

SERVICE CAMPAIGN BULLETIN

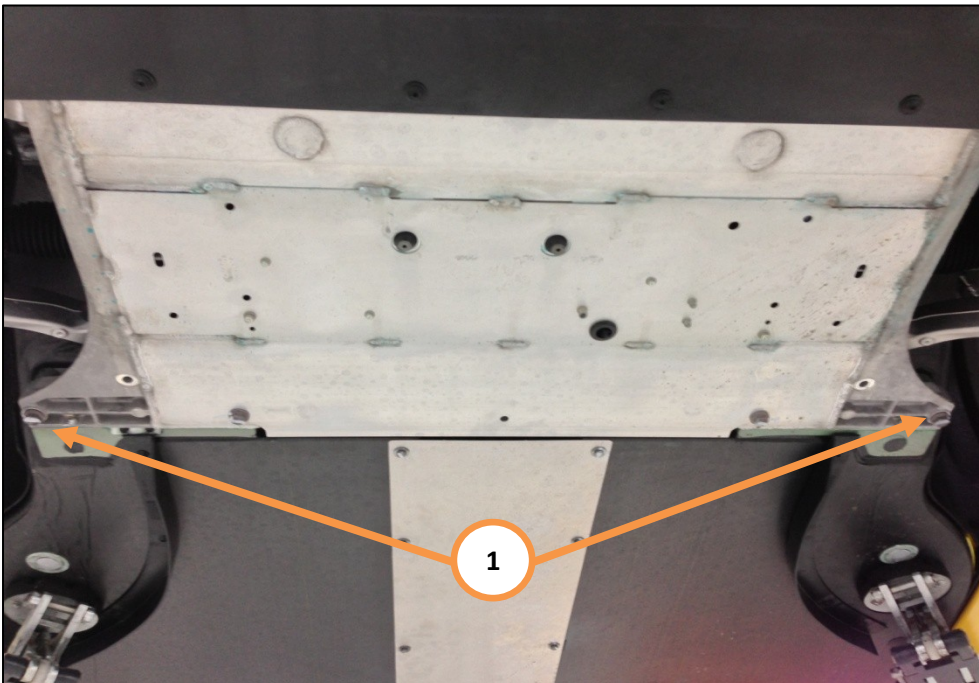
CAMPAIGN REF: 022
TITLE : Subframe Bolt Check
DOCUMENT # : 11 A 037

SITUATION : Quality Engineering at McLaren Automotive have identified that potentially a resultant creaking noise may become apparent when fitting bolts part number 00RA476 to the front subframe and applying the required torque values.

PROCEDURE : It is necessary to carry out the procedure in this document on all affected vehicles within your Aftersales car parc, both when carrying out Pre-Delivery Inspections (PDI) and at the next service centre visit.

BOLT INSPECTION PROCEDURE:

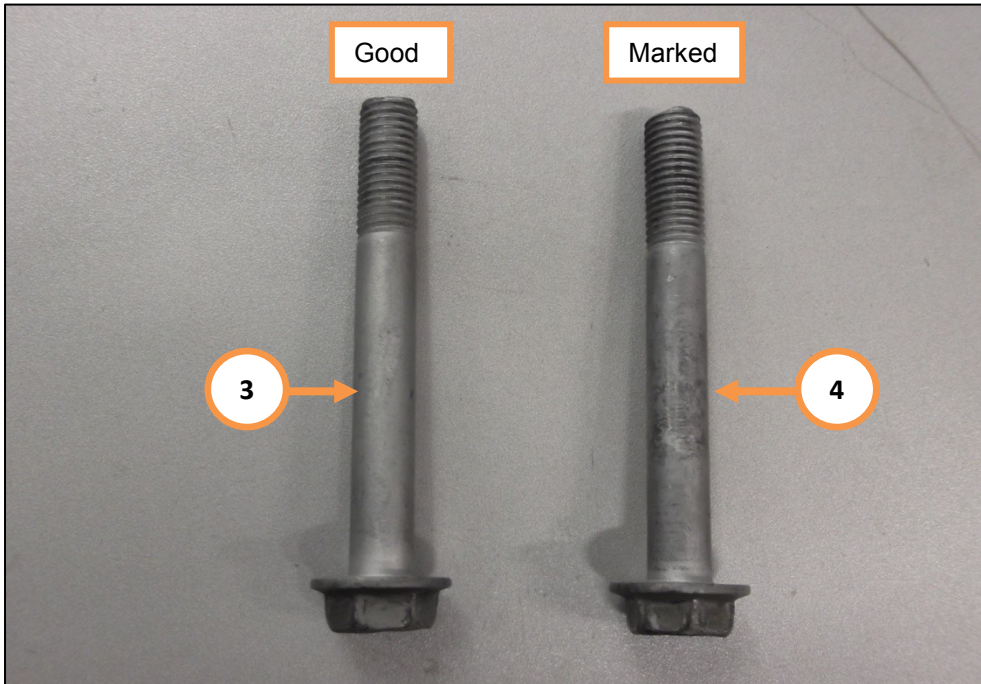
1. Please refer to AA-RM-02A04-04-007 Lift vehicle on lifting platform.
2. Locate the two rear outer bolts for the front subframe (1)



