



Repair Model 3 Body Side Outer In The Jack Pad Area

Classification Campaign Bulletin **Section/Group** 10 - Body **Country/Region** All

Year 2017 **Model** Model 3 **Version** All

Bulletin Classification: *This campaign bulletin addresses a known non-safety-related condition and provides recommended technical diagnosis and repair procedures. Apply this procedure to all vehicles in the affected VIN range listed. These instructions assume knowledge of motor vehicle and high voltage electrical component repairs, and should only be executed by trained professionals. Tesla assumes no liability for injury or property damage due to a failure to properly follow these instructions or repairs attempted by unqualified individuals.*

Condition

The body side outer might be slightly bent in the jack pad area, due to a misalignment with a fixture in manufacturing. This results in minor paint damage and could expose the body side outer to corrosion.

Correction

Inspect the vehicle in the jack pad area for damage, and repair the damage if possible. If damage cannot be repaired in a Service Center, send the vehicle to a Tesla Approved Body Shop.

| Correction Description | Correction | Time |
|--|------------|------|
| Inspect Body Side Outer for Damage; No Damage Found | S011810001 | 0.25 |
| Inspect Body Side Outer for Damage, Sublet To Tesla Approved Body Shop | S021810001 | 0.25 |
| Inspect, Repair, And Paint Body Side Outer | S031810001 | 0.50 |

Shop supplies:

Isopropyl Alcohol
 Dow BETAPRIME™ 5504G primer
 Dow BETASEAL™ Express
 Corrosion-Resistant Primer

⚠ WARNING: Wear the appropriate personal protective equipment (PPE) when performing this procedure.

⚠ WARNING: Use only Tesla-approved urethane sealant; refer to [BR-15-92-008](#), "Approved Structural Adhesive and Urethane Sealants" for a list of current approved urethane sealant.

Procedure

1. Remove the LH and RH lower rocker panel cover (refer to Service Manual procedure 12202602).
2. Remove the rubber plugs (x4) near the jack pads.
3. Inspect the underside of the body side outer in the jack pad areas on the LH and RH sides (Figure 2):
 - If there is structural or paint damage only to the body side outer (Figure 3), continue this procedure.
 - If there is damage to the side sill inner, side sill outer, or jack pad bracket, or the damage is too severe to be completed in a Service Center (Figure 4), discontinue this procedure, reinstall any component that was removed for access, and sublet the repair to a Tesla Approved Body Shop.

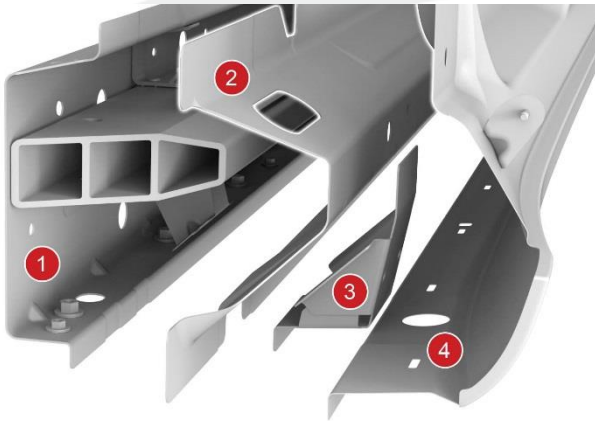


Figure 1 (Area overview)

1. Side sill inner
2. Side sill outer
3. Jack pad bracket
4. Body side outer

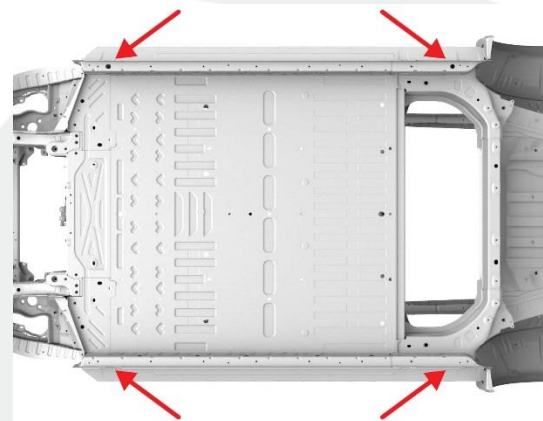


Figure 2 (Inspection area)

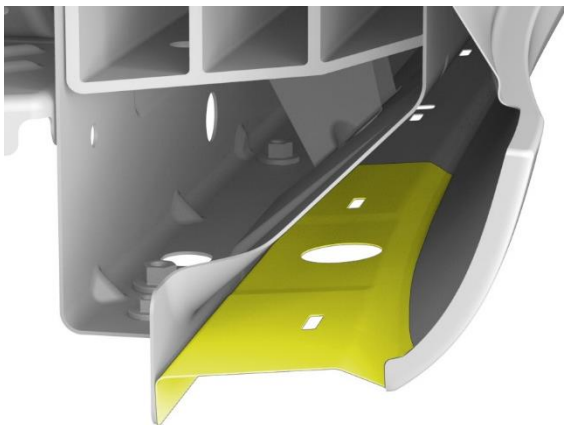


Figure 3 (Acceptable repair area)

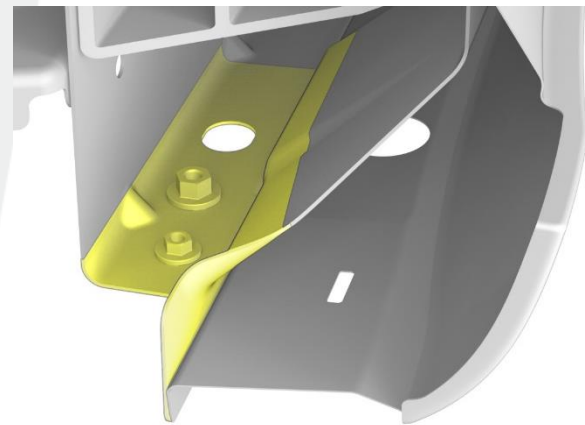


Figure 4 (Unacceptable repair area)

4. Use a wire brush to remove any debris (rust, chipped paint, sealant) from the damaged area.

⚠ WARNING: Remove the debris in a well-ventilated area. Wear suitable personal protective equipment.

⚠ WARNING: This procedure involves steel components. Use the appropriate tools to avoid cross-contamination.

5. Clean the damaged area with isopropyl alcohol.

⚠ WARNING: Wipe off the remaining isopropyl alcohol with a clean, dry towel immediately after application. Do not let the remaining isopropyl alcohol air dry. Letting the remaining isopropyl alcohol air dry can compromise the urethane bond.

6. Apply urethane primer to the area between the body side outer and the sill outer (Figure 5).



Figure 5

7. Apply urethane sealant to the repair area. Make sure that the sealant fills the damaged area completely.

8. Use adjustable joint pliers to bend the body side outer flange into position.

9. Clamp the flange in the repair area (Figure 6).



Figure 6

10. Prime any bare metal with a suitable corrosion-resistant primer.

11. Allow the primer to dry for 5 minutes before continuing to the next step.

12. Remove the clamp, and then apply touch up paint to the repair area.

⚠ WARNING: Touch up paint has a 30 minute cure time. Make sure that the paint is dry before continuing to the next step.

13. Reinstall any component that was removed for access.

Affected VIN(s) Affected Model 3 vehicles built before approximately September 12, 2017.

NOTE: This is a simplified summary of the affected VIN list. Refer to the VIN/Bulletin Tracker or Customer/Vehicle profile to determine applicability of this bulletin for a particular vehicle.

For feedback on the accuracy of this document, email ServiceBulletinFeedback@tesla.com.