



HYUNDAI

Technical Service Bulletin

GROUP	NUMBER
CAMPAIGN	25-01-052H
DATE	MODEL(S)
OCTOBER 2025	SANTA CRUZ (NXT) SANTA FE (MX5A)

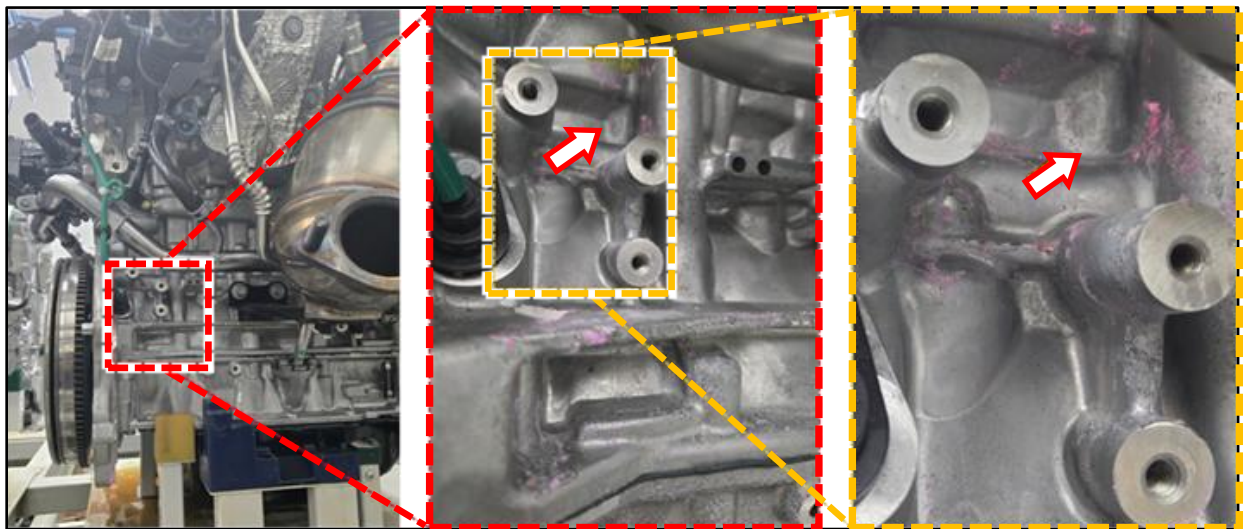
SUBJECT: 2.5T-GDI ENGINE REPLACEMENT FOR COOLANT LEAK
(SERVICE CAMPAIGN 9C3)

*** IMPORTANT**

Dealers must perform this service campaign on all affected vehicles prior to customer retail delivery and whenever an affected vehicle is in the shop for any maintenance or repair.

Access the “Vehicle Information” screen via WebDCS to identify open campaigns.

Description: Certain 2025MY Santa Cruz (NXT) and Santa Fe (MX5A) vehicles equipped with the 2.5T-GDI Theta III engine may exhibit coolant residue on the back side (exhaust side) of the engine caused by a crack in the cylinder block. Follow the procedure outlined in this bulletin to replace the engine sub-assembly on affected vehicles.







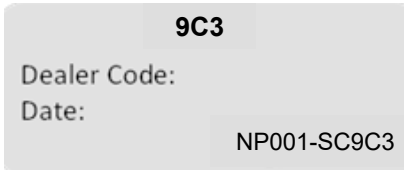

i Information

A Prior Approval (PA) request is **NOT** required to order the engine for this campaign.

Applicable Vehicles (Certain):

Model Year	Model	Engine	Production Dates
2025	Santa Cruz (NXT)	2.5T-GDI	02/04/2025
	Santa Fe (MX5A)		12/13/2024 – 01/25/2025

