

POWERTRAIN

Article No. 19

AIR BUBBLES IN COOLING SYSTEM

If air bubbles occur in the cooling system, inspect the vehicle to determine whether it is equipped with a drain tube from the radiator top tank to the upper coolant pipe. If not so equipped, install a drain tube as outlined below:

1. Partially drain the radiator using the drain cock located on the lower left of the radiator.
2. Remove the upper radiator metal tube (radiator to water pump) and install a modified tube, Part Number D16Y-8290-F, which incorporates a drain tube connection (see Fig. 3).
3. Remove the brass welsh plug from the upper right corner of the radiator tank and install a straight connector, Part Number 50331067, and a sealing washer, Part Number 00052157.
4. Install a rubber drain tube (18 inches long by 3/16 inch inside diameter) between the radiator connector and the connector on the upper metal tube. Secure using appropriate size hose clamps, Part Number D16Y-8287-A.
5. Refill the cooling system and bleed in accordance with the procedures detailed in Pantera T. S. B. Number 2 (6/19/72) Article Number 13.

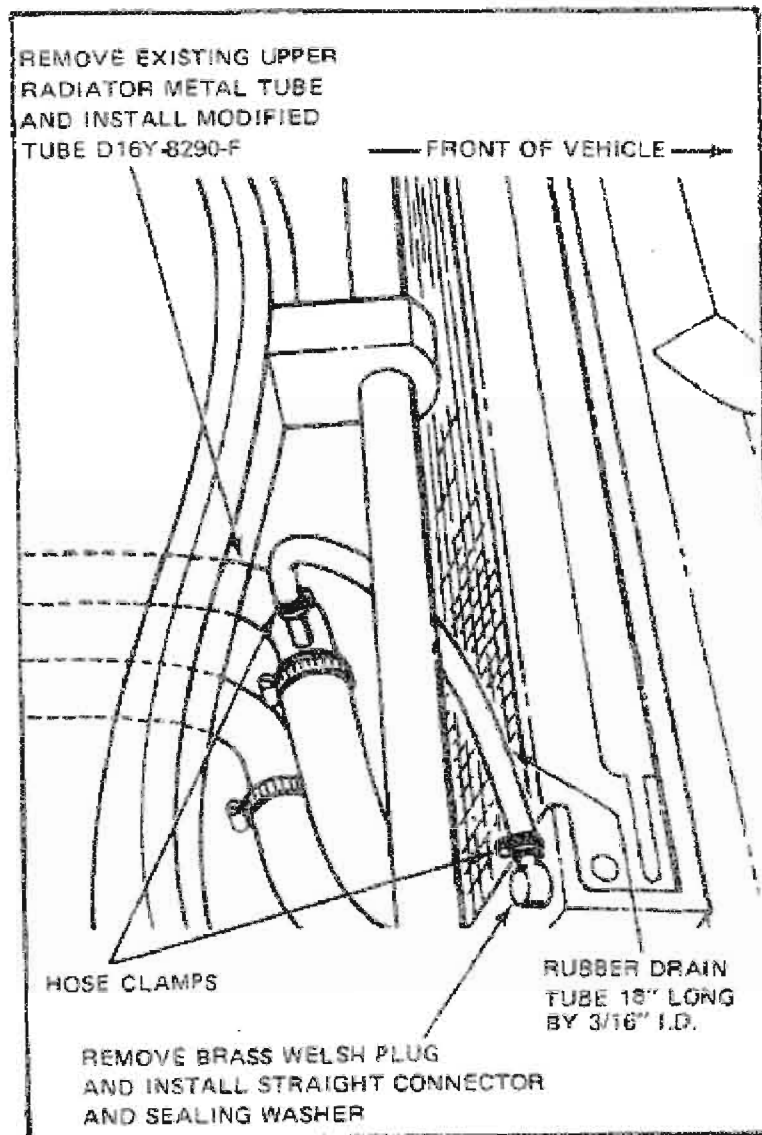


Fig. 3 - Article 19

If air continues to accumulate in the cooling system after the above procedures were performed, it may be necessary to relocate the radiator bleed hose from the lower return pipe (Fig. 3) as described in T.S.B. No. 3, Article 19, dated 9/1/73, back to the radiator supply tank as follows:

1. Partially drain the radiator using the drain cock located on the lower right side of the radiator.
2. Disconnect and discard the existing rubber drain hose from the top of the radiator and the lower return pipe.
3. Plug the outlet from the lower return pipe, by using a short section of the original rubber drain hose, two hose clamps and a suitably sized plug.
4. Obtain and connect one end of a 15 foot long by 3/16" i.d. rubber hose to the connector at the top right corner of the radiator. Secure using the hose clamp removed in step 2.
5. Route the rubber tube to the rear of the vehicle following the route of the coolant tubes underneath the floor pan. Attach the rubber hose to the metal cooling tubes at regular intervals using plastic cable ties. The end of the rubber hose should emerge on the right side of the engine next to the supply tank.
6. Remove the supply tank and braze a short (1-1/2" - 2") length of 3/16" O.D. pipe, such as brake line, to the very top of the supply tank next to the water inlet pipe and above the sender unit boss (Fig. 4).
7. Reinstall the supply tank and connect the rubber drain hose to the new outlet (cut off any excess hose). Secure using a suitable hose clamp.
8. Refill the system and purge the air using the procedure described at the beginning of this section.

