Tesla, Inc. Service Bulletin		*Adjust Overflush Charge Port Door*
SB-20-10-001 June 9, 2020		

Classification	Section/Group	Mobile Service
Repair Bulletin	10 - Body	Can Perform (where permitted)

Model Year	Model	Country/Region	Version
All	Model 3, Model Y	All	All

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.

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 3 and Model Y vehicles might have a charge port door that is overflush (protrudes in comparison) to the LH taillight assembly.

Correction

Upon customer complaint, inspect the vehicle for symptoms related to the condition. If symptoms are present, adjust the charge port sheet metal to reduce the overflush.

Correction Description	Correction	Time
SB-20-10-001 Not Applicable	S012010001	0.00
Inspect For Overflush; No Adjustment Required	S022010001	0.05
Inspect For Overflush And Adjust Charge Port Sheet Metal	S032010001	0.70
Inspect For Overflush, Adjust Charge Port Sheet Metal, And Install New Charge Port Door	S042010001	0.70

	Part Number	Description	Quantity
Parts Required	1453382-00-A	M3 BODYSIDE LAMP CONNECTOR GASKET	1
	1453381-00-A	M3 BODYSIDE LAMP T-STUD GASKET	2
	1117252-00-A	BOLT,HF,M12x40,STL[109],ZN,ADH,MAT	1
	1111033-00-E	BRACKET - PLASTIC	1
If Necessary, One of the Following		**For Model Y:**	
	1505513-00-A	CHARGE PORT DOOR, MY, NA	1
		For Model 3:	
	1084854-00-G	CHARGE PORT DOOR,TOP ASY,GEN3,M3,NA (North America, Japan, Taiwan, South Korea)	1
	1446051-99-E	CHARGE PORT DOOR,TOP ASY,GEN3,M3,ECE (EMEA, Australia, Hong Kong)	1
	1451453-00-C	CHARGE PORT DOOR,TOP ASY,GEN3,M3,GB (China)	1

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Catalog.

Special Tools	1536089-00-A or 1061138-00-A	PDR Knockdown, Chargeport HV Battery Handle
Shop Supplies	Masking tape Touch-up paint	

Paint pen

Procedure

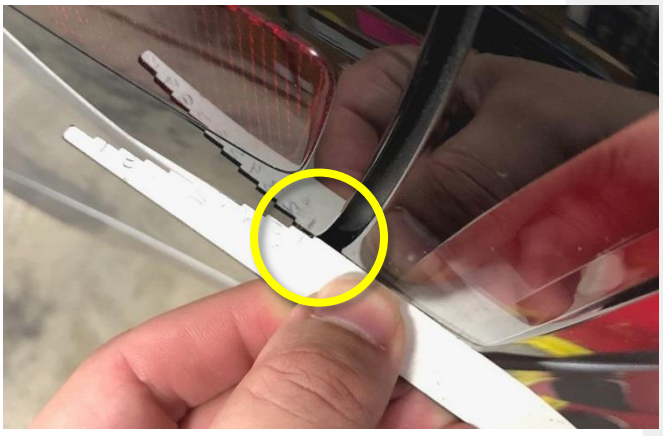
1. Use a gap and flush tool to check the overflush between the charge port door and the LH taillight.

   NOTE: Record the overflush at the top and bottom (Figure 1) of the line between the charge port door and the LH taillight. Overflush in the middle is not considered, as it is not adjustable.

Figure 1 – Overflush check locations

2. If the overflush at:

   - Both the top and bottom is 1.5 mm or less (Figure 2), the overflush is within specification. Discontinue this procedure.
   - Either the top or bottom is greater than 1.5 mm (Figure 3), continue to the next step.



✓**Figure 2 – Overflush 1.5 mm or less**

✗**Figure 3 – Overflush greater than 1.5 mm**

3. Remove the charge port door assembly (refer to Service Manual procedure 44011502 - NA, 44015302 - EMEA, 44014302- China).

4. Lay a straight edge so that it touches the front corner, the tip of the weld tab at the midpoint, and the rear upper corner where the charge port assembly installs in the rear quarter (Figure 4).

