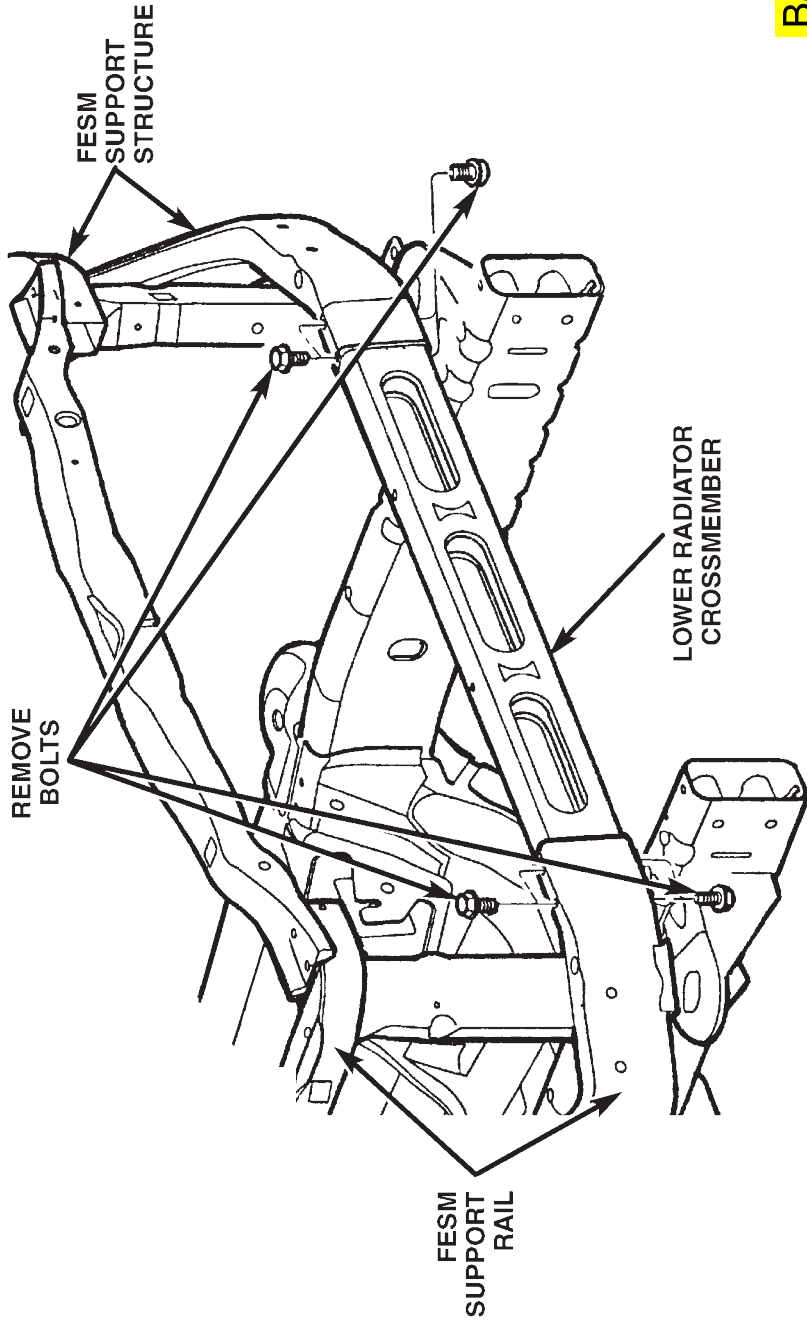


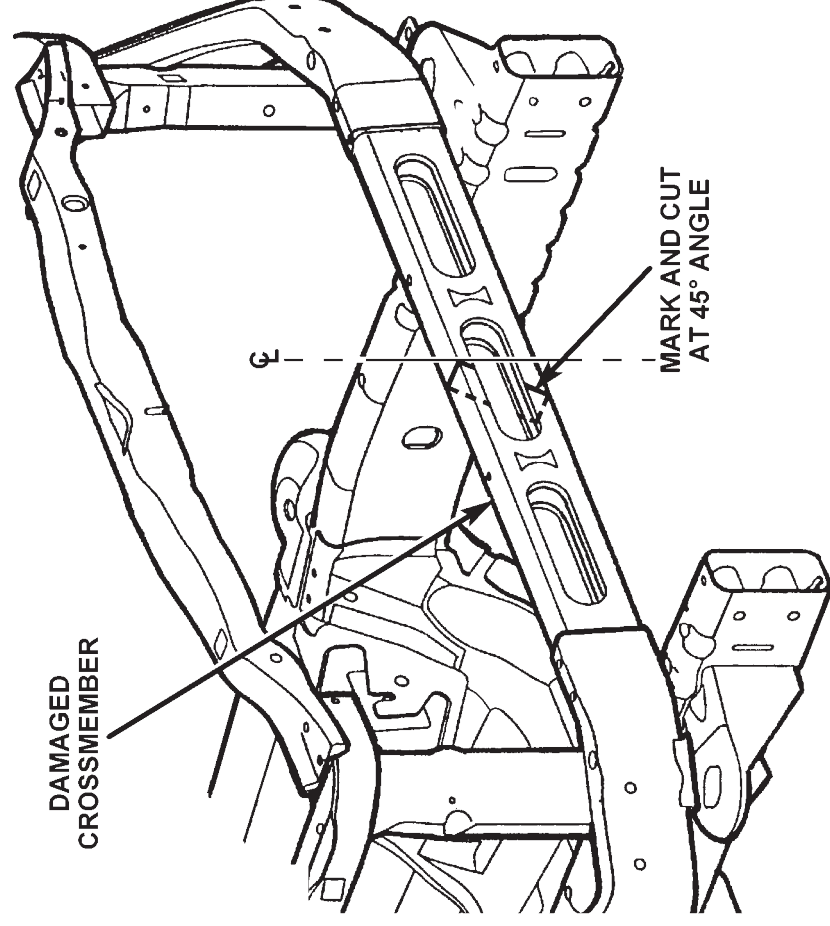
DODGE RAM

FRONT LOWER RADIATOR CROSSMEMBER REPLACEMENT

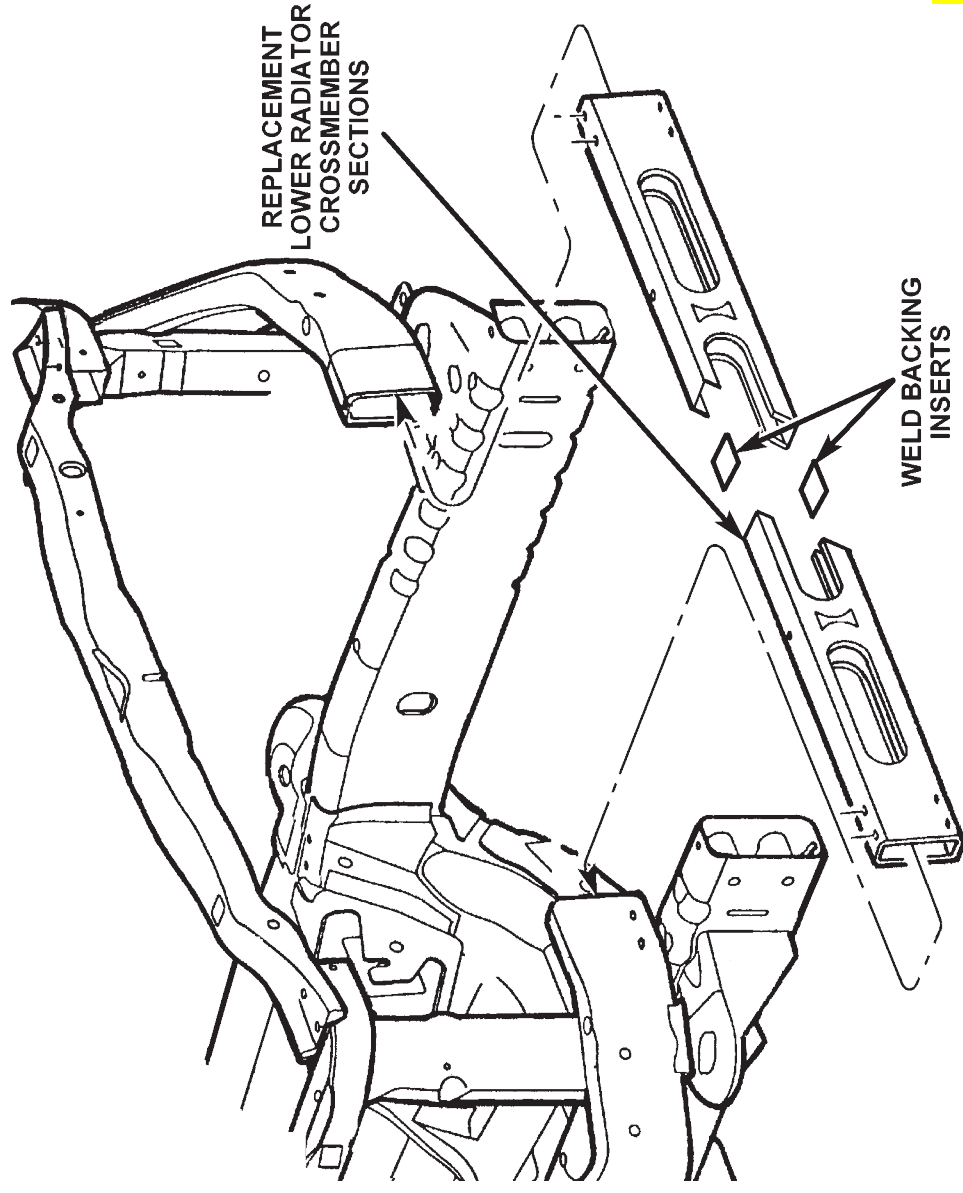
1. Remove all components necessary to access crossmember.
2. Using three-dimensional measuring equipment, confirm dimensional integrity of front end sheet metal (FESM) supporting structure and correct if necessary.
3. Remove bolts holding crossmember to FESM structure—four per side.



4. Using a reciprocating saw, or equivalent, cut old crossmember at a 45 degree angle and remove (when cut, slip one half of crossmember into FESM structure until bottomed, then pull other section out and free. Next remove remaining section.)
5. Cut new crossmember in center at a 45 degree angle.
6. Using old part, cut and fabricate two weld backing inserts 2 inches wide—inserts should fit snugly into top and bottom of crossmember but not so tight that inserts will not slide for adjustment.
7. Slightly bevel cut edges of replacement crossmember at joining location.



8. Install first half of crossmember into structure until bottomed out.
9. Install remaining section of replacement crossmember into opposite side of structure.
10. Install weld backing inserts into top and bottom of crossmember at joining location.
11. Ensure a weld root gap of approximately 1/16" and weld crossmember together—weld must be performed completely so that no gap remains from the cutting operation.



12. Dress crossmember weld and inserts for finishing.
13. Apply corrosion resistant primer to all bare metal.
14. Apply paintable urethane sealant to all edges of inserts to seal out any corrosion causing agents.
15. Refinish crossmember.
16. Reassemble vehicle.