SUBJECT:**2.5T-GDI ENGINE REPLACEMENT FOR COOLANT LEAK
(SERVICE CAMPAIGN 9C3)****Parts Information:**

Model	Part Name	Part Number	Figure	Remarks
Santa Cruz (NXT)	Complete Engine Assy – Sub Kit	11HT0-2SK00QQH (2WD and 4WD)		Partial Service Kit included with Engine Sub-Assy (Includes Engine Oil) Qty: 1
Santa Fe (MX5A)		83HT0-2SK00QQH (2WD and 4WD)		
Santa Cruz (NXT) & Santa Fe (MX5A)	O-Ring	97690-34350		A/C Discharge O-Ring (Compressor Side) Qty: 1
	O-Ring	97690-34330		A/C Suction O-ring (Compressor Side) Qty: 1
	Pink, Antifreeze/ Coolant	00232-19098		Qty: 2 gallons
	Campaign Sticker	NP001-SC9C3		Apply to all vehicles regardless of state
	Vehicle Emission Recall - Proof of Correction Card	NP050-09006		Order only for states: CA, CO, CT, DE, ME, MD, MA, NJ, NY, OR, PA, RI, VT, WA

SUBJECT:**2.5T-GDI ENGINE REPLACEMENT FOR COOLANT LEAK
(SERVICE CAMPAIGN 9C3)****Parts Information (continued):*****i* Information**

Components listed below are provided with the new engine sub-assembly. Do **NOT** order these parts separately.

Model	Part Name	Part Number	Remarks
Santa Cruz (NXT) & Santa Fe (MX5A)	Exhaust Pipe Gasket (Front)	28751-3S100	Qty: 1
	Exhaust Pipe Gasket (Rear)	28751-2S000	Qty: 1
	Steering Joint Assembly - Bolt	56415-L1000	Qty: 1
	Split Pin (Outer Tie Rod to Spindle) + (LCA Ball Joint)	57799-4D200	Qty: 4
	Lock Nut (Outer Tie Rod to Spindle)	55259-2M000	Qty: 2
	Roll Rod Bracket Bolt	21991-P6000	Qty: 1
	Castle Nut (Front Axles)	49551-4T000	Qty: 2
	Front and Rear Propeller Shaft Bolts	11435-10256-K	Qty: 7 (Only for AWD)
	Front Stabilizer Bar Nuts	54559-1F000	Qty: 2
	Engine Support Bracket Nuts	51759-F6000	Qty: 3

SST Information:

Tool Name	Tool Number	Figure	Ordering Information
Ball Joint Separator	09568-2J100		Website: https://hyundaiesentialtools.com/ Email: Hyundaitools@snapon.com Phone: 1-855-763-9199 Hours: 7 AM – 7 PM CST
Lower Control Arm Ball Joint Separator	09568-4R100		
AGA Lift Table XL	AGALIFTXL		
Water Pump Belt Remover & Installer	09252-C1000		

NOTE: Commercially available equivalent tools may be used instead.

SUBJECT:**2.5T-GDI ENGINE REPLACEMENT FOR COOLANT LEAK
(SERVICE CAMPAIGN 9C3)****Warranty Information:**

Model	Drivetrain	Op. Code	Operation	Op. Time	Causal Part	Nature Code	Cause Code
Santa Cruz (NXT)	4WD	50DA04R1	Engine Sub-Assembly Replacement (Wheel Alignment Adjustment Included)	8.0 M/H	24HS1-2SK00	L31	ZZ3
Santa Fe (MX5A)	4WD	50DA04R2		7.3 M/H			
	2WD	50DA04R3		7.0 M/H			

NOTE 1: Submit claim on Claim Entry Screen as “Campaign” type.

NOTE 2: If a part is found in need of replacement while performing this campaign and the affected part is still under warranty, submit a separate claim using the same repair order. If the affected part is out of warranty, submit a Prior Approval request for goodwill consideration prior to performing the work.

NOTE 3: This TSB includes repair validation photos. Op times include VIN, mileage, and repair validation photo(s) as outlined in the Digital Documentation Policy.

NOTE 4: The incident parts are subject to callback through the normal Warranty Technical Center (WTC) parts return process. **Claim is subject to debit if the part is not returned.**

NOTE 5: Dealer will be reimbursed for 2 gallons of coolant under each operation code.

NOTE 6: A Prior Approval (PA) number is **not** required for this engine replacement.

Service Procedure:**DIGITAL DOCUMENTATION**

This TSB includes repair validation photos. Refer to the latest Warranty Digital Documentation Policy for requirements.

NOTICE

Applying the recommended torque to all fasteners is essential to reduce potential issues from occurring after the service procedure.

