

## Vehicle: All Technical Service Bulletins

### Rear Wheel/Tire Position in Wheel Well Opening

FILE IN SECTION: 3 - Steering/Suspension

BULLETIN NO.: 53-34-03

DATE: May, 1995

#### SUBJECT:

Rear Wheel/Tire Position in Wheel Well Opening (Elongate Axle Bracket Control Arm Attaching Bolt Holes)

#### MODELS:

1994-95 Chevrolet Caprice/Impala SS

#### CONDITION

Some customers may comment that one rear wheel may appear more forward in wheel well opening than wheel on opposite side of vehicle or that vehicle appears to dog track when viewed from the rear when in operation.

#### CAUSE

Rear lower control arm frame bracket holes pierced off location during frame manufacturing.

#### CORRECTION

Elongate holes in rear axle control arm bracket per service procedure indicated below:

1. Raise vehicle and support rear axle to simulate curb height position (weight of vehicle on axle).

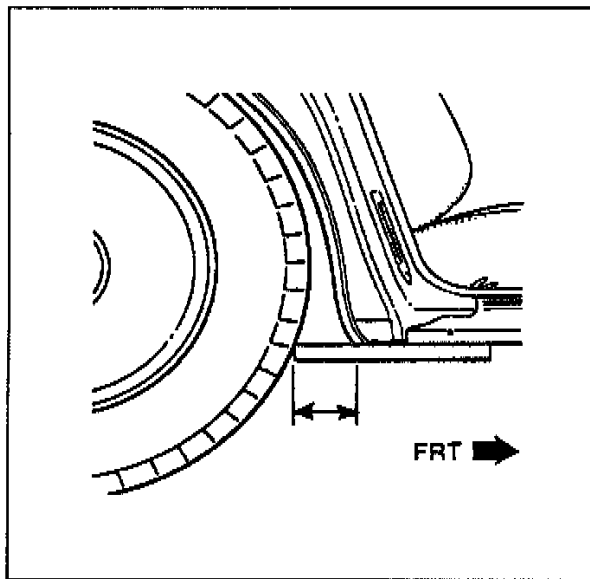


Figure 1

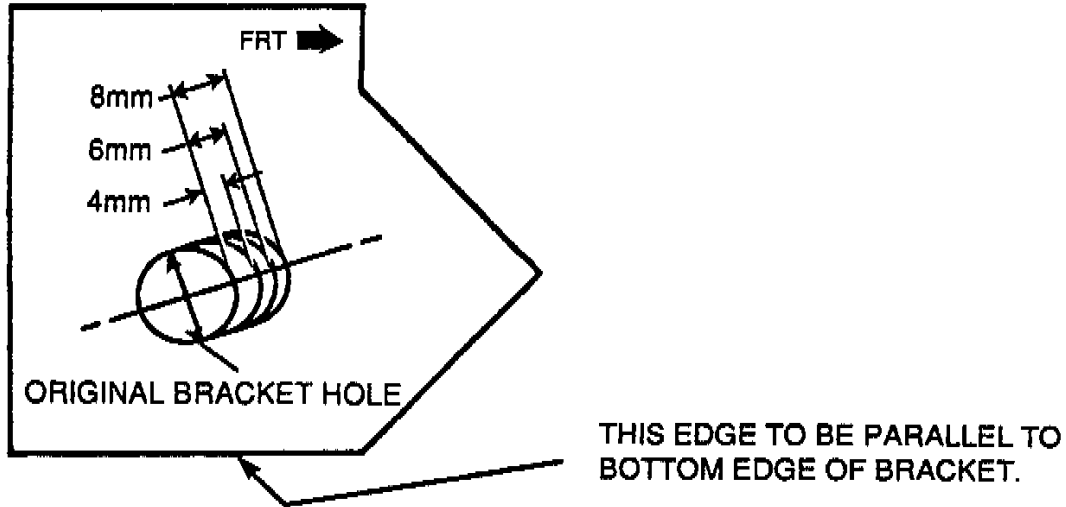
2. Using lower edge of sill plate as a guide for scale/ruler, measure distance from tire to wheel well opening on both sides of vehicle (Reference Figure 1).
3. Subtract smaller dimension from larger one and refer to chart below to determine amount holes of axle lower control arm bracket are to be elongated.

