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OFFICE OF DEFECTS
INVESTIGATION

December 22, 2003

Mr. Kenneth N. Weinstein
Associate Administrator for Safety Assurance
National Highway Traffic Safety Administration
400 Seventh Street, S.W., Room 5321
Washington, D.C. 20580

04V-002 ①α⑩

Dear Mr. Weinstein:

The following information is submitted pursuant to the requirements of 49 CFR 573.6 as it applies to a determination by General Motors of a safety defect involving certain 2004 Saturn ION model vehicles.

573.6(c)(1): Saturn Corporation, a subsidiary of General Motors Corporation.

573.6(c)(2)(3)(4): This information is shown on the attached sheet.

573.6(c)(5): Saturn has decided that a defect relating to motor vehicle safety exists in certain 2004 model year ION sedan and coupe vehicles. These vehicles may have been built with some welds between the passenger's side motor rail and the front bumper bracket that do not meet engineering specifications. Long term durability of the subject joint may be reduced and separation of the bumper from the frame on the passenger's side of the vehicle may result. To eliminate the possibility of the cold weld joints degrading in the future, we are conducting a safety recall.

573.6(c)(6): On December 10, 2003 a Spring Hill Assembly Technician discovered a cold weld on the motor rail. Spring Hill Assembly immediately notified the supplier and an investigation and containment began.

The investigation revealed that on December 3, 2003, a technician at the supplier's (Shiloh Industries, Inc) stamping facility made a process change to compensate for an out of position weld shank on weld robot gun 9-2. This led to the events which caused the cold weld condition. This process change, which occurred on the South robot welder during second shift, created a condition where weld tip degradation was not properly compensated for on the welder. At certain intervals in tip life this could lead to a "cold weld" condition. The process was corrected on December 8, 2003.

On December 12, 2003, GM conducted a conference call regarding vehicles that may have been shipped from Spring Hill with the weld condition. An engineer at the assembly plant advised that this condition would cause a noncompliance with FMVSS 208. The Senior Management was advised and it recommended that the issue proceed to the Field Action Decision Committee. Saturn issued a Stop Delivery to retailers on December 12, 2003 and the FADC decided to conduct a recall on December 15, 2003.

On December 16, 2003, I informed NHTSA by telephone of the decision to conduct a field action. Later that day, Crashworthiness Engineering was consulted and it advised that compliance with FMVSS 208 would not be affected. GM then decided to proceed with this field action as a safety defect recall.

Product Investigations

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2125-35267 673.doc

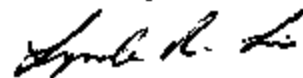


573.6(c)(8): This information is included in the service procedure of the attached dealer bulletin.

Pursuant to 577.11(e), GM does not believe notification about reimbursement is required for this recall. Due to the Stop Delivery issued, there are no involved vehicles in customer's possession.

573.6(c)(9): A copy of the retailer bulletin is attached. Saturn plans to notify retailers on December 23, 2003 about this safety recall.

Sincerely,



Lyndon R. Lie
Director
Product Investigations

2123 - 03067
Attachments

573.6(c)(2),(3),(4)VEHICLES POTENTIALLY AFFECTED BY MAKE, MODEL, AND MODEL YEAR
PLUS INCLUSIVE DATES OF MANUFACTURE

<u>MAKE</u>	<u>MODEL SERIES</u>	<u>MODEL YEAR</u>	<u>NUMBER INVOLVED</u>	<u>INCLUSIVE MANUFACTURING DATES (FROM) (TO)</u>		<u>DESCRIPTIVE INFO. TO PROPERLY IDENT. VEH.</u>	<u>EST. NO. W/CONDITION</u>
Satum	A	2004	344	12/03	12/03	ION	5%

RECALL BULLETIN

NO.:

03067

SAFETY

DATE:

December, 2003

CATEGORY TYPE:

Body & Accessories - 08

CATEGORY:

Frame & Underbody - 61**PRODUCT SAFETY RECALL**

SUBJECT: DISCREPANT WELDS ON RIGHT FRONT MOTOR RAIL

YEAR and MODEL: 2004 SATURN ION VEHICLES

TO: ALL SATURN RETAILERS AND AUTHORIZED SERVICE PROVIDERS

The US National Traffic and Motor Vehicle Safety Act provides that each vehicle that is subject to a recall of this type must be adequately repaired within a reasonable time after the owner has tendered it for repair. A failure to repair within sixty (60) days after tender of a vehicle is prima facie evidence of failure to repair within a reasonable time.

