



# SERVICE BULLETIN INDEX

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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## 1974 SERIES (FEDERAL)

1974/01	Class III	Gearlever Stop Adjustment (Elite)	08.07.74
1974/02	Class III	Headlamps (Elite)	08.07.74
1974/03	Class III	Water Entry - 'BC' post (Elite)	08.07.74
1974/04	Class III	Body Components Repair (Elite)	08.07.74
1974/05	Class III	5-speed Gearbox (Elite)	08.07.74
1974/06	Class III	Gasket-Exhaust Manifold (Elite)	08.07.74
1974/07	Class III	Engine Belts Adjustment (Elite)	08.07.74
1974/08	Class III	Radio Suppression (Elite)	19.07.74
1974/09	Class III	Plenum Chamber Seal (Elite)	19.07.74
1974/010	Class III	Labour Schedule Ammendments (Elite)	19.07.74
1974/011	Class III	Clutch Cable Insulator (Elite)	19.07.74
1974/012	Class III	Servo Vacuum Pipe Clip (Elite)	16.09.74
1974/013	Class III	Front and Rear Suspension Insulators (Elite)	16.09.74
1974/014	Class III	Anti-Roll Bar (Elite)	16.09.74
1974/015	Class II	Protective Sleeve (Fuel Feed Pipe) (Elite)	15.11.74

## NEW NUMBERING SYSTEM. NEXT BULLETIN FROM 1974/23 ONWARDS

1974/23	Class III	Torque Loading - Front Suspension (Elite)	03.10.74
1974/24	Class III	Steady Bracket (Clutch Cable) (Elite)	15.10.74
1974/25	Class III	Eliminate Heterodyning (Rad. Cooling Fans) (Elite)	15.10.74
1974/26	Class II	Glove Box Door Finisher(Elite)	15.10.74
1974/27	Class III	Change Clutch Cable and Release Mechanism to R.H. Side (Elite L.H. Drive)	15.10.74
1974/28	Class III	A.B.S. (Plastic) Ext. Rear Quarter Light Finishers (Elite)	15.10.74
1974/29	Class III	Labour Schedule Ammendments (+2 and Elite)	15.10.74
1974/30	Class III	Speedo Drive Spindle Endfloat (Elite)	15.10.74



# SERVICE BULLETIN INDEX

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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1974/31	Class II	Additional Carpet Fasteners, Front Foot Mats (Elite)	15.11.74
1974/32	Class II	Addition of Snapper Clips Vac. Take Off (Manifold)	15.11.74
1974/33	Class III	Modification to Wiper Motor (Elite)	15.11.74
1974/34	Class II	Improved Filler Neck Hoses (Elite)	15.11.74
1974/35	Class III	One Piece Clutch Cable Insulator Bush (Elite)	15.11.74



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/01
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

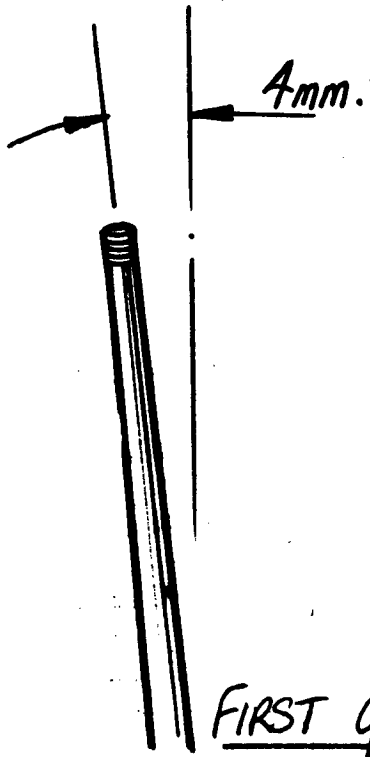
Circulation List	Service Manager		Foreman				
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**Title:** Gear Lever Stop Adjustment.

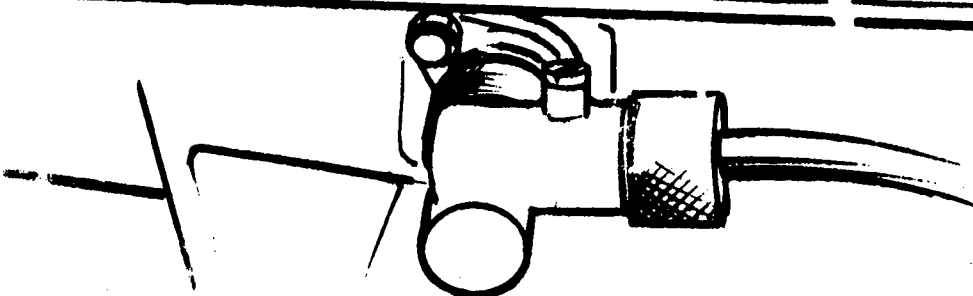
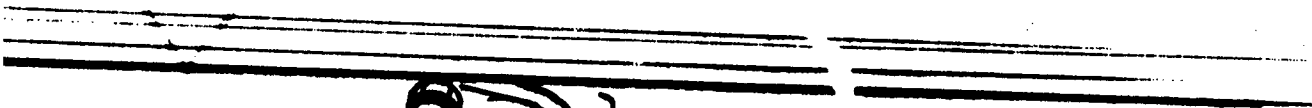
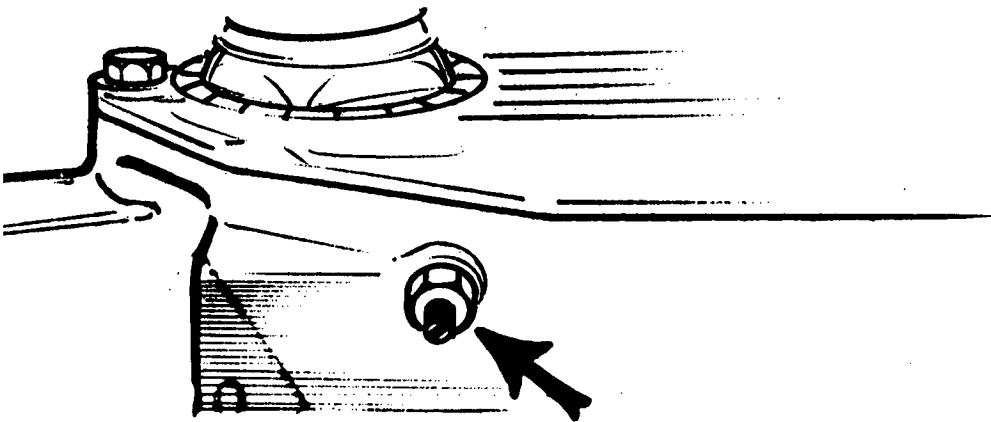
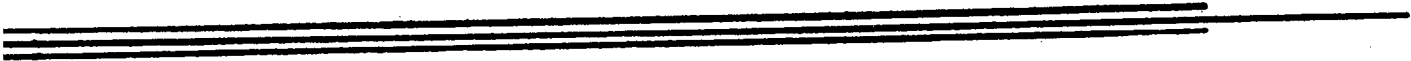
**Reason:** To avoid possibility of dis-engagement between the gear selector link and the selector rod assembly, when fitting a new gear lever.

**Action:**

1. Select 1st gear, noting there is free play at EACH SIDE of gear lever. With the lever at its mid-position (side-to-side), but still in gear, screw in the stop adjusting screw (marked with arrow on illustration), until the gear lever is JUST BEGINNING TO MOVE. The side-to-side movement at the top of the lever MUST NOT EXCEED 4 mm (adjust as necessary), then tighten the locknut. Select all gears to ensure correct operation of gear selector mechanism.
2. Please amend paragraph '7' on page of Section 'F' (Gearbox) of the recently issued Preliminary Workshop Manual, to include this TOTAL MOVEMENT of 4 mm.



FIRST GEAR ENGAGED.





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/02
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Headlamps

Reason: To advise Dealer personnel of possible damage to pods

- Action:
1. Dealer personnel are WARNED that the bonnet MUST NOT be opened or closed, UNLESS the headlamp pods are in the FULLY DOWN or FULLY UP positions.
  2. If the pods are in the partly up (or partly down) position when the bonnet is opened or closed, both components will be damaged.
  3. If, before opening or closing the bonnet, the headlamp pods are in the partly up (or partly down) positions, OPERATE THE LAMPS VACUUM SWITCH to raise the pods.

NOTE: This information MUST BE BROUGHT TO THE ATTENTION of owners and drivers.



# LOTUS SERVICE BULLETIN

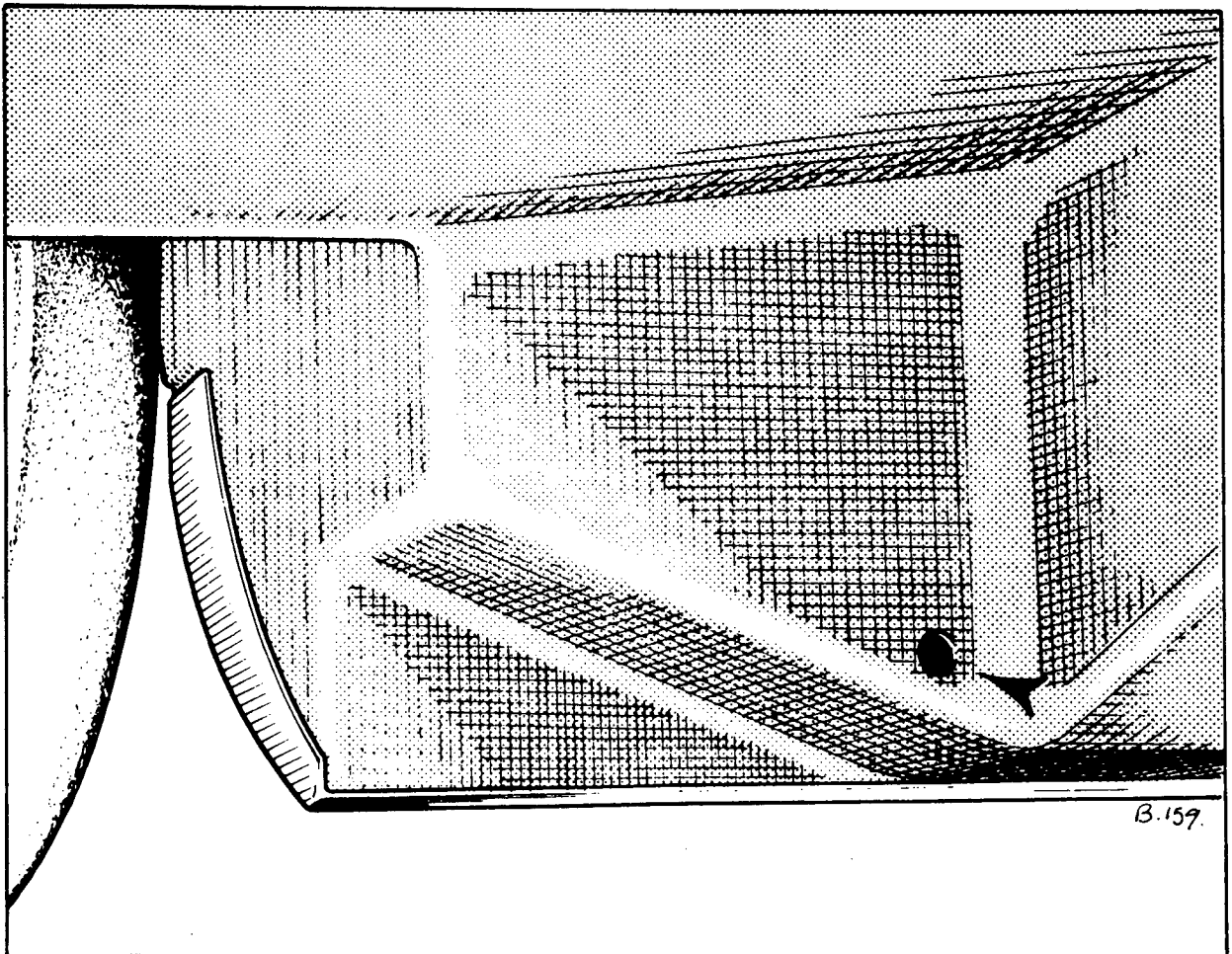
Class	III
Number	1974/03
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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- Title:** Water entry into 'BC' post through air extraction vents.
- Reason:** To prevent the possibility of water collecting in the floor pan beneath the rear seats.
- Action:** With the car on a ramp, and standing beneath the rear axle looking towards outside of car at the forward end of rear wheelarch, and using the illustration as a guide, drill an 8 mm. diameter hole (as indicated by arrow) in the floor pan.
- Note that the L/H side is illustrated, but the R/H side is symmetrically opposite.



