NHTSA SAFETY RECALL NUMBER: 24V642
Truck Body Attic Crossmember End Clip Repair Procedure

NOTICE: USE ALL PROPER PERSONAL PROTECTION EQUIPMENT DURING INSPECTION AND REPAIR.

Estimated Repair Time: 3.0 Hours

CROSSMEMBER END CLIP REPAIR KIT INSTRUCTIONS:

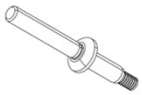
NOTE: If this repair kit is needed, it must be installed prior to the TRUCK BODY ATTIC FLOOR REPAIR KIT.

Inspect the aluminum attic crossmember end clips, and if any are found to be cracked or broken or bent away from bottom rail farther than 1/8", these will need to be replaced per the following instructions.

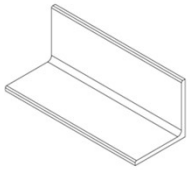
PARTS IN KIT:

SCREW -3/8-16x1¼
X 12
1204438128

NYLON INSERT LOCKNUT
3/8-16
X 12
1441438001



BLIND RIVET
X 12
163MBPR6M5



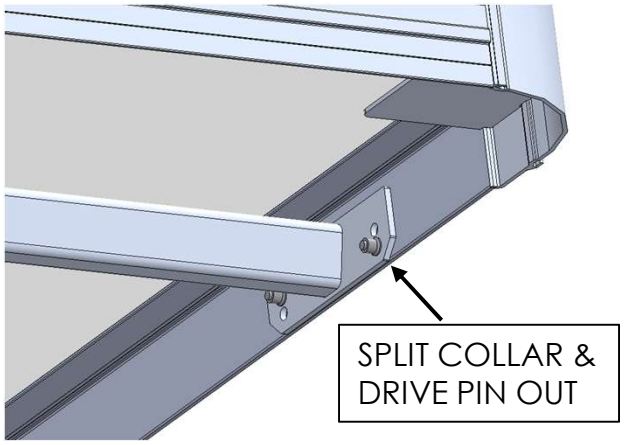
ANGLE CROSSMEMBER
SUPPORT
X 6
RD160-M3-001

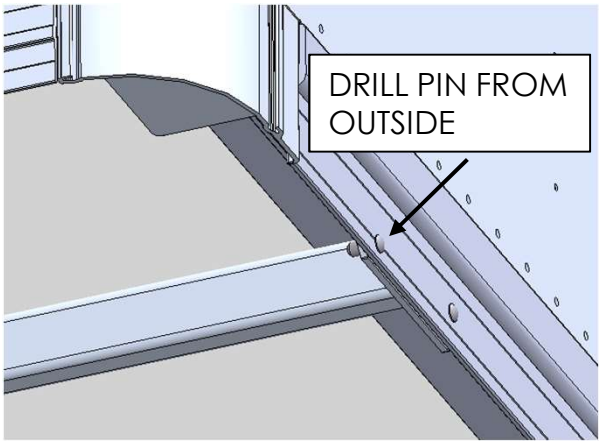
SUGGESTED TOOLS AND SUPPLIES NEEDED:

Power Drill Driver
Putty knife
Reciprocating Saw
Air hammer with Sharp Chisel, Cutoff Wheel or Nut Splitter
3/8" Drill Bit
#7 Drill Bit
9/16 Wrench
T40 Driver Bit
Blind Rivet Puller with Nose for 3/16 rivets
Gloves
Safety Glasses

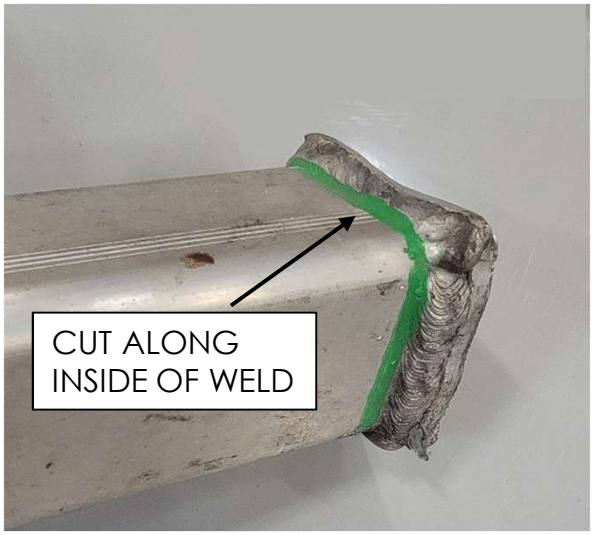
CROSSMEMBER END REPLACEMENT KIT INSTRUCTIONS

- Remove Huck fasteners from attic crossmembers to lower aluminum rail. One method is to use an air hammer with sharp chisel, cut off wheel, or nut splitter to split the Huck collar on the inside of the lower aluminum rail, being careful not to cut into the rail. Once the collar is split, the Huck pin can be driven out from the inside. An alternate method is to drill through the head of the Huck fastener using a power drill and 3/8" drill bit. Drill deep enough so the head can be removed, being carful not to drill into the rail.

