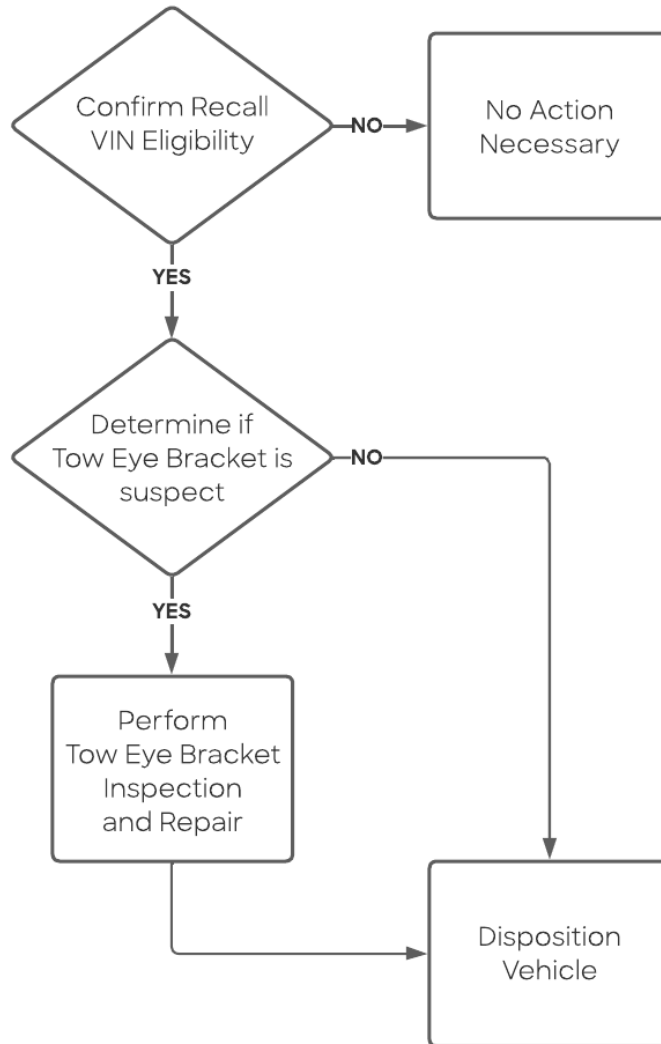


Technical Instructions
Lucid Safety Recall SR-22-02-0
Tow Eye Bracket

I. PROCESS OVERVIEW



II. DOCUMENTATION DETAILS

Warranty Claim Procedure

To ensure that vehicle campaign repairs are claimed correctly, please reference the following when creating work orders for this campaign:

Job Code SR-22-02-0 Tow Eye Bracket
 Pay Type Campaign
 Defect Code Campaign
 Casual PN P11-SA0000-09

For all affected vehicles, click on the VIN recall record (under the Related section on the Asset). Insert the Work Order number in the Work Order field to automatically populate the required job code(s). Once the repair is finished, change the status on the VIN Recall to 'Closed'.

Please use the Labor Operation Code that best reflects the procedure performed on the vehicle.





Labor Op Code	Action	Description	FRT*
96.220201	Inspect	SR-22-02-0 Tow Eye Bracket Inspect Subframe Numbers – No Additional Action Required	0.2
96.220202	Inspect and Repair	SR-22-02-0 Tow Eye Bracket Inspect Subframe Numbers – Install Rivets	2.3
96.220203	Inspect and Replace	SR-22-02-0 Tow Eye Bracket Inspect Subframe Numbers – R&R Subframe	8.2

**NOTE: Flat Rate Time (FRT) is subject to change.*

Parts

Part Number	Description	Qty Per Vehicle
P00-F740BZ-00	Rivet for Tow Bracket	2
P00-FA640P-00	Fir Tree	2
P00-F95DOP-00	Clip Fir Tree Cable Strap	1

Special Tools Provided

Part Number	Description	Picture
T1S-S66300-00	Tow Eye Drill Jig	
T1S-E76000-00	FEM Cutting Template Panel	
Supplied by Service	1/4" Rivet Gun Milwaukee	
Supplied by Service	12" Drill Bit Extension	
Supplied by Service	17/64" Drill Bit	