B.159



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/04
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Body Components Repair

**Reason:** To advise Dealer personnel of recommended procedures and materials when repairing the under-mentioned body components.

**Action;** a. Spoiler  
When a spoiler has split, it can be repaired using a proprietary 'cold setting epoxy glue'.

b. Tailgate Trim Clips  
When replacing these clips, use only 'Avelbond' cyanoacrylate adhesive (Part No. A075 U 6045Z) for their retention.

c. Tailgate Trim Surround  
When replacing the surround, apply thin even film of polyurethane '2-part' adhesive (Part No. A075 B 6017V) to both mating faces. Mix the adhesive (parts 'A' and 'B') in the ratio of 1:1, but only in sufficient quantity as required.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/05
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** 5-speed Gearbox

**Reason:** Assembly procedure amended

**Action:** Amend the Workshop Manual, Section 'F' (Gearbox), Front Cover - ascertaining the correct bearings 'nip'.  
On page 11 of 'Gearbox', under the heading 'To Replace' delete lines 'c' and 'd' and add in their place:

- c. Measure the uncompressed new gasket thickness=C
- d. Shim thickness required is B+C-A. The compression of the gasket on assembly will thus ensure the required bearing 'nip' of .05 mm (.002 in)





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/06
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Gasket - Exhaust Manifold to Downpipe.

**Reason:** To advise Dealer personnel of recommended assembly procedure.

**Action:** The specified gasket fitted at the joint of manifold to downpipe, is steel-faced on both sides. The Part Number of this gasket is B907 E 0638Z.  
Where the downpipe has been removed, or released, for any reason, (i.e. to rectify 'blowing' at the joint), then the steel-faced gasket must be used on re-assembly.  
If this gasket is not available for any reason, do NOT use ANY OTHER GASKET - USE Holts 'Firegum' in place of the recommended gasket.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/07
Type	Elite
Date	08.07.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Engine Belts Adjustment.

**Reason:** To remind Dealer personnel of correct procedure as given in the Workshop Manual.

**Actions:** The adjustment, and checking of tension of all belts is as given in the Lotus Elite Preliminary Workshop Manual (Part No. AO75 T 0348Z)

a. Timing Belt:

The belt tension can ONLY be checked satisfactorily with the aid of a Borroughs Gauge (Type BT-33-86A), as shown in Section 'E', Engine of the Workshop Manual.

b. Alternator Belt (with, or without air conditioning):

Both belts are correctly tensioned when a total of 12mm. (.5 in) movement can be obtained on the longest run of the belts (see Section 'M' Electrics).

c. Compressor Drive Belt (air conditioning):

The belt is correctly tensioned when a total of 9 mm. (.35 in) movement can be obtained on its longest run.

d. Power Steering Pump (when fitted):

The belt is correctly tensioned when a total of 12 mm. (.5 in) movement can be obtained on the longest run.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/08
Type	Elite
Date	19.07.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Radio Suppression

Reason: Addendum to Section 'M' (Electrics) of the Lotus Elite Preliminary Workshop Manual

Action: Given below is a checking list of where all radio suppressors are fitted. Please add this information to the Workshop Manual

COIL: a. Bond (in loom) - from coil mounting bolt to starter solenoid.

b. Filter - 2uf. capacitor mounted on bolt with cable to POSITIVE terminal

CLOCK: 1uf. capacitor between POSITIVE and NEGATIVE.

FUEL PUMP: 1uf. capacitor mounted on casing screw with cable to pump POSITIVE terminal.

FRONT WIPER MOTOR: 1uf. capacitor to Green feed cable, with 'Scotchlock' connector, and ring terminal to casing bolt.

REAR WIPER MOTOR: 1uf. capacitor to Blue/Light Green  
1uf. capacitor to Red/Light Green  
1uf. capacitor to Brown/Light Green  
using 'Scotchlock' connectors, attach ring terminals to casing bolt.

VOLTAGE STABILISER: 1uf. capacitor from input POSITIVE (B-12v) to NEGATIVE (speedometer mounting stud) terminals.

ALTERNATOR: a. 60 amp. (Chrysler) - 2uf. capacitor attached to mounting bolt, ring terminal to main output.

b. 45 amp. (Lucas) - 3uf. capacitor fitted by manufacturer.

BONNET: The underside of the bonnet is fitted with foil, and bonded to 'earth' to reduce H.T. interference.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/09
Type	Elite
Date	19.07.74

LOTUS CARS (SERVICE) Ltd NORWICH NORFOLK NR92W Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Plenum Chamber Seal

**Reason:** To advise Dealer personnel of a revised method of sealing the plenum chamber.

**Parts Required:** A075 U 6056V Seal 1 off

**Action:** Both types of seal are attached to the rim of the plenum chamber.

1. With the 'original type' seal, a further seal is attached to the underside of the bonnet, the two seals being in abutment with each other when the bonnet is closed.
2. When the 'later type' seal is fitted, which stands higher on the rim of the plenum chamber, the seal on the underside of the bonnet is NOT FITTED.
3. Where existing cars are fitted with the 'later type' seal (Part No. A075 U 6056V), it is IMPORTANT that the bonnet underside seal is REMOVED, otherwise when the bonnet is closed, gel-cracks could occur in the vicinity of the seal.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/010
Type	Elite
Date	19.07.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Labour Schedule

Reason: To give ammendments where shown

Action: 1. Amend the following pages:

Page 8

Operation No. E913, amend time to 11.5  
Operation No. E914, amend time to 13.0  
Operation No. E932, amend time to 6.5

Page 9

Operation No. F901, amend time to 6.5

Page 16

Operation No. Q902, amend time to 7.5  
Operation No. Q903, amend time to 7.5  
Operation No. Q904, amend time to 7.2



# LOTUS SERVICE BULLETIN

Class	
Number	111
Type	1974/011
Date	Elite

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH 19 07 74  
TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Clutch Cable Insulator Bush Assembly

Reason: To reduce general engine and transmission noise which may be transmitted into the car, via the clutch cable.

Parts Required:

A075 Q 0055Z	Adaptor, Clutch Cable Abutment	1 off
A075 Q 0056Z	Insulator, adaptor	1 off
A075 Q 6014Z	'O' Ring	1 off

Action:

#### To Install

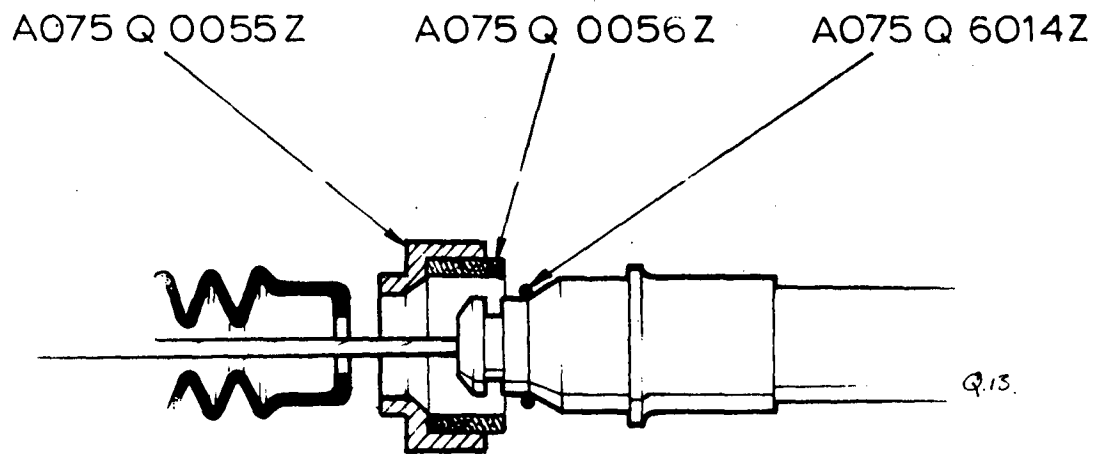
1. Remove the clutch cable from its abutment on the bell housing (see Section 'Q' in the Workshop Manual).
2. Fit the insulator (Part No. A075 Q 0056Z) to the adaptor (A075 Q 0055Z).
3. Fit the 'O' ring (Part No. A075 Q 6014Z) to the clutch cable sleeve, adjacent to its tapered shoulder, and fit insulator assembly to the outer sleeve of the cable (see illustration).
4. Using a pair of Mole grips (or similar), compress the insulator assembly on to the sleeve of the cable, and fit the rubber boot to the cable. Ensure that the boot is securely located in the retaining groove of the cable sleeve. Remove the Mole grips.
5. Fit the clutch cable assembly to the bell housing, by feeding the rubber boot through the abutment hole. Assemble the cable to the clutch release lever, and adjust the cable for ZERO free play. Tighten locknut after adjustment.
6. A final check should be made on the clearance between the outer cable abutment and the adjacent engine bearing housing boss. A MINIMUM clearance of 1.58 mm (.06 in.) MUST BE ACHIEVED; if necessary, lightly file the bearing housing boss to ensure this clearance.

