



DE LOREAN MOTOR CARS OF AMERICA
Division of DeLorean Motor Company

SERVICE BULLETIN

NUMBER ST-03-2/82

CATEGORY: TECHNICAL

ATTENTION: ALL DEALERS/SERVICE MANAGERS

SUBJECT: REPAIR OF FRONT FRAME EXTENSION

In the event that the front frame extension of a De Lorean is damaged in an accident the following repair procedure has been established:

1. Empty the fuel tank.
2. Remove fuel pump inspection cover located under spare tire and rollover valve inspection cover located in rear left quarter of luggage compartment beneath fuel filler cap.
3. Disconnect fuel lines from fuel pump, fuel filler hose and vent hose from fuel tank.
4. Disconnect electrical connections to fuel pump and fuel gauge.
5. Using appropriate equipment, evacuate the air-conditioning system.
6. Raise the vehicle on a hoist.
7. Drain the coolant system.
8. Remove air ducting shroud between air dam and radiator.
9. Disconnect air-conditioning lines and coolant hoses from radiator.
10. Disconnect wiring harness from coolant fans.
11. Remove right and left side radiator mounting brackets and remove radiator, condenser and fan as a unit.
12. Remove fuel tank closing plate and fuel tank.
13. Undo lower steering rack u-joint, steering rack brackets and tie rod ends and remove steering rack.

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14. Using a hole saw cut a 10 inch diameter hole in spare wheel well. THIS WILL PROVIDE ACCESS TO TOP OF RIGHT OF FRAME EXTENSION.

NOTE: Save the piece removed as it will be necessary to replace it at a later time.

15. Using an air chisel, high rotary grinder or metal saw, remove damaged frame impact extension.

NOTE: Do not use an oxyacetylene torch.
Do not cut into parent metal.

16. Grind all surfaces to be welded flush with parent metal allowing approximately 3/4 inch to 1 inch of clean metal at points to be welded.
17. Attach alignment jig J-33229 loosely to front cross member (See Figure 1).

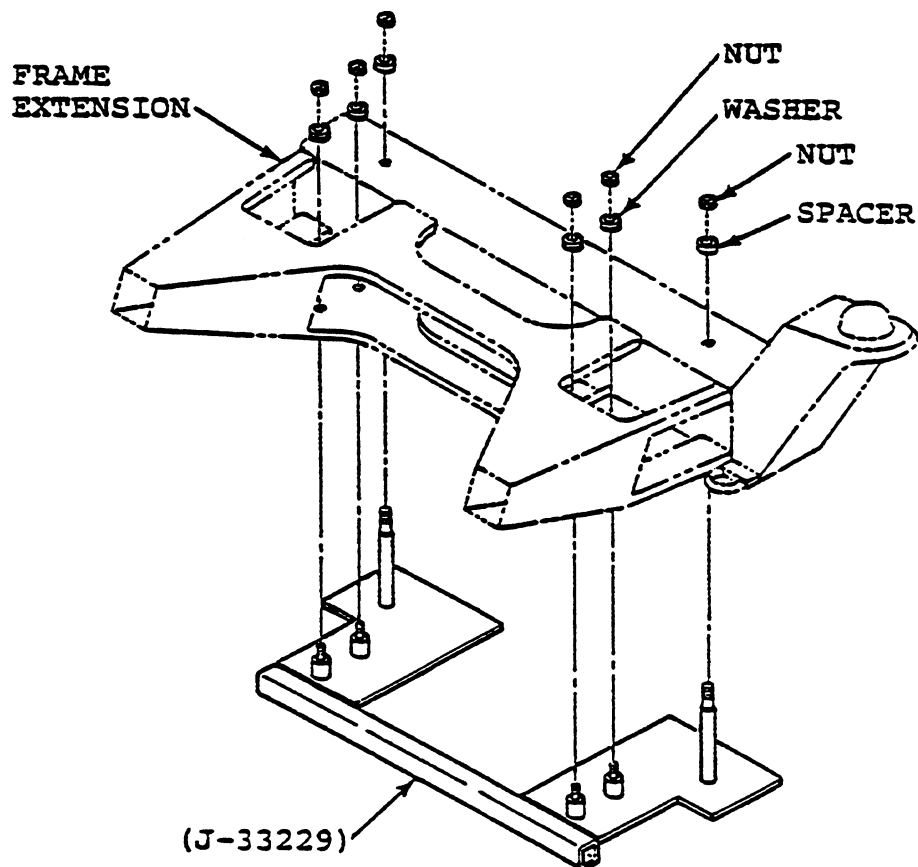


FIGURE 1

18. Attach new front frame extension (Part No. 105289) to alignment jig J-33229 (See Fig. 1). Tighten all fasteners on alignment jig while simultaneously checking positioning of frame extension to cross member.
19. Tack weld at all major contact points and remove jig. Continue welding until all contact areas are joined. Allow to cool.
20. Clean all bare metal surfaces and coat with corrosion protective kit Part No. 109264/5. Allow to dry.
21. Reinstall all parts in reverse order. Replace section removed from spare wheel well using a suitable fiberglass repair kit.

