

# Service Bulletin

Mazda Motor of America, Inc.  
7755 Irvine Center Drive  
Irvine, California 92718  
Telephone (714) 727-1990



Category S	Applicable Model/s 1995-97 Millenia	Subject REAR BUMPER INSTALLATION METHOD	Bulletin No. 042/96 Issued 09/23/96 Revised
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## AFFECTED MODELS

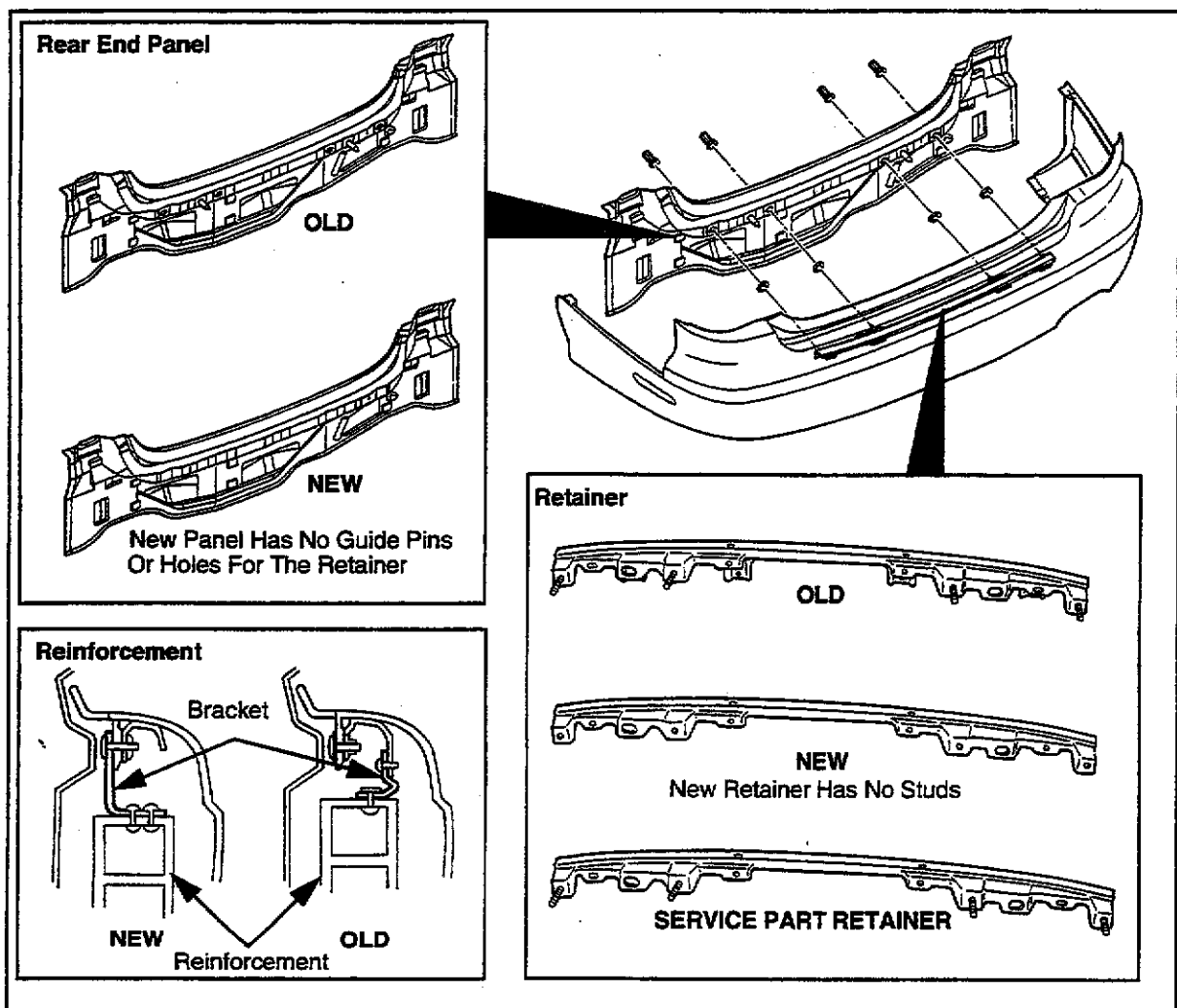
All 1995 - 97 Millenia.