Labour Time for fitting the above: 0.5 hours

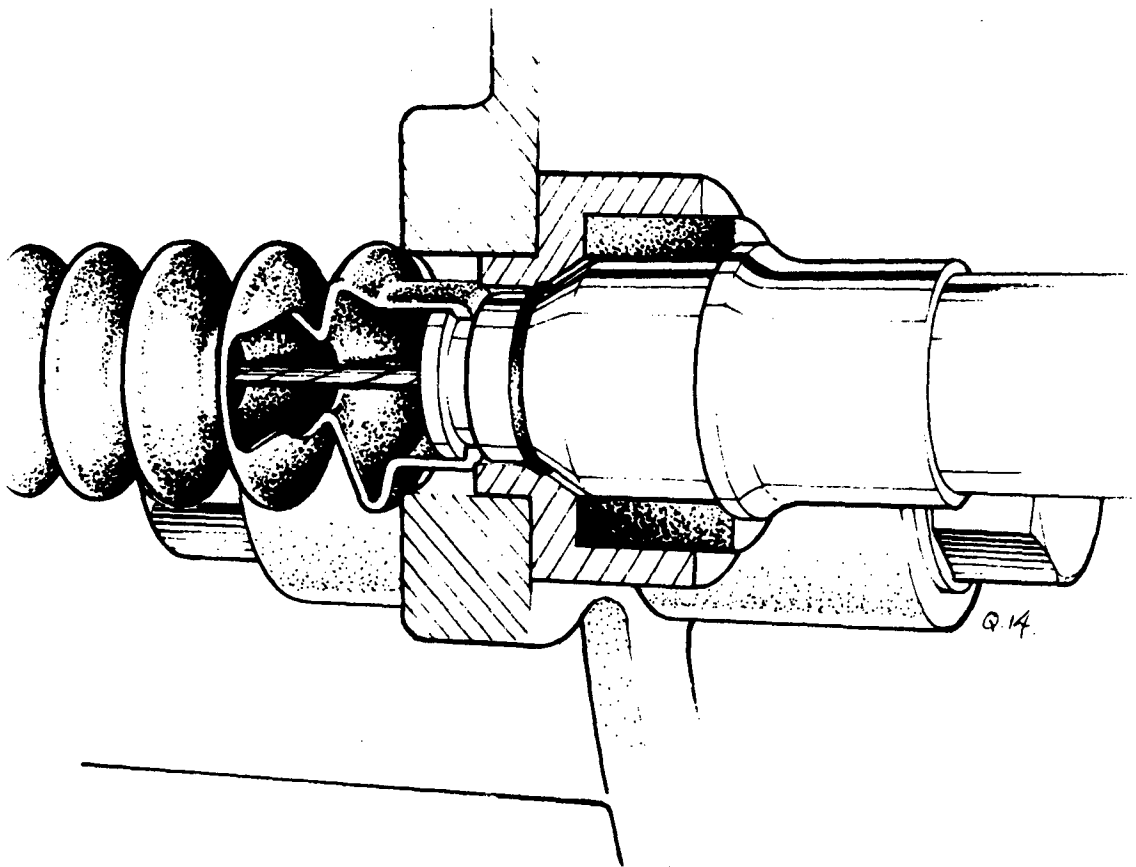
#### To Check and Adjust

1. On cars fitted with the clutch cable insulator bush, release the locknut and adjusting nut on the cable, to eliminate any possible pre-load on the clutch assembly.
2. Adjust the cable for ZERO free play. DO NOT OVER-ADJUST. Tighten the locknut after adjustment.

NOTE: On cars fitted WITHOUT the clutch cable insulator bush, proceed as detailed in Section 'Q' of the Workshop Manual.



ASSEMBLY PROCEDURE



CUTAWAY SECTION SHOWING CLUTCH CABLE  
INSULATOR BUSH ASSEMBLY



# LOTUS SERVICE BULLETIN

Class	111
Number	1974/012
Type	Elite
Date	16.09.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Servo Vacuum Pipe

Reason: To secure pipe to non-return valve

Parts Required: X054 J 6028Z Clip 1 off

Action: In cases where the servo vacuum hose has a tendency to become parted from the non-return valve, it is recommended that a clip (Part No. X054 J 6028Z), be fitted to secure the hose to the valve.





# LOTUS SERVICE BULLETIN

Class	111
Number	1974/013
Type	Elite (FED.)
Date	16.09.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Front and Rear Suspension Insulators and Spacers

Reason: To ensure correct bumper heights.

Parts Required: A075 C 0146F Insulator, front 2 off  
A075 D 0266Z Spacer, rear 2 off

Action: To maintain the correct kerbside\* bumper heights of:

Front -  $20.05 + .25$  in. from top edge of bumper plinth to ground,  
on centre-line,

Rear -  $19.15 + .25$  in. from top edge of bumper plinth at transverse  
centre-line,

the following action is recommended.

\* Kerbside is unladen, with all fluids, but no driver or passengers.

## Front:

1. Remove the existing spring insulator (rubber abutment, or spring seat), and fit new insulator (Part No. A075 C 0146F). Full instructions for removing and replacing the insulators are contained in the Lotus Elite Preliminary Workshop Manual.
2. If insulator (Part No. A075 C 0146F) is unobtainable, it is permissible to use the existing insulators (Part No. A075 C 0129Z), in pairs, in the following manner:
  - a. Cut the spigot from the underside of one of the insulators.
  - b. Apply a film of Dunlop Adhesive '758' to the cut underside of an insulator, and to the top surface of a further insulator. Allow 10 minutes to elapse before joining the two insulators together.
  - c. Do NOT modify insulators removed from the car - use NEW PARTS.

## Rear:

1. When springs (Part No. A075 D 0262Z) are fitted, it will be necessary to use spacers (Part No. A075 D 0266Z), beneath the springs.
2. When springs (Part No. D075 D 0261Z) are fitted, spacers are NOT REQUIRED, as these springs are longer.

3. To fit the spacers, proceed as follows:
  - a. Raise the rear of the car and support with stands. Remove the jack.
  - b. Remove the road wheels. From beneath the rear suspension, jack up that side of the suspension until spring is compressed. Fit spring clamps and lower jack, so that suspension is on full droop, but spring is free.
  - c. Slip the two halves of split spacer BENEATH the spring and into spring pan on damper. Raise jack, and remove spring clamps. Lower jack ensuring spring and spacer are seating correctly.
  - d. Repeat operations 'a, b and c' at other side of car. Fit wheels, raise car with jack, remove stands and lower car to ground.
  
4. Springs can be identified as follows:

	<u>A075 D 0262Z</u>	<u>D075 D 0261Z</u>
Colour code	Green/White	Red
Free length	407.5 mm.	398 mm.
Fitted length	264 $\pm$ 3 mm.	264 $\pm$ 3 mm.



# LOTUS SERVICE BULLETIN

Class	111
Number	1974/014
Type	Elite
Date	16.09.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Anti-Roll Bar.

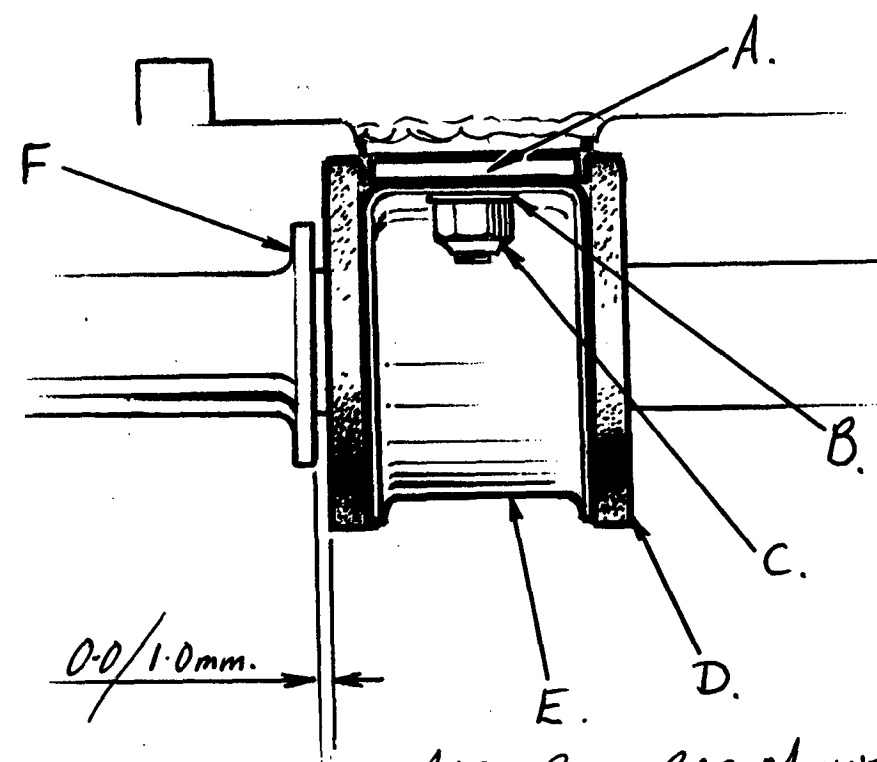
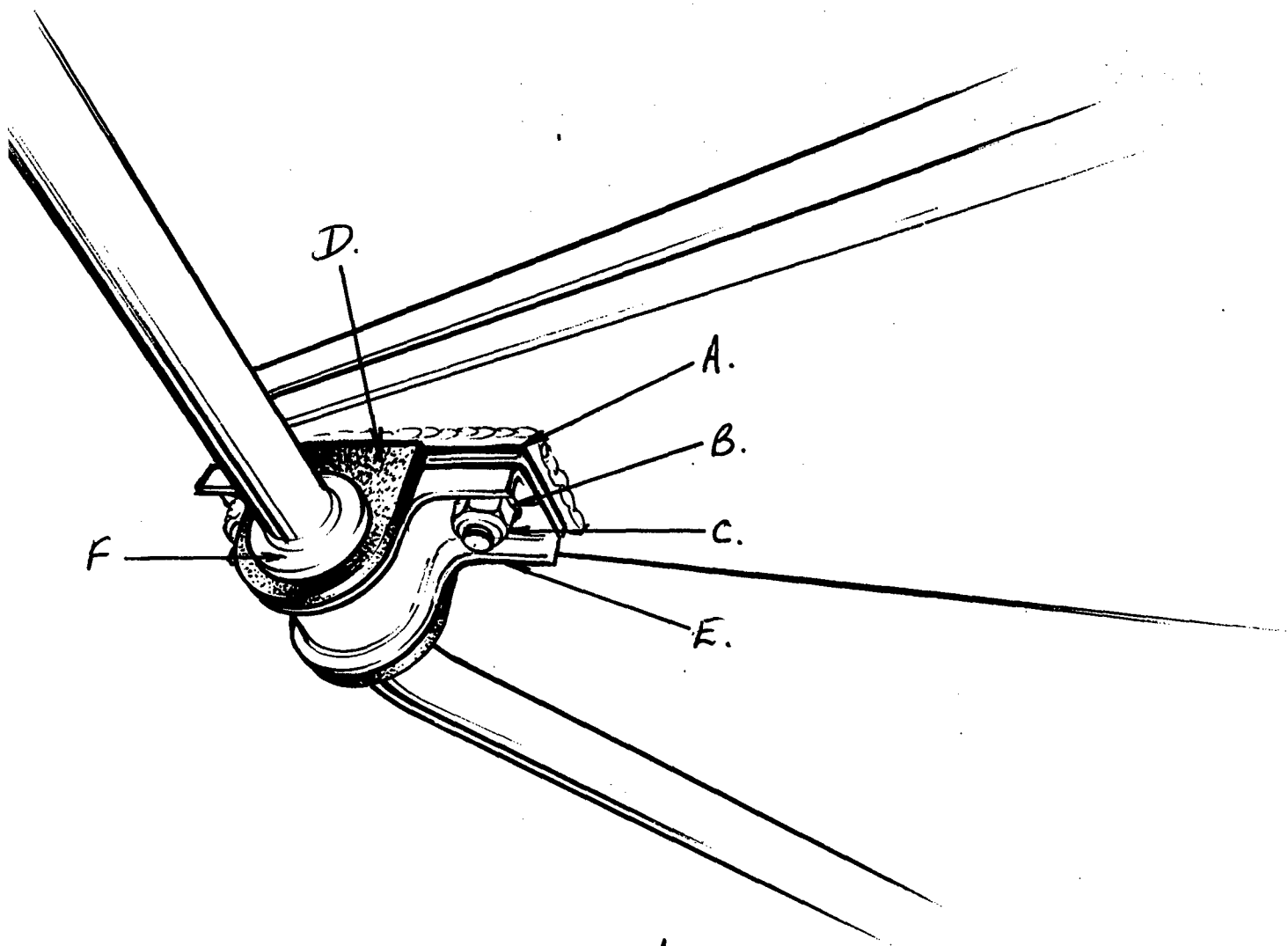
Reason: Improvement to fixing specification.

