



Repair Model S and Model X Rear Node to Subframe Mounting Area Damage

Classification	Repair Bulletin	Section/Group	30 - Chassis	Country/Region	All
Year	2018	Model	Model S and Model X	Version	All

Bulletin Classification: This repair bulletin provides instructions and guidelines for a noted condition or a customer concern. The information provided can address a broad range of known or perceived issues with the operation of Tesla vehicles. This bulletin might not be VIN-specific. 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

The rear node of some Model S and Model X vehicles might have damage in the forward mounting location of the rear subframe, resulting in noise, vibration, or harshness coming from that location.

Correction

Inspect the vehicle for the condition described. If the condition is present, add a repair plate to the damaged subframe mounting area and add spacer plates to undamaged subframe mounting areas of the rear node.

Correction Description	Correction	Time
SB-19-30-001 Not Applicable	S011930001	0.0
Inspect Rear Subframe Forward Mounting Area of Rear Node, Model S	S021930001	0.9
Install Front and Rear Spacer Plates in Rear Subframe Forward Mounting Area of Rear Node, Model S	S031930001	3.9
Install Repair Plate and Spacer Plates in Rear Subframe Forward Mounting Area of Rear Node, Model S	S041930001	4.9
Inspect Rear Subframe Forward Mounting Area of Rear Node, Model X	S051930001	1.1
Install Front and Rear Spacer Plates in Rear Subframe Forward Mounting Area of Rear Node, Model X	S061930001	4.1
Install Repair Plate and Spacer Plates in Rear Subframe Forward Mounting Area of Rear Node, Model X	S071930001	5.1

Repair Process Overview

When the vehicle is brought into a Tesla Service Center, the Service Center:

- Creates a Repair Order using the "Inspect Rear Subframe Forward Mounting Area" correction code (S021930001 for Model S vehicles or S051930001 for Model X vehicles).

2. Inspects the vehicle and submit the findings to Tesla Body Repair Technical Support for evaluation and guidance. (See "Inspection Procedure" for more information.)
 - If repairs are required, the Tesla Service Center will transfer the vehicle to a Tesla Approved Body Shop or a Tesla Body Shop, along with the repair instructions received from Tesla Body Repair Technical Support.
 - The body shop will then repair the vehicle and return it to the customer or to the Tesla Service Center.
3. Completes the Repair Order using the appropriate correction code (S031930001 or S041930001 for Model S vehicles or S061930001 or S071930001 for Model X vehicles).

Inspection Procedure

1. Remove the rear subframe assembly to expose the subframe attachment points (refer to Service Manual procedure 30010201).

NOTE: Do not discard the bolts that secure the subframe to the rear node at this time.

2. Inspect the forward subframe attachment points to both rear nodes (Figure 1 and Figure 2):

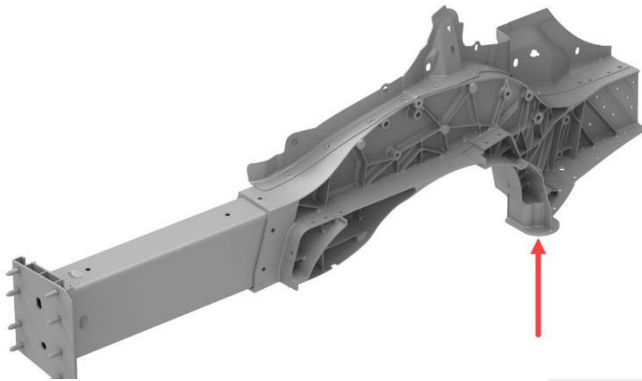


Figure 1 Model S Rear Node

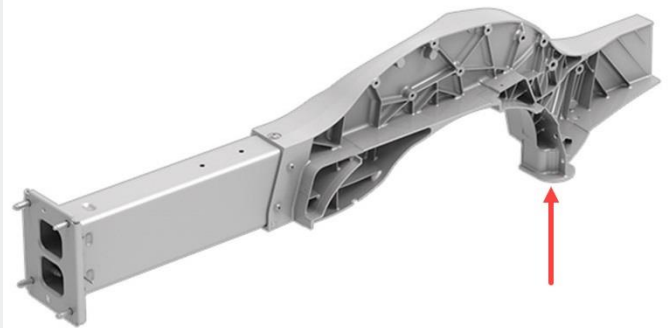


Figure 2 Model X Rear Node

- If no damage is present on the forward subframe attachment points on the LH or RH rear nodes, no repair is required. Discontinue this procedure and install the rear subframe assembly (refer to Service Manual procedure 30010201).
 - If damage is present, continue to the next step.
3. Measure the damaged area:
 - a. Measure the length and the width of the damaged area on the bottom face of the node (Figure 3).

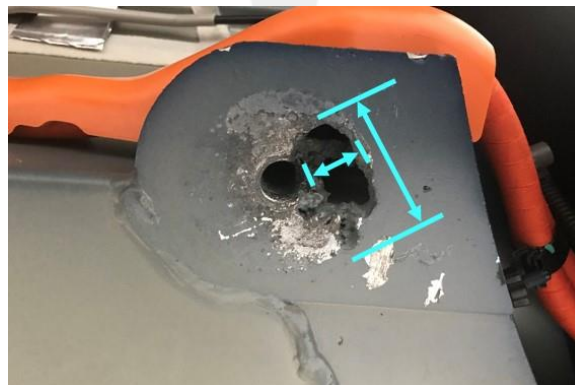


Figure 3

- b. Measure the distance between the edge of the subframe mounting bolt hole closest to the damaged area (① in Figure 4) and the edge of the damaged area (② in Figure 4).

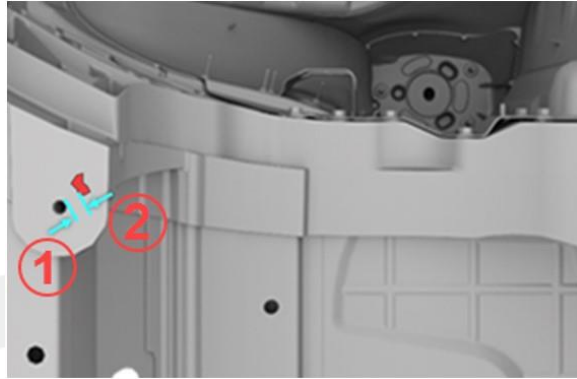


Figure 4

4. Take photographs that clearly show all damage to the subframe mounting area of the rear node.
5. Provide data and images of the damaged areas to Tesla Body Repair Technical Support for final repair guidance:
 - a. Using Warp, create a concern with the following:
 - **Type:** Service
 - **Symptom:** Body Shop Repair Process
 - b. For this concern, set the **Assign to Service Center** to “Tesla Body Repair Technical Support”
 - c. Attach the pictures of the damaged area.
 - d. Add notes with the measurements and any other relevant information.
 - e. Submit the concern and wait for guidance from Tesla Body Repair Technical.
6. Send an email to Bodyrepair@tesla.com:
 - **Subject line should contain:** The WARP reference number.
 - **Email body should contain:** The VIN, the WARP reference number, and all measurements of the damage.
 - **Attach to the email:** Photos showing rear node damage.
7. Install the rear subframe assembly (refer to Service Manual procedure 30010201).
8. Prepare to transfer the vehicle to the body shop for repair.

Affected VIN(s) Affected Model S and Model X vehicles built between June 15 and September 11, 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.

For feedback on the accuracy of this document, email ServiceBulletinFeedback@tesla.com.