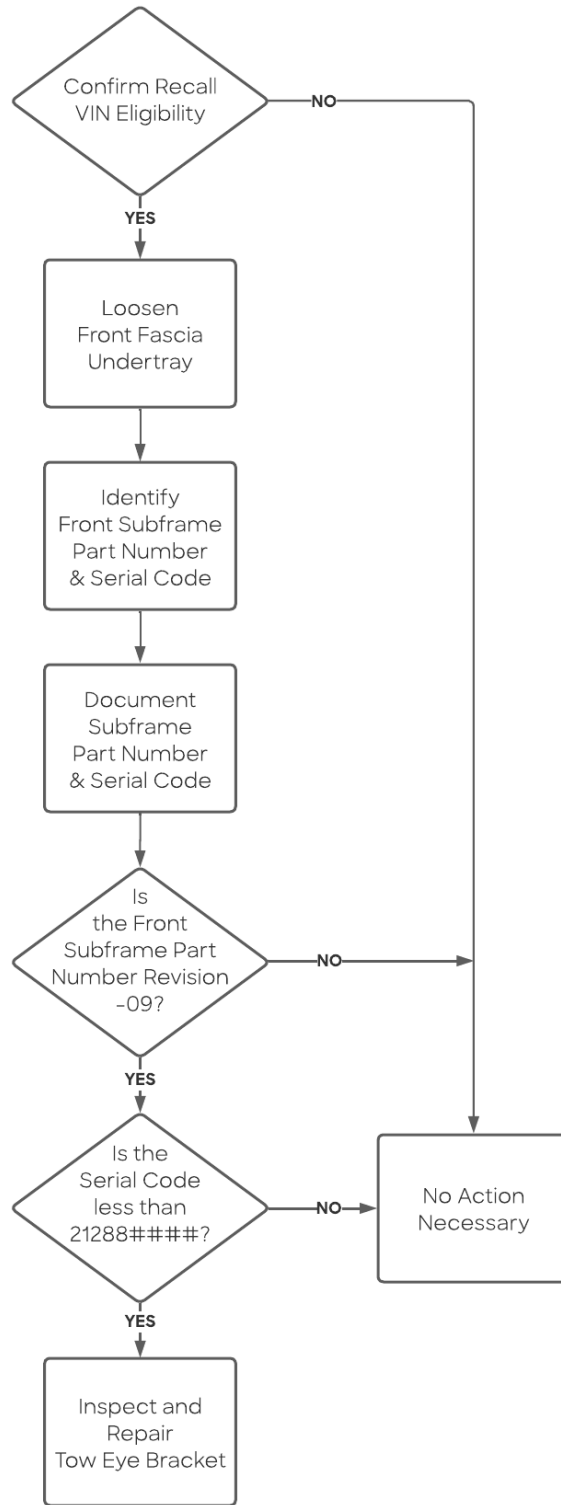
Service Tools Required

Part Number	Description	Qty
T0S-Z29700-00	Borescope	1
*	3/8" Drill	1
*	Dremel Tool	1
*	1" Cutting Wheel for Dremel	As Required
*	120 Grit Sandpaper	As Required
*	Disposable Gloves	As Required
*	Personal Protection Equipment (PPE) Safety Gloves Safety Glasses Hearing Protection Other as appropriate	As Required