Parts Required:	A075 C 0147K	Plate	2 off)
	A075 C 0148K	'U' bracket	2 off) per car
	A075 W 4024Z	Washer, plain	4 off)

Action: Where the anti-roll bar mounting (securing the anti-roll bar to the chassis) rubber bushes, are attempting to 'work out' from their fitted location, the following action is recommended:

1. Remove the existing 'U' brackets and fit the new 'U' brackets (Part No. A075 C 0148K), but with the additional plate (Part No. A075 C 0147K) BETWEEN the bush/bracket and the chassis.
2. Before fitting the securing bolts, ENSURE the washers (Part No. A075 W 4024Z) are fitted beneath head of bolts and the 'U' brackets.
3. Brackets should be bolted in position so that the dimension between abutment on the anti-roll bar and the rubber bushes is, Zero (just touching) to 1 mm. clear MAXIMUM, with the wheels in the straight-ahead position.

NOTE: This improvement MUST be fitted in PAIRS ONLY (2 plates, 2 brackets and 4 washers per car).



- KEY
- A - PLATE.
  - B - WASHER, PLAIN.
  - C - NUT.
  - D - RUBBER BUSH.
  - E - 'U' BRACKET.
  - F - ABUTMENT, ANTI-ROLL BAR.

ANTI-ROLL BAR MOUNTING (RH ILLUSTRATED)



# LOTUS SERVICE BULLETIN

Class	II
Number	1974/015
Type	Elite (Fed.)
Date	15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Fuel Feed Pipe.

Reason: To add protective sleeve to pipe to prevent inadvertant electrical 'shorting out' on starter solenoid, due to mis-handling during servicing.

Parts Required:	A907 E 6245K	Sleeve (480 mm long)	1 off
	A026 S 0133Z	Clip	1 off

Action:

1. Disconnect the battery.  
The car should be placed over an inspection pit, or raised on a hoist (ramp), to gain access to the underside of the car.
2. Disconnect the braided fuel feed pipe from the main fuel pipe on RH side of chassis. Plug the end of the pipe from the fuel tank, to avoid wastage of fuel.
3. Push the sleeve (A907 E 6245K) on to the braided pipe and secure the sleeve with clip (A026 S 0133Z) at the union end.
4. Connect the braided pipe to the pipe from the tank.
5. Connect the battery and check that there are no leaks on any pipe connections.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/23
Type	Elite
Date	3.10.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Front Suspension .

Reason: Ammendment to Torque Loadings .

Action: Under the heading of 'Torque Loadings, Front Suspension', on page 21 of the Lotus Elite Workshop Manual, amend the existing instruction, to read as follows:

Upper wishbone to chassis*	5.53-6.22	40-45
Lower link to chassis*	5.53-6.22	40-45



# LOTUS SERVICE BULLETIN

Class III  
Number 1974/24  
Type Elite  
Date 15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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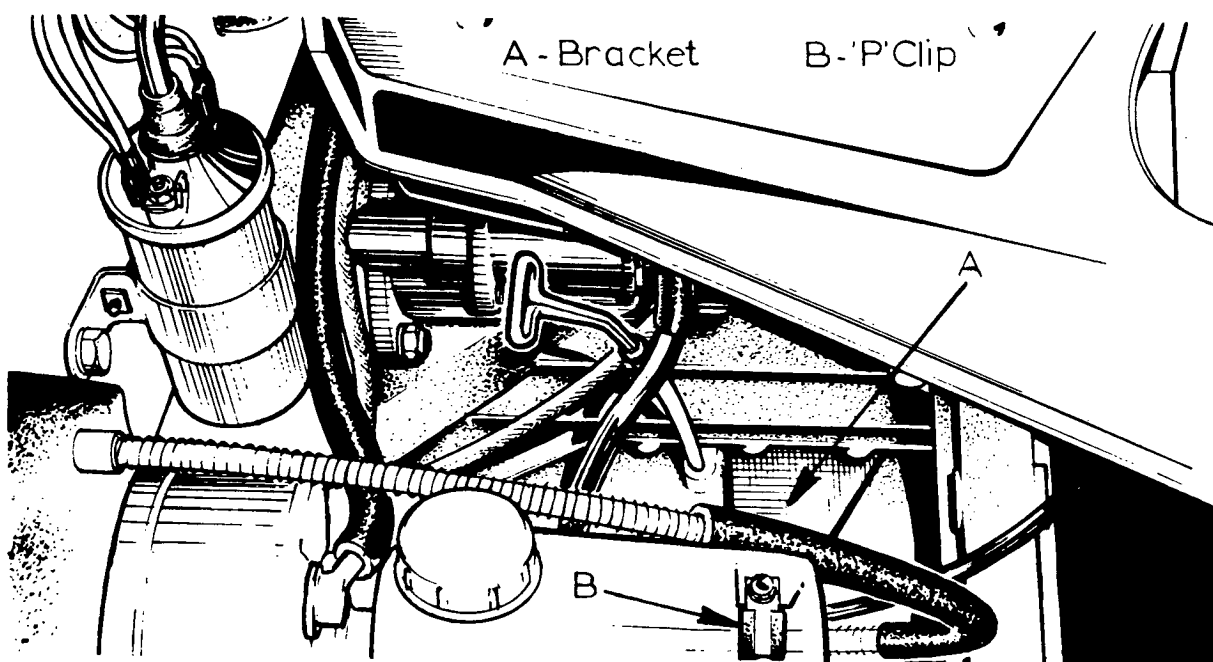
Title: Clutch Cable (R.H.D. only)

Reason: Correct location of cable.

Parts Required:	A075 Q 0054F	Steady bracket	1 off
	A075 Q 6013Z	'P' clip	1 off
	A075 W 1000Z	Screw, No.10	1 off
	A075 W 3000Z	Nut, nyloc, No.10	1 off

Action: If any difficulties are experienced in correctly locating the clutch cable, the following action is recommended:

1. Using the illustration as a guide, attach the steady bracket to the engine.  
The bracket is mounted on the first pair of sump studs rearward from the front of the engine, with its square edge rearward on the right hand side.
2. Secure the cable with the 'P' clip, and attach clip to bracket with the screw and nut.





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/25
Type	Elite
Date	15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Radiator Cooling Fans

Reason: To eliminate 'Heterodyning' of the Cooling Fans.  
Vibrations caused by synchronised fans.

Parts Required: A075 M 1297F Loom 1 off

Action: On cars suffering from heterodyning cooling fans, the fitting of the above loom, which is resistive, to one of the fan motors only, will reduce the fan speed by approximately 200 r.p.m.

1. Disconnect the battery.
2. Disconnect the FEED cable from one fan motor. Attach one end of the new loom to the end of FEED cable, and the other end to the FEED terminal on the fan motor.
3. Re-connect the battery.





# LOTUS SERVICE BULLETIN

Class II  
Number 1974/26  
Type Elite  
Date 15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Glove Box Door Finisher

Reason: Assembly instructions for fitting finisher

Parts Required: A075 U 0665Z Finisher 1 off  
A050 B 6181V Adhesive Strip - (200mm) 1 off

Charges: U.K. only - warranty - 0.4 hrs. per car, plus the parts.  
Normal warranty claims, which bear the full chassis No.  
of the car concerned, should be submitted, but marked:  
'Elite, 1974/26 Class II'.

- Action:
1. Using the illustration Fig. 1 as a guide, file the lower corners of the door to the shape indicated.
  2. If the finisher is fitted with tags, these should be carefully removed. Place a single strip of adhesive into the finisher section, pinching it slightly as shown on illustration, Fig. 2, to avoid excess adhesive being extruded as the finisher is fitted.
  3. Place the finisher in position centrally over the door, then press into position, using finger pressure only, all in one operation, as once fitted, difficulties will be experienced in moving the finisher without it being damaged.

Please complete attached slip, and return, marked for the attention of: Service Manager.

This 'action record' could be returned at the same time as the warranty claim form.

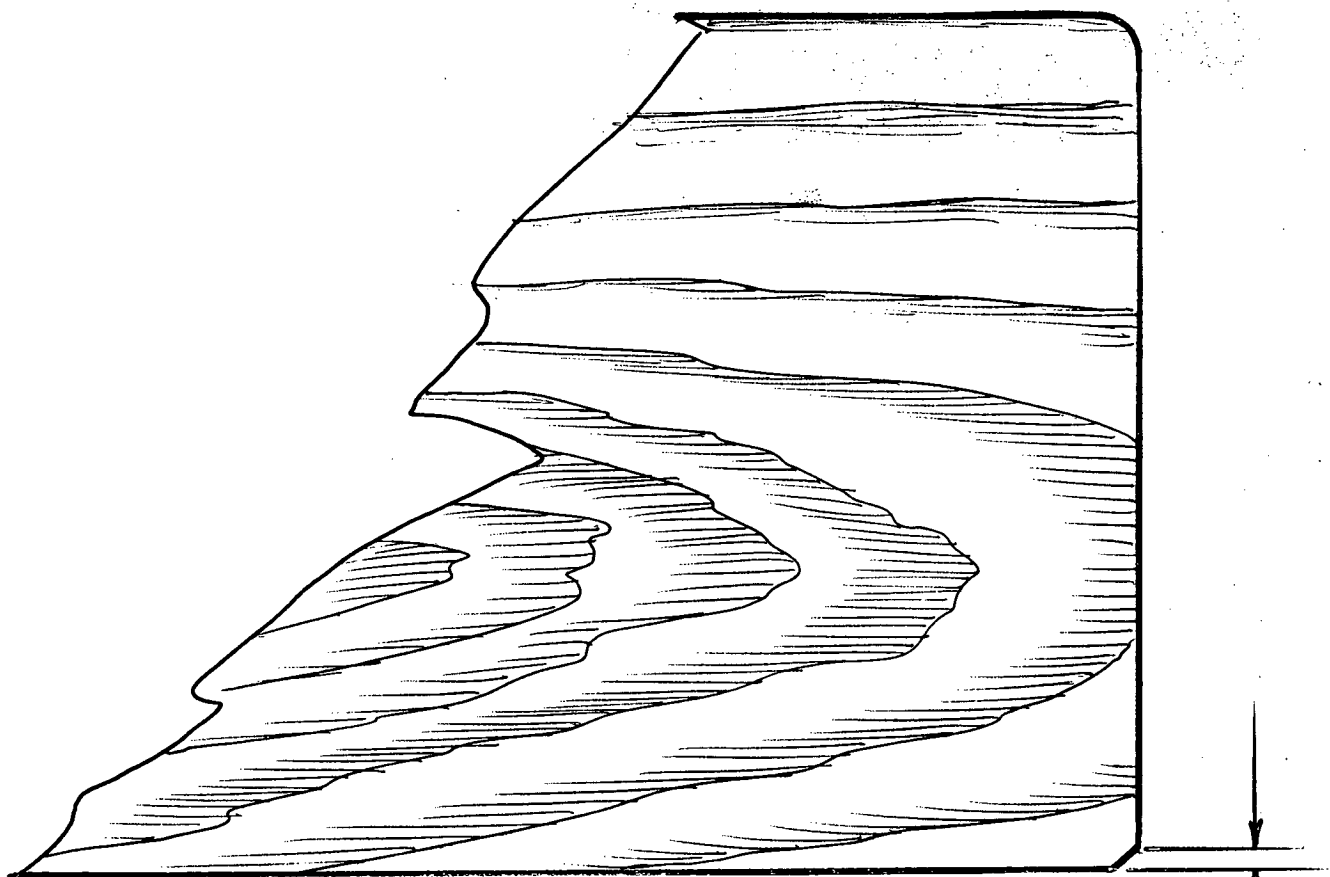


Fig. 1.

REMOVE LOWER CORNERS  $3.5\text{mm} \times 45^\circ$

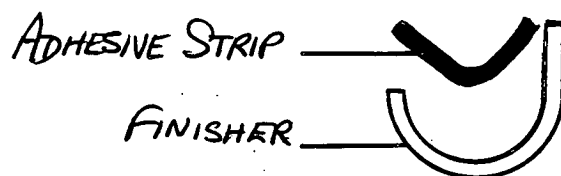


Fig. 2.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/27
Type	Elite L.H. Drive
Date	15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Change of clutch cable and clutch release mechanism to operate from right hand side of clutch housing.

