



Loose C-Pillar Brightwork

Classification	Repair Bulletin	Section/Group	12 - Exterior Fittings	Country/Region	All
Year	2013-2014	Model	Model S	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 electricity repairs, and should only be executed by trained professionals. Tesla Motors 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 Model S body side brightwork might become loose near the C-pillar on either side of the vehicle, causing a perceived quality issue (Figure 1).



Figure 1

Correction

Upon customer complaint of the body side brightwork becoming loose near the C-pillar, remove the body side brightwork, clean the window encapsulation and apply adhesives, then reinstall and clamp the body side brightwork.

Required Part(s):	Part Number	Description	Quantity
	1039307-00-A	ASY-BRIGHT MOLDING - BODY SIDE – LH	0 or 1
	1039308-00-A	ASY-BRIGHT MOLDING - BODY SIDE – RH	0 or 1
	1028377-00-A	LOCTITE 5510, CLEAR - SERVICE	As required
	1011954-00-B	PRIMER - DOW BETASEAL 43555	As required
	1048645-00-A	DOW BETASEAL EXPRESS - 310ML CARTRIDGE	As required

Shop supplies:

Alcohol wipes

Rotary multi-tool or cordless drill with rubber wheel attachment

3M Acrylic Plus Tape PT1500 or equivalent

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

Special Tool(s): Molding hold down tool

Correction Description	Correction	Time
Vehicle Inspection Only; C-Pillar Brightwork Not Loose	S011412005	0.1
Reattach Brightwork to the C-Pillar on LH Side of Vehicle	S021412005	0.8
Reattach Brightwork to the C-Pillar on RH Side of Vehicle	S031412005	0.8
Reattach Brightwork to the C-Pillar on LH/RH Sides of Vehicle	S041412005	1.6

Procedure

1. Remove the body side brightwork (refer to Service Manual procedure 12200502).

NOTE: Replace any plastic clips that might have been damaged.

2. Apply protective tape around the rear quarter window encapsulation to prevent it from being damaged in later steps (Figure 2).

NOTE: Subsequent images have the protective tape removed for clarity. Do not remove the protective tape until instructed.

3. Remove any adhesive residue from the rear quarter window encapsulation using an adhesive-removal rubber wheel on a rotary multi-tool or cordless drill (Figure 2).

⚠ WARNING: Wear protective eyewear and hearing protection when using a rotary multi-tool or drill.

⚠ CAUTION: Ensure that the rotary multi-tool or cordless drill is on the lowest speed setting while removing the adhesive residue.



Figure 2 (Window encapsulation highlighted)

4. Clean the rear quarter window encapsulation with alcohol wipes.

NOTE: Ensure that there is no adhesive on the window encapsulation and that the alcohol is dry before continuing to the next step.

5. Apply a thin layer of Betaseal 43555 Body Primer to the window encapsulation (Figure 3).

NOTE: The following image does not depict how the body primer arrives at Service Centers.



Figure 3

6. Allow the body primer to dry for approximately 1 minute before continuing to the next step.

7. Apply 3M Acrylic Plus Tape PT1500 or equivalent double-sided tape all along the top of the window encapsulation and a 25 mm strip of double-sided tape to the front bottom of the window encapsulation (Figure 4).



Figure 4 (Double-sided tape highlighted)

8. Apply Dow Betaseal Express adhesive to the bottom of the window encapsulation (Figure 5).

NOTE: Do not apply adhesive over the double-sided tape.

⚠ CAUTION: Avoid applying too much adhesive to prevent it from squeezing out once the brightwork is applied.



Figure 5 (Adhesive highlighted)

9. Apply a consistent layer of clear Loctite 5510 in the gap above the window encapsulation (Figure 6).



Figure 6

10. Apply a thin layer of Betaseal 43555 Body Primer to the rear inboard portion of the brightwork that adheres to the window encapsulation (Figure 7).



Figure 7 (Affected area highlighted in yellow)

11. Remove the protective tape from around the rear quarter window encapsulation.

12. Reinstall the body side brightwork.

⚠ CAUTION: When reinstalling the brightwork, loosely install the forward most screw to support the brightwork then install the other 11 screws starting from the rear of the vehicle and moving forward.

⚠ CAUTION: Do not damage the vehicle's paint when handling the brightwork.

13. Use the molding hold down tool to clamp the front, bottom portion of the brightwork into place. Apply tape as necessary to provide additional pressure on the brightwork while it cures (Figure 8).

⚠ CAUTION: Do not tighten the molding hold down tool enough to damage the brightwork. The clamp should only be tight enough to make the brightwork flush to the door belt molding.



Figure 8 (Tape highlighted)

14. Allow the adhesive to cure for a minimum of 2 hours before continuing to the next step.

NOTE: Take this time to inspect the other side of the vehicle for the body side brightwork becoming loose near the C-pillar. If the body side brightwork is becoming loose, repeat this procedure.

15. Remove the molding hold down tool and tape.

Affected VIN(s) Affected Model S vehicles built between approximately December 18, 2013 and July 14, 2014.

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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