suspension bolts with the new hardware to ensure assembly.

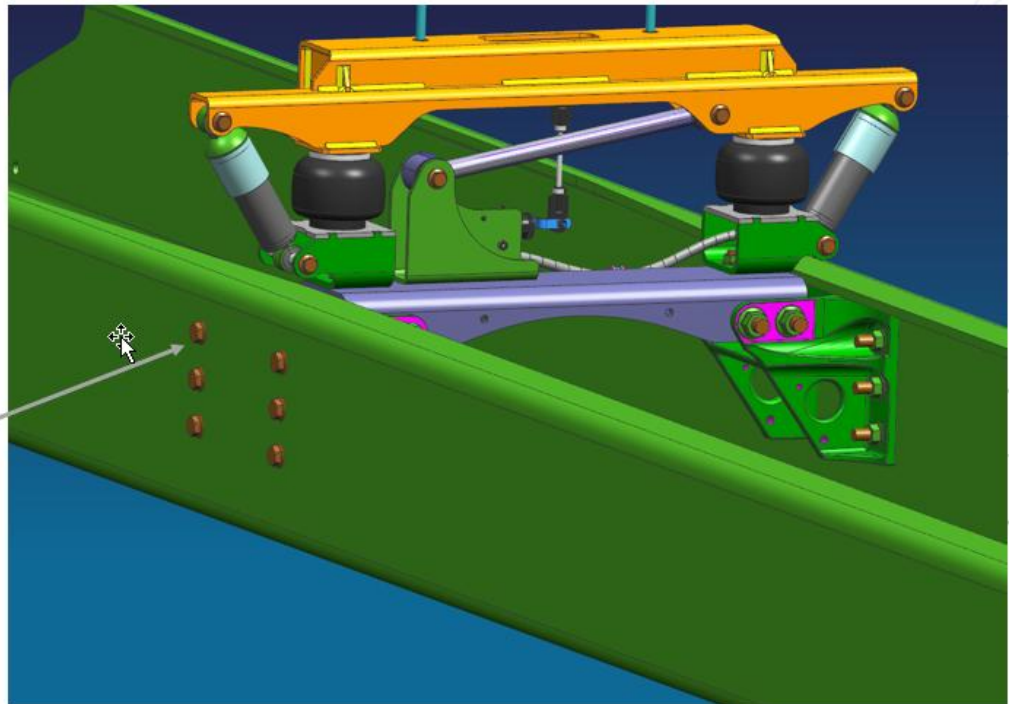
Do not tighten yet.



Installed new M12 x 35 bolt/ Nut -
30745R2/ 30746R1 on both sides

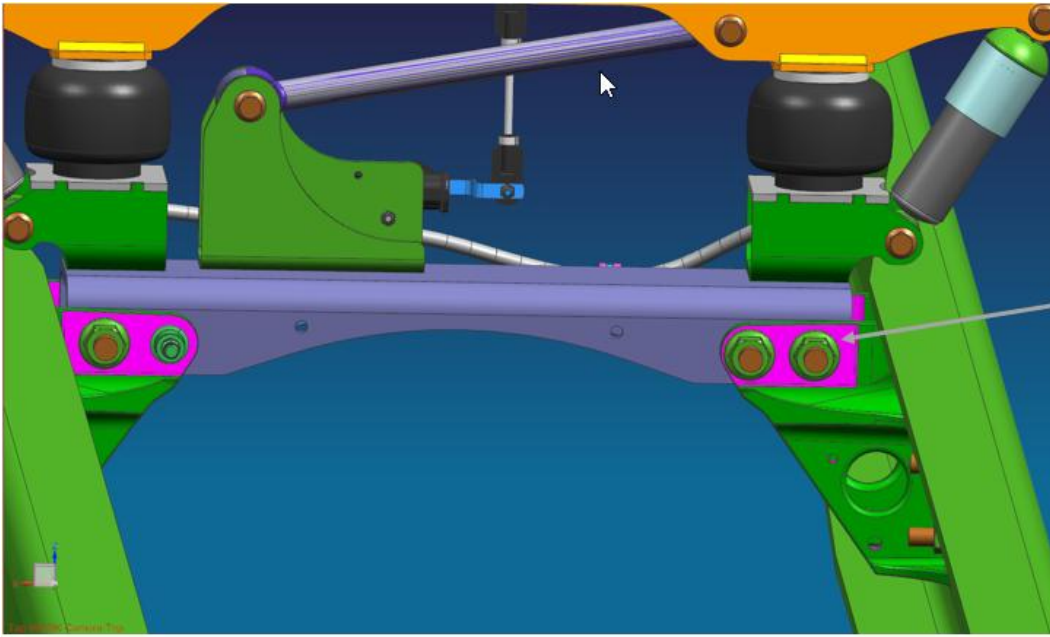
Installed new M16 x 40 bolt/ Nut –
30750R2/ 30756R1

