



Information on Drilling High Strength Steel Related to Collision Repair (Aug 6, 2010)

Bulletin #10-08-98-002



Models: **2011 and Prior GM Passenger Cars and Light Duty Trucks**
 2010 and Prior HUMMER H2
 2009 and Prior HUMMER H3
 2010 and Prior Saturn Models
 2009 and Prior Saab 9-7X

To improve safety, fuel economy and vehicle performance, a number of high strength steels are used in manufacturing General Motors vehicles. These various high strength steels and their location in specific vehicles can be found in Service Information | Body Repair | Collision Repair | Visual Identification.

To perform structural or collision damage repairs, it is often necessary to drill out (remove) resistance spot welds in order to separate the components being serviced from the vehicle structure.

A variety of drill bits are available to remove these resistance spot welds, however the useful life of many of these drills is limited by the hardness of the high strength steels.

The General Motors Collision Repair Technology Center has recently validated *CryoCobalt™ drill bits developed for use with very hard metals. These drill bits performed with exceptional results and should allow for increased production and reduced overall cost related to resistance spot weld removal. These drill bits can also be re-sharpened.

*CryoCobalt™ drill bits are available directly from the manufacturer. Refer to the ordering information below.

*We believe this source and their products to be reliable. There may be additional manufacturers of such products/materials. General Motors does not endorse, indicate any preference for, or assume any responsibility for the products or material from this firm or for any such items that may be available from other sources.

Ordering Information

Use the part numbers listed below for special GM pricing.

Order Code#	Description	Size
GM801-4-1664	CryoCobalt Drill Bit (min.6)	1/4"
GM801-4-1665	CryoCobalt Drill Bit (min.48)	1/4"
GM801-4-2064	CryoCobalt Drill Bit (min.6)	5/16"
GM801-4-2065	CryoCobalt Drill Bit (min.48)	5/16"
GM801-4-2464	CryoCobalt Drill Bit (min.6)	3/8"
GM801-4-2465	CryoCobalt Drill Bit (min.48)	3/8"
GM999-9-4029	CryoCobalt Drill Bit-Index 1/16" to 1/2"	N/A

Contact the drill bit manufacturer, **PARTSMASTER**, at:

Customer Service: 972-438-0523, 7am - 5:30pm CT (E-mail: csdparts@partsmaster.com)

Technical Service: 972-438-0162, 8am - 5pm CT (E-mail: technicalservice@partsmaster.com)

GM bulletins are intended for use by professional technicians, NOT a "do-it-yourselfer". They are written to inform these technicians of conditions that may occur on some vehicles, or to provide information that could assist in the proper service of a vehicle. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do a job properly and safely. If a condition is described, DO NOT assume that the bulletin applies to your vehicle, or that your vehicle will have that condition. See your GM dealer for information on whether your vehicle may benefit from the information.



WE SUPPORT
VOLUNTARY
TECHNICIAN
CERTIFICATION