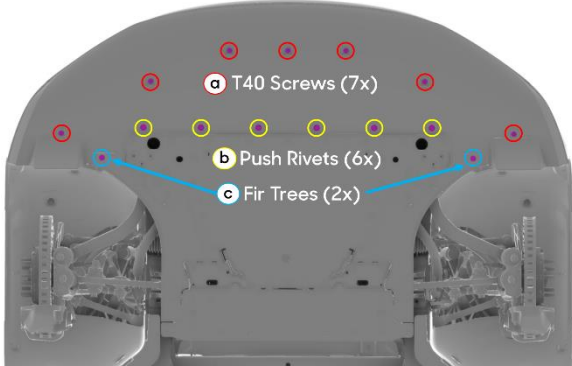

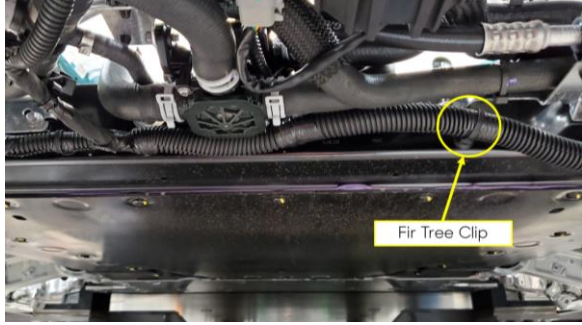
**NOTE: To be locally sourced.*

III. FRONT SUBFRAME PART NUMBER AND SERIAL CODE INSPECTION

Inspection Process Flow

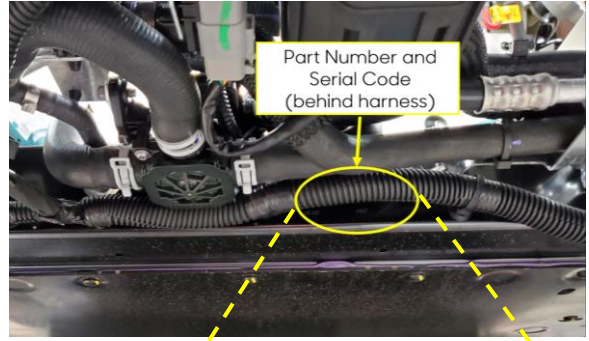


Subframe Part Number and Serial Code Inspection Procedure

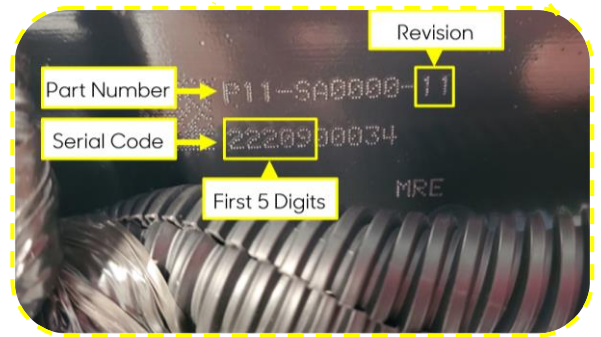
<p>1. Confirm Recall VIN Eligibility</p> <p>Eligible Assets will have a Service Campaign Flag and a Work Hold. Service Campaign: CP-00009 Title: SR-22-02-0 Tow Eye Bracket</p>	<p>Please be aware, there is at least one open Service Campaign for this vehicle!</p>
<p>2. Position Vehicle on a 2-Post Lift</p>	<p>Refer to Service Manual</p>
<p>3. Loosen Front Fascia Undertray</p> <p>a) Remove T40 screws (7x). b) Remove push rivets (6x). c) Remove fir trees (2x).</p> <p><i>NOTE: The Fir trees are one-time use and will require replacement upon reinstallation of the Front Fascia Undertray.</i></p>	 <p>The diagram shows the underside of the front fascia undertray. It is marked with three types of fasteners: 'a' T40 Screws (7x) in red circles, 'b' Push Rivets (6x) in yellow circles, and 'c' Fir Trees (2x) in blue circles. Blue arrows point from the labels to the corresponding fasteners on the undertray.</p>
<p>4. Locate the Front Subframe Part Number and Serial Code</p> <p>a) Carefully pull down on the Front Fascia Undertray.</p> <p><i>NOTE: Front Fascia Undertray removal is not required for the inspection procedure.</i></p> <p>b) Remove Wire Harness Fir Tree Cable Clip from the Front Subframe.</p> <p><i>NOTE: Wire Harness Fir Tree Cable Clip is a one-time use and will require replacement upon reinstallation of the Wire Harness.</i></p> <p><i>NOTE: Photo (b) shows the view of the subframe with the Front Fascia Undertray removed to provide the necessary detail. The inspection will be completed with the Front Fascia Undertray installed.</i></p>	<p>a)</p>  <p>b)</p>  <p>The photo shows the front subframe area with the undertray removed. A yellow circle highlights a 'Fir Tree Clip' on the subframe, with a yellow arrow pointing to it. A label 'Fir Tree Clip' is placed below the arrow.</p> <p>Front Vehicle View</p>

- c) Use a borescope to locate and view the Front Subframe Part Number and Subframe Serial Code.
- d) Take a photo of the Front Subframe Part Number and Serial Code.

NOTE: The Part Number and Serial Code are located behind the Wire Harness, as indicated in the picture.