If the condition is not adequately repaired within a reasonable time, the owner may be entitled to an identical or reasonably equivalent vehicle at no charge, or to a refund of the purchase price less a reasonable allowance for depreciation.

To avoid having to provide these burdensome remedies, every effort must be made to promptly schedule an appointment with each customer and to repair their vehicle as soon as possible. In the recall notification letter, customers are told how to contact the US National Highway Traffic Safety Administration if the recall is not completed within a reasonable time.

CONDITION

Saturn has decided that a defect relating to motor vehicle safety exists in certain 2004 Model Year ION sedan and coupe vehicles. These vehicles may have been built with some welds between the passenger's side motor rail and the front bumper bracket that do not meet engineering specifications. Long term durability of the joint may be reduced and separation of the bumper from the frame on the passenger's side of the vehicle may result.

SATURN 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 **SATURN** Retailer for information on whether your vehicle may benefit from the information.

CORRECTION

Retailers will inspect the Julian date code on the right front motor rail to determine if a repair is necessary.

VEHICLES INVOLVED

A complete vehicle identification number (VIN) list for vehicles involved in this recall is provided on page 7.

You must verify recall involvement through your AS400 system. **It is important to note that recall claims will only be paid on involved vehicles.**

OWNER NOTIFICATION

Owners of all involved vehicles located within areas covered by the US National Traffic and Motor Vehicle Safety Act will be notified of this recall by Saturn.

RETAILER RESPONSIBILITY

All unsold new vehicles in Retailers' possession and subject to this recall must be held and inspected/repared per the service procedure of this recall bulletin before customers take possession of these vehicles.

Retailers are to service all vehicles subject to this recall at no charge to customers, regardless of mileage, age of vehicle, or ownership, from this time forward. Owners who have recently purchased vehicles sold from your vehicle inventory are to be contacted by the retailer and arrangements are to be made to make the required correction according to the procedure contained in this bulletin.

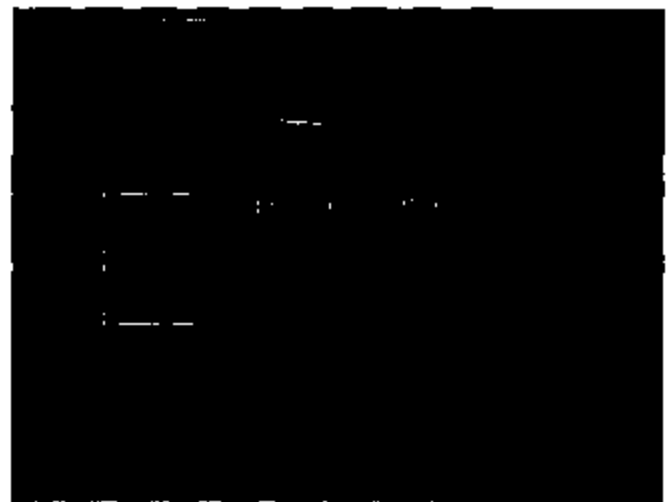
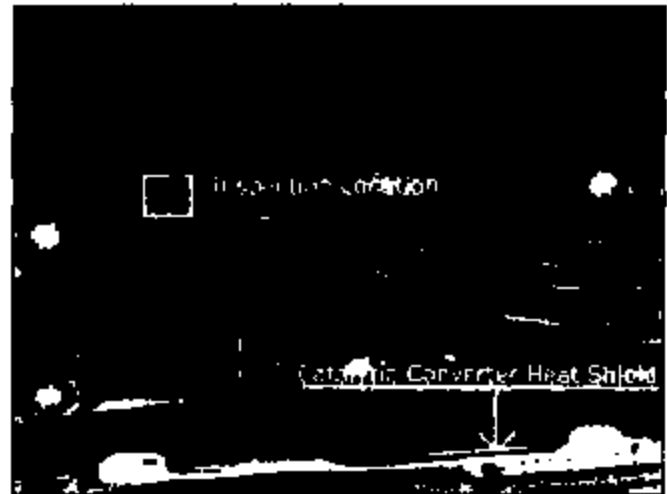
MOTOR RAIL JULIAN DATE CODE INSPECTION PROCEDURE (03067)

