

Prop Shaft Crossmember

Instruction Sheet for kit number 23133821
 Instruction sheet part number is 19300879

Crossmember to be installed:

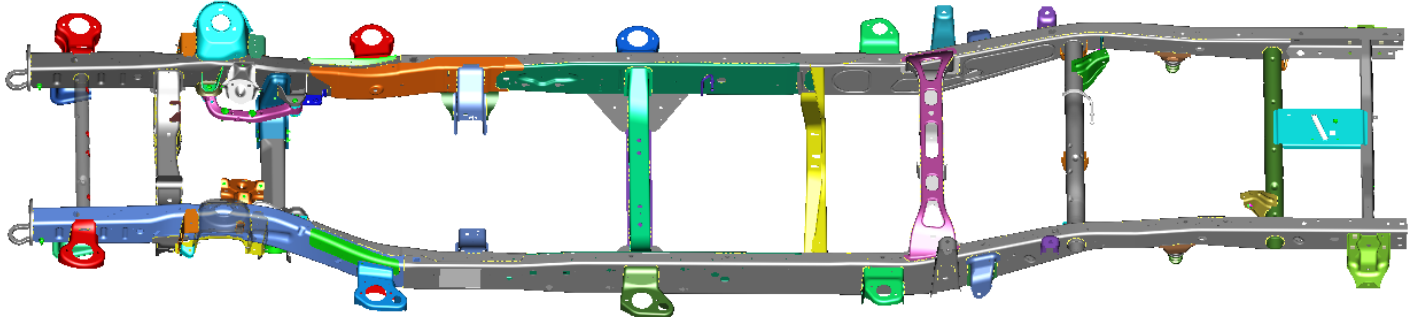


Figure 1

Crossmember Installation Instructions

1. Clean frame to bare metal in area Crossmember will attach.
2. Locate Crossmember on LH and RH sides, 160 mm forward of factory seam of Rear Frame Section as shown. Figure 2.
3. Locate Crossmember on LH and RH sides, 17 mm up from bottom surface of frame and bottom edge cross member as shown. Figure 3.
4. Tack weld Crossmember into position and double check measurements to ensure it is located properly.
5. Fully weld the Crossmember along the front vertical edge and across the top and bottom as shown. Figure 4.
6. Apply corrosion resistant paint and coating to the weld area after frame has cooled.

