



Replace High Voltage Controller to Penthouse Cover Bolts

Classification	Campaign Bulletin	Section/Group	16 - Battery System	Country/Region	United States
Year	2017 – 2018	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.

This Service Document supersedes SB-18-16-004 R1, dated 12-Jun-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

On certain Model 3 vehicles, the one-time use bolts that attach the high voltage controller to the penthouse cover were not torqued to Tesla's internal specification.

Correction

Replace and torque the bolts to the internal specification.

Correction Description	Correction	Time
SB-18-16-004 Not Applicable	S011816004	0.0
Replace High Voltage Controller To Penthouse Cover Bolts	S021816004	0.45

Required Part(s):	Part Number	Description	Quantity
	1115916-00-C	BOLT,TE,M6-1.0x14,[88],G1009,CA,UHS	5
	1108958-00-A	SEAL,PROBE LID,HVBAT	1
	1108907-00-A	BREATHER, NITTO Z-PLUG-S	1
	1117669-00-A	BOLT,5-LOBE,M6x19,[109],ZNNI,MAT,PTP,SEAL	2
	1111033-00-D	BRACKET - PLASTIC	1
	1117252-00-A	BOLT,HF,M12x40,STL[109],ZN,ADH,MAT	1

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):	1076921-00-B	Insulation Multimeter, Fluke 1507
	1130480-00-A	Test Probes, Slim, Fluke TP38
	1059330-00-B	Skt, 1/4in Dr, 5-Lobe Torx External
	1026636-00-A	Pack Enclosure Leak Tester, HV Battery
	1140501-00-A	Pack Kit, Enclosure, Leak Test, HV Battery, Complete
	1144879-00-A	Kit, Encl Leak Test Adapters, HV Battery
	1455410-00-A	Kit, Dummy Plug
1108272-00-B	Cap, Logic Conn, Inv, 3DU	

Procedure

1. Perform the vehicle electrical isolation procedure (refer to Service Manual procedure 17010000).
2. Remove and discard the bolt that attaches the center 2nd row buckle to the body, and then set the buckle aside (Figure 1).

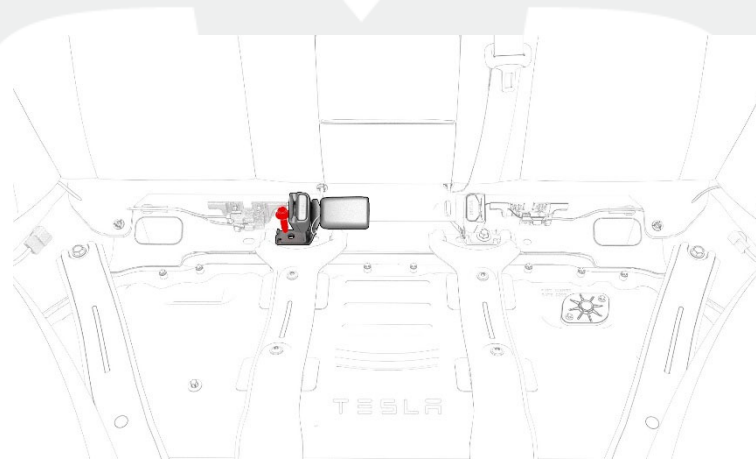


Figure 1 (Center 2nd row buckle and bolt)

3. Remove the RH inner 2nd row rail (Figure 2) (refer to Service Manual procedure 13052202).

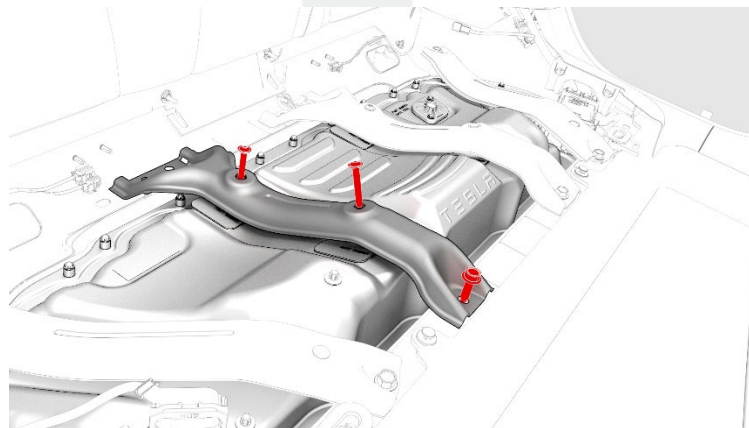


Figure 2 (RH inner 2nd row rail and bolts)