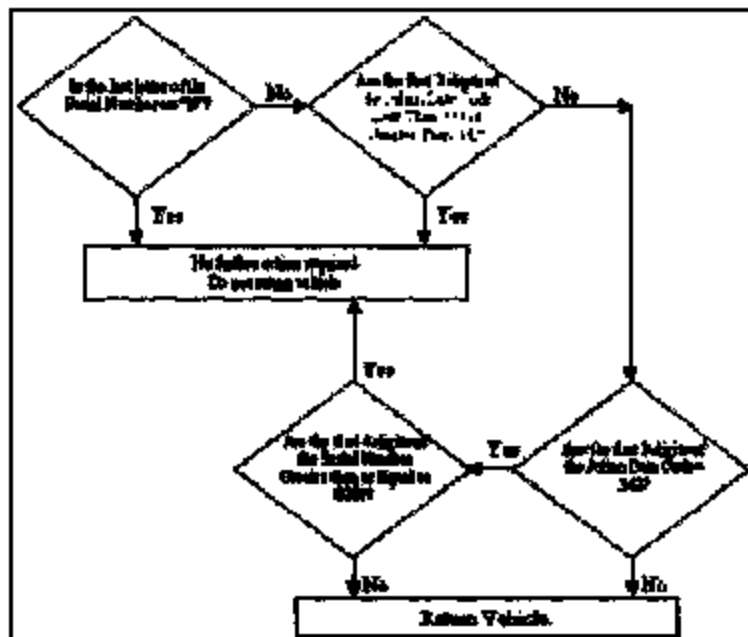
1. Identify suspect vehicles by comparing the vehicle identification number (VIN) of the vehicle to VIN list provided.
 - If vehicle VIN is included in list, go to step 2.
 - If vehicle VIN is not listed, no further action is required.
2. Raise vehicle on hoist.

IMPORTANT: Inspect the right side (passenger side) motor rail only. The motor rail is the outer rail that runs from the engine compartment and terminates mid-vehicle near the B-pillar.

3. Locate the right side rear of the motor rail (located below B-pillar area).

IMPORTANT: The rear-most end of the motor rail will be stamped with a series of alpha numeric characters on the top row, which defines the part serial number. The serial numbers to be inspected will end in the letters "N" or "S" (the "N" or "S" denotes the line the motor rail was built on). Suspect vehicles will have the designation of "S." The third row of numeric characters define the Julian date code.

