



# Secure Triple Camera Windshield Bracket

<b>Classification</b>	Campaign Bulletin	<b>Section/Group</b>	15 - Interior Trim	<b>Country/Region</b>	Asia Pacific, Europe
<b>Year</b>	2019	<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.*

*This Service Document supersedes SB-19-15-002, dated 12-Jun-2019. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.*

## Condition

Some Model 3 vehicles were manufactured with triple camera windshield brackets that were not properly secured to the windshield. Autopilot is designed to deactivate if errors occur, but as a precaution, Autopilot features have been disabled on all suspect vehicles until this bulletin has been performed.

## Correction

Inspect the vehicle for the symptom related to the condition. If the symptom is present, secure the triple camera windshield bracket to the windshield, calibrate the cameras, and re-enable Autopilot features. If the symptom is not present, re-enable Autopilot features.

Correction Description	Correction	Time
SB-19-15-002 Not Applicable	S011915002	0.00
Inspect Vehicle, Triple Camera Windshield Bracket Is Secure	S021915002	0.05
Inspect Vehicle, Secure Triple Camera Windshield Bracket	S031915002	0.40

<b>Special Tool(s):</b>	1053066-00-A 1448868-00-A 1080593-00-A	CALIBRATION STAND, DRIVER ASSIST CAMERA WRENCH, 2.5MM, THIN TOOL, CAULKING & ADHESIVE GUN, M18 (or similar)
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## Procedure

1. Carefully pull on the rear view mirror with approximately 10 lbs (4.5 kg) of force in the directions illustrated (Figure 1): up/down, left/right forward/backward.
  - If any looseness or excessive movement is detected, continue to the next step.
  - If the rear view mirror feels secure, go to Toolbox Article [52599](#), follow the instructions in the “Steps to fix” section, and then discontinue this procedure.

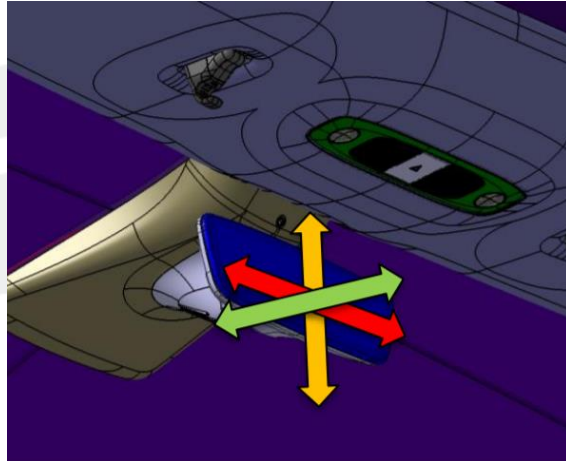


Figure 1

2. Remove the forward facing camera (refer to Service Manual procedure [17231002](#)).
3. Remove the GPS antenna (refer to Service Manual procedure [21320102](#)).
4. Photograph the relative humidity and temperature sensor PCBA label (Figure 2) and the windshield logomark (Figure 3), and then upload the photos to the Repair Order.

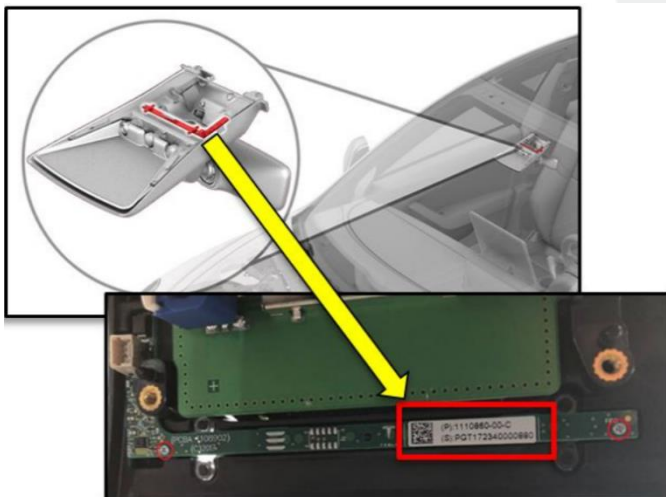
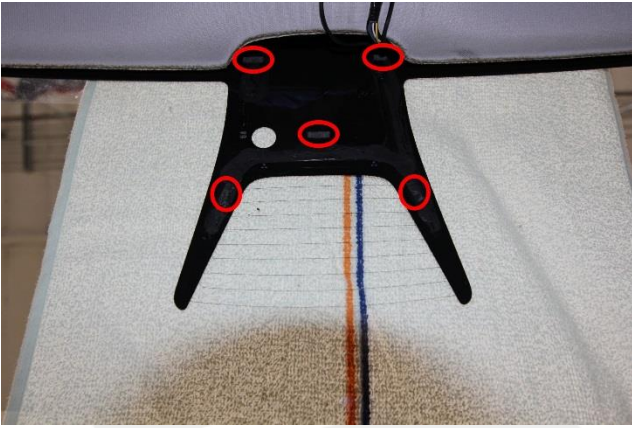