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Engine Replacement

1. Remove the engine sub-assembly from the affected vehicle.

Refer to the shop manual:

- **Engine Mechanical System > Engine and Transaxle Assembly > Engine and Transaxle Assembly > Repair procedures**



2. The new engine sub-assembly will contain many components already pre-installed onto the engine. Do **NOT** remove the components listed below from the original engine sub-assembly.

- Intake Manifold
- Throttle Body
- Dual Mass Flywheel
- Alternator Assembly
- Throttle Body
- High Pressure Fuel Components
- Ignition Coils and Spark Plugs
- Exhaust Manifold
- Turbocharger Assembly
- Water Pump Assembly
- Crankshaft Pulley
- Idler / Tensioner Assembly
- ITM Assembly

Transfer all remaining components from the original engine sub-assembly to the **new** one.

NOTICE

Do **NOT** damage or discard the old engine sub-assembly.

Refer to the shop manual for more details:

- **Engine Mechanical System > Engine and Transaxle Assembly > Engine and Transaxle Assembly > Repair procedures**



- Place the **original** engine sub-assembly in the same crate that the new engine sub-assembly arrived in.

NOTICE

Do **NOT** damage or discard the crate in any manner; claim is subject to chargeback if damage is found.



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DIGITAL DOCUMENTATION

Using the STUI camera function, take a photo of the new engine serial number.

Upload the photo to STUI.

NOTE: If the STUI camera function is **NOT** used, write the last 6 digits of the VIN and date of repair on a piece of paper to include in the photo.



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- Install all remaining parts in reverse order of the removal process.
- Reinstall and connect the cooling system components.

Then fill the cooling system with approximately **35-50%** coolant/anti-freeze, diluted with distilled water.

7. **Before** starting the engine:

- Verify the engine oil level is at the “Full” mark as shown.

i Information

The new engine sub-assembly will come pre-filled with engine oil.



- Disable the fuel system temporarily by removing the **10A Fuel Pump (Santa Fe) or 20A Fuel Pump (Santa Cruz)** fuse in the engine fuse box cover.
- Crank the engine for **approximately 5 seconds** to prime the lubrication system and reinstall the removed fuse.

8. Start the engine to warm it up and begin the cooling system air bleeding process.

Refer to the shop manual:

- **Engine Mechanical System > Cooling System > Coolant > Repair procedures**

S/W Management	
5NMP44GL3SH068791 B28AAca526250529001F SANTA FE(MX5A)/2025/G 2.5 T-GDI	
Integrated Thermal Module Coolant Filling Mode	
Purpose	This mode assists coolant refilling by opening the coolant flow line for the engine equipped with an ITM.
Enable Condition	1. IG ON, ENG RUN 2. Transmission position P / Parking brake ON 3. Vehicle speed 0km/h (0 mile/h) 4. Coolant temperature is 90°C or under
Concerned Component	ITM
Concerned DTC	-
Fail Safe	-
Etc	-

9. Check for any coolant leaks during the air bleeding process.

10. After the engine has warmed up to normal operating temperature, turn the engine **OFF**, then wait **approximately 10 minutes** to allow oil to return to the oil pan.

Verify the engine oil level is still at the “Full” mark.

11. Perform a wheel alignment.

Refer to the shop manual:

- **Suspension System > Tires/Wheels > Alignment > Alignment or Adjustment**

12.

DIGITAL DOCUMENTATION



Using the STUI camera function, take a photo of the completed alignment sheet clearly showing the vehicle's VIN and date of alignment .

Upload the photo to STUI.

NOTE: If the STUI camera function is **NOT** used, write the last 6 digits of the VIN and date of alignment on a piece of paper to include in the photo.



13. Verify all fluids have been filled fully, then complete the following quality checks:
- Erase all DTCs that have incidentally occurred during the engine sub-assembly replacement.
 - Reset the engine adaptive values using the GDS.
14. Proceed to [Campaign Sticker Application \(for All Vehicles\)](#) on the next page.

Campaign Sticker Application (for All Vehicles)

1. Fill in the Dealer Code and Date on the Campaign Sticker, and apply adjacent to the existing Emission Label, on the underside of the hood, as shown.

Be sure to clean the mounting surface to ensure proper label adhesion.



- 2.

