

<b>REFERENCE:</b>	<b>TSB:</b> 23-015-26 <b>GROUP:</b> 23 - Body	<b>Date:</b>	May 5, 2026	<b>REVISION:</b>	—
<b>VEHICLES AFFECTED:</b>	<b>2024 - 2025 (VF) RAM ProMaster</b> This bulletin applies to vehicles built on or after June 28, 2024 (MDH 0628XX) and on or before September 05, 2025 (MDH 0905XX).			<b>MARKET APPLICABILITY:</b> <input checked="" type="checkbox"/> NA <input type="checkbox"/> MEA <input type="checkbox"/> EE <input type="checkbox"/> IAP <input type="checkbox"/> SA <input type="checkbox"/> CH <b>NOTE:</b> This bulletin applies to North America markets.	
<b>CUSTOMER SYMPTOM:</b>	<b>Customers may comment on the following:</b> <ul style="list-style-type: none"> <li>Right front rack bracket is missing.</li> </ul>				
<b>CAUSE:</b>	Manufacturing issue				

**REPAIR SUMMARY:**

This bulletin involves installing the right front roof rack bracket.

**CLAIMS DATA:**

Labor Operation No:	Labor Description	Skill Category	Labor Time
23-06-10-90	Bracket, Roof Rack - Install <b>\$22.04 material allowance.</b> 0 - Introduction	6 - Electrical and Body Systems	3.5 Hrs.
Failure Code	ZZ	Service Action	

**SPARE PARTS:**

Qty	Part No.	Description	Notes
1	68118827AA	Reinforcement, Roof Rail	Right

**DIAGNOSIS:**

If the customer describes any of the symptoms listed above in the customer symptom section, perform the Repair Procedure.

**SPECIAL TOOLS/EQUIPMENT:**

Description	Ref. No.	Notes
3M™ Weld Thru II Coating	05917	
Gas Metal Arc Welder		
3M™ OEM Match Epoxy Seam Sealer	08524	
Blair Spotweld Cutter	11094	
Masking Tape	NPN	
Drill	NPN	
10mm (3/8 in.) Drill Bit	NPN	
Center Punch	NPN	
ER70S-6 (or-3) Electrode Wire	NPN	
Epoxy Primer	NPN	
#36 Grit Grinding Disc	NPN	
Grinder	NPN	

**REPAIR PROCEDURE:**

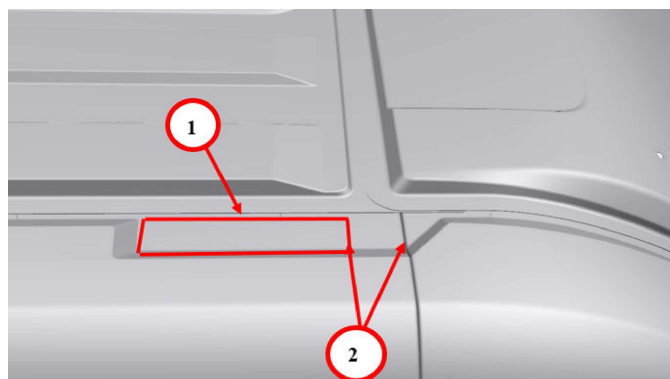
The right front bracket that holds the roof rail in place is missing. A replacement roof rail bracket needs to be installed by aligning and welding it into place Fig. 1. Six 10 mm (0.4 in.) holes will be drilled in the roof rail bracket and six 8mm (0.3 in.) holes will be cut into the upper part of the body side aperture, aligned and welded using Gas Metal Arc Welding (GMAW) processes.



**Fig. 1**  
Right Front Roof Rail Bracket

- 1 - Right Front Roof Rail Bracket
- 2 - Upper Right Front Body Side Aperture
- 3 - Right Front Roof Rail Bracket Installed To Upper Right Front Body Side Aperture

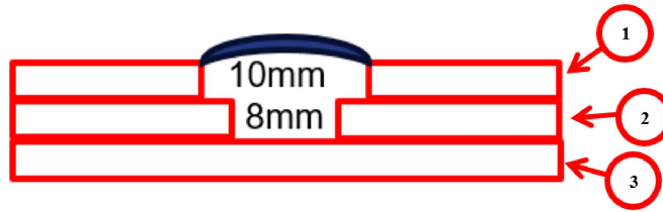
The roof rail bracket will be installed 49mm (1.9in.) from the forward seam and 5mm (0.2 in.) from the edge of the roof panel Fig. 2.