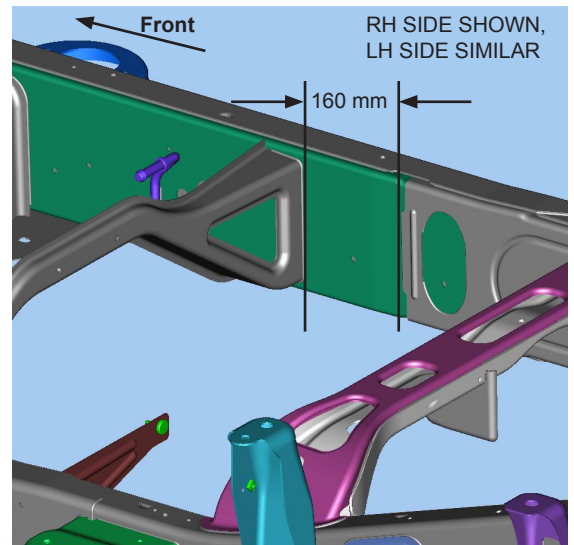


Figure 2

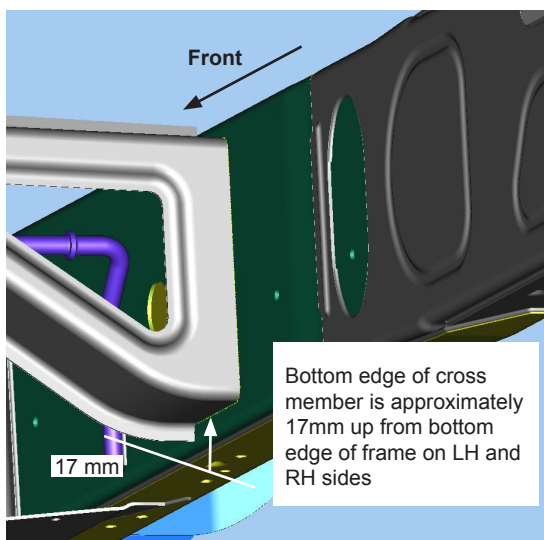


Figure 3

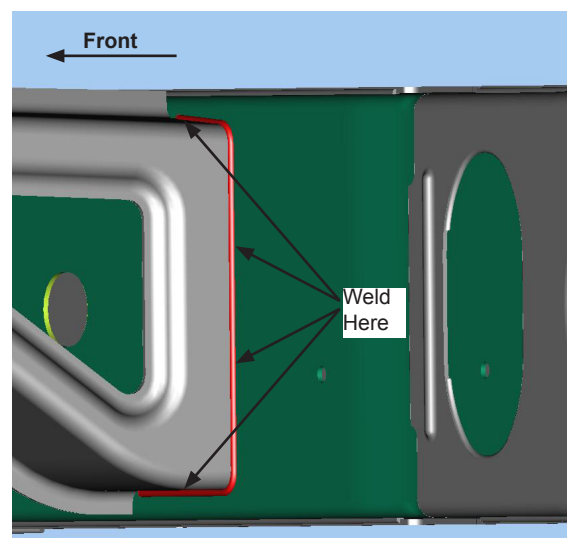


Figure 4

Prop Shaft Crossmember

IR 07JA13

PART NO.

19300879

SHEET **1** OF **3**

ALL INFORMATION WITHIN ABOVE BORDER TO BE PRINTED EXACTLY AS SHOWN ON 8.5 x 11 WHITE 16 POUND NON-BOND RECYCLABLE PAPER. PRINT ON BOTH SIDES, EXCLUDING TEMPLATES. TO BE UNITIZED IN ACCORDANCE WITH GM SPECIFICATIONS.

DATE	REVISION	AUTH	DR
07JA13	Initial Release - Joseph Madaffari	n/a	

TITLE	INSTALLATION INSTRUCTIONS Prop Shaft Crossmember		
PART NO.	19300879	SHEET	1 OF 3

Traverse d'arbre de transmission

Feuille d'instructions pour la trousse numéro 23133821
 Le numéro de pièce de la feuille d'instructions est 19300879

Traverse à poser :

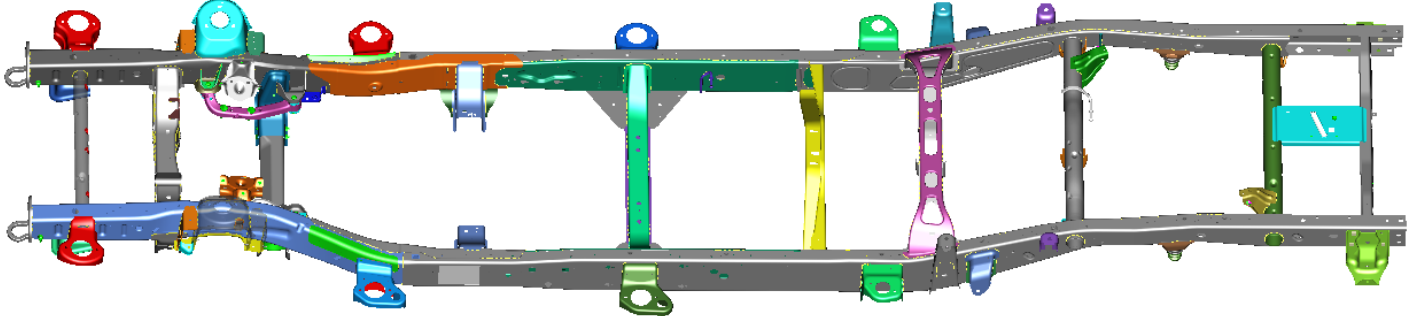


Figure 1

Instructions de pose de traverse

1. Amener le cadre jusqu'au métal nu dans la zone de fixation de la traverse.
2. Repérer la traverse des côtés gauche et droit, 160 mm à l'avant du joint d'usine de la section du cadre de châssis, comme indiqué. Figure 2.
3. Repérer la traverse des côtés gauche et droit, 17 mm au-dessus de la surface inférieure du cadre de châssis et de la traverse du bord inférieur, comme indiqué. Figure 3.
4. Souder par points la traverse pour la maintenir en place et contre-vérifier les mesures pour s'assurer que la traverse est correctement positionnée.
5. Souder en entier la traverse le long de la bordure verticale avant et de la surface supérieure à la surface inférieure, tel qu'illustré. Figure 4.
6. Appliquer de la peinture et un revêtement anticorrosion sur la zone de la soudure une fois que le cadre a refroidi.

