



# Service Bulletin

File in Section: 08 - Body and Accessories

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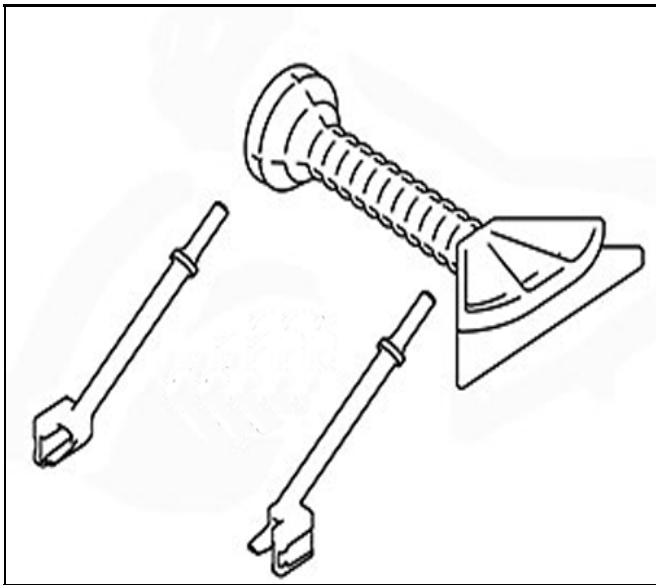
## INFORMATION

**Subject:** Hem Flange Rust Repair

**Models:** 2017 and Prior GM Passenger Cars and Trucks

**Attention:** This Bulletin also applies to any of the models that may be Export from North America vehicles.

This Bulletin has been revised to add the 2017 Model Year and update the Repair Procedure section. Please discard Corporate Bulletin Number 02-08-98-002F.



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In the event that hem flange corrosion becomes a concern on lower door panels, a new tool has been released by Kent Moore, J-46162-A, which allows for easier opening and closing of the hem flange. This kit includes a left and right hand flange opening tool that is used with an air hammer, and a hem flange closing tool. Using these tools the lower door hem flange can be opened, the rust treated and the hem flange closed without having to refinish the outer door area.

A combination of specialized metal coating products, manufactured by Lloyds, have been found to be the most suitable materials to provide corrosion control and protection. Our recommendation is to prep the metal surface using \*Lloyd's Pure Prep™ Metal Surface Preparation P/N 25418, then topcoat with \*Lloyds

Kryptonite Metal Treatment P/N 36502 Life Long Rust Protection. It is strongly recommended they be applied according to the manufacturer's procedures.

**Important:** To ensure proper coating performance, all of the manufacturer's "Applications Guidelines" MUST be followed.

### Repair Procedure

1. Remove the affected body panel from the vehicle and place on a clean non marring work surface.
2. Clean the hem flange area with wax and grease remover.
3. Inspect the area for rust perforation or "micro pin holes."

**Important:** If perforation is present, replace the affected panel.



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4. Using the appropriate (left or right hand) flange opening tool, open the flange as shown.



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5. Protect the adjacent area with cloth protective (duct) tape.  
6. Sand blast the rust area. Ensure all of the rust is removed leaving clean bare metal.



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If sand blasting is not available, remove the rust using a 3-M Scotch-Brite™ Clean and Strip Disc, Part # 07466, abrasive wheel.



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7. Using \*Lloyd's Pure Prep™ Metal Surface Preparation P/N 25418 (10 fluid ounce bottle) in a spray bottle, saturate the complete flange area with the pre-diluted solution and scrub the area well, rendering a foaming of the Pure Prep.™ This will greatly improve adhesion and corrosion resistance in the repair areas.





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8. Using a water dampened clean towel, remove any residue and dry the affected area. Dry the repair area completely using an air hose to blow dry the frame.
9. Check the repair area for phosphate treatment by wiping it to see if any corrosion residue can be picked up. Correctly treated areas will not have any residue on the surface.

10. Apply a light coat of \*Lloyds Kryptonite Metal Treatment P/N 36502 with a small brush as shown. This first coat should flash in approximately 3-5 minutes.
11. Apply a second coat of Lloyds Kryptonite.



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12. Using a small tip opening, apply a small bead of seam sealer such as \*LORD Fusor® 123 (white) = 10.1 oz (300 mL) or the equivalent to the open joint area.

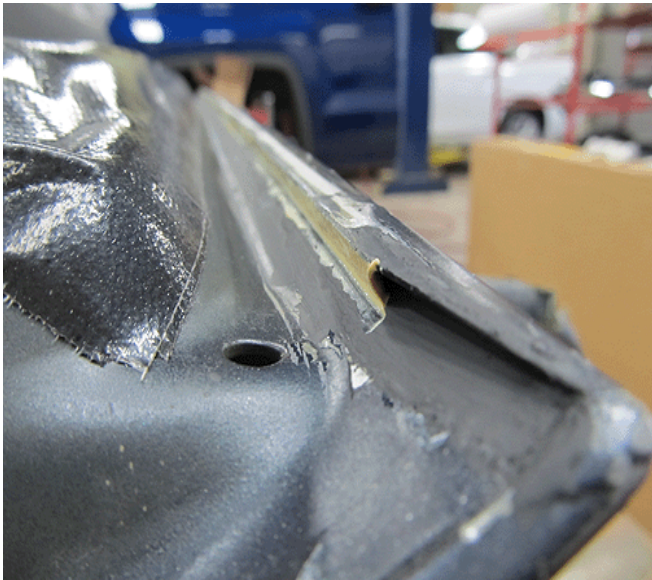




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14. Close the hem flange using the flange closing tool.