**Reason:** To eliminate the possibility of clutch cable seizure on left hand drive cars.

<b>Parts Required:</b>	B075 Q 0051W	Clutch Cable LHD	1 off
	A075 Q 6013Z	Clip-cable to sump	1 off
	A075 W 6038Z	Fastex Cable strap	1 off
	A075 Q 6010Z	Pivot-Clutch release lever	1 off

**Action:** Remove the engine/gearbox assembly (Section E26).  
Remove the existing clutch cable (Section Q3) and discard the cable.  
Part the gearbox from the engine at the bell housing.  
Remove the clutch release lever and the release bearing.  
Remove the dust cover from the RH side of the bell housing and fit the dust cover to the LH side. Leave the existing pivot for the clutch release lever in the bell housing.  
Apply loctite RC 35 to the lower part of the additional pivot Part Number A075 Q 6010Z and fit it to the LH side in the bell housing. Fit the clutch release bearing and the clutch release lever with its grommet so that the clutch release lever is protruding from the RH side of the bell housing. See Fig.1.  
Fit the gearbox to the engine. Replace engine and gearbox assembly. Fit the new (longer) clutch cable Part Number B075 Q 0051W, and route the cable to the RH side of the bell housing. The Two rubber sleeves on the clutch cable are positioned to provide insulation against the body and the steering unit. Secure the cable with cable strap Part Number A075 W 6038Z to the metal part of the heater/pipe to prevent cable movement and possible fouling of the crankshaft 'V' pulley.

Remove the rubber insulator from 'P' clip part number A075 Q 6013Z, slide the clip over the rubber insulating sleeve at the lower part of the clutch cable and secure the clip to the RH front of the sump. See Fig.2 . Fit the clutch cable insulator Bush Assembly as detailed in Service Bulletin Number 1974/17.

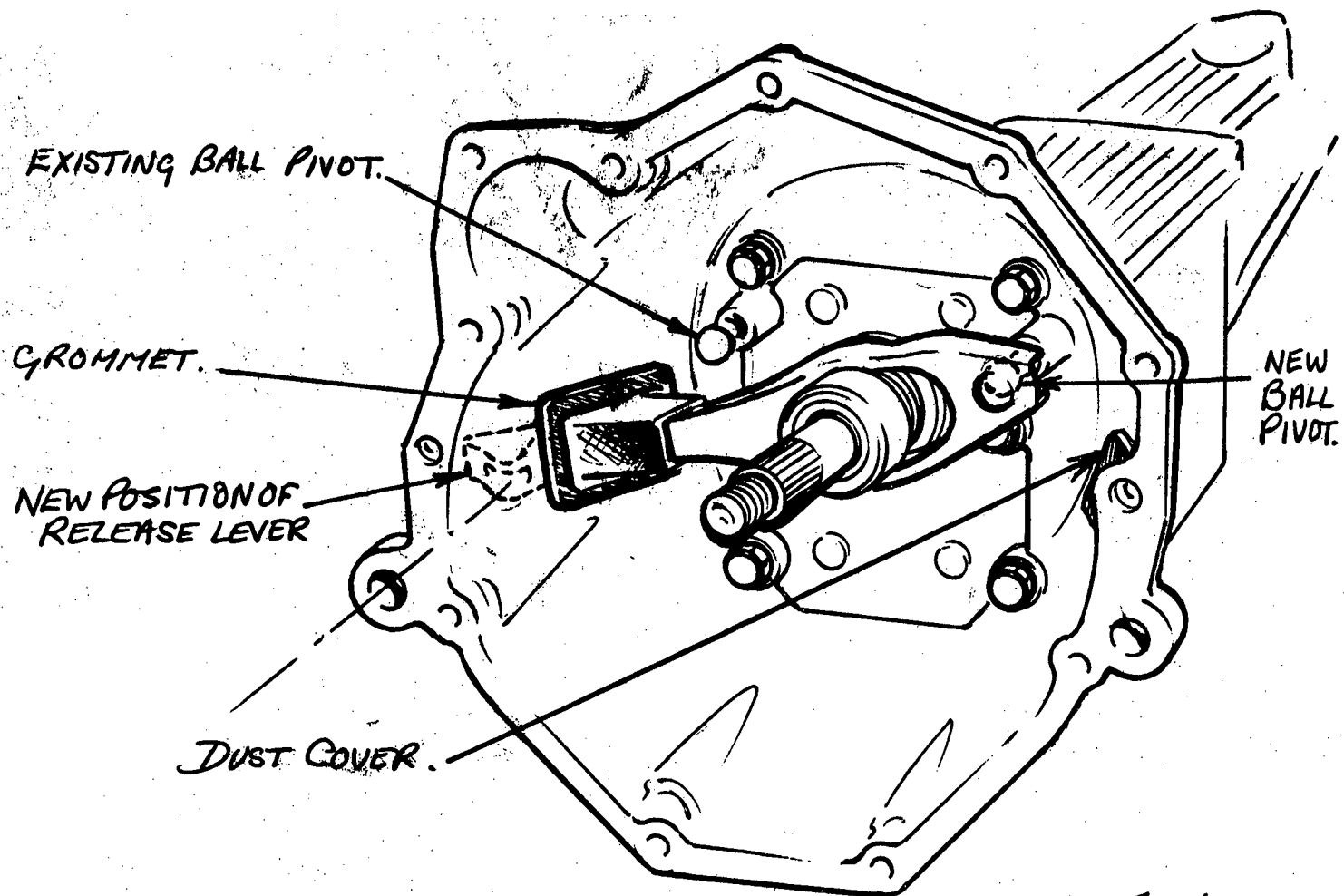
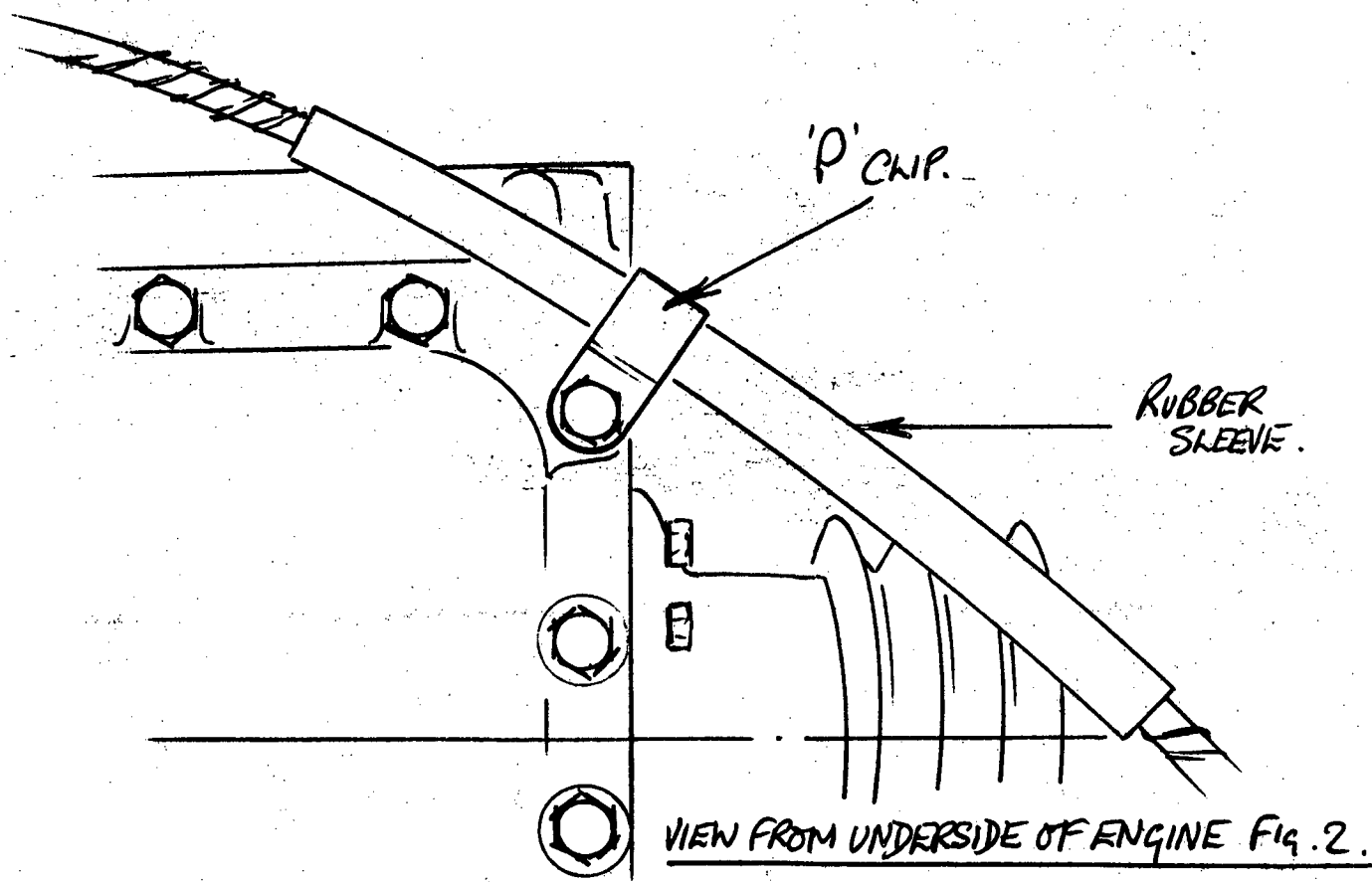


Fig. 1.





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/28
Type	Elite
Date	15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

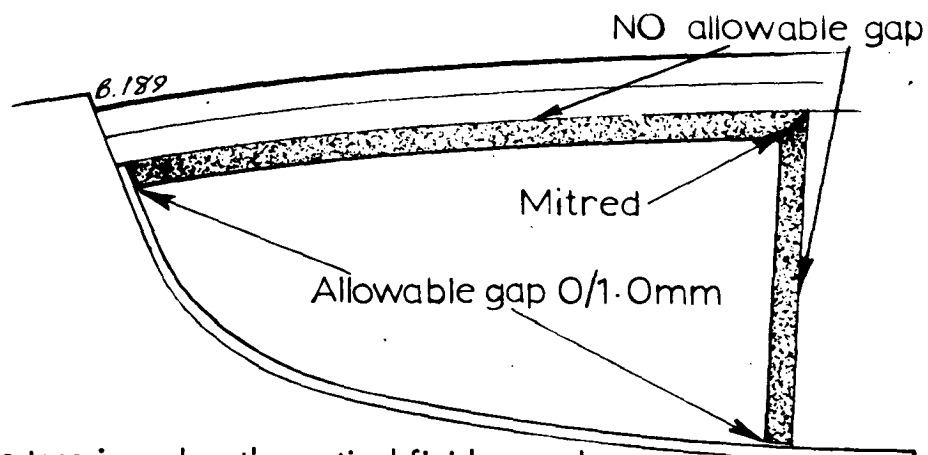
Circulation List	Service Manager		Foreman				
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Title: A.B.S. (Plastic) exterior rear quarter light finishers.

Reason: Improved specification altering the assembly procedure.

Parts Required: A075 U 6070V Double sided adhesive tape, 25 mm wide, )  
.8 metres long. ) per  
A075 U 6071V Double sided adhesive tape, 35 mm wide, ) car  
1.5 metres long. )

- Action:
1. Place the finishers on the glass and trim them as necessary to achieve correct fitting dimensions. See illustration. Remove the finishers.
  2. Clean the mating faces on the glass and on the finishers with a soap type solution, rinse it and dry with paper towelling.
  3. Apply the adhesive tape to the finisher. Care should be taken not to stretch the adhesive tape. Do not remove the backing tape until the last moment prior to fitting the finisher.
  4. Place the finisher on the glass, but do not apply any pressure until the finisher is satisfactorily located. Having achieved a satisfactory assembly apply heavy pressure for a short period. Finally clean the rear quarter light glass of any finger marks etc.