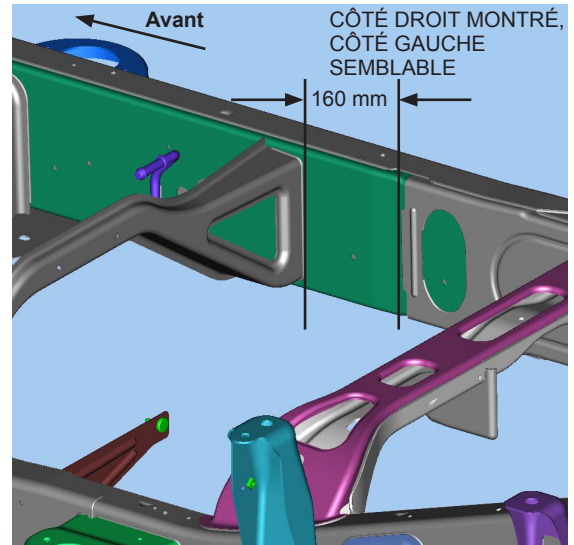


Figure 2

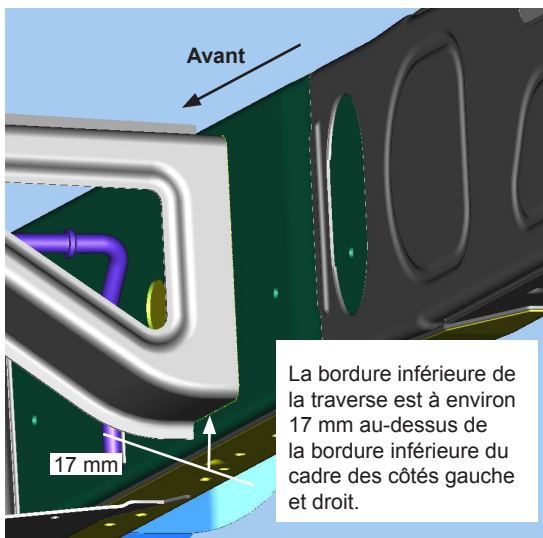


Figure 3

La bordure inférieure de la traverse est à environ 17 mm au-dessus de la bordure inférieure du cadre des côtés gauche et droit.

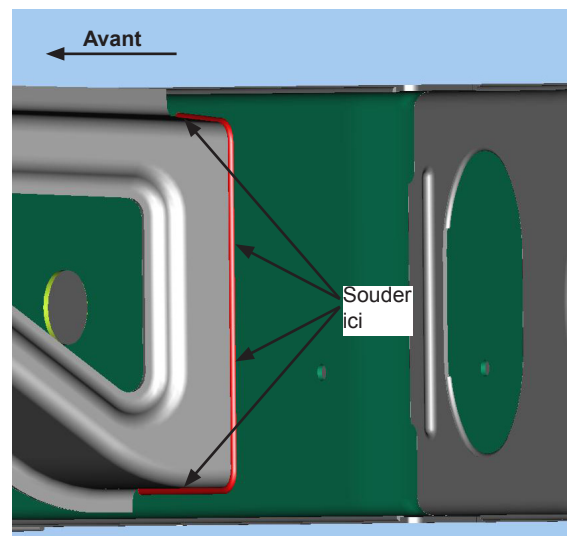


Figure 4

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Travesaño de eje de impulso

Hoja de instrucciones para juego número 23133821
 El número de parte de la hoja de instrucciones es 19300879

Travesaño a instalar:

