



CHEVROLET MOTOR DIVISION
 General Motors Corporation
 Chevrolet Service Department



Chevrolet Dealer Service Technical Bulletin

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Subject: REPAIR OF RUST AT WINDOW OPENINGS -
 1965-68 PASSENGER CARS EXCEPT CORVAIR

Attn: Service Manager

TO: ALL CHEVROLET DEALERS

This bulletin is being re-issued to change part number on page 4 from 428A to 426.

This bulletin covers the proper service procedure for repairing rust areas that may occur around the rear window openings of 1965 through 1968 passenger cars. These occurrences of rust have generally been noted on units operating under certain climatic conditions and usually only occur on backglass installations incorporating stainless steel reveal moldings and adhesive caulking.

A change was made in production effective March, 1967, which incorporated the use of two zinc anode clips at both lower corners of the back window glass of all passenger cars except station wagon and convertible models.

The procedure on the following pages provides for both the restoration of the body finish where the rust conditions have occurred and provisions to inhibit recurrence through the use of special zinc anode molding clips and aluminum tape.

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Important That All Service Personnel Read—Please Initial

Service Manager		Shop Foreman		Service Salesman			Service Technicians						

Proper Repair of Rust Around Rear Window Openings

1. Remove necessary window reveal moldings and clips,
2. Mask off window glass and adjacent paint surfaces not affected by rust.
3. Where necessary, trim off excess adhesive caulking from bottom of window opening to facilitate zinc anode clip installation. Also, trim off caulking from sides and top of opening, as required, to allow an effective paint repair.
4. Remove complete paint finish and all evidence of rust from affected surfaces to insure that metal is clean and "bright".

NOTE: This can be done most quickly and efficiently by sandblasting prior to removal of any glass. Exercise care to prevent damage to glass.
5. If minor "rust conditions" are encountered, such as a pin-point size, the conditions can be checked with an application of epoxy base plastic. Follow label directions.
6. If severe "rust-through" conditions are encountered, glass removal is necessary. Then, perform necessary metal replacement and/or solder filling operations as required.
7. Locate and drill holes for anode clip screws and for missing weld studs in rabbet at bottom of window opening (See Figure 1). Space anode clip holes evenly preferably five or less inches apart.

Use No. 44 or 3/32" drill bit. Use care in spacing and positioning anode clips so they will not interfere with reveal molding clips and molding installation. Anode clips are about two inches long.
8. Remove masking which protected paint surfaces. Featheredge cut edges of paint and clean adjacent paint surfaces as required for paint application and blending.
9. Metal condition bare metal surfaces as follows:
 - a. Clean bare metal with metal conditioner for steel (DuPont - VM 5717; Rinshed-Mason #801; Ditzler DX-453; or equivalent). Follow label directions.
 - b. For best results, also apply a zinc phosphate treatment (Granodine No. 50 available by "Special Order" through Ditzler Jobbers or equivalent). Follow label directions.

10. Carefully apply one very thin coat of zinc chromate primer to bare metal only. Primer may be applied carefully with a brush. Follow label directions. Allow to air dry at least 30 minutes.

<u>ZINC CHROMATE PRIMER</u>	<u>SOURCE</u>	<u>STOCK NUMBER</u>
	DuPont	2085-S
	Ditzler	DPE-1537 or 1538
	Rinshed-Mason	831

CAUTION: Extreme care must be exercised to prevent "sandwiching" zinc chromate primer (enamel base) between coats of acrylic system, as "lifting" will occur.

11. Apply primer-surfacer to zinc chromated surfaces and to surfaces not hidden by reveal moldings. Allow to dry.
12. Carefully water-sand surfaces not hidden by moldings, DO NOT SAND surfaces hidden by moldings. Use extreme care to avoid cut-throughs at edges and corners.
13. Apply color to repair area and blend into adjacent surfaces as required. Allow color to dry. Rub out after thorough drying.
14. On 1965 models, install screw-retained reveal molding clips. Replace rusted clips.
15. At each anode clip location and wherever a weld stud has been broken off, seal and install screws (Part No. 4492963). Use No. "0" Phillips screwdriver.

NOTE: These screws also may be used for replacement of conventional weld studs which may be missing or have broken loose from surface.

16. Install window glass if it was removed previously.
17. On 1966 and later models, clean and install reveal molding clips on welded studs. Replace rusted clips.
18. Install zinc anode clips (Part No. 7741144) across bottom of window opening. (See Attached Illustration.) 10 to 15 clips are required depending upon the body style.
19. Clean up all reveal moldings as required. Then apply aluminum foil tape (described below) to entire length of upper and side reveal moldings. Apply tape only on outer flange of molding which is next to paint finish. Position tape at radius of molding (See Illustration) and slick tape down securely to molding. Properly positioned tape should not be evident after molding installation.

Aluminum foil tape availability:

SOURCE

3-M
Behr-Manning

STOCK NUMBER

Tape No. 426 (1/4" Wide x 60 Yards)
Tape No. 900 (1/4" Wide x 60 Yards)

IMPORTANT: Tape is available through any of the source jobbers and can be ordered if not on hand. The specified tapes meet minimum thickness requirements. Use of aluminum tapes less than 5 mils thick is not recommended.

20. Install reveal moldings and clean-up as required.