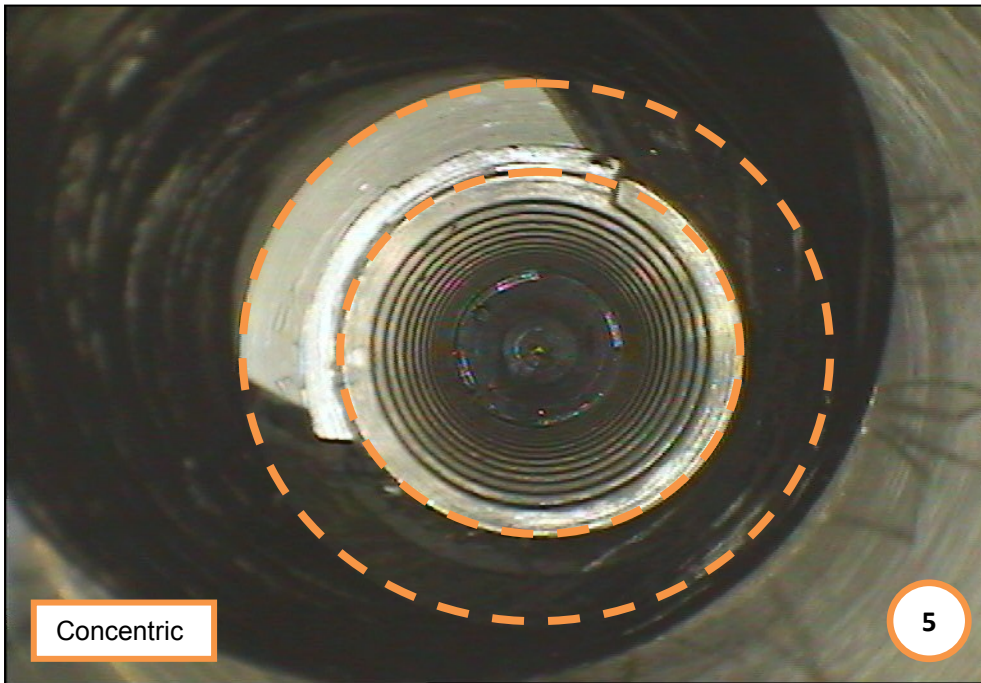
3. Torque check the bolts (1) by setting the torque wrench to 50Nm and check to see if the bolt turns. If it does not turn then repeat the process setting the torque wrench to 55Nm. Continue to repeat this process increasing the torque value by 5Nm until you have reached 70Nm. Should the bolt turn at any point before reaching 70Nm stop and proceed to step #4. If 70Nm is reached please continue with the remaining checks described in this document. The Results of these checks must be communicated to McLaren Technical Support.
4. Loosen both bolts (1) so they are protruding by 15mm and take a picture to show the positioning of bolt in the hole (2).