Figure 2

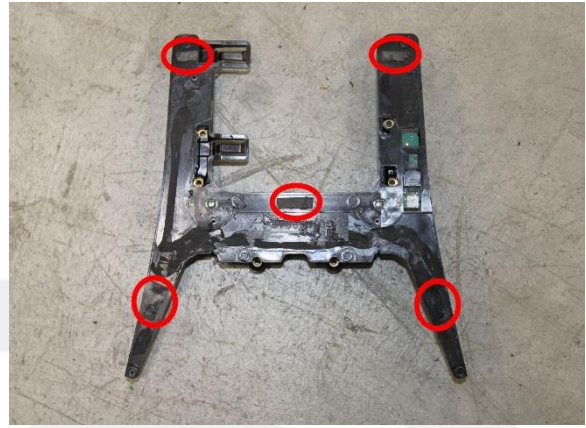


Figure 3

- Carefully remove the triple camera windshield bracket from the vehicle, and then remove the double sided tape (x5 strips) from the bracket and/or the windshield (Figures 3 and 4).

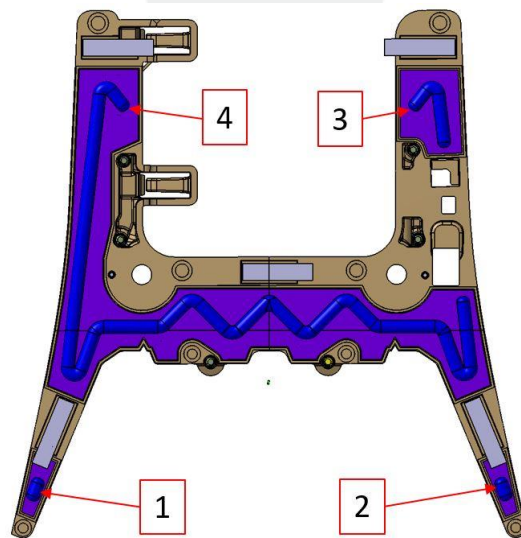


**Figure 3 (Possible tape locations on windshield)**



**Figure 4 (Possible tape locations on camera bracket)**

- Clean the triple camera windshield bracket and windshield mounting surfaces with IPA wipes. Allow the IPA to dry for at least 1 minute.
- Load urethane into a caulking gun, and then cut a 2 mm diameter tip on the urethane applicator.
- Apply urethane to the triple camera windshield bracket, following the 4 urethane application paths (in blue) as illustrated (Figure 5).



**Figure 5**

- Carefully position the triple camera windshield bracket on the windshield, aligning the triangle-shaped reference points with the angled cutouts on the bracket (Figure 6).



**Figure 6**

- Firmly press the triple camera windshield bracket onto the windshield, ensuring the reference points are still aligned with the cutouts (Figure 5).
- Tape the bracket to the windshield (Figure 7) and allow the urethane to dry for at least 3 hours.



**Figure 7**

- After at least 3 hours have elapsed, carefully remove the tape from the bracket and windshield.
- Use IPA and a razor blade (if necessary) to remove any urethane that has leaked out of the bracket.

14. Use glass cleaner to clean the camera viewing area on the windshield (Figure 8).



**Figure 8**

15. Install the GPS antenna (refer to Service Manual procedure [21320102](#)).
16. Install the forward facing camera (refer to Service Manual procedure [17231002](#)).
17. Install the upper quad camera cover (refer to Service Manual procedure [15051802](#)).
18. Install the rear view mirror (refer to Service Manual procedure [15050202](#)).

**NOTE:** Support the bracket assembly with one hand while screwing the mirror on with the other hand.

19. Calibrate the forward facing camera (refer to Service Manual procedure [17230600](#)).
20. Install the lower quad camera cover (refer to Service Manual procedure [15050902](#)).
21. Go to Toolbox Article [52599](#), follow the instructions in the “Steps to fix” section, and then end this procedure.

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**Affected VIN(s)** Affected Asia Pacific and Europe Model 3 vehicles built between approximately January 25, 2019 and January 26, 2019.

**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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