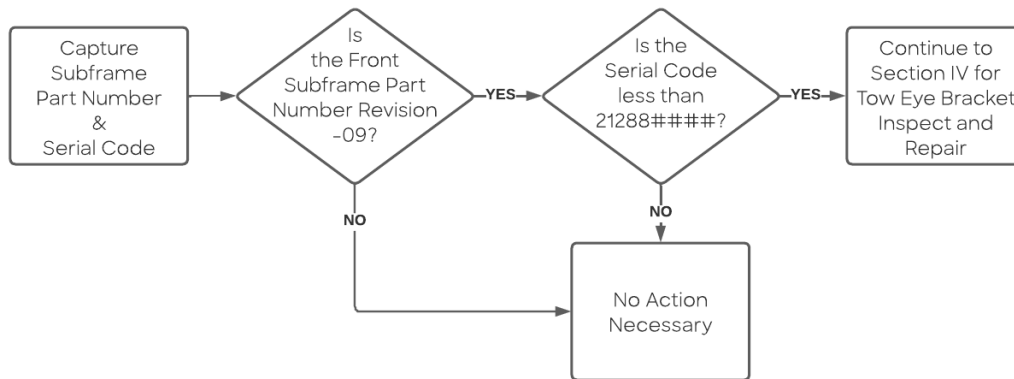


c)




5. Validate Subframe Part Number and Serial Code

Recall remedy only applies to Part Number Revision (-09) AND Serial Code (first 5 digits less than 21288) noted in the process diagram and visual aids below.

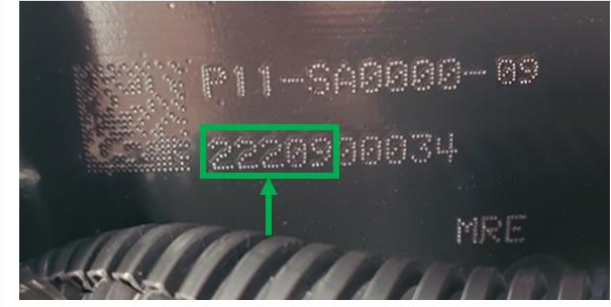



PART NUMBER REVISION

OK PART NUMBER REVISION	NOK PART NUMBER REVISION
	
<p>OK Part Number Revision: P11-SA000-10 / P11-SA000-11</p>	<p>NOK Part Number Revision: P11-SA000-09</p>

AND

SERIAL CODE

OK SERIAL CODE	NOK SERIAL CODE PERFORM RECALL REMEDY
	
<p>First 5 Digits Greater or Equal to \geq 21288 ##### Ex. 22209 #####</p>	<p>First 5 Digits Less than $<$ 21288 ##### Ex. 21096 #####</p>