**NOTE:** Millenia's with a VIN of JM1TA22\*\*S1144979 and higher are produced with the new style parts.

## DESCRIPTION

The installation method for the rear bumper has changed. The instructions in this bulletin should be used to determine the appropriate installation when matching old and modified parts.

Service Managers should provide a copy of this bulletin to all body shop personnel and/or sublet shops.



**CONSUMER NOTICE:** The information and instructions in this bulletin are intended for use by skilled technicians. Mazda technicians utilize the proper tools / equipment and take training to correctly and safely maintain Mazda vehicles. These instructions should not be performed by "do-it-yourselfers." Customers should not assume this bulletin applies to their vehicle or that their vehicle will develop the described concern. To determine if the information applies, customers should contact their nearest authorized Mazda dealership.

**INSTALLATION CONFIGURATION No. 1*****New Rear Panel, Service Part Retainer, New Reinforcement***

1. Drill four (4) 8mm holes in the rear panel as illustrated. Refer to Fig. 1.
2. Using three (3) bolts, assemble and tighten the reinforcement brackets and the retainer to the rear bumper.

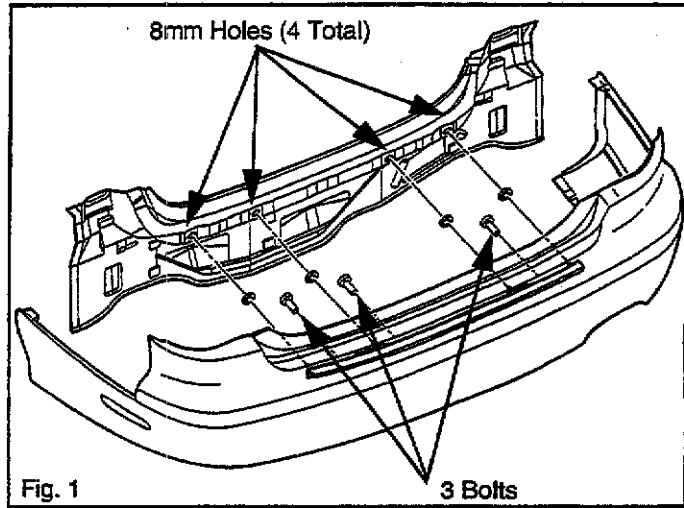


Fig. 1

3. Loosely install the rear bumper.
  - Use a piece of packing (see Parts Information) for spacing the bracket from the rear end panel. Refer to Fig. 3.

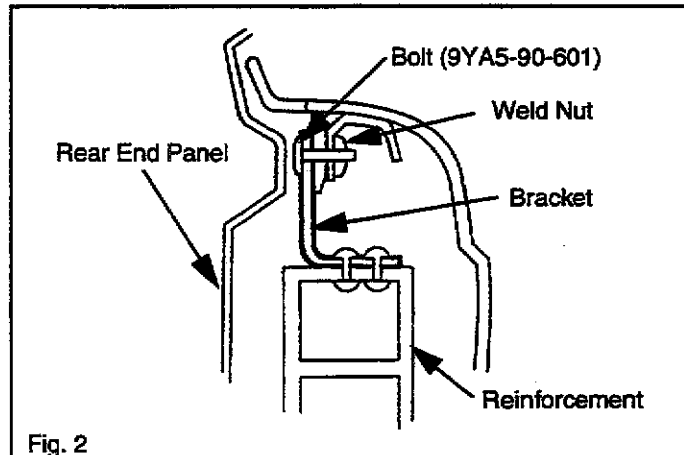


Fig. 2

**NOTE:** Clearance between the rear bumper and the rear finisher of the trunk lid must be adjusted to 8mm prior to tightening. Clearance of less than 8mm may result in interference between the parts.