7. Tighten driver's side bolts first and then the passenger's side. Ensure the alignment while tightening.

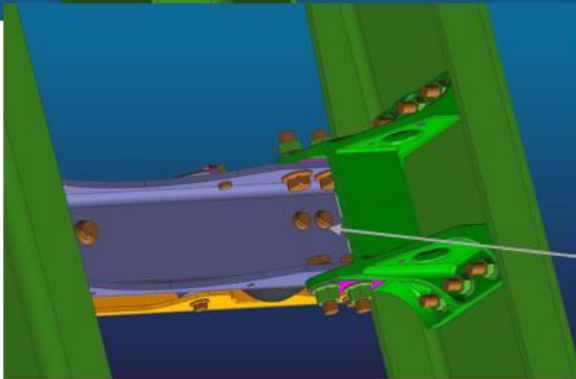
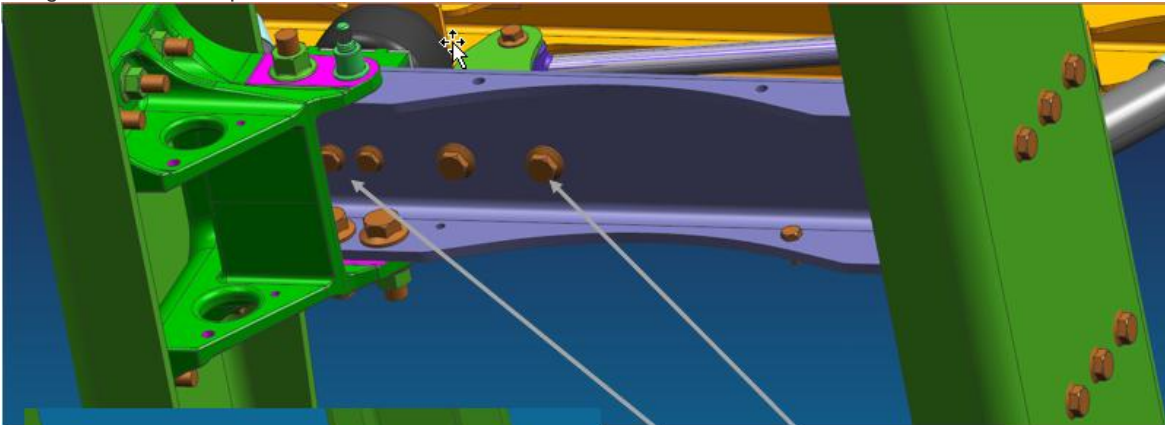


Torque M16 bolts
30753R2/30756R1 to
310 Nm (229 ftlbs)

8. Torque the M20 bolt/nut 31087R1/40204R1 to 593Nm/437ftlbs
NOTE: These fasteners were removed from the assembly are to be reused.



9. Tighten the cab suspension hardware to the crossmember.



Torque as follows –

M16 – 310 Nm (229 ftlbs)

M12 – 129 Nm (95 ftlbs)

10. Remove wheel chocks

11. Return vehicle back to service

Warranty Information

Warranty Claim Coding:

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

Standard Repair Time(s):

Refer to the [SRT Manual](#) for Repair Times

Other Resources

[Master Service Information Site](#)

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