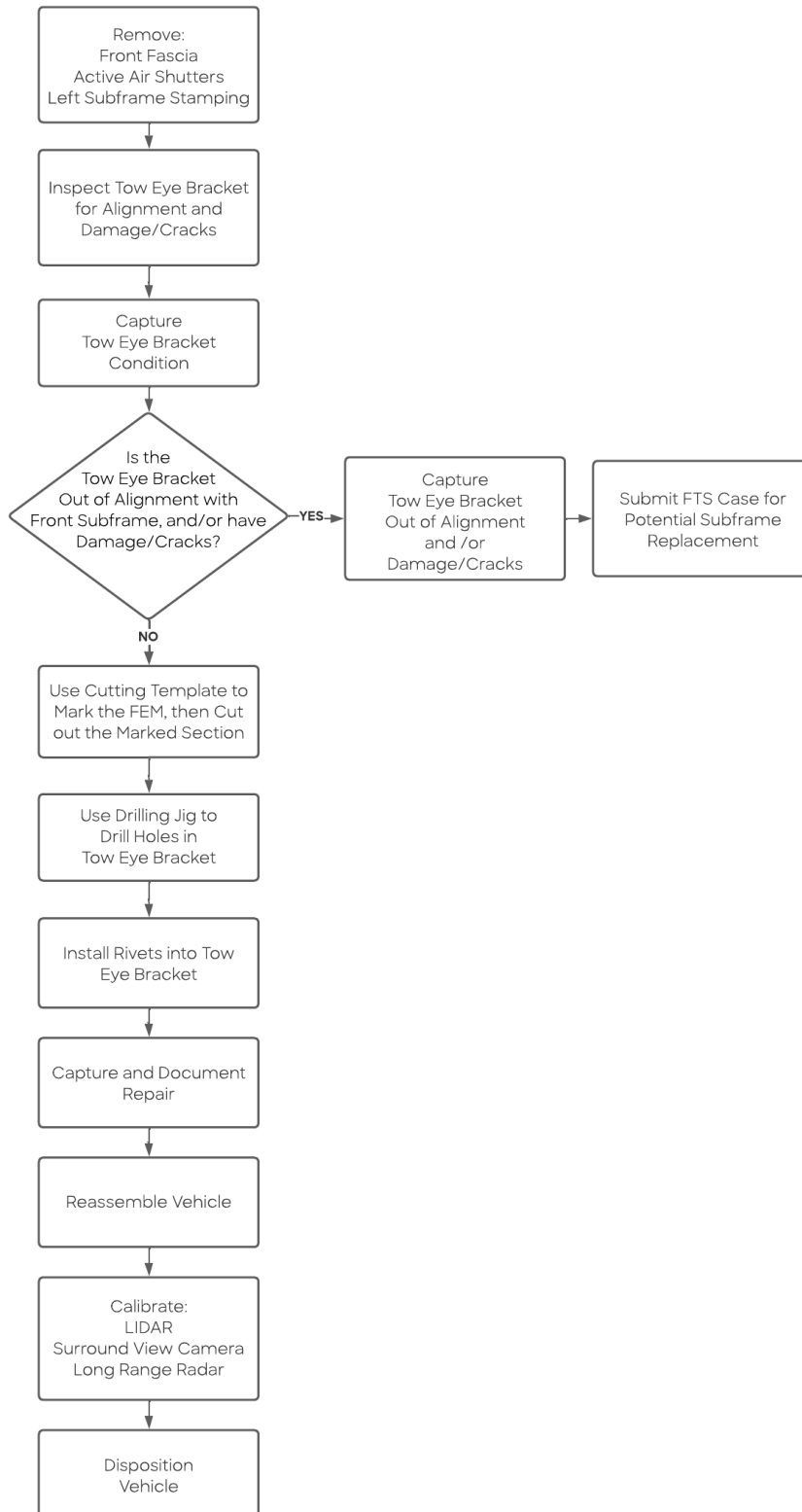
NOTE: Suspect Subframes must be Revision -09 AND the First 5 Digits of the Serial Code less than 21288.

6. Document Subframe Part Number & Serial Code


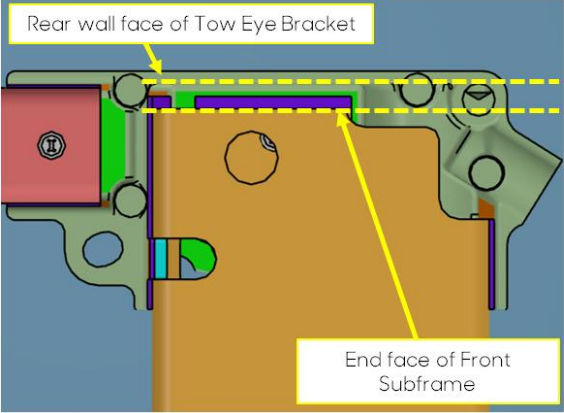
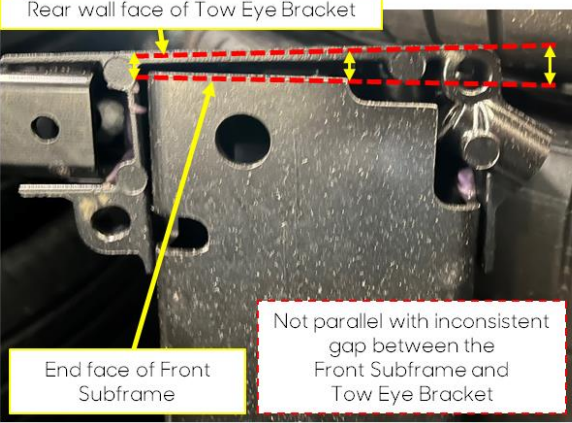
Attach Front Subframe Part Number and Serial Code photo to Work Order.