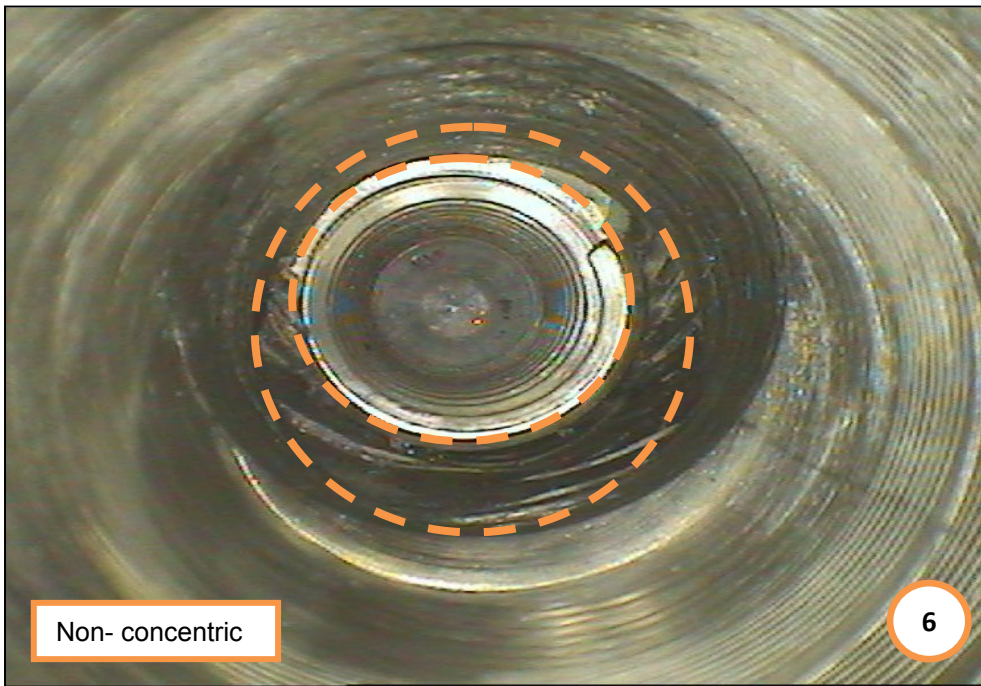


5. Remove both bolts and check for witness marks on the bolt shank. The picture below shows a good bolt shank (3) and one with rubbing marks (4). Supply a picture showing both removed bolts.



6. Using a borescope, take a picture to show the concentricity of the bolt hole. Below you can see picture of a concentric (5) and non-concentric bolt hole (6).





Care Point: Ensure that all requested pictures are labelled which side they represent.

7. Email the pictures to technical.support@mclaren.com and your regional manager quoting the vin number.

Care Point: Do **NOT** proceed with the bolt rework procedure below without McLaren's prior authority.

8. McLaren Technical Support will then advise if the bolt rework procedure can be carried out. If the pictures supplied show that the bolt hole is non-concentric, McLaren will send a Mobile Specialist to carry out a different repair procedure to the vehicle.

BOLT REWORK PROCEDURE:

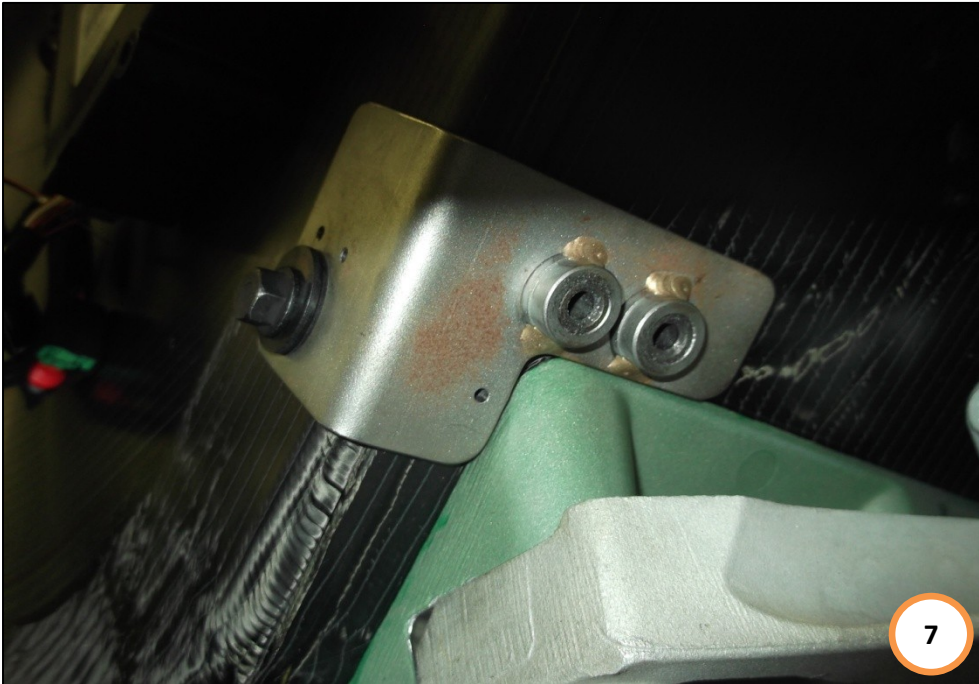
Care Point: Bolt 00RA155 must **NOT** be used in the procedure below.