**NOTE:**

The 25mm wide tape is used on the vertical finisher, and the 35mm wide tape is used on the top horizontal finisher.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/29
Type	+2 and Elite
Date	15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Labour Schedules

Reason: To give ammendments where show .

Action: 1. Labour Schedule (A036 T 0328D)

Amend as follows: Operation No. F102a, amend time under both Elan and +2 to read 14.00.

2. Labour Schedule (A075 T 0328Z)

Amend as follows:

## Page 7

Operation No. E903, amend to read:

E903 - Camshaft cover, inlet R & R .2

E903a - Camshaft cover, exhaust R & R .3

Operation No. E907, amend time to .6

## Page 8

Operation No. E 917, amend time to 8.5

919 10.5

920 11.0

921 10.5

922 11.0

933 7.5

934 7.8

936 8.0

937 9.0

940 7.5

## Page 9

Operation No. F 902, amend time to 12.5

903 6.7

904 6.7

## Page 11

Operation No. K900, amend time to .5

## Page 15

Add:

Page 915 - To charge system .7

Page 916 - 'V' belt, compressor, R & R .6



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/30
Type	Elite
Date	15.10.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

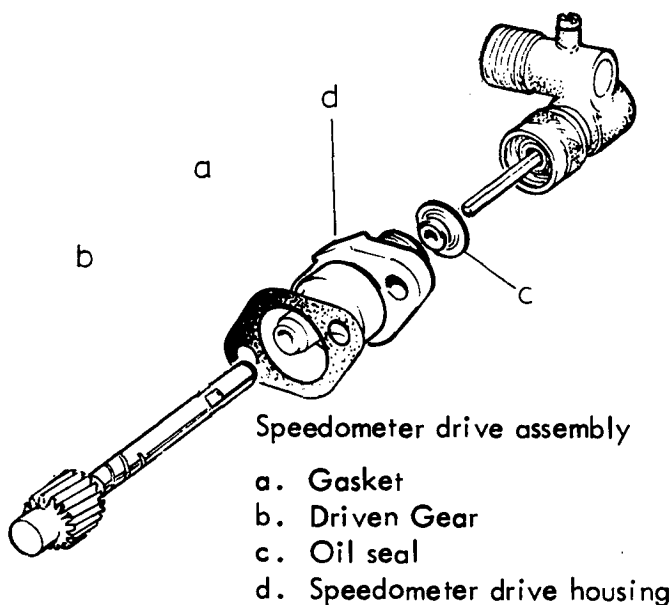
Circulation List	Service Manager		Foreman				
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Title: Speedo Drive Spindle Endfloat.

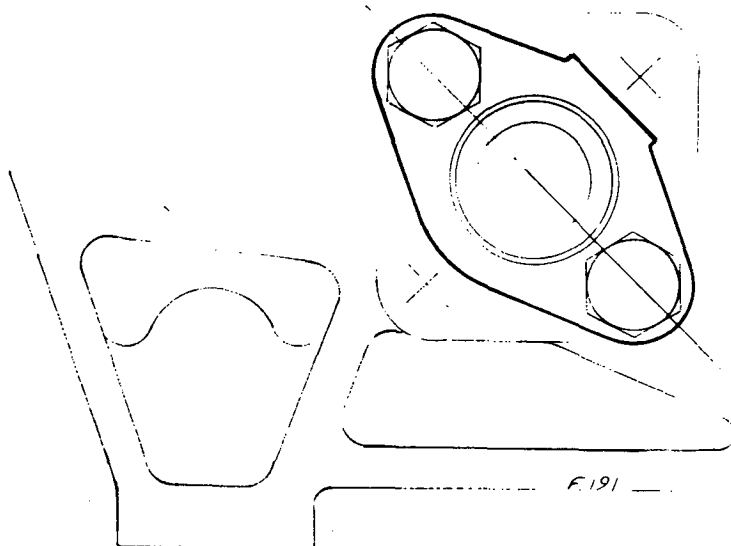
Reason: To avoid the possibility of the Speedo Drive Spindle seizing in the speedometer Drive Housing.

Action:

1. Remove the right angled speedo drive assembly from the speedometer drive housing.
2. Check the endfloat of the speedo drive spindle in the housing, which should be from 0.22 mm (.009 in) to 0.48 mm (.019 in).
3. If the endfloat is correct, refit the right angled speedo drive assembly. In cases, where there is less than 0.22mm (.009 in) endfloat on the speedo drive spindle, the following procedure is recommended:



- a) Drain the gear box oil.
- b) Remove the two bolts and washers securing the speedometer driven gear assembly to the tailshaft housing and remove the assembly
- c) Fit additional gaskets (See A on illustration) to achieve correct spindle endfloat.
- d) Apply 'Silastic' to both sides of the speedometer drive housing gasket(s) and place the gasket(s) on the speedometer drive housing.
- e) Using the illustration as a guide, assemble the speedometer drive assembly in the following order:
  1. Gasket on speedometer drive housing.
  2. Place driven gear into speedometer drive housing.
  3. Fit oil seal to driven gear, with the lip of seal facing inwards.
  4. Secure the assembly with its bolts and washers to the outputshaft housing. See illustration for correct position of the speedometer drive assembly on the outputshaft housing.
  5. Refit the right angle speedo drive assembly and re-fill the gearbox with recommended lubricant.





# LOTUS SERVICE BULLETIN

Class II  
Number 1974/31  
Type Elite  
Date 15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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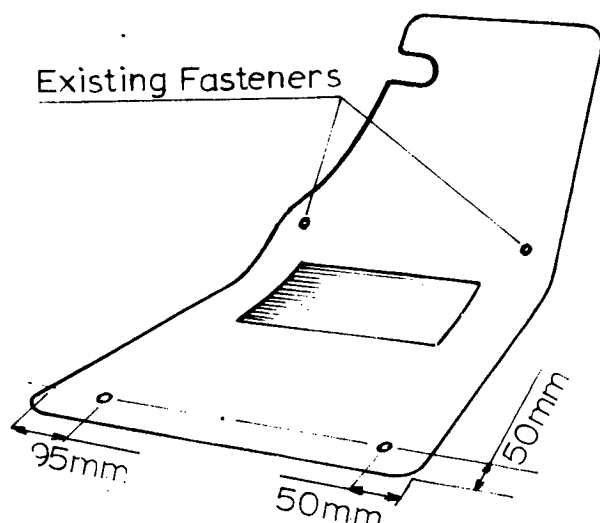
Title: Additional Carpet Fasteners to Front Footmats

Reason: To provide more fixings for passenger's and driver's footmats.

Parts Required:	A075 W 6053Z	Retaining ring	4 off
	A075 W 6059Z	Carpet fixing	4 off
	A075 W 6061Z	Socket	4 off
	A075 W 4004Z	3/16 penny washer	4 off
	A075 W 6013Z	Spire nut	4 off
	A075 W 5030Z	Spire screw	4 off

Charges: U.K. only - warranty. 0.5 hours per car, plus the parts. Normal warranty claims, which bear the chassis number of the car concerned, should be submitted, but marked: 'Elite, 1974/31 Class II'.

Action: Using the illustration as a guide, fit two additional carpet fixings to each front footmat and the car floor. Drill an appropriate diameter hole and secure each socket to the floor in the following order: socket, penny washer, secure them with a spire screw and a spire nut on the underside of the car floor. Seal each screw with underseal to prevent the ingress of water.



Please complete the enclosed slip, and return, marked for the attention of: Service Manager. This 'action record' could be returned at the same time as the warranty claim form.





# LOTUS SERVICE BULLETIN

Class	II
Number	1974/32
Type	Elite
Date	15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:**

Addition of snapper clips to vacuum pipe connections on the inlet manifold for the headlamp and air-conditioning system.

**Reason:**

To eliminate any possibility of connection tubes splitting.

**Parts Required:**

A075 W 6204Z      Snapper Clip      2 off

**Charges:**

U.K. only - warranty. 0.2 hours per car, plus the parts. Normal warranty claims, which bear the chassis number of the car concerned, should be submitted, but marked: 'Elite, 1974/32 Class II'.

**Action:**

1. Check that the end of the rubber connection pipes are cut off square and free from notches. Rectify if necessary.
2. Fit snapper clip (A075 W 6204Z) to each rubber connection hose on the vacuum take off pipe on the inlet manifold. One for the headlamp and one for the air-conditioning vacuum system.

Please complete the enclosed slip, and return, marked for the attention of: Service Manager. This 'action record' could be returned at the same time as the warranty claim form.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/33
Type	Elite
Date	15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

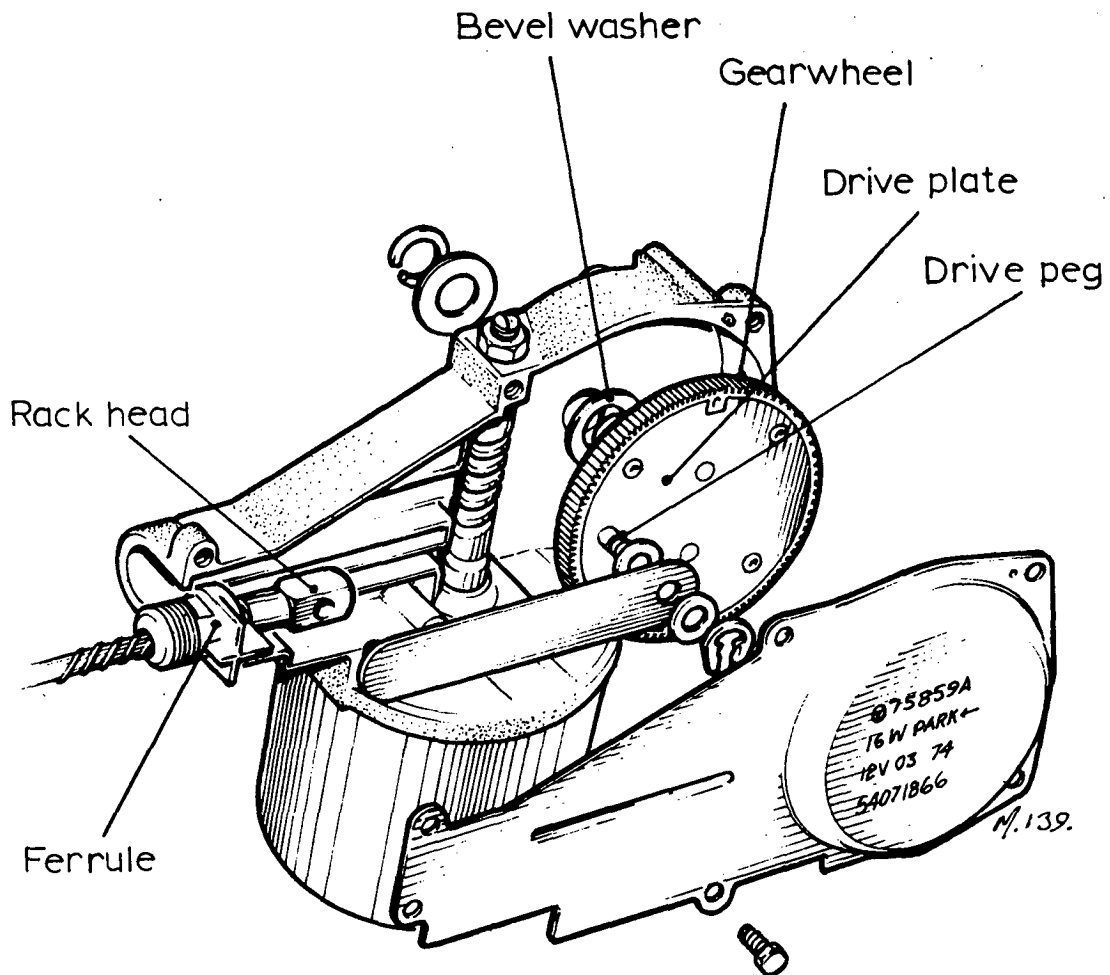
Circulation List	Service Manager		Foreman				
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Title: Modification to Wiper Motor

Reason: To lower the park position of the wiper blade.

