



Resecure Triple Camera Windshield Bracket

Classification Campaign Bulletin **Section/Group** 15 - Interior Trim **Country/Region** All

Year 2018 **Model** Model X **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.*

This Service Document supersedes SB-18-15-008, dated 14-Dec-18. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.

Condition

Certain Model X vehicles were manufactured with triple camera windshield brackets that were not properly secured to the windshield. The bracket may look uneven and/or move when manipulated. However, there is no effect on Autopilot functionality or rear view mirror stability.

Correction

Perform the following procedure to resecure the triple camera windshield bracket to the windshield.

Correction Description	Correction	Time
SB-18-15-008 Not Applicable	S011815008	0.00
Resecure Triple Camera Windshield Bracket	S021815008	0.35
Inspect Triple Camera Windshield Bracket; Bracket Already Secure	S031815008	0.05

Required Part(s):	Part Number	Description	Quantity
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Shop supplies:

IPA wipes
 Masking tape
 Betaprime 5504G All-in-One primer
 Betaseal Express urethane
 Caulking gun

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Manual.

Special Tool(s): 1053066-00-A ASY, CALIBRATION STAND, DRIVER ASSIST CAMERA

Procedure

1. Remove the rear view mirror (refer to Service Manual procedure 15050202).
2. Remove the screws that attach the upper mirror cover to the triple camera windshield bracket (torque 0.8 Nm) (Figure 1).

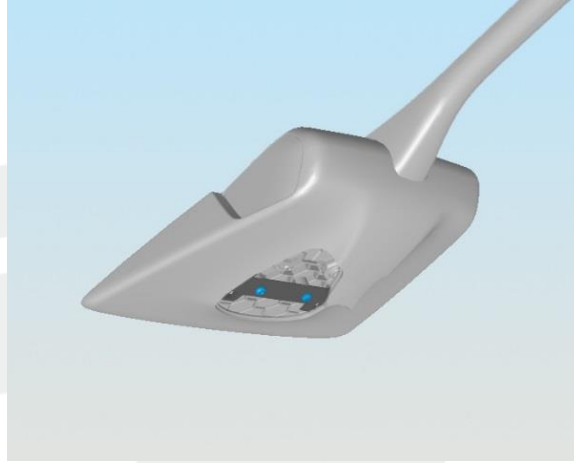


Figure 1

3. Release the clips (x2) that attach the upper mirror cover to the triple camera windshield bracket, and then remove the cover (Figure 2).

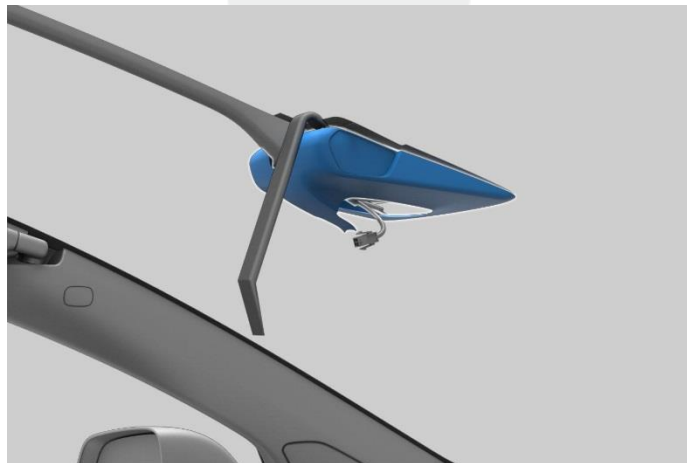
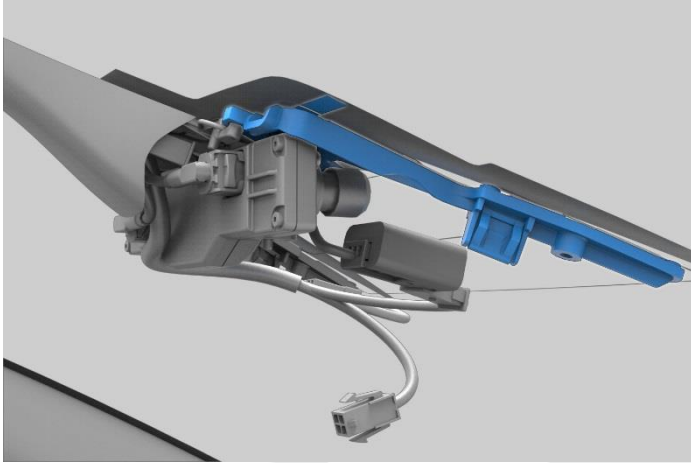


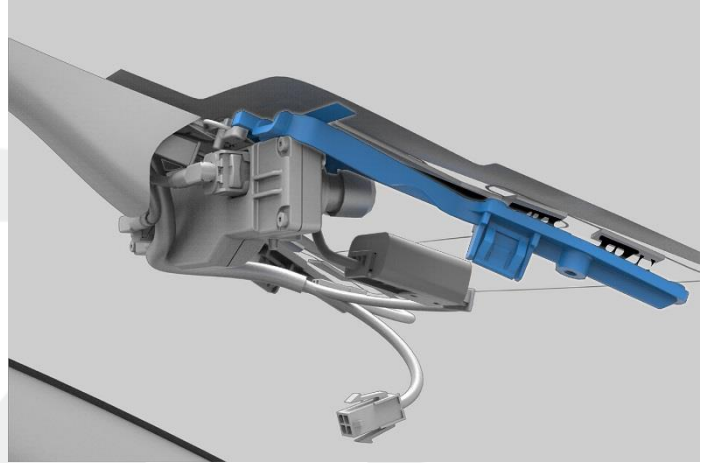
Figure 2

4. Inspect the LH and RH sides of the triple camera windshield bracket.

- If both sides of the bracket are flush with the windshield (Figure 3), discontinue this procedure and install all parts that were removed.
- If either side of the bracket is not flush with the windshield (Figure 4), continue to the next step.