1. Please refer to AA-RM-03B03-01-001 - Remove/Install wheel.
2. Please refer to AA-RM-02A02-03-002 - Remove/install wheel arch liner – Front.

Care Point: Only use the drilling jigs supplied by McLaren to complete the next two steps of this procedure..

Care Point: Ensure that the drilling jig is butt up against the green machine stock.

3. Install the drilling jigs to each side of the tub using one of the wheel arch liner screws (7).



Care Point: To complete the next step only use the drills supplied by McLaren.

Care Point: Use one 3mm and one 5mm drill bit per vehicle. They should not be reused on any other vehicle.

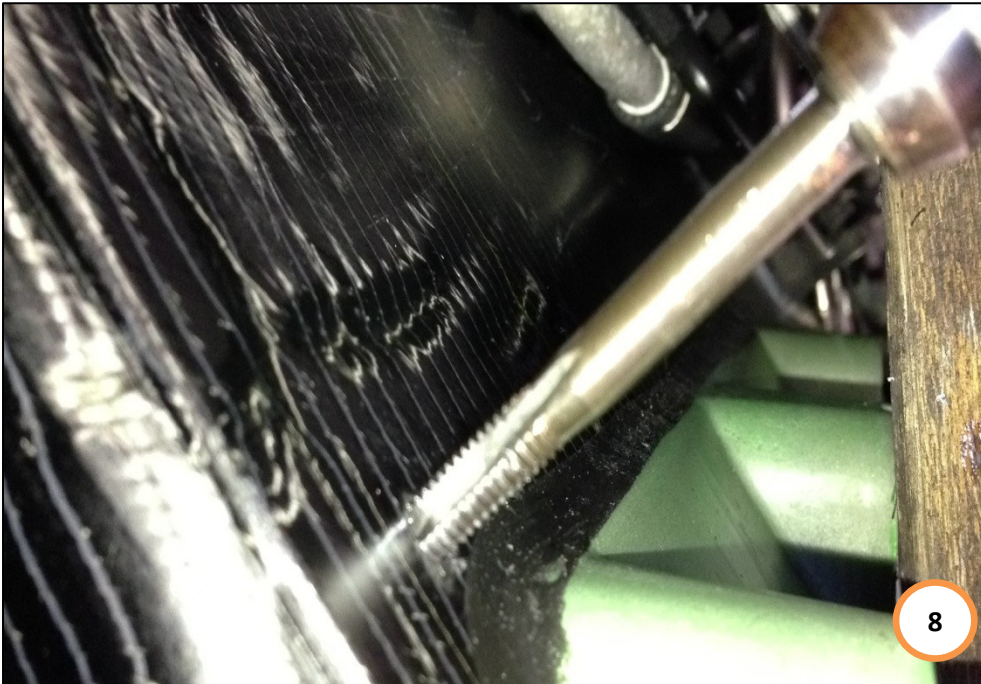
Care Point: To prevent overheating regularly clean and cool the hole and drill bit.

Care Point: Do NOT install the bolts 00RA476 or 00RA534 and washer 00RC065 until steps 4 to 7 have been completed.