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13. Using a squeegee, force the sealer into the open joint area.

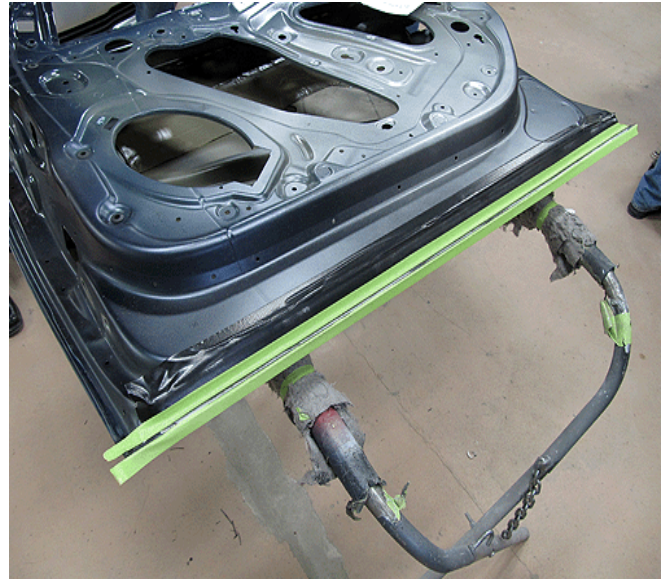
- Make an initial pass with the tool parallel to the door outer panel.





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- Make a second pass with the tool at a 40° angle towards the inner panel to close the flange completely.



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15. Mask the area as shown to create a 10 mm (0.40 in) wide sealer area.



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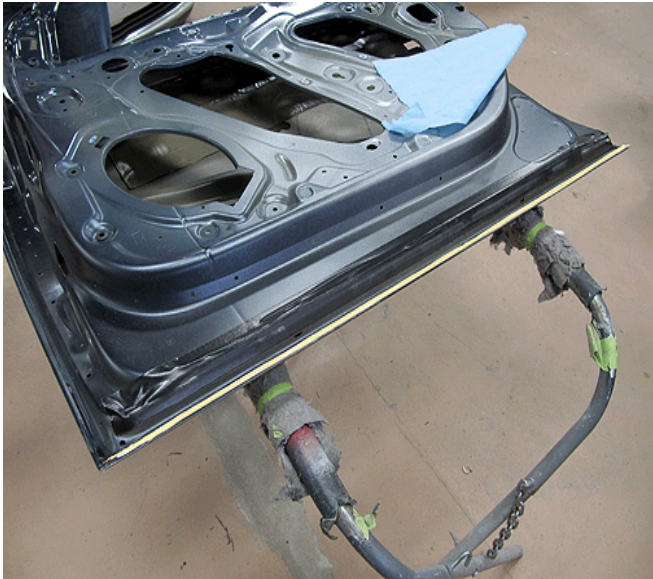
16. Apply a bead of \*LORD Fusor® 123 (white) = 10.1 oz (300 mL) or the equivalent, as shown to completely seal the hem flange.





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Use a small brush to finish the area, the sealer will self level to remove any brush marks.



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17. Remove the masking tape.

**Important:** Refer to the GM Approved Refinish Materials booklet (GMW-15406) for specific products.

To access the booklet, go to [www.genuinegmparts.com](http://www.genuinegmparts.com). Click on FOR PROFESSIONALS > Additional Resources: Touch-Up Paint > Downloadable Guides. Select 2016 GM Approved Refinish Materials. In Canada, the GM Approved Refinish Materials Booklet is also available in GM GlobalConnect in the Reference Library under Service Department.

18. Prime and refinish the area as required.

19. Reinstall the body panel.

\*We believe these sources and their products to be reliable. There may be additional manufacturers of such material. General Motors does not endorse, indicate any preference for or assume any responsibility for the products from these firms or for any such items which may be available from other sources.

**Parts Information**

To order this tool (J-46162-A), call Bosch Automotive Service Solutions at 1-800-GMTOOLS.

LORD Fusor® and 3M® Clean and Strip may be obtained from your local body shop supplier.

Dealers should obtain 25418 and 36502 by contacting Lloyds by e-mail at [sales@lloydslaboratories.com](mailto:sales@lloydslaboratories.com), or by calling 1-800-361-6766.

**Warranty Information**

For vehicles repaired under warranty, use:

Labor Operation	Description	Labor Time
1480208*	Lower Door Hem Flange Rust Repair	Use Actual Clock Time
*This is a unique Labor Operation for Bulletin use only.		