Action: Where complaints of this nature are received, the following action should be taken.

1. Remove the front wiper motor assembly.
2. Release the five hexagon headed screws securing the inspection cover, and remove the cover.
3. Detach the connecting rod from the gear wheel assembly by releasing the circlip, removing the plainwasher, lift out connecting rod and removing the washer underneath.
4. From the otherside of the casing remove the circlip and plainwasher, securing the gearwheel assy. to the casing. Push the gearwheel out of the casing. Do not misplace the bevel washer between the gearwheel and the casing.
5. Drill out the four pop rivets securing the plastic gear to the drive plate. Lay the plastic gear across the jaws of a vice and tap the end of the shaft until it is freed from the gearwheel.
6. Remove the drive peg from the drive plate by drilling it out. Re-position the drive peg to the extreme edge of the drive plate as shown on illustration Fig. 1. Braze the drive peg on to the drive plate and fill the existing hole (where peg was removed from) at the same time.
7. Re-reattch the drive plate to the gearwheel.  
NOTE: The actuating cam for the wiper 'parking' switch on the gearwheel must be opposite the drive peg.
8. Grind .8 mm (1/32 in.) min. off the wiper rack head, see Fig. 2.
9. Counterbore the ferrule 11.15 mm (7/16 in.) diameter to a depth of 1.6 mm (1/16 in.) see Fig. 3.
10. Re-assemble the wiper motor and run with the inspection cover off, to check for operational clearance. Fit the cover if satisfactory and fit the wiper motor assembly to the car.
11. Fit the wiper arm/blade assembly so that when parked on passenger side of windscreen, the arm/blade assembly is as low as possible, without fouling the bright trim.



Move drive peg to extreme edge of drive plate.

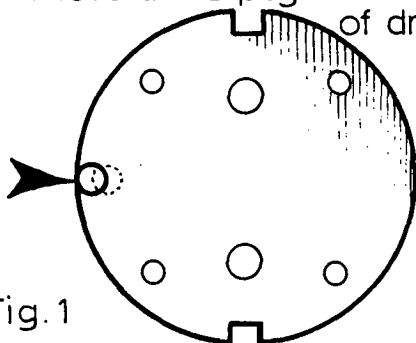
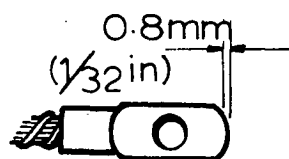
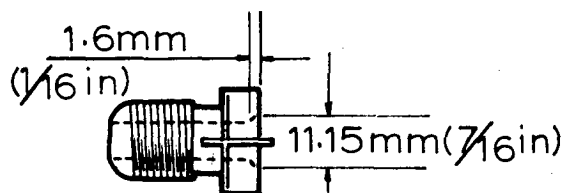


Fig. 1



Grind down rack head.

Fig. 2



Counterbore ferrule.

Fig. 3



# LOTUS SERVICE BULLETIN

Class	II
Number	1974/34
Type	Elite (All)
Date	15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Updated Specification for Rubber Filler Neck Hoses.

Reason: To eliminate any possibility of aromatics inside the boot area.

Parts Required:

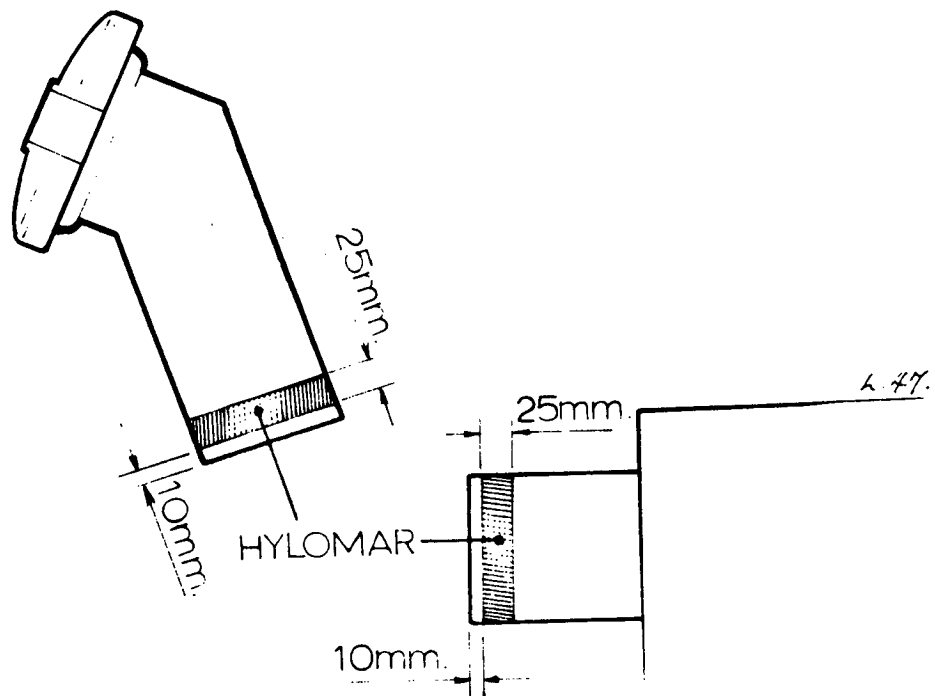
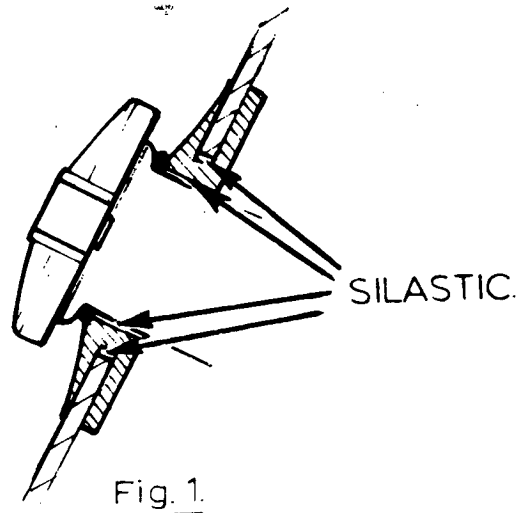
B075 L 0105F	(LH)	Filler Neck Hose	1 off
B075 L 0106F	(RH)	Filler Neck Hose	1 off

Charges: U.K. - Only warranty 2 hours per car, plus the parts. Normal warranty claims, which bear the chassis number of the car concerned, should be submitted, but marked, 'Elite, 1974/34, Class II'.

Action:

1. Disconnect the battery and ensure that the fuel level in the tank is only half full or below.
2. Remove the filler neck assemblies, the filler neck grommets and the rubber filler neck hoses. Discard the filler neck hoses. Ensure that no fuel is spilt inside the boot area.
3. Apply silastic (A036 E 6038V) to the grommet sealing the filler necks to the body, in the position indicated in Fig. 1. This is to prevent any fuel spilt during re-fuelling entering the boot. Fit the grommet and filler necks to the appropriate sides of the body.
4. Before fitting the new rubber hoses, part number B075 L 0105F (LH) and B075 L 0106F (RH) (filler neck to tank), apply a 25 mm wide continuous strip of hylomar (A036 S 6175V), 10 mm up from the open ends on both the tank outlets and the filler necks (See Fig. 2), but ensuring that the compound does not contaminate the inner surfaces. Secure the rubber hoses with their clips to the tank outlets and the filler neck assemblies.
5. Check that there are no fuel leaks. Connect the battery

Please complete the enclosed slip, and return, marked for the attention of: Service Manager. This 'action record' could be returned at the same time as the warranty claim form.





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/35
Type	Elite
Date	15.11.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: One Piece Clutch Cable Insulator Bush.  
This Bulletin supercedes Bulletin 1974/17

Reason: Simplification to existing system.

Parts Required: A075 Q 0049Z Insulator Bush 1 off.

Action: To Install

1. Remove the clutch cable from its abutment on the bell housing. (See section 'Q' in the Workshop Manual).
2. Fit the insulator bush (Part No. A075 Q 0049Z) to the clutch cable abutment on the bell housing.
3. Fit the clutch cable to the insulator bush, fit rubber boot to the cable, and locate boot on groove of insulator bush. Assemble the cable to the clutch release lever.
4. Adjust the clutch cable to give 3 mm free play at the release lever. Tighten locknut after adjustment.

NOTE:

On cars fitted with the three piece insulator bush assembly, the clutch cable should be adjusted as described in Bulletin 1974/17.

5. A final check should be made on the clearance between the outer cable abutment and the adjacent engine bearing housing boss. A MINIMUM clearance of 1.58 mm (.06 in.) MUST BE ACHIEVED; if necessary, lightly file bearing housing boss to ensure this clearance.



# LOTUS SERVICE BULLETIN

Class	III
Number	1974/38
Type	Elite
Date	13.12.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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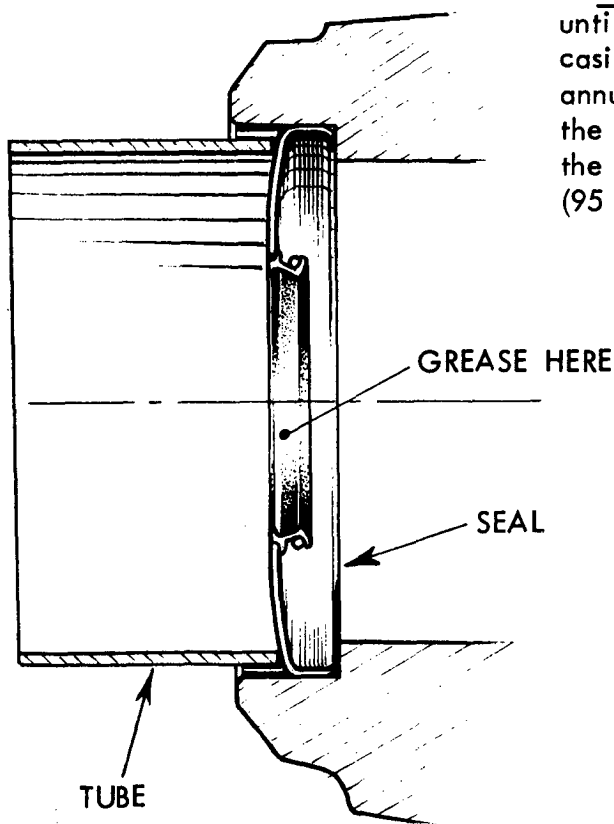
Title: Introduction of Chicago Rawhide Poly-Acrylic Differential Pinion Oil Seal.

Reason: Improved specification of Oil Seal. Change in assembly procedure.

Parts Required: A075 R 6048H Pinion Oil Seal 1 off

## IMPORTANT:

Do not use special tool SL5 (Pinion Oil Seal Replacer) when fitting Pinion Oil Seal (A075 R 6048H) as the outer face of this seal is conical and prone to distortion. Before fitting Oil Seal apply sealing compound (well seal or similar) to the surface of the seal housing. Place the seal in position and using a tube with an outside diameter of approximately 71 mm (2.75 ins.) and a wall thickness of No More than 2.5 mm (0.1 ins.) press in the seal until it is seated squarely on the shoulder in the differential casing. Apply a film of grease (Shell Retinax A) to the annular cavity between the primary and secondary lips of the seal. Fit the flange, washer and pinion nut. Tighten the pinion nut to a torque loading of 13.13 - 14.52 k.g.m (95 - 105 lbs. ft.)





