		Tesla, Inc. Service Bulletin	<i>Inspect Outer Rear Quarter Panel Body Joint Sealant For Trunk Water Ingress</i>	
SB-21-11-001 January 22, 2021				
Classification		Section/Group	Mobile Service	
Campaign Bulletin		11 - Closures	Cannot Perform	
Model Year	Model	Country/Region	Version	
2020	Model 3	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>				

Campaign Bulletin: 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 list.

Condition


On some Model 3 vehicles, the body joint sealant on the outer rear quarter panels are missing or were not properly applied, causing water ingress to the trunk compartment.

Correction

Inspect the vehicle for symptoms related to the condition. If symptoms are present, apply new sealant to the affected area(s).

Correction Description	Correction	Time
SB-21-11-001 Not Applicable	S012111001	0.00
Inspect Outer Rear Quarter Panel Body Joint Sealant; No Repair Needed	S022111001	0.05
Inspect Outer Rear Quarter Panel Body Joint Sealant; Apply Sealant To LH Side Only (No Repair Needed On RH Side)	S032111001	0.15
Inspect Outer Rear Quarter Panel Body Joint Sealant; Apply Sealant To RH Side Only (No Repair Needed On LH Side)	S042111001	0.15
Inspect Outer Rear Quarter Panel Body Joint Sealant; Apply Sealant To Both LH And RH Sides	S052111001	0.20

Part Number	Description	Quantity
Parts Required (If Necessary)		
Use one of the following:		
1460201-00-A	ADHESIVE, LOCTITE 5910, SI	As Needed
1589861-00-A	LOCTITE 5900, GEN 3 CHARGER SEALANT 190 ml	As Needed
1031090-02-A	3M Drip-Chek Sealer	As Needed
	* Permatex Clear RTV Sealant	As Needed
	* LOCTITE SI 595 CL (Clear RTV Silicone Adhesive Sealant)	As Needed
	* Source using Procurement tool or locally	

 **NOTE:** One tube of sealant can typically be used for multiple vehicles.

If none of the sealants listed above are available, source a sealant using the following criteria:

- Non-corrosive, water resistant, and 120% to 140% elongation at rupture/break
- Promotes adhesion for a variety of surfaces and bonds to dissimilar materials
- Material: RTV, silicone, or polyurethane
- Color: Clear (ideal for precise and neat application)
- Can withstand a temperature range of at least -50°F to 150°F / -45°C to 65°C

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

Shop Supplies Blow Gun
Caulk And Adhesive Gun
Bone Tool

Procedure

1. Remove the trunk garnish (refer to Service Manual procedure [15111102](#)).
2. Remove the trunk sill trim (refer to Service Manual procedure [15244802](#)).
3. Move the LH quarter glass seal aside (Figure 1), and then insert a trim tool between the body and quarter glass for access (Figure 2).



Figure 1



Figure 2

4. Visually inspect the area between the body panels under the seal lip (Figure 3).



Figure 3

- If there is no visible gap, continue to the next step.
- If there is a visible gap, skip to step 6.

5. Apply a small amount of soapy water to the body joint sealant area, and then blow the area with shop air (Figures 4 and 5).

⚠ WARNING: To reduce the risk of personal injury, use appropriate eye protection while performing this step.