4. Remove and discard the bolts that attach the high voltage controller to the penthouse cover (Figure 3).

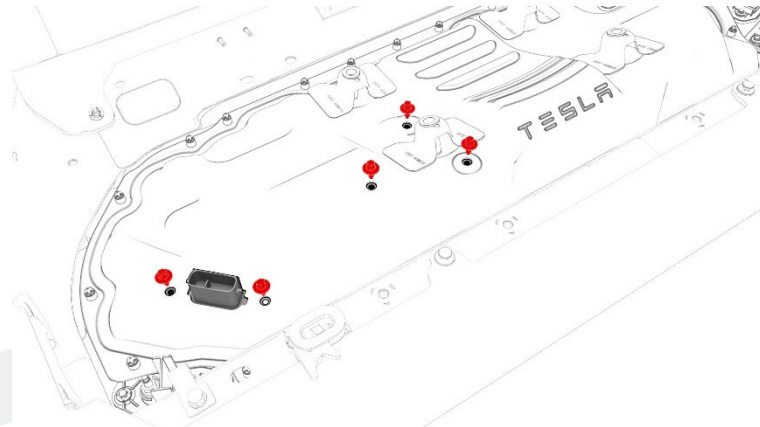


Figure 3 (Bolts that attach the high voltage controller to the penthouse cover)

5. Inspect each of the high voltage controller to penthouse cover bolt holes (x5), and if present, remove any gasket residue (Figure 4).

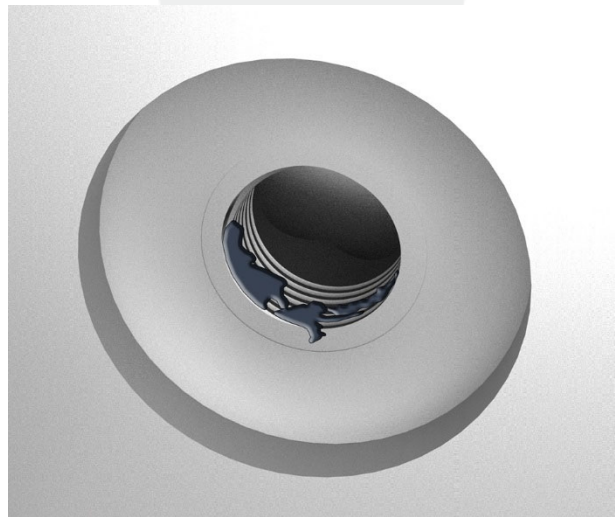


Figure 4 (High voltage controller to penthouse cover bolt hole gasket residue)

6. Hand-tighten the new bolts that attach the high voltage controller to the penthouse cover (Figure 3).

7. Tighten the bolts in the sequence shown (torque 5 Nm +20°), and then mark each bolt with a paint pen (Figure 5).

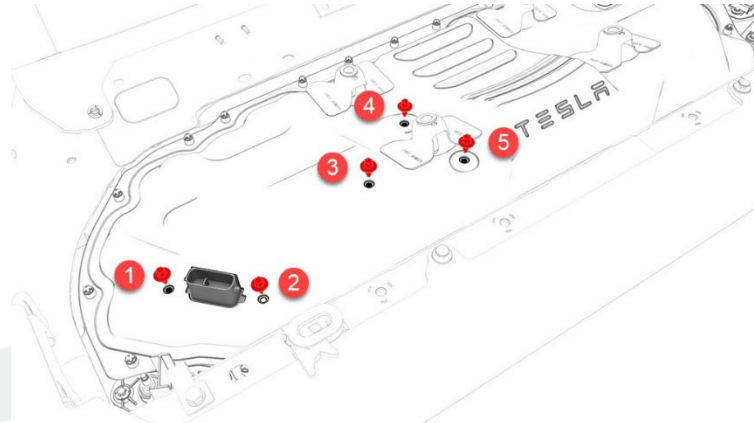


Figure 5 (Torque sequence)

8. Perform a penthouse air leak test (refer to Service Manual procedure 16100400).

NOTE: Do not connect 12V power at this time.

9. Install the RH inner 2nd row rail (Figure 2) (refer to Service Manual procedure 13052202).
10. Install the center 2nd row buckle, and install a new bolt (torque 40 Nm) (Figure 1).
11. Connect 12V power (refer to Service Manual procedure 17010200).

Affected VIN(s) Affected Model 3 vehicles built between approximately:
October 26, 2017 to January 23, 2018, and May 2, 2018 to August 13, 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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