



**NUMBER:** 23-044-22

**GROUP:** 23 - Body

**DATE:** October 20, 2022

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**This Technical Service Bulletin (TSB) has also been released as a Rapid Service Update (RSU) 22-197, date of issue October 20, 2022. All applicable Sold and Un-Sold RSU VINs have been loaded. To verify this RSU service action is applicable to the vehicle, use VIP or perform a VIN search in DealerCONNECT/Service Library. All repairs are reimbursable within the provisions of warranty. This RSU will expire 18 months after the date of issue.**

**SUBJECT:**

Noise from Rear Cargo Area of Vehicle

**OVERVIEW:**

This bulletin involves repairing missing welds and repainting the rear wheel tub area.

**MODELS:**

2022 (VF) RAM ProMaster

**NOTE: This bulletin applies to vehicles within the following markets/countries: North America.**

**NOTE: This bulletin applies to vehicles built on or before June 13, 2022 (MDH0613XX).**

**SYMPTOM/CONDITION:**

The customer may notice a noise from the rear cargo area.

**DIAGNOSIS:**

Using a Scan Tool (wiTECH) with the appropriate Diagnostic Procedures available in DealerCONNECT/Service Library, verify all related systems are functioning as designed. If DTCs or symptom conditions, other than the ones listed above are present, record the issues on the repair order and repair as necessary before proceeding further with this bulletin.

If a customer's VIN is listed in VIP or your RSU VIN list, perform the repair. **This bulletin applies to vehicles on the RSU VIN list only.**

1. Inspect the welds at the rear of the wheel tubs. Are they missing? (Fig. 1) , ( Fig. 2)
  - YES>>> Proceed to [Step 1](#) of the Repair Procedure.
  - NO>>> This bulletin has been completed, use inspect LOP (23-70-01-95) to close the active RSU.

**PARTS REQUIRED:**

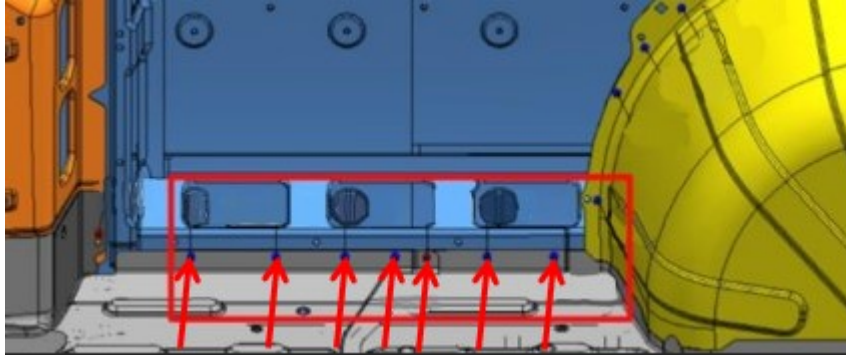
Qty.	Part No.	Description
1 (AR)	NPN	Bonderite® C-S0 263 Wipes

**NOTE: Some additional upfitter components may have to be removed to access these welds.**

**REPAIR PROCEDURE:**

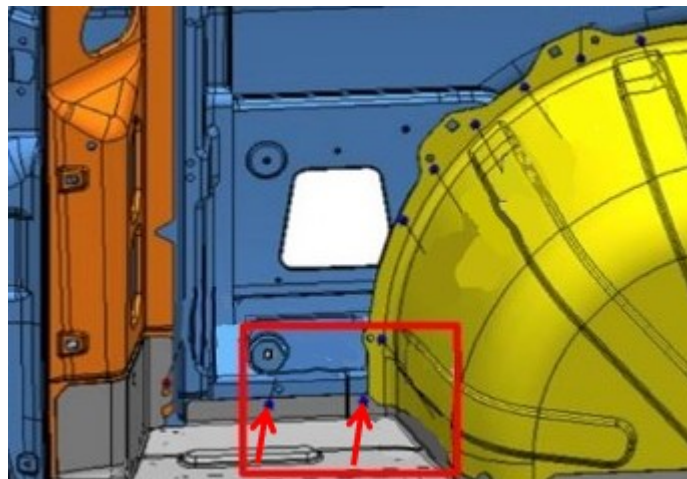
1. With a paint grinder or disk sander, grind all paint and e-coat at the missing seven (long wheelbase) (Fig. 1) , or two (Short wheelbase) (Fig. 2) weld flanges.

**NOTE: Grind only at weld locations. Avoid thinning the flanges over 10%.**



**Fig. 1**

**Long Wheelbase Missing Weld Points**



**Fig. 2**

**Short Wheelbase Missing Welds Points**

- Using a 10-12 mm ( 3/8"- 15/32") hole saw cutter or equivalent, drill holes in one or two metal thicknesses for 2T or 3T conditions, respectively (Fig. 3) .