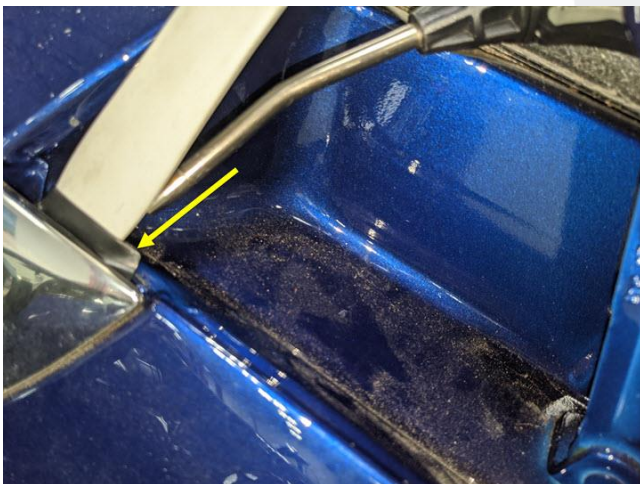


Figure 4

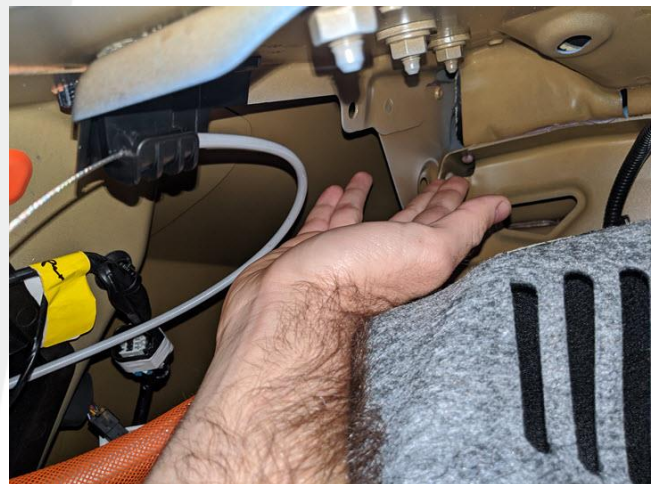


Figure 5

- If a leak is detected, continue to the next step.
- If no leak is detected, repeat from step 3 for the RH side of the vehicle.
- If no leak is detected on the LH and RH sides of the vehicle, skip to step 11.

6. Prepare a caulking gun and sealant.


 **NOTE:** The applicator tip should have an opening 2 mm wide (Figure 6).



Figure 6

7. Using the lowest speed setting on the caulking gun, apply sealant to the gap between the body panels (Figure 7).

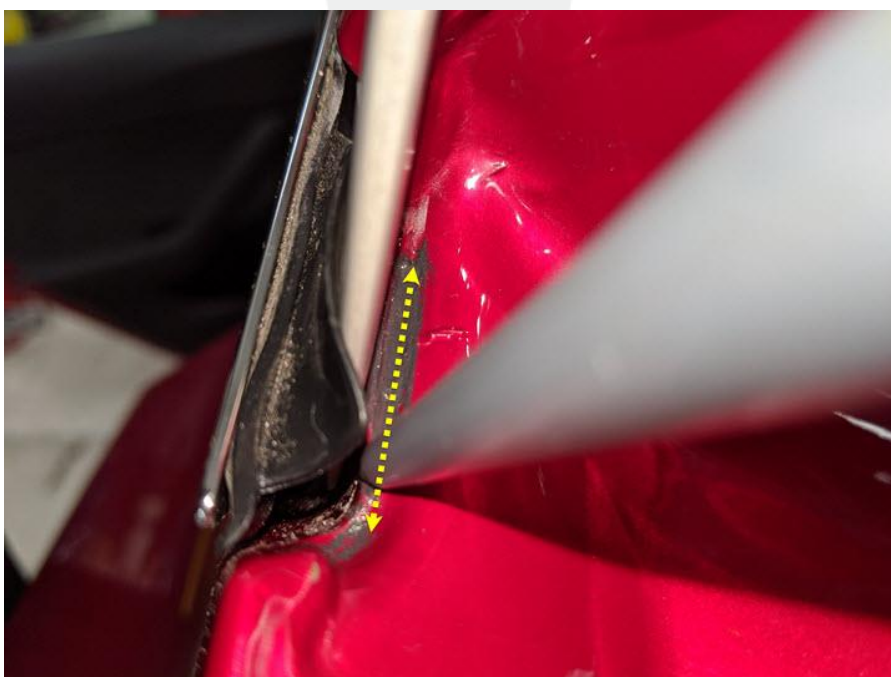


Figure 7


8. Flatten the bead of the sealant (Figure 8) and remove any excess sealant from the surrounding area.



Figure 8

9. Repeat step 3 through step 8 for the RH side of the vehicle.

10. Allow the sealant to dry for at least 30 minutes.

 **NOTE:** Refer to the body sealant label for work time and full cure time. Chemicals may vary by region.

11. Install the trunk sill trim (refer to Service Manual procedure [15245302](#)).

12. Install the trunk garnish (refer to Service Manual procedure [15111102](#)).