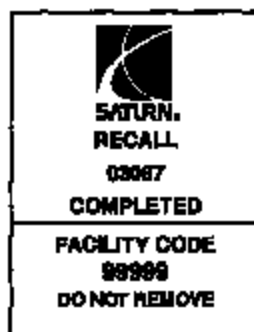




4. Locate and record the serial number stamped on the rear-most end of the motor rail. (Record serial number on the CSO.)
- If the serial number in the top row of alpha numeric characters end in the letter "N," no further action is required. Place Recall Identification Label on radiator support and process claim with labor operation number V1093.
 - If the serial number in the top row of alpha and numeric characters ends in the letter "S," it will be necessary to compare the Julian date code on line 3 of the stamped information on the motor rail and compare with the information below.
 - Record the Julian date code number on the CSO.
 - If the first three digits of the Julian date code are less than 337 or greater than 343, no further action is required. Place a Recall Identification Label on radiator support and process claim with labor operation number V1093.
 - If the first three digits of the Julian date code are 342, inspect the first four digits of the serial number.
 - If the first four digits of the serial number are 0301 or greater, no further action is required. Place a Recall Identification Label on radiator support and process claim with labor operation number V1093.
- OR**
- If the first four digits of the serial number are 0300 or less, the vehicle must be held for return shipment to Saturn Corporation. Process claim with labor operation V1094. (Refer to Vehicle Return Process in this bulletin.)
 - If the first three digits of the Julian date code on line 3 are 337, 338, 339, 340 or 341, the vehicle must be held for return shipment to Saturn Corporation. Process claim with labor operation V1094. (Refer to Vehicle Return Process in this bulletin.)

RECALL IDENTIFICATION LABEL

Upon completion of the recall, a Recall Identification Label and Clear Protective Cover should be affixed on a clean, dry surface of the radiator core support in an area clearly visible when the hood is raised. Each label provides a space to print in ink (or type) the recall number (03067) and the five (5) digit facility code of the retailer performing the recall service.



As a reminder, additional labels may be ordered from Saturn publications (1-800-828-2112, prompt 3, Item Number S03 00013A for the Recall Identification Label, and item number S03 00013B for the *Clear Protective Cover*).

CREDIT

1. To receive credit, submit a claim with the information below:

Repair Performed	Parts Allow.	Sale Type	Case Type	Labor Op.	Labor Hrs.	Admin. Hrs. *
Recall (03067) Motor Rail Julian Date Code Inspect: Inspect and Approve	N/A	WC	VC	V1093	0.2	0.1
Recall (03067) Motor Rail Julian Date Code Inspect: Inspect and Return	N/A	WC	VC	V1094	0.2	0.1

2. Check your Saturn **SERVICELINE.XL** Claim Memorandum daily. Remember to code the claim as a WC sale type, and VC case type. Contact your field representative if you need assistance.
3. **All labor operations claimed in this bulletin must be submitted on individual (unrelated) CSO lines.** Refer to the Customer Service Order Preparation Manual for details on Product Recall Claim Submission.

* Recall administration allowance

VEHICLE RETURN PROCESS

IMPORTANT: Please inspect all vehicles in your inventory per the included VIN list prior to contacting the Retail Support Team. This will assist in ensuring that Saturn is able to efficiently expedite the logistical process to return the vehicles to Spring Hill for repair.

1. After following the inspection process and determining that the vehicle meets the criteria for return, the following information will be needed when contacting the Retail Support Team to facilitate the return:
 - Retailer code
 - Retailer name
 - Vehicle Identification Number
 - Frame rail serial number (per inspection procedure)
 - Frame rail Julian date code (per inspection procedure)
2. Contact the Retail Support Team at 1-800-828-2112, prompt 8, prompt 2 to provide the information gathered above.