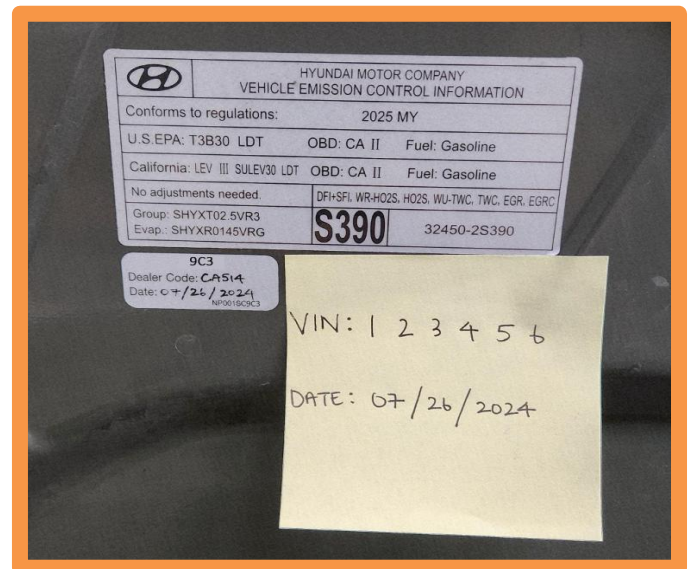
DIGITAL DOCUMENTATION



Using the STUI camera function, take a clear photo of the campaign sticker attached to the vehicle.

Upload the photo to STUI.

NOTE: If the STUI camera function is **NOT** used, write the last 6 digits of the VIN and date of repair on a piece of paper to include in the photo.



3. Proceed to the next section and complete the [Vehicle Emission Recall - Proof of Correction Card](#) for the states listed.

If **NOT** applicable to your state, the repair process is complete.

SUBJECT:**2.5T-GDI ENGINE REPLACEMENT FOR COOLANT LEAK
(SERVICE CAMPAIGN 9C3)****Vehicle Emission Recall – Proof of Correction Card (for Vehicles Registered in Certain States)**

For vehicles registered in California, Colorado, Connecticut, Delaware, Maine, Maryland, Massachusetts, New Jersey, New York, Oregon, Pennsylvania, Rhode Island, Vermont, and Washington:

VEHICLE EMISSION RECALL - PROOF OF CORRECTION CARD

A Vehicle Emission Recall - Proof of Correction card must be filled out for all vehicles registered in California, Colorado, Connecticut, Delaware, Maine, Maryland, Massachusetts, New Jersey, New York, Oregon, Pennsylvania, Rhode Island, Vermont, and Washington. Residents of these states, who own an affected vehicle, will be required to possess a Vehicle Emission Recall - Proof of Correction card as evidence of voluntary service campaign completion, when they apply for vehicle registration renewal.

WHAT TO DO WITH THE CARD:

The Vehicle Emission Recall - Proof of Correction card must be completed by the Dealership's Service Manager using a permanent ink pen. A fine point pen is recommended. When filling in the information, copy the information directly from the vehicle, not from the repair order.

ALL INFORMATION MUST BE PRINTED AND NEAT.

The copy of the card shown below indicates the areas to be filled in. Each area must be filled in.

The completely filled out Vehicle Emission Recall - Proof of Correction card should be given to the owner of the vehicle upon completion of the Campaign.

- | | |
|--------------------------------------|--|
| 1. Enter Vehicle's License Number | 7. Enter Dealership Name |
| 2. Enter "Hyundai" | 8. Enter Dealership's Address
NOTE: Enter the physical address, not the mailing address (not a P.O. Box) |
| 3. Enter Model Year | 9. Enter Date of Repair |
| 4. Enter Model (e.g. Santa Cruz) | 10. Service Manager Sign Here |
| 5. Enter the vehicle's VIN Number | |
| 6. Enter Campaign Number: 9C3 | |

Vehicle Emission Recall – Proof of Correction					
License No.	Make	Model Year	Body Type	Vehicle Identification Number	
1	2	3	4	5	
Manufacturer:			2	Recall Number:	
				6	
The above described vehicle has been repaired, modified and/or equipped with new emission control devices to meet applicable California Emission Control Laws.					
Dealer's Name			Address, City, State and Zip		
7			8		
Date		Dealership's Authorized Signature			
9		x 10			
Return this certificate to DMV only when required – otherwise retain for your records.					
NP050-09006 8/14					