**Fig. 2**  
Right Front Roof Rail Bracket Location

- 1 - Right Front Roof Rail Bracket Installed Position is 5mm (0.2in.) From Roof Panel Edge
- 2 - Right Front Roof Rail Bracket Installed Position is 49mm (1.9in.) From Forward Seam

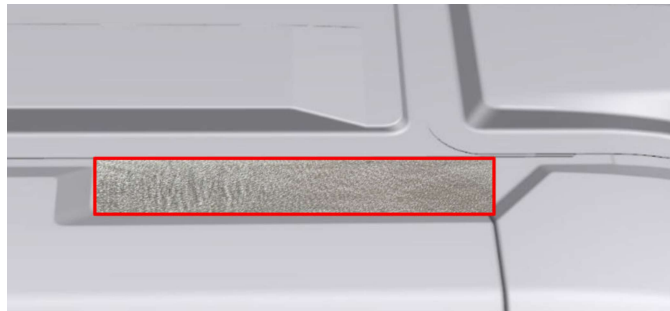
The component stack-up is made of three layers of sheet metal [Fig. 3](#). A 3T weld will be made using a 10mm (0.4 in.) hole in the replacement roof rail bracket and an 8mm (0.3 in.) hole in the upper body side aperture to produce the "funnel" shape for the weld.



**Fig. 3**  
Component Stack-Up

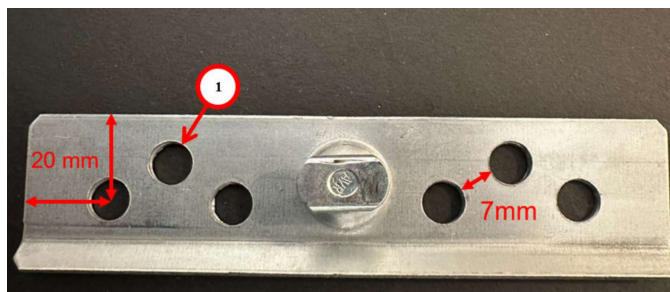
- 1 - Replacement Right Front Roof Rail Bracket
- 2 - Upper Body Side Aperture Panel
- 3 - Body Side Aperture Bracket Reinforcement

1. Thoroughly clean all residue from the right front roof rail bracket attachment area [Fig. 4](#).



**Fig. 4**  
Right Front Roof Rail Bracket Installation Area

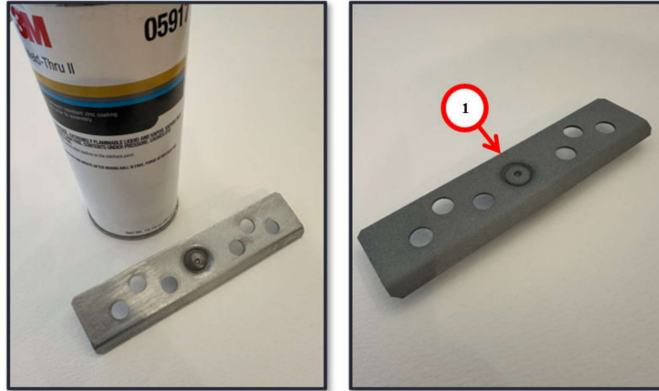
2. Wipe the right front roof rail bracket installation area with a clean, lint free cloth, moistened with a 50% solution of water and alcohol. Wipe dry the areas immediately with a dry, lint free cloth [Fig. 4](#).
3. Drill six holes in right front roof rail bracket using a 10mm (3/8 in.) drill bit or Blair Spotweld Cutter. The holes should be 7mm (0.25 in.) apart from each other and 20mm (0.8 in.) inboard from both ends of the roof rail bracket. The drilled holes placements should be as shown in [Fig. 5](#).



**Fig. 5**  
Drilled Right Front Roof Rail Bracket

1 - Drilled 10mm (0.4 in.) holes.