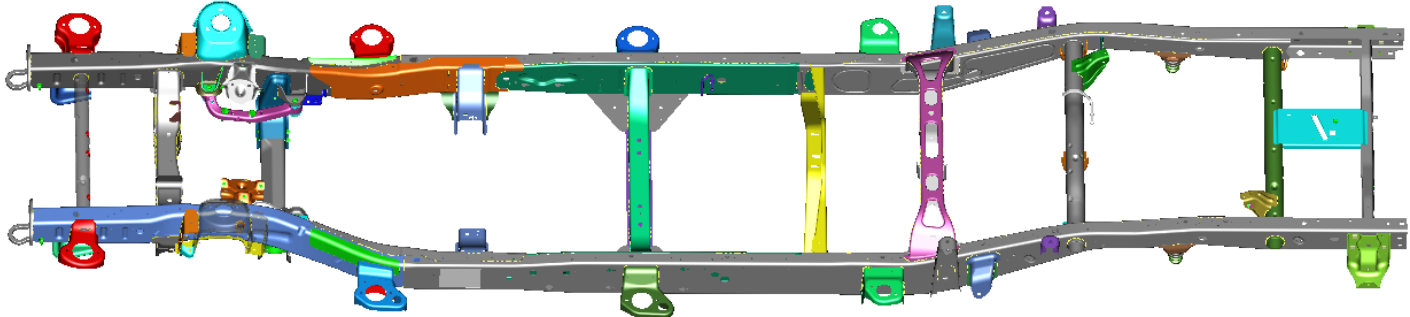


Figura 1

Instrucciones de instalación de travesaño

1. Limpie el marco hasta llegar al metal desnudo en el área que se sujetará el Travesaño.
2. Localice el travesaño en los lados izquierdo y derecho, 160 mm al frente del sello de fábrica de la Sección del marco trasero como se muestra. Figura 2.
3. Localice el travesaño en los lados izquierdo y derecho, 17 mm hacia arriba desde la superficie inferior del marco y el travesaño del borde inferior como se muestra. Figura 3.
4. Suelde por puntos el travesaño en su posición y verifique de nuevo las mediciones para asegurar que esté colocado adecuadamente.
5. Suelde completamente el travesaño a lo largo del borde vertical delantero y a través de la parte superior e inferior como se muestra. Figura 4.
6. Aplique pintura y recubrimiento resistentes a la corrosión al área soldada después que se enfríe el marco.

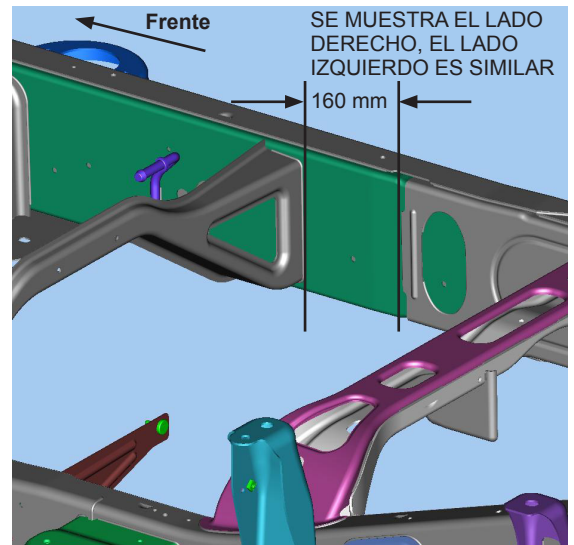


Figura 2

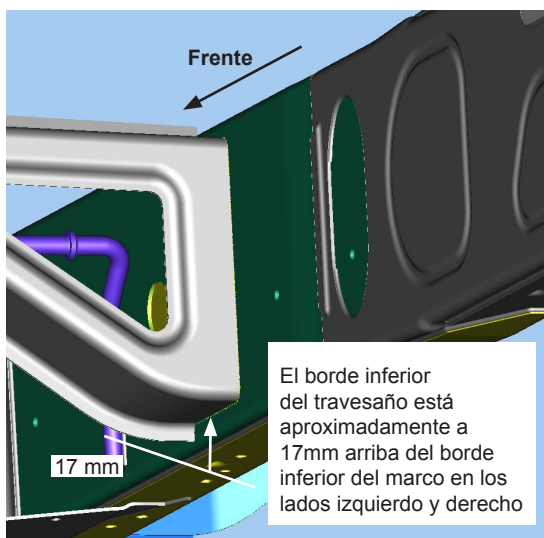


Figura 3

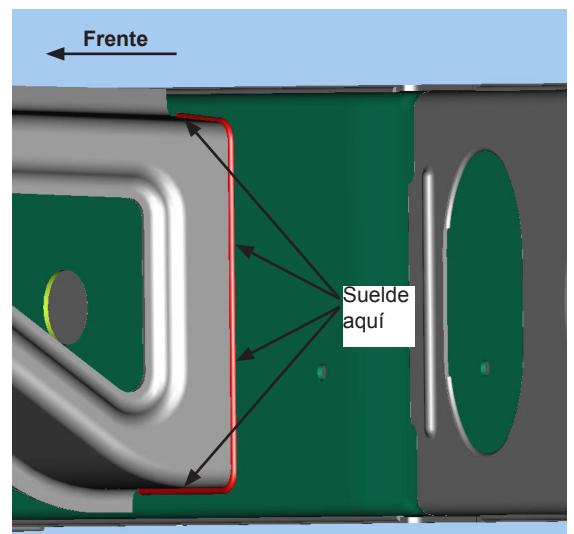


Figura 4

Prop Shaft Crossmember

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