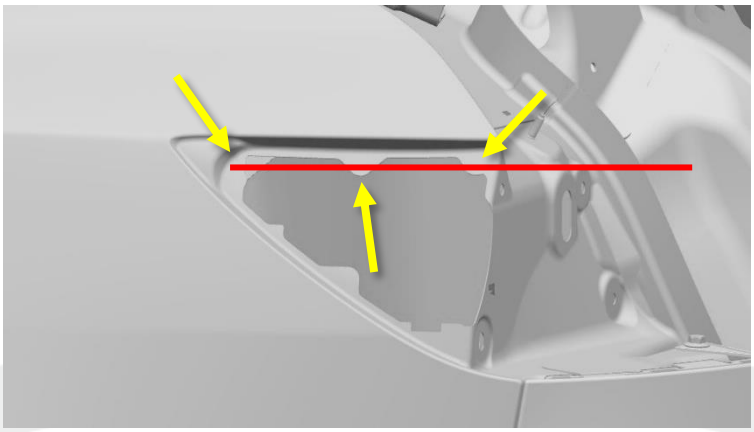


Figure 4

5. Gently but firmly press the tip of the weld tab into the body so that when released, the straight edge touches both the front corner and rear upper corner at the same time.

   CAUTION: Do not bend the weld tab in so much that it will contact the HV connector of the charge port upon assembly.

6. Apply tape to the upper and lower rear corners where the charge port door assembly mounts (Figure 5).

Figure 5 – Tape corners

7. Use the PDR charge port knockdown kit (if available) or a dead blow hammer and HV battery handle to adjust the sheet metal where the overflush is greater than 1.5 mm.

   NOTE: If the PDR charge port knockdown kit is available, use the large diameter flat head attachment and the included hammer.

CAUTION: Do not adjust where the overflush is 1.5 mm or less.

8. Carefully and firmly tap 3 times at the locations where adjustment is necessary (Figures 6 and 7).

NOTE: Try to minimize paint damage at the tap points. Use firm taps, not hard blows.

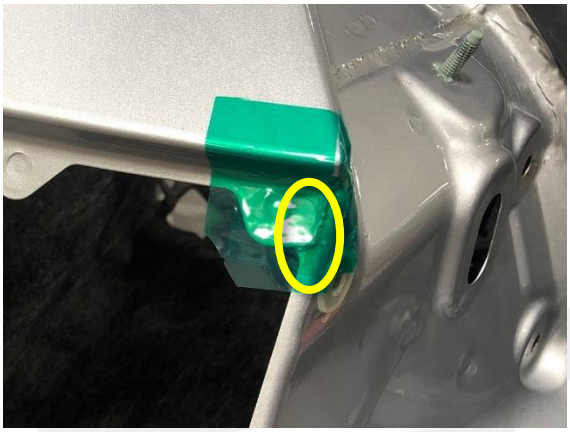


Figure 6 – Upper tap locations

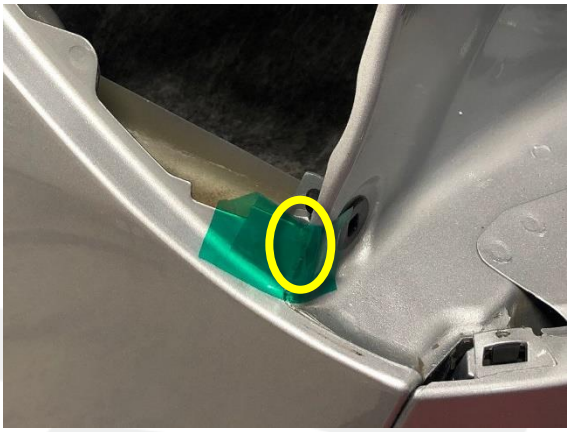


Figure 7 – Lower tap locations

9. Temporarily fit the charge port door assembly and LH taillight to the body, and measure the overflush again.

NOTE: Do not install new gaskets onto the taillight at this time.

- If a location previously overflush greater than 1.5 mm is now 1.5 mm or less, the adjustment for that location is complete.
- If a location previously overflush greater than 1.5 mm location is still greater than 1.5 mm, continue to adjust that location.

10. Remove the charge port door assembly and the LH taillight.

11. Repeat steps 8 through 10 until both locations are overflush 1.5 mm or less.

NOTE: The adjustment is an iterative and learning process that might require steps 8 through 10 to be repeated with additional force to correct the condition.

NOTE: If steps 8 through 10 have been repeated 3 times and a location is still greater than 1.5 mm overflush, replace the charge port door assembly. Continue to step 12.

12. Remove the tape from the upper and lower rear corners, and use an IPA wipe to clean any paint that might have been damaged by the adjustment (Figures 8 and 9).

Figure 8 – Upper corner

Figure 9 – Lower corner

13. If necessary, apply touch up paint to damaged areas, and allow at least 5 minutes to dry.

14. Install the charge port door assembly (refer to Service Manual procedure 44011502 –NA, 44015302 - EMEA, 44014302- China).

NOTE: If it was not possible to adjust a location overflush to 1.5 mm or less, install a new charge port door assembly.

NOTE: Install new gaskets onto the taillight now.