NOTE: Prior to installing anti-roll bar clamps and radiator mounting brackets, ensure that the frame extension stiffeners are installed as follows:

- a. Using the bolts to hold the side of the radiator bracket to the impact extension, install two (2) strengthening brackets (Part Nos. 111140/111141) to the impact extension loosely (See Fig. 2).

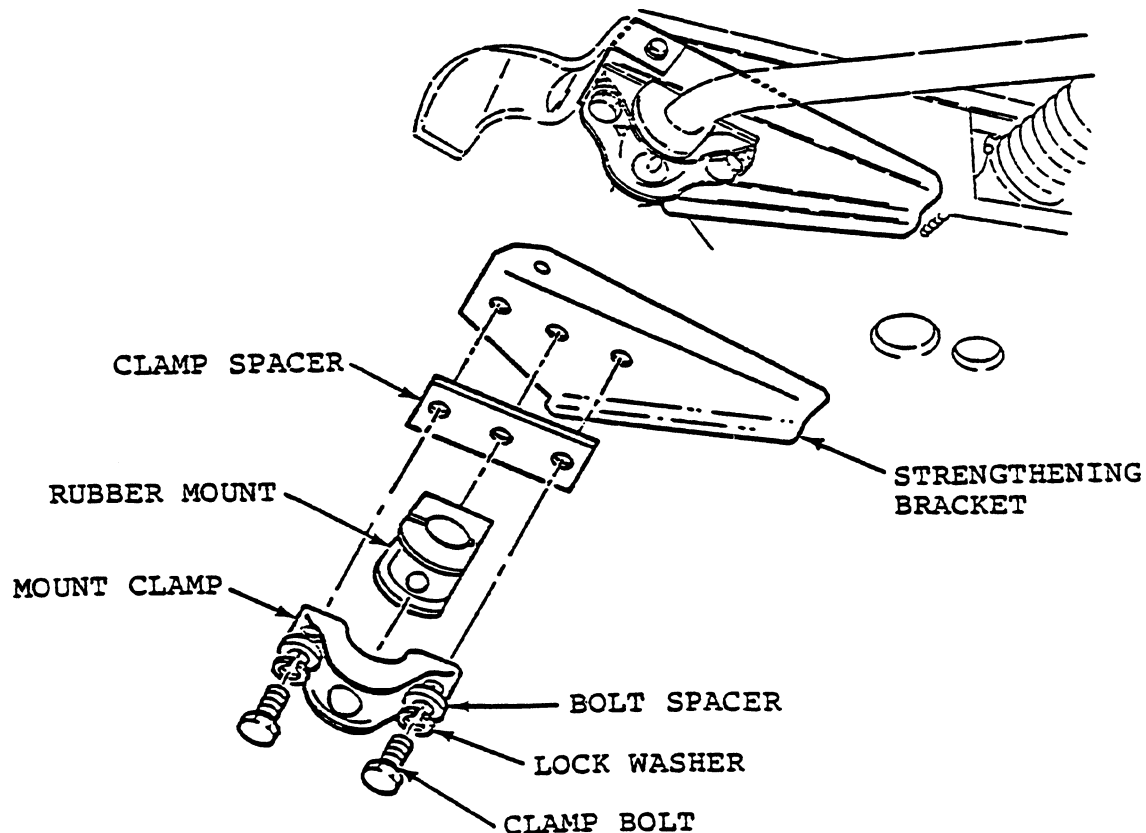


FIGURE 2

- b. Install clamp spacer (Part No. 106960) and anti-roll bar bracket (Part No. 108998) and spacers (Part No. 111205) using bolt (Part No. 111204) coated with Loctite 242. Torque to 35 NM (26 ft. lb.) (See Fig. 2).
 - c. Ensure radiator is positioned as far as possible to the right of the vehicle before tightening the radiator support bracket, side bolts and top bolts.
 - d. Tighten lower radiator mounting bolts.
- 21. Refill cooling system and pressure test.
 - 22. Recharge air-conditioning system.
 - 23. Check and, if necessary, adjust wheel alignment.

Please inform all personnel concerned.

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