4. Drill a 2mm deep guide hole using the 5mm drill bit
Drill a 25mm deep pilot hole using the 3mm drill bit
Using the 5mm drill bit, drill to the same depth. Repeat the same to the other side.
5. Remove both drilling jigs.

Care Point: Regularly clean and lubricate the tap.

6. Tap all drilled holes with an M6X1.0 to the depth of 25mm (8).



7. Apply Loctite 263 or 270 to 00RA078 screw threads. Install to the tapped holes and torque to 5Nm (9).



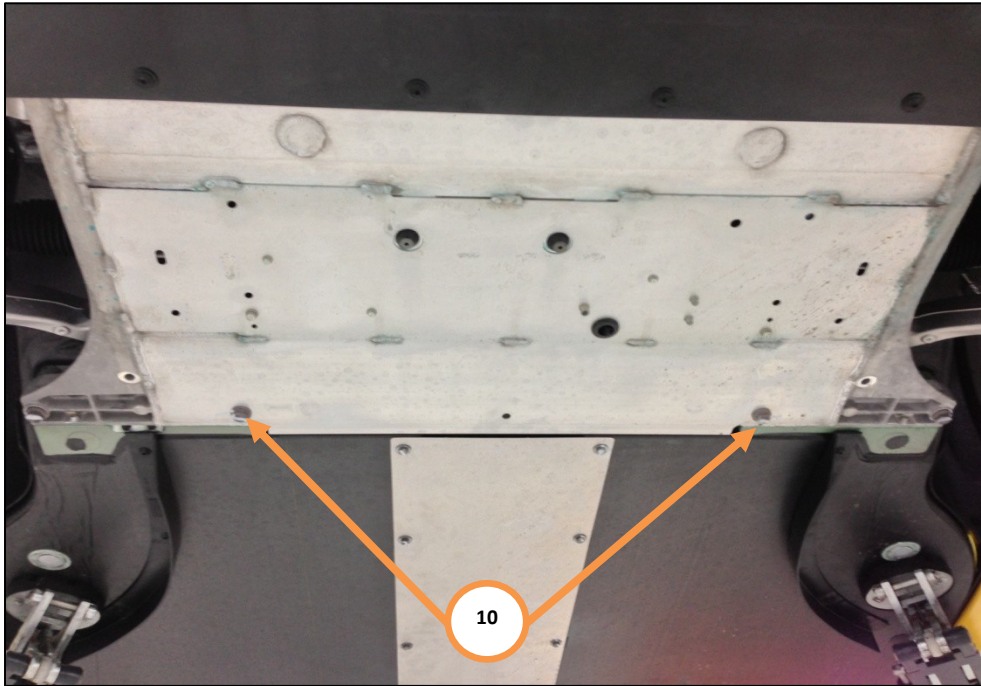
8. Apply Rocol wax Z30 or a similar product to the head of the bolts.

Care Point: Bolt 00RA534 and washer 00RC065 must be installed together.

Care Point: Washer 00RC065 must not be installed with bolt 00RA476.

9. Install bolt 00RA476 or 00RA534 and washer 00RC065 and torque to 70Nm.

10. Remove the bolts (10), install 00RA476 and torque to 70Nm.



11. Install the components in reverse order.

McLaren Automotive will cover the cost of one Rocol wax Z30 and one Loctite 263 or 270 on the first vehicle claim.

Please contact your Regional Aftersales Manager should you have any questions relating to the information contained in this bulletin.

WARRANTY INFORMATION

DESCRIPTION	RESOLUTION CODE	TOTAL REPAIR TIME
Subframe bolt check	A0A10213A11C2J01	1.6 hours

PARTS INFORMATION

Bolt-hex head-flange- M10X1.5X85-10.9-72 LP	00RA534	4	Unipart
Plain washer M10X21X2.2- MS-80	00RC065	4	Unipart
Bolt-hex head-flange- M10X85-10.9	00RA476	4	Unipart
Screw-button head- M6X20-10.9	00RA078	4	Unipart
Loctite 263 or 270	N/A	1	Locally sourced
Rocal Wax Z30	11Q0532CP	1	Unipart