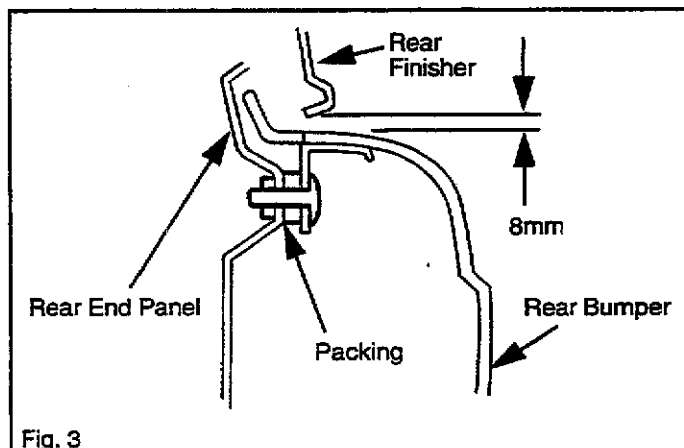


Fig. 3

**INSTALLATION CONFIGURATION No. 2**

***New Rear Panel, Pre-Modified Retainer, Pre-Modified Reinforcement***

1. Drill four (4) 8mm holes in the rear panel as illustrated. Refer to Fig. 1.
2. Assemble and fit the bumper according to the steps described in Configuration 1.

**NOTE:** Ensure 8mm clearance between rear finisher and bumper.

**INSTALLATION CONFIGURATION No. 3**

***Pre-Modified Rear Panel, Service Part Retainer, New Reinforcement***

1. Assemble bumper per instructions contained in Configuration 1.
2. Increase the spacing between the rear panel and the retaining bracket to 4mm.
  - Install packing and two (2) washers (see Parts Information) on each of the retaining bracket studs. Refer to Fig. 4.
3. Assemble and fit the bumper according to the steps described in Configuration 1.

**NOTE:** Ensure 8mm clearance between rear finisher and bumper.

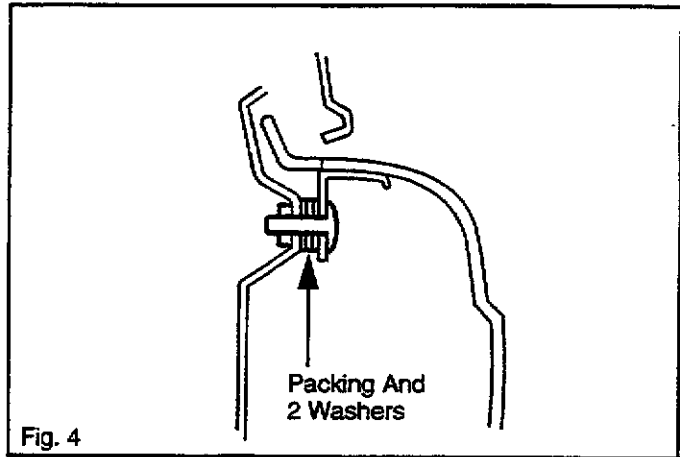


Fig. 4

**PARTS INFORMATION**

Part Number		Description	Qty.	Inter.
New (Modified)	Old (Pre-Modified)			
TA01-50-2R0B	TA01-50-2R0A	Retainer	1	N
TA01-50-260C	TA01-50-260B	Reinforcement	1	N
TA01-50-221C	TA01-50-221B	Rear Bumper	1	N
T001-50-CE1	TA01-50-CE1A	Bracket	3	N
T001-70-750D	T001-70-750B	Rear End Panel	1	N
TAY1-50-2R0		Service Part Retainer	1	N
J001-50-252		Packing	4 (as needed)	--
9995-10-618		Washer	8 (as needed)	--

**Interchangeability "N"** = The old and the new part are not interchangeable between each other.

**NOTES:** As part of the modification, the reinforcement and retainer are attached to the rear bumper by 3 brackets instead of the previous 4. Consequently, there is no parts interchangeability among these parts. The service part retainer is only compatible with the new reinforcement, brackets and bumper.

**Do not use the following part combinations:**

1. Modified rear end panel, modified retainer, pre-modified reinforcement.
2. Pre-modified rear end panel, modified retainer, pre-modified reinforcement.
3. Pre-modified rear end panel, pre-modified retainer, modified reinforcement.

**IMPORTANT:**

**Pre-modified reinforcement can only be used with pre-modified brackets. Modified reinforcement can only be used with modified brackets.**