 Tesla, Inc. Service Bulletin		<h2>Remove Front Door Outer Belt Seal Stuffers</h2>	
SB-19-11-006 December 2, 2019			
Classification		Section/Group	Mobile Service
Repair Bulletin		11 - Closures	Can Perform (where permitted)
Model Year	Model	Country/Region	Version
2016 - 2018	Model X	All	All
<small>The model(s) and model year(s) listed are a general approximation 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.</small>			

Repair Bulletin: This repair bulletin provides instructions on addressing a noted condition or possible customer concern regarding the operation of Tesla vehicles. These instructions should only be performed by trained professionals.

Condition

Some Model X vehicles are equipped with front door outer belt seals that apply excess pressure to the front door glass, potentially causing excess noise, vibration, or harshness (NVH), slow door glass movement, and/or unintended activation of door glass anti-pinch functionality.

Correction

Upon customer complaint of the conditions described, verify the condition, remove the stuffers from the LH and RH front door outer belt seals, perform a test drive to verify that the condition has been rectified, and if necessary, adjust the LH and/or RH front door glass.

Correction Description	Correction	Time
SB-19-11-006 Not Applicable	S011911006	0.00
Inspect LH and RH Front Door Glass, Repair Not Necessary	S021911006	0.05
Remove LH And RH Front Door Outer Belt Seal Stuffers And Perform Test Drive, Glass Adjustment Not Necessary	S031911006	0.80
Remove LH And RH Front Door Outer Belt Seal Stuffers, Perform Test Drive, And Adjust LH Front Door Glass	S041911006	0.95
Remove LH And RH Front Door Outer Belt Seal Stuffers, Perform Test Drive, And Adjust RH Front Door Glass	S051911006	0.95
Remove LH And RH Front Door Outer Belt Seal Stuffers, Perform Test Drive, And Adjust LH And RH Front Door Glass	S061911006	1.10

	Part Number	Description	Quantity
Parts Required	1025401-00-A	CLIP, HEART FLEX W WSHR 70 LBS RETENTION	20
	<small>These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Catalog.</small>		
Special Tools	1080585-00-A	Vise-Grip Sheet Metal Tool, 1-3/4' D Throat, 3-1/8" W Jaw	
Shop Supplies	Miracle Bubbles		

Procedure

1. Lower and raise the LH and RH front door glass a few times and check for excess NVH, slow door glass movement, and unintended activation of door glass anti-pinch functionality.
 - If none of these symptoms are observed, discontinue this procedure.
 - If at least one of these symptoms are observed, continue to step 2.
2. Remove the LH front door outer belt seal (refer to Service Manual procedure 11703002).

TIP: For reference, the outer belt seal contains 1 long stuffer and 1 short stuffer (Figure 1).



Figure 1 – Stuffers placed next to seal for reference

3. Carefully clamp the front end (Figure 1) of the outer belt seal so that an airtight seal is formed (Figure 2).

CAUTION: Do not clamp the stuffer; clamp only the rubber seal.

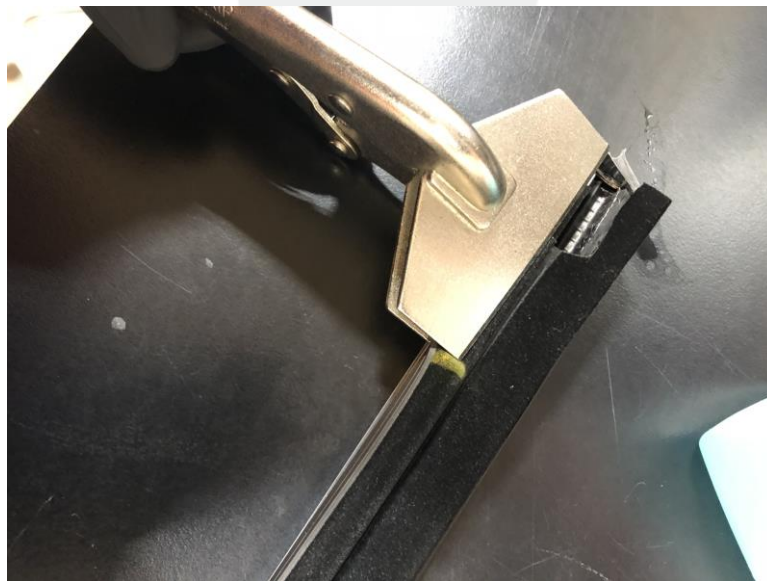


Figure 2

- Using a spray bottle, apply approximately 7 pumps of soapy water in the short stuffer at the rear end (Figure 1) of the front door outer belt seal (Figure 3).


 **NOTE:** Combine Miracle Bubbles and water to create the soapy water solution.



Figure 3

- Insert and wedge the tip of a shop air blowgun in the short stuffer opening (Figure 4).



Figure 4

- Loosely wrap a shop towel around the blowgun tip to catch fluid blowback when the next step is performed (Figure 5).



Figure 5

- While carefully blowing shop air into the short stuffer, pull on the blowgun to remove the stuffer from the outer belt seal.

⚠ WARNING: Wear proper personal protective equipment (PPE), such as eye protection, while using the blowgun.

⚠ CAUTION: Do not apply maximum air pressure to the stuffer, as this might damage the outer belt seal. Carefully modulate the blowgun trigger until the stuffer can be removed.

- Remove the stuffer from the blowgun.
- Remove the clamp from the outer belt seal.
- Carefully clamp the rear end (Figure 1) of the outer belt seal so that an airtight seal is formed (Figure 6).



Figure 6

- Repeat steps 4-9 on the long stuffer located at the front end (Figure 1) of the outer belt seal.
- Remove any excess fluid from the outer belt seal with a clean shop towel.

13. Install the front door outer belt seal (refer to Service Manual procedure 11703002).
14. Cycle the affected door glass up and down to verify window functionality.
15. Perform steps 2–14 on the RH front door outer belt seal.
16. Perform a highway road test at the maximum legal speed limit of the region where this repair is being performed. During testing, verify that the reworked front door glass closes properly and does not exhibit excess wind noise.
 - If the reworked front glass does not close properly, or if excess wind noise is observed from the reworked front glass, perform an adjustment on the affected front door glass (refer to Service Manual procedure 11500100).
 - If the reworked front glass closes properly and does not exhibit excess wind noise, end this procedure.