IV. TOW EYE BRACKET INSPECT AND REPAIR

Tow Eye Bracket Inspect and Repair Process Flow



Tow Eye Bracket Repair Procedure

<p>1. Remove Front Fascia Refer to "Front Fascia Assy R&I".</p>	<p>Refer to Service Manual</p>
<p>2. Remove Active Grill Shutters Refer to "Active Grill Shutter Assy R&I".</p>	<p>Refer to Service Manual</p>
<p>3. Remove Left Front Stamping Assembly</p> <ol style="list-style-type: none"> Remove T40 bolt from FEM Strut Lower Wishbone. Remove 10mm bolt from Left Front Subframe Stamping to Tow Eye Bracket. Remove 13mm bolt from Left Front Subframe Stamping Assembly to Subframe. 	
<p>4. Inspect Tow Eye Bracket for Alignment</p> <ol style="list-style-type: none"> Remove Tow Eye Bracket Gasket. Clean the area of the Tow Eye Bracket. Inspect the consistency of the gap between the rear wall face of the Tow Eye Bracket and the underside of the subframe. As shown in visual aid below, the two surfaces should be parallel with a consistent gap between both surfaces. <p><i>NOTE: Gap between both surfaces should be consistent.</i></p>	
<p style="text-align: center;">OK CONDITION</p> 	<p style="text-align: center;">NOK CONDITION</p> 
<p>Gap between faces must be parallel to each other</p>	<p>Gap between faces is not parallel to each other</p>
<p>5. Document Tow Eye Bracket Condition</p> <ol style="list-style-type: none"> Photograph the bottom of the Tow Eye Bracket to view the alignment as inspected in Step #4. Attach photographs to Work Order. 	

6. Inspect the Tow Eye Bracket for Damage and Cracks

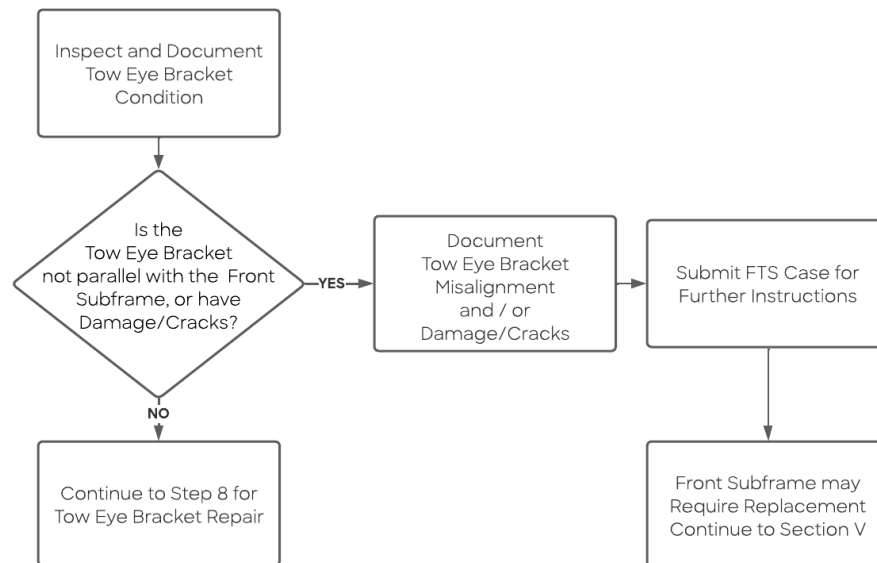
Inspect the entire surface of the Tow Eye Bracket for any signs of cracks or other damage. The locations highlighted below are critical to inspect.

TOW EYE BRACKET INSPECTION LOCATIONS

1 - Inspect zone around the two upper rivet locations (Along the line of the rivets).
 2 - Front face of casting close to lower left corner.
 3 - Around the tow eye attachment thread (In particular at 12 O'clock).
 4 - Tow eye casting rear outboard side zone. Excess purple adhesive shown is OK.

7. Document Tow Eye Bracket Condition

- a) Photograph critical points of the Tow Eye Bracket condition as inspected in Step #6.
- b) Attach photographs to Work Order.



8. Cut Front End Module (FEM)

NOTE: Removal of a FEM section is essential for access to the Tow Eye Bracket.