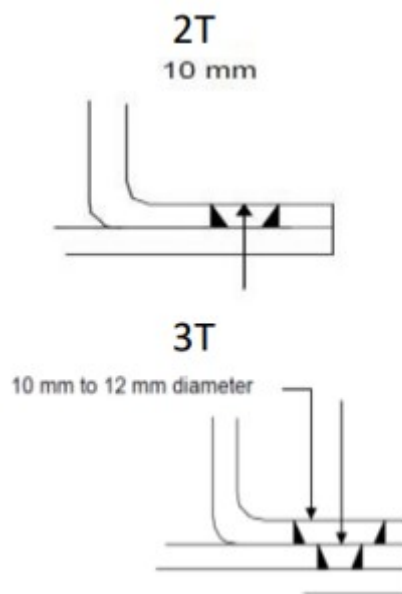


Fig. 3

Hole Saw Cutter Diameter Options

**NOTE: Drill only the upper sheet if 2T, drill two sheets when 3T. Blow out with air after drilling.**

- Plug weld per approved FCA Specifications. Refer to the detailed Service Procedures found in DealerCONNECT>Service Library under: 31 - Collision Information / Standard Procedure> Welding And Weld Bonding.
- After welding, use a finish orbiter and grind contour for the plug welds.

**NOTE: Avoid thinning of the components.**

- Apply cold Phosphate (Bonderite® C-S0 263 Wipes) based on procedure PSOP 1011.

**NOTE: Allow cold phosphate to dry.**

- Apply flash zinc primer (Code: DPX 1828, MS-PB16-2), based on anti-corrosive procedure PSOP 1003.
- Perform a paint match of the body to get the correct color for the repaired area.  
Which type of basecoat will be used?
  - Solvent basecoat >>> proceed to [Step 1](#) of the Solvent Basecoat Procedure.
  - Waterborne basecoat >>> proceed to [Step 1](#) of the Waterborne Basecoat Procedure.

**Solvent Basecoat Procedure:**

1. If using solvent basecoat procedure, paint the repaired area accordingly.
2. Refer to the approved refinish paint suppliers (Akzo Nobel, Axalta, BASF, PPG, SherwinWilliams and Valspar) recommended process for cleaning the primed surface area.
3. Apply DAS302X sealer or equivalent.
4. Apply DBC basecoat with DX57 hardener or equivalent.
5. Apply DC4000 clearcoat with SL814 universal flexibilizer or equivalent.
6. Repair is complete.
7. Test drive vehicle to validate noise is eliminated.

**Waterborne Basecoat Procedure:**

1. If using waterborne basecoat procedure, paint the repaired area accordingly.
2. Refer to the approved refinish paint suppliers (Akzo Nobel, Axalta, BASF, PPG, SherwinWilliams and Valspar) recommended process for cleaning the primed surface area.
3. Apply ECS2X sealer or equivalent.
4. Apply EHP basecoat with T492 and T581 hardener or equivalent.
5. Apply DC4000 clearcoat with SL814 universal flexibilizer or equivalent.
6. Repair is complete.
7. Test drive vehicle to validate noise is eliminated.

**POLICY:**

Reimbursable within the provisions of the warranty.

**TIME ALLOWANCE:**

Labor Operation No:	Description	Skill Category	Amount
23-70-01-95	Plug Welds - Inspect (1- Semi-Skilled)	6 - Electrical and Body Systems	0.2 Hrs.
23-70-01-96	Plug Welds - Inspect, Repair, and Paint (One Side) - Material Allowance \$104.30 Includes Paint Prep Labor Time (Short Wheel Base) (1- Semi-Skilled)	6 - Electrical and Body Systems	4.8 Hrs.
23-70-01-97	Plug Welds - Inspect, Repair, and Paint (Both Sides) - Material Allowance \$208.60 Includes Paint Prep Labor Time (Short Wheel Base) (1- Semi-Skilled)	6 - Electrical and Body Systems	8.5 Hrs.
23-70-01-98	Plug Welds - Inspect, Repair, and Paint One Side - Material Allowance \$104.30 Includes Paint Prep Labor Time (Long Wheel Base) (1- Semi-Skilled)	6 - Electrical and Body Systems	7.8 Hrs.

Labor Operation No:	Description	Skill Category	Amount
23-70-01-99	Plug Welds - Inspect, Repair, and Paint Both Sides - Material Allowance \$208.60 Includes Paint Prep Labor Time (Long Wheel Base) (1- Semi-Skilled)	6 - Electrical and Body Systems	14.5 Hrs.

**FAILURE CODE:**

ZZ	Service Action
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