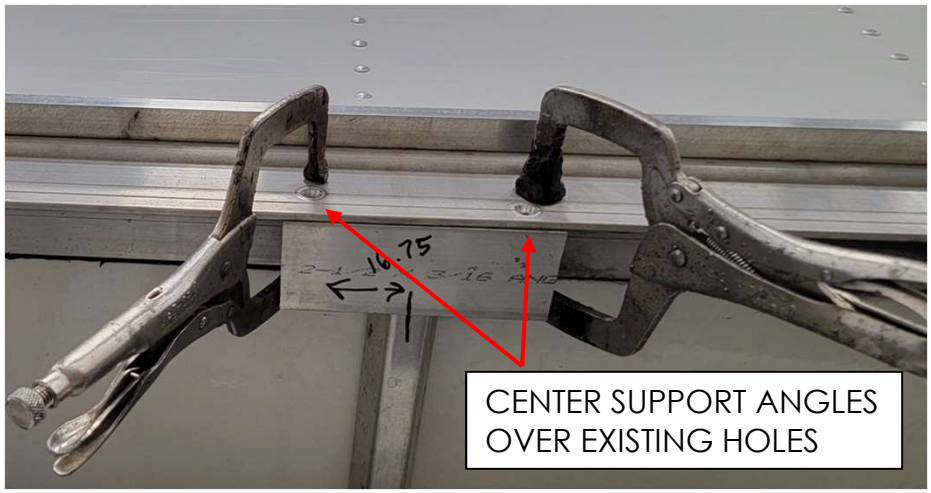




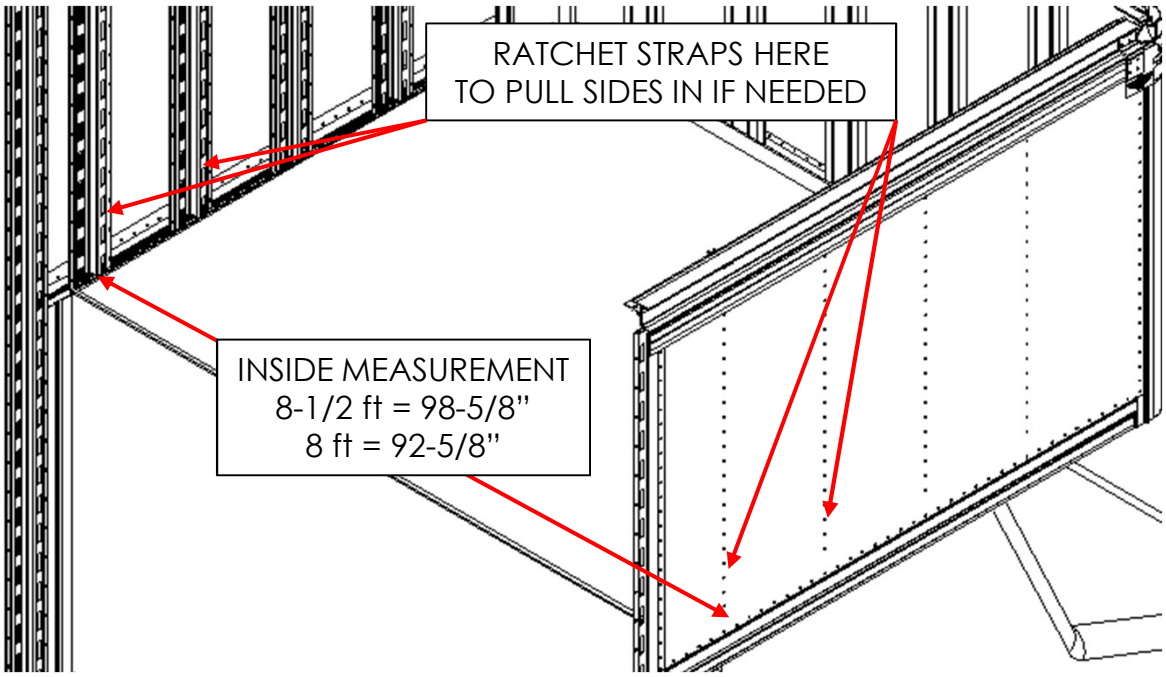
- Carefully remove the crossmember, and secure from movement on worktable, bench, etc.
- Using a putty knife, remove any adhesive remaining on top of crossmember.
- While still secured on worktable, cut both damaged end clips off the crossmember using a reciprocating saw with metal blade or similar tool. Make the cuts near the weld of each end clip as shown below. These crossmember(s) will be re-used.