VEHICLE IDENTIFICATION NUMBER (VIN) LIST

4Z159116	4Z159226	4Z159321	4Z159413	4Z159534	4Z159651	4Z159788
4Z159119	4Z159227	4Z159322	4Z159414	4Z159537	4Z159654	4Z159791
4Z159121	4Z159228	4Z159324	4Z159415	4Z159538	4Z159658	4Z159795
4Z159122	4Z159229	4Z159327	4Z159419	4Z159541	4Z159660	4Z159798
4Z159125	4Z159231	4Z159330	4Z159420	4Z159544	4Z159667	4Z159802
4Z159129	4Z159234	4Z159334	4Z159421	4Z159545	4Z159669	4Z159809
4Z159131	4Z159237	4Z159336	4Z159422	4Z159551	4Z159675	4Z159812
4Z159133	4Z159238	4Z159337	4Z159424	4Z159554	4Z159677	4Z159815
4Z159137	4Z159242	4Z159338	4Z159426	4Z159556	4Z159678	4Z159819
4Z159151	4Z159244	4Z159339	4Z159427	4Z159558	4Z159681	4Z159821
4Z159158	4Z159247	4Z159340	4Z159428	4Z159559	4Z159682	4Z159822
4Z159159	4Z159248	4Z159341	4Z159429	4Z159564	4Z159685	4Z159826
4Z159162	4Z159249	4Z159344	4Z159430	4Z159565	4Z159686	4Z159829
4Z159164	4Z159252	4Z159345	4Z159432	4Z159567	4Z159689	4Z159830
4Z159165	4Z159253	4Z159346	4Z159433	4Z159568	4Z159690	4Z159831
4Z159168	4Z159256	4Z159348	4Z159434	4Z159569	4Z159691	4Z159832
4Z159167	4Z159258	4Z159351	4Z159437	4Z159571	4Z159692	4Z159837
4Z159168	4Z159260	4Z159352	4Z159441	4Z159580	4Z159696	4Z159845
4Z159171	4Z159261	4Z159353	4Z159445	4Z159587	4Z159697	4Z159847
4Z159173	4Z159262	4Z159354	4Z159451	4Z159588	4Z159701	4Z159860
4Z159176	4Z159263	4Z159355	4Z159456	4Z159589	4Z159704	4Z159865
4Z159178	4Z159264	4Z159357	4Z159460	4Z159590	4Z159707	4Z159866
4Z159179	4Z159267	4Z159359	4Z159462	4Z159594	4Z159711	4Z159876
4Z159181	4Z159269	4Z159361	4Z159464	4Z159596	4Z159712	4Z159879
4Z159182	4Z159270	4Z159362	4Z159465	4Z159599	4Z159713	4Z159887
4Z159184	4Z159274	4Z159364	4Z159466	4Z159600	4Z159716	4Z159888
4Z159185	4Z159275	4Z159365	4Z159473	4Z159603	4Z159717	4Z159889
4Z159186	4Z159279	4Z159371	4Z159474	4Z159605	4Z159718	4Z159896
4Z159188	4Z159281	4Z159372	4Z159475	4Z159606	4Z159731	4Z159899
4Z159189	4Z159282	4Z159373	4Z159476	4Z159609	4Z159732	4Z159904
4Z159191	4Z159283	4Z159374	4Z159477	4Z159610	4Z159733	4Z159911
4Z159192	4Z159284	4Z159376	4Z159478	4Z159612	4Z159737	4Z159913
4Z159193	4Z159287	4Z159378	4Z159481	4Z159614	4Z159738	4Z159926
4Z159195	4Z159288	4Z159380	4Z159482	4Z159615	4Z159739	4Z159937
4Z159198	4Z159289	4Z159381	4Z159484	4Z159619	4Z159741	4Z159940
4Z159203	4Z159291	4Z159382	4Z159497	4Z159620	4Z159744	4Z159958
4Z159204	4Z159292	4Z159384	4Z159498	4Z159621	4Z159745	4Z159974
4Z159205	4Z159295	4Z159385	4Z159502	4Z159625	4Z159746	4Z159996
4Z159206	4Z159296	4Z159386	4Z159503	4Z159626	4Z159748	4Z160035
4Z159207	4Z159298	4Z159387	4Z159504	4Z159627	4Z159753	4Z160041
4Z159209	4Z159299	4Z159388	4Z159508	4Z159629	4Z159754	4Z160060
4Z159210	4Z159300	4Z159389	4Z159511	4Z159635	4Z159759	4Z160102
4Z159212	4Z159304	4Z159392	4Z159512	4Z159636	4Z159764	4Z160116
4Z159213	4Z159305	4Z159393	4Z159515	4Z159637	4Z159765	4Z160175
4Z159214	4Z159306	4Z159399	4Z159518	4Z159640	4Z159772	
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4Z159216	4Z159312	4Z159407	4Z159525	4Z159643	4Z159778	
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