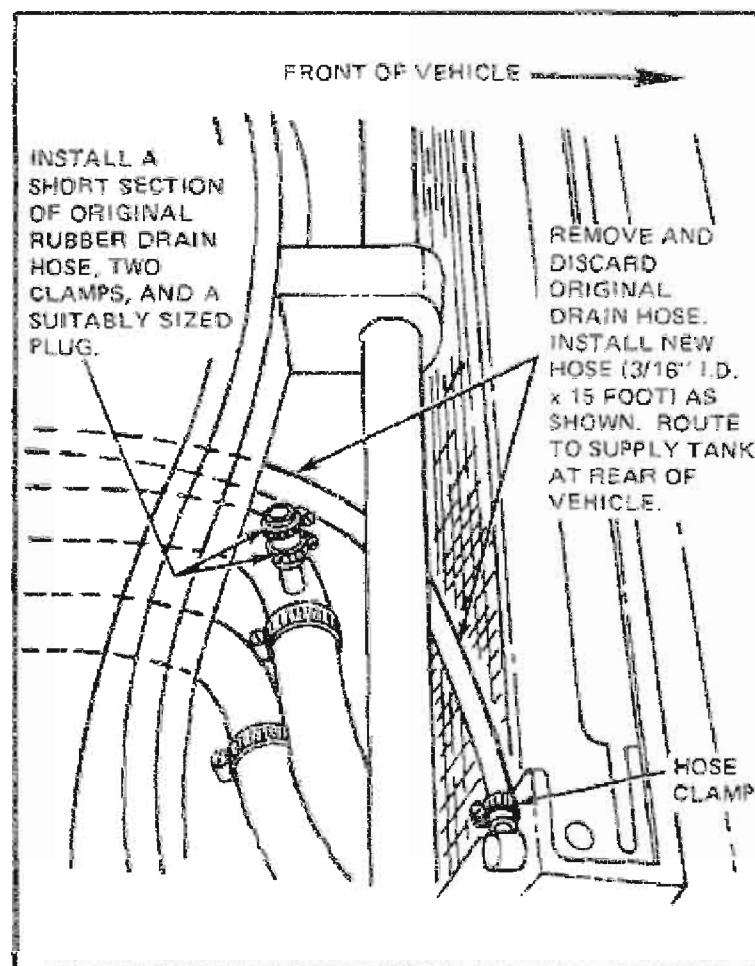


Fig. 3—Article 61

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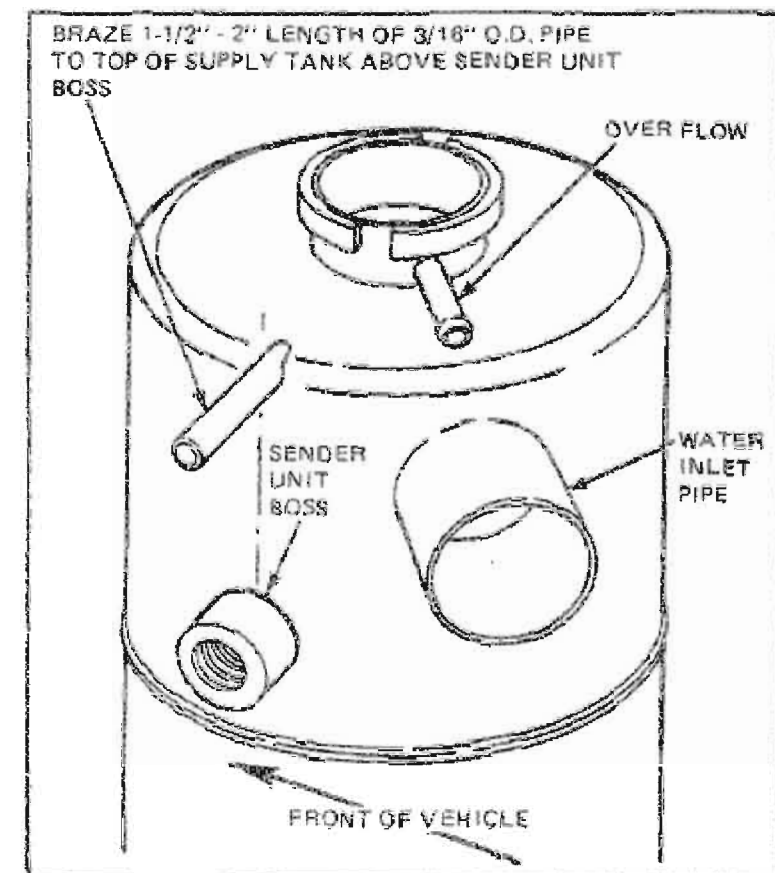


Fig. 4—Article 61