



# Replace Rear Drive Unit HV Header and Positive Contactor Bolts

<b>Classification</b>	Campaign Bulletin	<b>Section/Group</b>	16 - HV Battery System	<b>Country/Region</b>	United States, Canada
<b>Year</b>	2018	<b>Model</b>	Model 3	<b>Version</b>	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

On certain Model 3 vehicles, the rear drive unit HV header bolts and the positive contactor bolt within the High Voltage (HV) battery penthouse were insufficiently torqued to internal specifications during manufacturing.

## Correction

Replace and properly torque the rear drive unit HV header bolts and the positive contactor bolt.

Correction Description	Correction	Time
SB-18-16-008 Not Applicable	S011816008	0.0
Replace And Torque RDU HV Header And Positive Contactor Bolts	S021816008	1.2

Required Part(s):	Part Number	Description	Quantity
	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
	1104475-00-C	BOLT AND WSHR [DBL], M8X23, STL ZNFL, SDOG ADH	5
	1115916-00-A	BOLT, TE, M6X14, [88], ZNNI, SEAL, SDOG	5
	2007104-00-B	NUT HFPT M8X1.25 [10]-ZNNI	1
	1117252-00-A	BOLT, HF, M12X40, STL [109], ZN, ADH, MAT	2
	1111033-00-D	M3 2R BOLSTER CLIP	1
	<b>If necessary:</b>		
	1467483-00-A	KIT, PENTHOUSE HV INSULATORS, M3	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):	Part Number	Description
	1076927-00-A	Resistance meter, microohm, Hioki RM 3548
	1126496-00-B	Wrench, Torque+Angle, 3/8" DR
	1059330-00-B	Skt, 1/4in Dr, 5-Lobe Torx External

1144879-00-A	Kit, Encl Leak Test Adapters, HV Battery
1026636-00-A	Pack Enclosure Leak Tester, HV Battery
1108272-00-B	Cap, Logic Conn, Inv, 3DU
1133603-00-A	Kit, HV Pyro-disconnect Replacement, BRP
1131071-00-A	Dummy Disconnect, Pyro, Safety
1057602-00-A	Ratchet, 1/4" Sq Dr, HV Insulated
1057603-00-A	Ext Bar, Wobble, 1/4" Dr, HV Insulated
1057607-00-A	Magnet, Flexible, HV Insulated, 18"
1133768-00-A	Socket, 1/4" Dr, Deep, 10 mm, Thin Wall, Insul
1057606-00-A	Skt, 1/4" Sq Dr, 13mm, HV Insulated
1127845-00-A	Asy, Service Cover, Penthouse, Model 3

## Procedure

1. Remove the pyrotechnic battery disconnect (refer to Service Manual procedure 16300200).
2. Remove the insulator cap from the HV battery positive contactor output terminal bolt (Figure 1).



Figure 1

3. Remove and discard the bolt that attaches the HV battery positive contactor to the positive busbar (Figure 2).



Figure 2

4. Install a new bolt to attach the HV battery positive contactor onto the positive busbar, and then mark the bolt with a paint pen after it is torqued (torque 5 Nm +60°) (Figure 2).

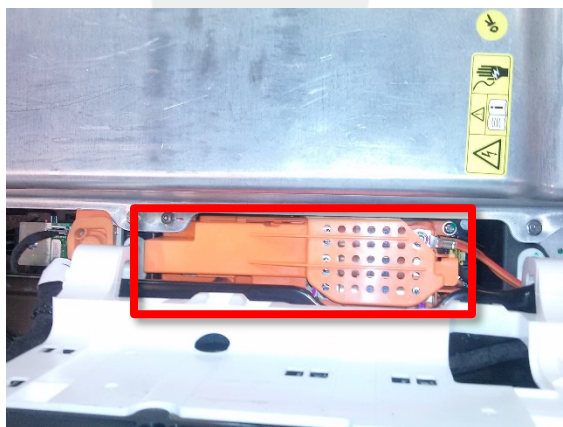
5. Use the Hioki resistance meter to measure the resistance at the HV joint between the HV battery positive contactor and the positive busbar (Figure 3).

**NOTE:** The maximum acceptable resistance is 0.060 mΩ (60 μΩ). If the resistance is above this value, escalate a Toolbox session, as appropriate.



**Figure 3**

6. Install the insulator cap onto the HV battery positive contactor output terminal bolt (Figure 1).
7. Raise the high voltage controller vertically, release the clips that attach the fuse access insulator to the penthouse, and then remove the insulator from the penthouse (Figure 4).



**Figure 4**

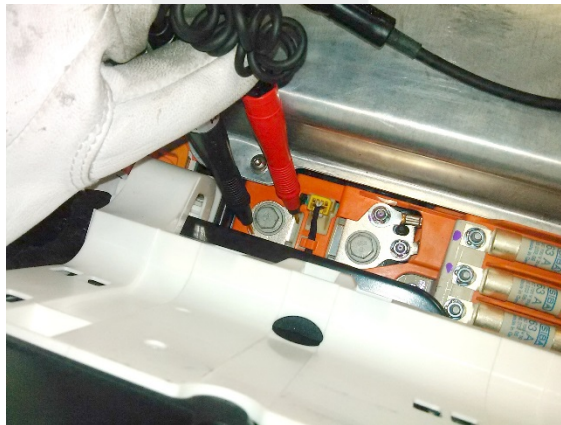
- Remove and discard the bolts that attach the positive and negative busbars to the rear drive unit HV header (Figure 5).



**Figure 5**

- Install new bolts to attach the positive and negative busbars to the rear drive unit HV header, and then mark the bolts with a paint pen after they are torqued (torque 5 Nm +60°) (Figure 5).
- Use the Hioki resistance meter to measure the resistance at the HV joint between the rear drive unit HV header and the busbar at each bolt (Figure 6).

**NOTE:** The maximum acceptable resistance is 0.070 mΩ (70 μΩ). If the resistance is above this value, escalate a Toolbox session, as appropriate.



**Figure 6**

- Install the fuse access insulator, fasten the clips that attach the insulator to the penthouse, and then lower the high voltage controller (Figure 4).
- Install the pyrotechnic battery disconnect (refer to Service Manual procedure 16300200).

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**Affected VIN(s)** Affected Model 3 vehicles built between approximately June 12, 2018 and July 12, 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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