Side to Side Dimension Difference	Hole Elongation Amount
5 mm through 10 mm	4 mm
11 mm through 15 mm	6 mm
16 mm through 20 mm	8 mm

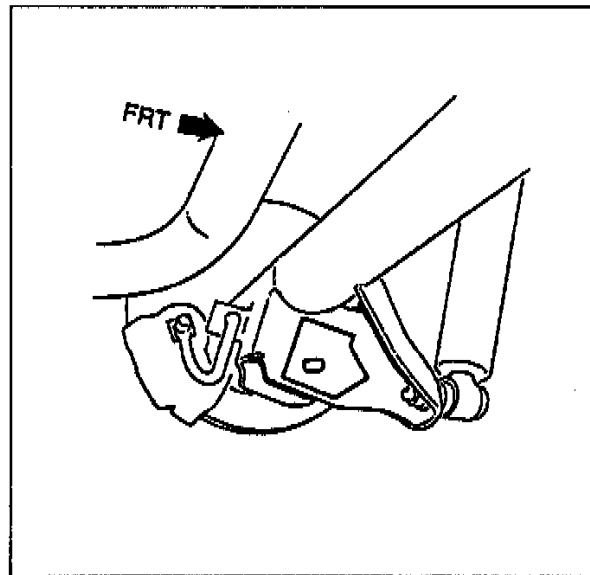
**Important:**

Holes to be elongated in a forward direction are those on the rear axle lower control arm bracket, on the side of the vehicle that had the smaller dimension measured in Step 2.

4. Disconnect and remove rear stabilizer shaft, if equipped.
5. Remove lower control arm to axle assembly attaching bolt and swing control arm downward on side of axle determined in Step 3 to require hole elongation.

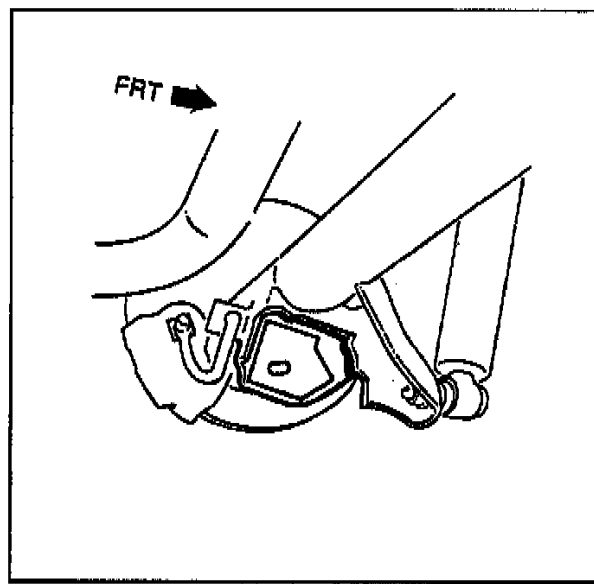


6. Cut out template along outer outline. Cut out hole in template indicated as original bracket hole. (Reference Figure 5).



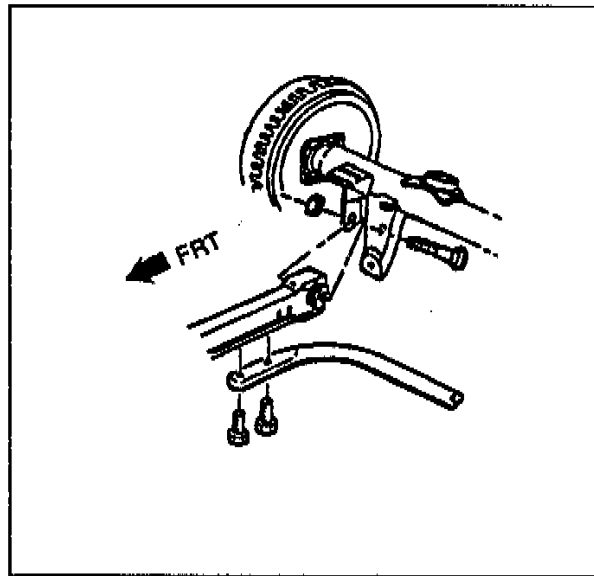
**Figure 2**

7. Position template on inboard surface of axle control arm bracket as shown in Figure 2. Align hole in template with hole in bracket and insure bottom edge of template is parallel to bottom edge of bracket.
8. Transfer from the template to the bracket the amount hole is to be elongated along axis indicated on template.



**Figure 3**

9. Position template on outboard surface of axle control arm bracket as shown in Figure 3. Align hole in template with hole in bracket and insure bottom edge of template is parallel to bottom edge of bracket.
10. Repeat step 8.
11. Using a die grinder or other suitable tool, elongate holes.



**Figure 4**

12. Swing lower control arm into position and install attaching bolt and nut as shown in Figure 4. With axle assembly positioned as far rearward as elongated holes will allow, torque attaching bolt to 190 Nm (140 lb.ft.) holding nut with a backup wrench.
13. Position and connect stabilizer shaft and torque attaching bolts to 85 Nm (63 lb.ft.).
14. Lower vehicle.

#### WARRANTY INFORMATION

For vehicles repaired under warranty, use:

Labor Operation	Labor Time
E5610	Use Published Labor Operation Time.