✓ Figure 3 (RH shown, check LH also)



✗ Figure 4 (RH shown, check LH also)

5. Remove the glare shield (refer to Service Manual procedure 15052502).

6. Use IPA wipes and a trim tool/pick to remove as much old adhesive as possible from under the affected side of the triple camera windshield bracket.

⚠ CAUTION: Take care not to damage the windshield heater grid.

NOTE: It may not be possible to completely remove the old adhesive residue.

7. Apply masking tape to both edges of the affected side of the triple camera windshield bracket (Figure 5).

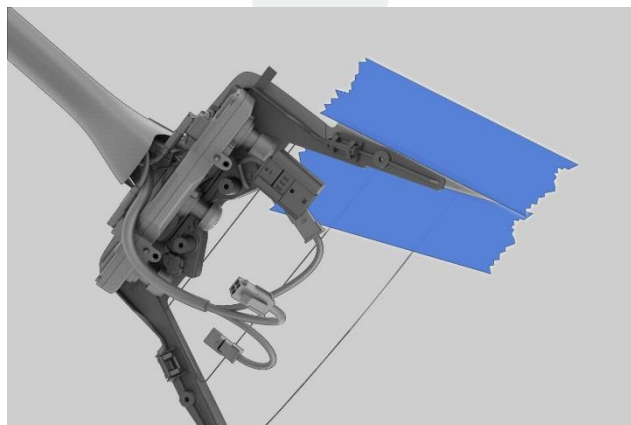


Figure 5 (RH shown, LH similar)

8. Apply Betaprime primer to the windshield and the side of the triple camera windshield bracket that makes contact with the windshield (Figure 6). Let the primer dry for 2 minutes.

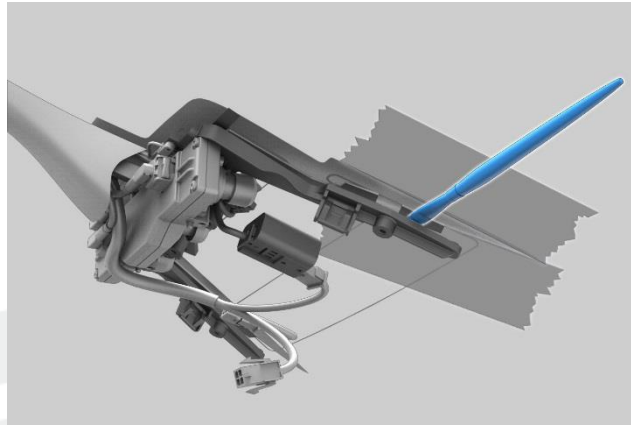


Figure 6 (RH shown, LH similar)

9. Load the Betaseal urethane into the caulking gun.

NOTE: If preparing an unopened tube of Betaseal, cut off as little of the applicator tip as possible to create a very small opening.

10. Apply a small amount of Betaseal urethane between the windshield and triple camera windshield bracket. Wipe away any excess urethane.
11. Remove the masking tape from the windshield (Figure 5). Wipe away any excess urethane.
12. While pressing the triple camera windshield bracket against the windshield, apply multiple strips of masking tape over the top of the bracket to secure it to the windshield (Figure 7). Let the urethane dry for 2 hours.

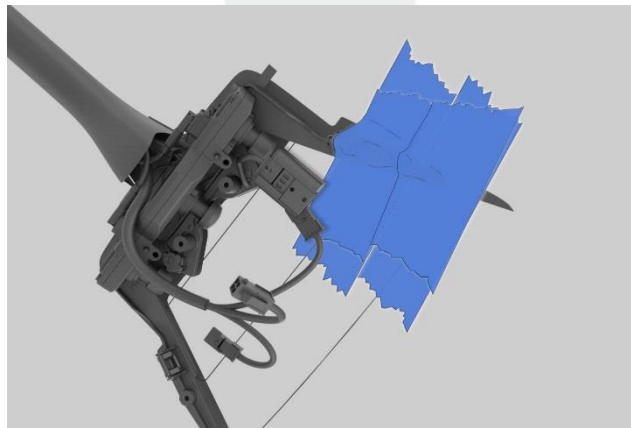


Figure 7 (RH shown, LH similar)

13. After 2 hours have elapsed, remove the masking tape from the triple camera windshield bracket and windshield (Figure 7), and check that the bracket is flush with the windshield.
14. Install the glare shield (refer to Service Manual procedure 15052502).
15. Perform the forward facing camera pre-calibration (refer to Service Manual procedure 17230800).

16. Align the clips that attach the upper mirror cover to the triple camera windshield bracket, and then install the upper mirror cover (Figure 2).

⚠ CAUTION: Take care not to pinch the rear view mirror harness between the upper mirror cover and glare shield.

17. Install the screws that attach the upper mirror cover to the triple camera windshield bracket (torque 0.8 Nm) (Figure 1).

18. Install the rear view mirror (refer to Service Manual procedure 15050202).

NOTE: Inform the customer that the vehicle will need to be driven for up to 100 miles in order to fully calibrate Autopilot.

Affected VIN(s) Affected Model X vehicles built between approximately August 1, 2018 and September 30, 2018.

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.

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