

Component Procedures: Wheels

Table of Contents

1. Parts and Labor (itype_189)
2. Replacement Wheels Description (Article 13635)
3. Aluminum Wheel Refinishing (Article 13640)
4. All New Technical Service Bulletins (itype_432)
5. All Technical Service Bulletins (itype_100)
6. Repair Tips (itype_110)
7. OEM Policies and Procedures (itype_120)
8. Tools and Equipment (itype_113)

Component Procedures: Wheels

Parts and Labor (itype_189)

Labor

Operation	Qualifier Path	Skill	Std Hrs	Wty Hrs
Balance	Chassis & Wheels > Wheels, Balance > One	C	0.5	0.0
Balance	Chassis & Wheels > Wheels, Balance > Each Add?	C	0.3	0.0
Rotate	Chassis & Wheels > Wheels, Rotate > 4 Wheels	C	0.4	0.0
Rotate	Chassis & Wheels > Wheels, Rotate > 4 Wheels ?		0.1	
Remove & Replace	Chassis & Wheels > Wheels, R&R > One	C	0.5	0.0

Replacement Wheels Description (Article 13635)

Replace the wheel if any of the following conditions exist:

- The wheel exhibits excessive runout.
- The wheel is bent.
- The wheel mounting surface is bent.
- The wheel is cracked.

Replace the wheel, the wheel hub studs and the wheel nut s, if any of the following conditions exist:

- The wheel has elongated wheel stud holes.
- The wheel nuts loosen repeatedly.
- Damage to the wheel bearing , the wheel fastener s and the wheel
- Tire damage caused by the modified clearance to the adjacent vehicle components
- Adverse vehicle steering stability caused by the modified scrub radius
- Damage to the vehicle caused by the modified ground clearance
- Speedometer and odometer inaccuracy
- Replacement wheels must be equivalent to the original equipment wheels in the following ways:
 - The load capacity.
 - The wheel diameter.
 - The rim width.
 - The wheel offset.
 - The mounting configuration.
- A wheel of the incorrect size or type may affect the following conditions:
 - Wheel and hub -bearing life.
 - Brake cooling.
 - Speedometer/odometer calibration.
 - Vehicle ground clearance.
 - Tire clearance to the body and the chassis.

Aluminium wheel identification is cast into the inboard side of the wheel.

Aluminum Wheel Refinishing (Article 13640)

Finish Damage Evaluation Procedure

- If the wheels are chrome-plated, do not re-plate or refinish the wheels.
- If the wheels are polished aluminum, do not refinish the wheels in the dealer environment. Utilize a refinisher that meets manufacturer guidelines.
- Inspect the wheels for damage from uncoated wheel balance weights or from automatic car wash facilities.
- Inspect the wheels for the following conditions:
 - Corrosion
 - Scrapes
 - Gouges
- Verify the damage is not deeper than what sanding can remove.
- Inspect the wheels for cracks. If a wheel has cracks, discard the wheel.
- Inspect the wheels for bent rim flanges. If a rim flange is bent, discard the wheel.

Refinishing Procedure

- Remove the tire and wheel assembly from the vehicle. Refer to Tire and Wheel Removal and Installation .
- Remove the balance weights from the wheel.
- Remove the tire from the wheel. Refer to Tire Dismounting and Mounting .
- Do not re-machine the wheel.
- Use a suitable cleaner in order to remove the following contaminants from the wheel:

- Lubricants
- Wax
- Dirt
- Do not use chemicals in order to strip the paint from the wheel.
- Use plastic media blasting in order to remove the paint from the wheel.
- If the wheel had a machined aluminum finish, spin the wheel and use sand paper in order to restore the circular machined appearance.
- Mask the wheel mounting surface and the wheel nut contact surface.
- Follow the paint manufacturer's instructions for painting the wheel. Refer to the latest GM Approved Refinish Materials Booklet (GMW 15406) for specific products for aluminum refinishing. To access the booklet, go to www.genuinegmparts.com. Click on GM Collision Parts. Click on Touch-Up Paint. Click on Downloadable Guides. Click on GM Refinish Materials GMW-15406.
- Unmask the wheel.
- Install a new valve stem.
- Install the tire to the wheel. Refer to Tire Dismounting and Mounting .
- Use a suitable cleaner in order to remove the following contaminants from the wheel mounting surface:
- Overspray
- Install the tire and wheel assembly to the vehicle. Refer to Tire and Wheel Removal and Installation .

All New Technical Service Bulletins (itype_432)

Tsbs

- Chemical Staining, Pitting, Corrosion and/or Spotted Appearance of Chromed Aluminum Wheels (00-03-10-002M, 2024/07/22)
- Information on Guidelines When Changing Tire and Wheel Size (26-NA-069, 2026/03/02)
- Tire Slowly Goes Flat, Tire Air Loss, Low Tire Pressure Warning Light Illuminated, Aluminum Wheel Bead Seat Corrosion (Clean and Resurface Wheel Bead Seat) (08-03-10-006I, 2025/03/14)
- Guidelines When Changing Tire And Wheel Size (PIT3271P, 2024/07/11)
- General Motors Position on Refinishing Fully Color Painted Aluminum Wheels with Base Paint (U.S. ONLY) (17-NA-052, 2024/04/08)

All Technical Service Bulletins (itype_100)

Tsbs

- Wheel Weights for Black Painted Wheels (PI0569A, 2012/04/12)
- Information on Hunter Road Force Balancer (17-NA-170, 2023/10/06)
- Chemical Staining, Pitting, Corrosion and/or Spotted Appearance of Chromed Aluminum Wheels (00-03-10-002M, 2024/07/22)
- Wheels - Information on Swapping Wheels (PIC5280E, 2014/07/23)
- Information on Guidelines When Changing Tire and Wheel Size (26-NA-069, 2026/03/02)
- Tire Slowly Goes Flat, Tire Air Loss, Low Tire Pressure Warning Light Illuminated, Aluminum Wheel Bead Seat Corrosion (Clean and Resurface Wheel Bead Seat) (08-03-10-006I, 2025/03/14)
- Wheels - Preventing Chrome Clad Wheel Damage (09-03-10-016B, 2014/02/21)
- Information on Tire/Wheel Characteristics (Vibration, Balance, Shake, Flat Spotting) of GM Original Equipment Tires (03-03-10-007K, 2021/11/08)
- Guidelines When Changing Tire And Wheel Size (PIT3271P, 2024/07/11)
- General Motors Position on Refinishing Fully Color Painted Aluminum Wheels with Base Paint (U.S. ONLY) (17-NA-052, 2024/04/08)

Repair Tips (itype_110)

Tsbs

- Wheels - Information on Swapping Wheels (PIC5280E, 2014/07/23)
- Wheels - Preventing Chrome Clad Wheel Damage (09-03-10-016B, 2014/02/21)

OEM Policies and Procedures (itype_120)

Tsbs

- Wheel Weights for Black Painted Wheels (PI0569A, 2012/04/12)
- Information on Tire/Wheel Characteristics (Vibration, Balance, Shake, Flat Spotting) of GM Original Equipment Tires (03-03-10-007K, 2021/11/08)
- Guidelines When Changing Tire And Wheel Size (PIT3271P, 2024/07/11)
- General Motors Position on Refinishing Fully Color Painted Aluminum Wheels with Base Paint (U.S. ONLY)

(17-NA-052, 2024/04/08)

Tools and Equipment (itype_113)

Tsbs

- Information on Hunter Road Force Balancer (17-NA-170, 2023/10/06)
- Wheels - Preventing Chrome Clad Wheel Damage (09-03-10-016B, 2014/02/21)