- a) Place the Cutting Template Panel over the FEM. PN: T1S-E76000-00

NOTE: Ensure the Cutting Template Panel is perfectly aligned and flush with the FEM geometry.

- b) Using a marker/wax pen, mark the FEM to be cut by tracing the inner edges of the Cutting Template Panel.
- c) Mark and **drill** holes on both upper edges of the cut-out area about 5mm from each edge with the supplied 17/64" drill bit.

NOTE: The radiused edges of the holes will prevent stress cracks.

- d) Cut the marked area of FEM with a Dremel tool.

CAUTION: The upper radius of the holes must remain after the cut.

- e) Remove and discard the FEM cut-out section.
- f) Smooth any rough edges of the cut-out area with 120 grit sandpaper.

b)



c)



d)



e)



f)



9. Install Drilling Fixture

- a) Place Drilling Jig over the Tow Eye Bracket (as shown).
- b) Install and lightly tighten the bolt on the right side of the Tow Eye Bracket.

a)



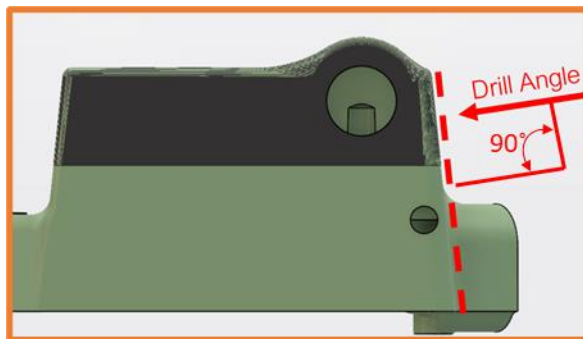
b)



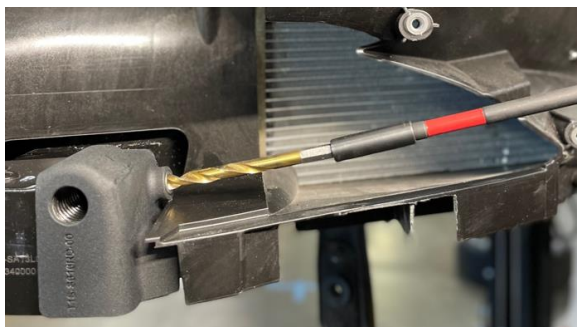
10. Drill Tow Eye Bracket Holes

CAUTION: The side of the Tow Eye Bracket casting is not vertical. The holes must be drilled perpendicular to the face of the casting.

CAUTION: Use caution while drilling, as the FEM may break.



- a) Drill the upper and lower holes using a 17/64" Drill Bit and 12" Extension.





NOTE: A 12" Extension is required for proper drill angle and clearance.

- b) Remove Drilling Fixture.
- c) Clean the Subframe holes and outboard face of metal debris and contaminants.



11. Install Rivets


- a) Insert a rivet in each of the Tow Eye Bracket holes.
- b) Check for fit and alignment.
- CAUTION:** Use caution when bending the FEM as it may crack.
- c) Use the Lucid supplied rivet installation tool to set both rivets.
- d) Inspect rivets for flushness and proper installation.



a)



c)

	 <p>c)</p> <p>d)</p>
<p>12.Document Repair Photograph the completed repair and attach photograph to Work Order.</p>	
<p>13.Re-Assembly</p> <ul style="list-style-type: none"> a) Install Tow Eye Bracket Gasket. b) Install 13mm bolt from Left Front Subframe Stamping Assembly to Subframe. (Torque - 25Nm) c) Install 10mm bolt (1x) from Left Front Subframe Stamping Assembly to Tow Eye Bracket. (Torque - 15Nm) d) Install T40 bolt from FEM Strut Lower Wishbone. (Torque - 10Nm) e) Install Active Grill Shutters. f) Install Front Fascia. 	<p>Refer to Sevice Manual</p>
<p>14.Calibrate Cameras and Sensors</p> <ul style="list-style-type: none"> a) Perform LIDAR Calibration. b) Perform Surround View Camera Calibration. c) Perform Long Range Radar Calibration. 	<p>Refer to Sevice Manual</p>

V.SUBFRAME REPLACEMENT

Only perform subframe replacement if it has been approved by the FTS Team

1.Replace Front Subframe Refer to "Front Subframe Assy R&R".	Refer to Sevice Manual
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