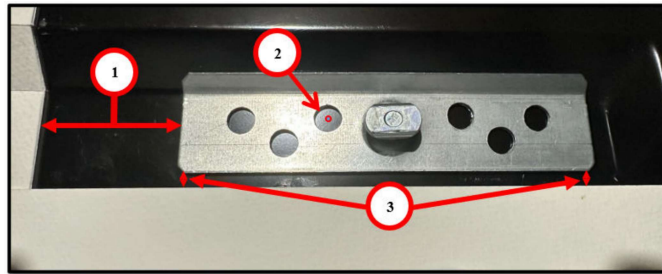
4. Prepare the roof rail bracket after drilling by deburring the backside, cleaning and applying two thin coats of 3M™ Weld-Thru Primer for corrosion protection prior to welding [Fig. 6](#).



**Fig. 6**  
Roof Rail Bracket Backside Preparation

1 - Prepared Roof Rail Bracket

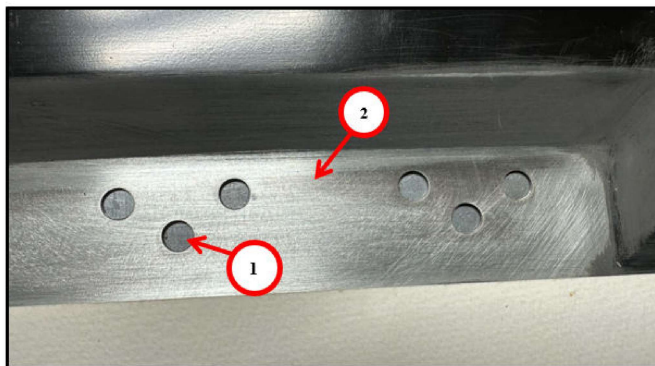
5. Temporarily align the roof rail bracket on the outer body side aperture [Fig. 7](#). Use a center punch and mark the center of each of the six holes to prepare for cutting 8mm (0.3 in.) holes in the outer body side aperture only.



**Fig. 7**  
Roof Rail Bracket Alignment

1 - Right Front Roof Rail Bracket Installed Position 49mm (1.9in.) From Forward Seam  
2 - Center Punch Mark  
3 - Right Front Roof Rail Bracket Installed Position 5mm (0.2in.) From Roof Panel Edge

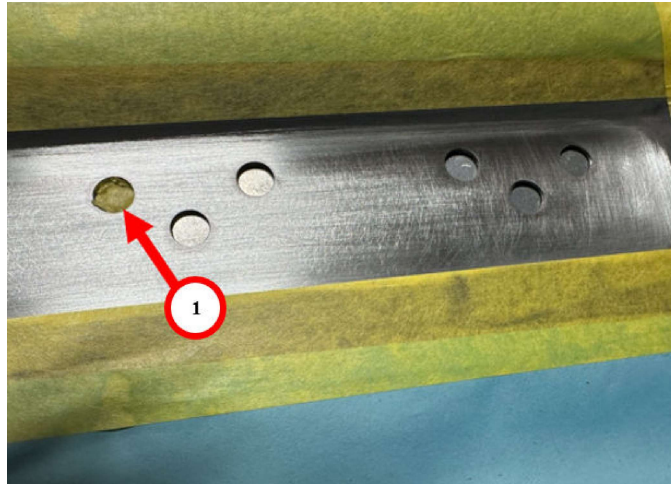
6. Remove the roof rail bracket after aligning, marking and center punching each of the six areas to be drilled. Use a Blair Spotweld Cutter and cut 8mm (0.3 in.) holes in the outer body side aperture as shown in [Fig. 8](#). **Do not cut into the inner reinforcement bracket.**