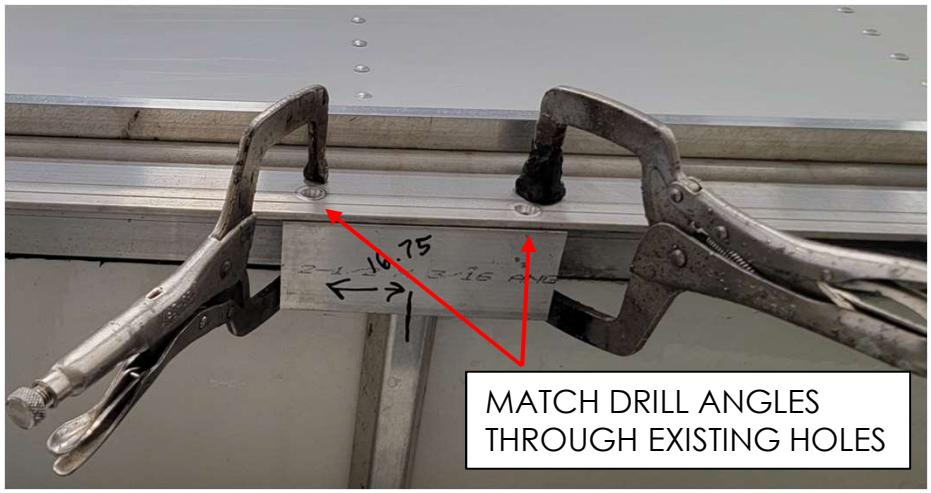
- Clamp the 6.5" long aluminum crossmember supports to the lower aluminum rail, centered over the existing holes in bottom rail as shown below. Place the trimmed crossmembers on the inner lip of the supports and ensure that they are centered on the supports and centered on the attic. Adjust the supports so the crossmembers are snugly clamped between the supports and lower aluminum rails. The bottom of the supports will protrude approximately 1/16"-1/8" below lower aluminum rail as seen in the figure below.



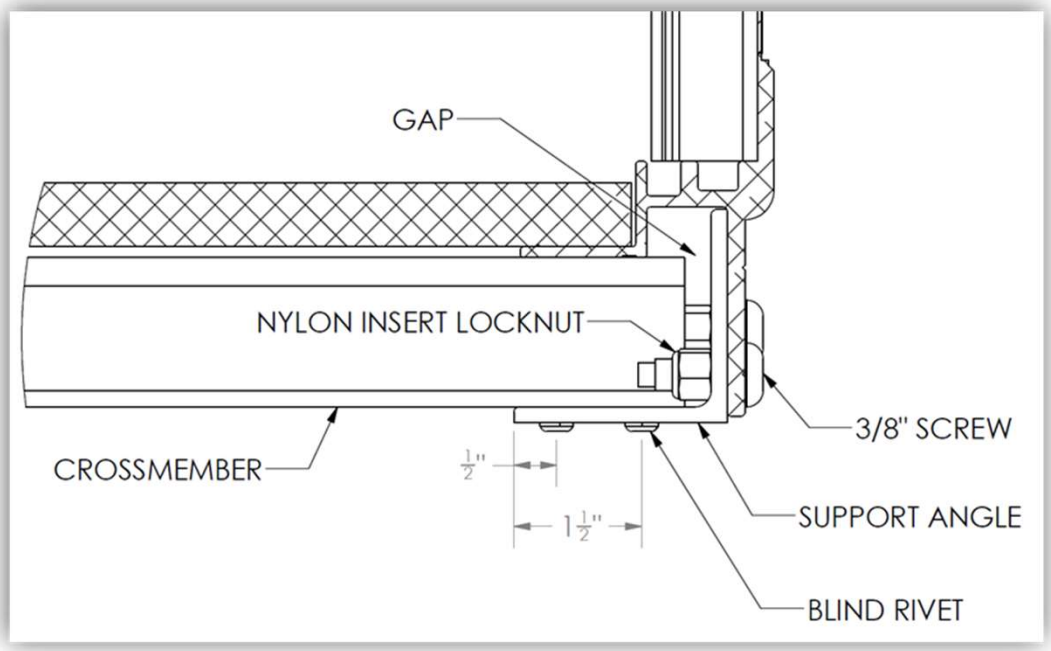
- If the attic floor has come loose from the back of the bulkhead, the side walls may have spread a little and need to be pulled back to the proper width. If the walls need to be pulled back to the proper width, ratchet straps can be installed near the bottom of the posts at the rear of the attic, and used to pull the lower aluminum rails back to their proper width. Confirm the bottom rail width is within 1/8" of the measurements shown below.



- Once the width has been verified and the crossmembers have been clamped into place, the crossmember support angles can be installed. Using a power drill and 3/8" drill bit, match drill the support angles using the existing holes in the lower rail.



- Fasten the angles to the lower rails using supplied 3/8" Screws and Nylon Insert Locknuts. (Torque to 18 – 26 ft-lbs.).
- With the crossmembers located properly on the support angles, mark the two drill locations as shown below. Then drill, at these locations, up through the bottom flange of the support angle into the bottom surface of the crossmember using a #7 drill bit.



- Insert the blind rivets into drilled holes until head is tight against the bottom of the angle. Set them using a rivet puller.
- Repeat this process for all crossmember support angles.