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/39
Type	Elite
Date	13.12.74

LOTUS CARS Ltd NORWICH NORFOLK NR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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**Title:** Addition of Rubber Cover to the Front Dampers.

**Reason:** To avoid the possibility of the Front Springs 'Ringing' against the Front Dampers. Where complaints of this nature are received, the following action should be taken:

**Parts Required:** B075 D 0253Z          Cover          2 off

**NOTE:** This cover is used at present on the rear dampers.

**Action:**

1. Remove the front damper/spring assemblies.  
(See Section C6 in the Workshop Manual).
2. Fit rubber cover (B075 D 0253Z) over the dampers.
3. Replace the front damper/spring assemblies  
(See Section C6 in the Workshop Manual).





# LOTUS SERVICE BULLETIN

Class	III
Number	1974/40
Type	Elite
Date	13.12.74

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
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Title: Elite Cooling System

Reason: Overheating due to high cut in temperature of Otter Switch.

Action: Remove the Otter Switch and immerse in water at  $70^{\circ}\text{C}$ . Increase temperature and check that contact between the two terminals occurs at a temperature of  $84^{\circ}\text{C}$ , + or -  $2^{\circ}\text{C}$ . Switches operating outside this limit should be discarded. Replace switch using a new grommet.

Parts Required:	Otter Switch (Thermostat Cooling Fan)	A036 K 6026Z
	Grommet	A036 K 6027Z



# Lotus Service Bulletin

Class	11
Number	1975/18
Type	Elite
Date	21.05.75

Lotus Cars Limited Norwich, Norfolk, NR14 8EZ. Telephone: Wymondham (095 360) 3411. Telegrams: Lotus Norwich. Telex: 97401

Circulation List	Service Manager		Foreman				
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Title: Upper Steering Column Assembly.

Reason: Revised assembly procedure of the lower mounting flange to the body.

THIS MODIFICATION IS TO BE CARRIED OUT TO ALL ELITES PRIOR TO CHASSIS NUMBERS:

0300A, 0101B, 0009C

Parts Required:	Rubber Washer	A036L6019Z	2 off
	Plain Washer	A075W4021Z	2 off
	(8mm I/D x 25 mm O/D)		
	Nyloc Nut	A075W3010Z	2 off

Charges: 0.3 hrs. per car plus the parts. Warranty claims, which bear the chassis and engine number of the car concerned should be submitted, and marked, Elite 1975/18, Class 11.

Please complete the enclosed action record form (No. 167) and return, marked for the attention of: Service Manager. This action record could be returned at the same time as the Warranty Claim form.

Action: The car should be placed over an inspection pit, or raised on a hoist (ramp).

1. Remove the roadwheel (on the drivers side) or turn the front wheels on full lock to gain access to the lower, upper column mounting bolts.
2. Release the mounting bolts and discard the nyloc nuts and the plain washers.
3. Re-assemble in the following order:  
Rubber washer (against body) A036L6019Z  
Plain washer (8mm I/D x 25 mm O/D) A075W4021Z  
and new nyloc nut A075W3010Z  
Repeat this for the other mounting bolt.  
Tighten both bolts to a torque loading of 10 - 13 lbs. ft.  
(1.3 - 1.8 kgm)

If removed, refit the roadwheel and tighten the wheel nuts to a torque loading of 40 lbs. ft. (5.5 kgm)



# Lotus Service Bulletin

Class	III
Number	1975/19
Type	ELITE
Date	21.05.75

Lotus Cars Limited Norwich, Norfolk, NR14 8EZ. Telephone: Wymondham (095 360) 3411. Telegrams: Lotus Norwich. Telex. 97401

Circulation List	Service Manager		Foremen				
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## ELITE PARTS LIST AMENDMENT

**TITLE:** Revised fuel tank, filler necks and breather system.

**REASON:** Improved filler neck to tank sealing and deletion of vented fuel caps.

**ACTION:** On cars from chassis numbers 401A 281B and 047C the following parts are fitted in production, replacing the obsolete parts listed.

<u>PLATE REF.</u>	<u>NEW PARTS</u>	<u>PART NO.</u>	<u>QUANTITY</u>
LA1	Fuel Tank	A075L0144F	1
LA5	Fuel Filler Neck RH	A075L0146F	1
	Fuel Filler Neck LH	A075L0145F	1
	Tubing Fuel Breathers	A036L0085V	A/R
	Clip Tubing to body	A075W6000Z	4
	Screw Clip to Body	A075W5007Z	4
LA6	Tube Filler Neck to Tank	A075L0149F	2
LA7	Clips. Tube	A075L6027F	4

<u>PLATE REF.</u>	<u>OBSOLETE PARTS</u>	<u>PART NO.</u>	<u>QUANTITY</u>
LA1	Fuel Tank	A075L0100W	1
LA5	Fuel Filler Neck RH	B075L0104W	1
	Fuel Filler Neck LH	B075L0103W	1

On cars prior to the above chassis numbers if either the fuel tank or the filler necks need replacing, the adjacent parts must also be replaced as they are not compatible, for example: If a new fuel tank is fitted, new filler necks, connecting hoses, clips and breather tubes must also be fitted.

For breather pipe layout see Service Bulletin 1974/22.

**NOTE:** Existing Federal breather tubes can be retained.

The old type connecting hoses plate ref. LA6 part number B075L0105/6Z will remain available for servicing cars with old type tank and vented fuel filler cap/neck assembly.



# Lotus Service Bulletin

Class	III
Number	1975/20
Type	ELITE
Date	21/5/1975

Lotus Cars Limited Norwich, Norfolk, NR14 8EZ. Telephone: Wymondham (095 380) 3411. Telegrams: Lotus Norwich. Telex: 97401

Circulation List	Service Manager		Foreman				
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TITLE:

Repairs to the rear screen (tailgate) assembly.

REASON:

To inform dealer personnel that complete rear screen assemblies will not be changed, under warranty, for damage to one section of the bright trim or for heating element failure.

ACTION:

The heating element should be repaired as per Service Bulletin 1975/7 and 1975/12. To replace one section of the bright trim surround, the following procedure is recommended.

PARTS REQUIRED:

5 minute Epoxy adhesive (2 part)  
Resin A050V6004Z A/R  
Hardener A050V6005Z A/R

Adhesive, (one part) clip to glass - A075U6045Z  
White silastic - A075U6044 - Bright trim as required,  
see Elite Parts List.

NOTE:

When replacing one section of the bright trim surround, it is usually necessary, to replace the corner trim caps and the trim retaining clips (4 clips for the upper or lower and 2 clips for each side trim section).

Replacement of one section of the bright trim

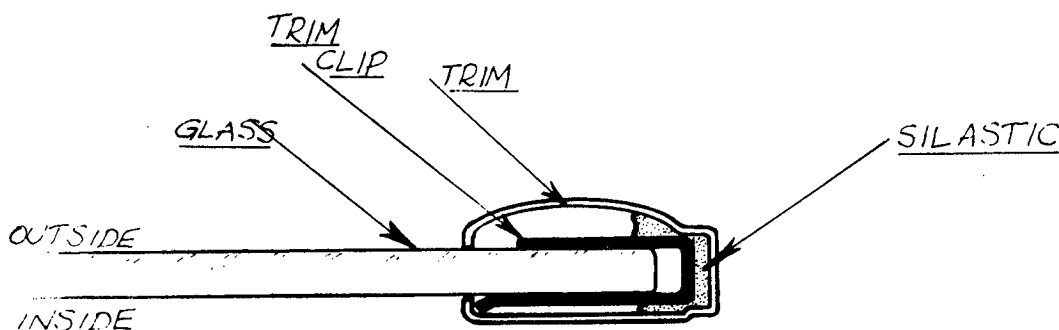
To remove:

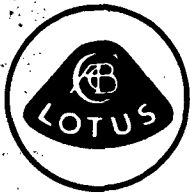
1. Mark the position of the damaged trim section on the glass, using some tape or a "magic" marker.
2. Remove the corner trim cap from each end of the damaged trim section.
3. Release the trim from the glass on both sides.  
Note that the trim on the inside of the tailgate glass has to be lifted over the trim retaining clips, see illustration, and remove the damaged trim section.

P.T.O.

To replace:

1. Mark the position of the existing trim clips on the glass, then remove the trim clips.
2. Ensure that the mating areas on the trim clips and the glass are clean and free of grease. Degrease using methelated spirit, acetone or similar. Apply adhesive A075U6045Z to both sides of the glass and push on the trim clip (with its longer part on the inside of the tailgate glass), to the position as marked on removal. Clamp the clip in position until the adhesive has set.
3. Apply a bead of silastic to the entire length in the base of the trim U - section. Fit the trim section with its flat side to the inside face of the glass.
4. Temporarily fit the corner trim cap and mark its position (using some tape) on the adjacent trim section. Abrade the marked sections on the trim and all the inside area of the corner trim cap.
5. Apply a bead of silastic to the corner edge of the glass. Mix a required amount of 2 part 5 minute epoxy adhesive A050V6004Z and A050V6005Z to a ratio of 1:1. Fill the corner trim cap mating area on the tailgate and inside the corner trim cap with 5 minute epoxy adhesive. Fit the corner trim cap, ensuring continuous even lines with the adjacent trim. Wipe off excessive adhesive before it has set. Repeat operations 4 and 5 for the other corner trim.
6. Apply a continuous bead of white silastic A075U6044Z between the bright trim and the glass on the outside of the tailgate. Carefully press the rolled edge of the trim against the glass, to achieve an even line between the glass and the bright trim. Wipe off excessive silastic.





# LOTUS PARTS AMENDMENTS

LOTUS CARS Ltd NORWICH NORFOLK NOR92W

Tel: WYMONOHAM 3411, CABLES LOTUS NORWICH TELEX 97401

Circulation List	Manager						
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To. All Distributors and Dealers.

14th May 1975.

For the attention of Parts Manager.

Gentlemen,

Considerable confusion has arisen over the correct identification and part numbers of the Renault Europa Rear Bearing Housings. The correct part numbers and descriptions are:-

A046 D 0004Z      Rear Bearing Housing - RIGHT HAND

A046 D 0005Z      Rear Bearing Housing - LEFT HAND

Please amend page D.A.2 of the Renault Europa Parts List.

Yours faithfully,  
Lotus Cars Limited.

H. Wilson,  
Service Parts Controller.

HW/jpw



# LOTUS SERVICE LETTER

LOTUS CARS Ltd NORWICH NORFOLK NR92W Tel WYMONOHAM 3411 CABLES LOTUS NORWICH TELEX 97401

20 June 1974

RFH:BJ

To All: Distributors, Dealers & Service Dealers

Gentlemen,

## LOTUS ELITE OPTIONAL EXTRAS

Our Lotus Elite Price List details certain extras which will be supplied through the Service Division. These are:-

<u>Extra</u>	<u>Part Number</u>	<u>Retail Price</u>	<u>Discount Code</u>
5 piece luggage set	A075V6024W	£66	15%
Rear seat belt kit - Federal	A075V0611W	£14	-
Rear seat belt kit - ECE	A075V1191W	£14	-
Rear seat belt kit - UK	A075V1190W	£14	-
Workshop Manual	A075T0348Z	£10	-

The prices quoted are exclusive of VAT and Car Tax, where applicable.

Yours faithfully,

R. F. Harris,  
General Manager - Parts & Service.