**Fig. 8**  
Reinforcement Bracket

1 - Inner Reinforcement Bracket  
2 - Outer Body Side Aperture

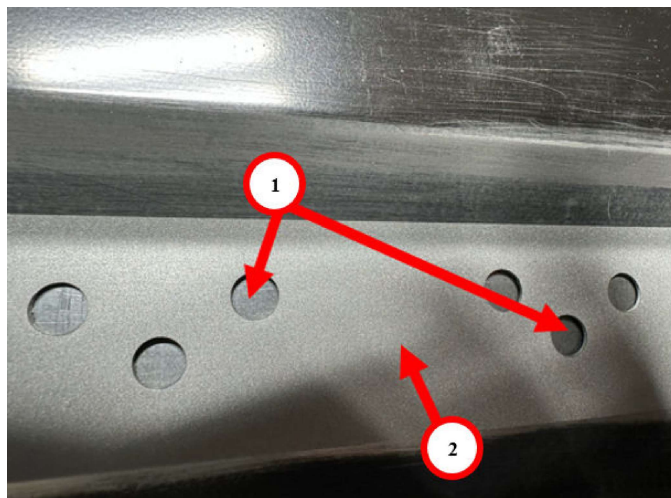
7. Prepare the outer body side aperture for 3M™ Weld-Thru Primer application by masking the outer area where the roof rail bracket will be attached [Fig. 9](#).



**Fig. 9**  
Weld-Thru Primer Preparation

8. Cut small pieces of masking tape to protect the inner reinforcement bracket from Weld-Thru Primer contacting the direct weld zone [Fig. 9](#).
9. Apply two coats of 3M™ Weld-Thru Primer and unmask [Fig. 10](#).

**NOTE: When the masking tape is removed from the drilled-out areas of the body side aperture, only bare metal should be showing on the Inner Reinforcement Bracket.**



**Fig. 10**  
Weld-Thru Primer Application

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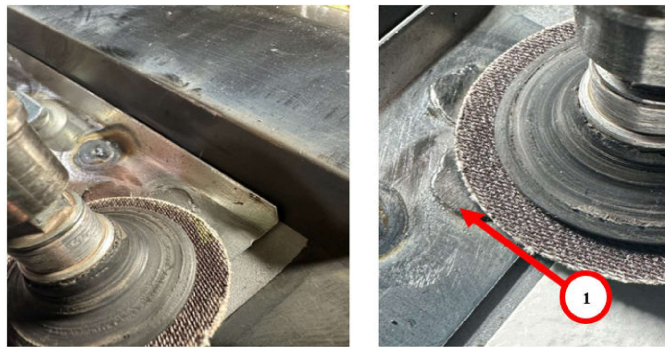
1 - Inner Reinforcement Bracket  
2 - Weld-Thru Primer Applied To Body Side Aperture

10. Align the roof rail bracket for welding. Note the “funnel shape” of the 3T weld [Fig. 11](#).



**Fig. 11**  
Roof Rail Bracket Alignment

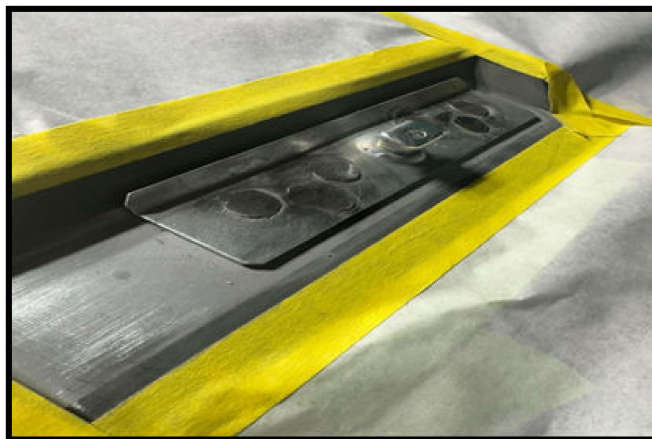
11. Use GMA welding processes and ER70S-6 (or-3) Electrode wire for Ring Fillet welding the roof rail bracket to the body side aperture [Fig. 12](#).
12. Dress the welds using a #36 grit grinding disc. Best practice is to leave a slight "edge" around the outside of the weld so no material is removed from the roof rail bracket itself.



**Fig. 12**  
Ring Fillet Welding

1 - Dressing The Welds Using A #36 Grit Grinding Disc

13. Apply masking tape to prepare the repair area for the use of a suitable epoxy primer and the 3M™ OEM Match Epoxy Seam Sealer application [Fig. 13](#).



**Fig. 13**  
Corrosion Protection

14. Apply 3M™ OEM Match Epoxy Seam Sealer Fig. 14.



**Fig. 14**  
Apply Seam Sealer

15. Allow the vehicle to set for 30-40 minutes allowing the treated surface to dry.

16. Prep and paint the area as required.

**POLICY:**

Reimbursable within the provisions of the warranty.

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