



Replace Aeroshield Support Tab, HV Battery 2.0

Classification	Repair Bulletin	Section/Group	16 - Battery System	Country/Region	All
Year	All	Model	Model S, Model X	Version	HV Battery 2.0

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.

This Service Bulletin supersedes SB-15-16-003, dated 6-Nov-15. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.

Condition

It is possible to accidentally break off the aeroshield support tab from the HV Battery (Figure 1). If the tab breaks, the mid aeroshield is not fully supported, reducing the aerodynamic efficiency of the vehicle. The operation of the HV Battery is not affected.

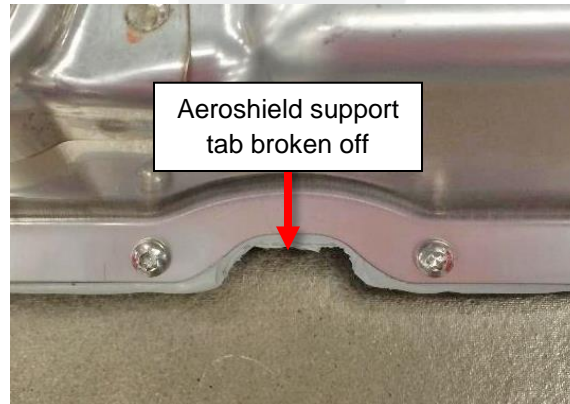


Figure 1

Correction

Replace the aeroshield support tab.

NOTE: This procedure applies only to HV Battery 2.0 (Figure 2). Refer to SB-15-16-002 for HV Battery 1.0 and 1.5 (Figure 3).

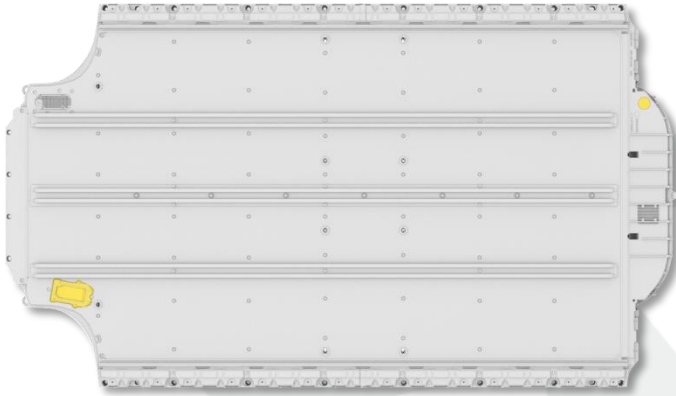


Figure 2 (Underside of HV Battery 2.0; fuse cover and discharge port highlighted)

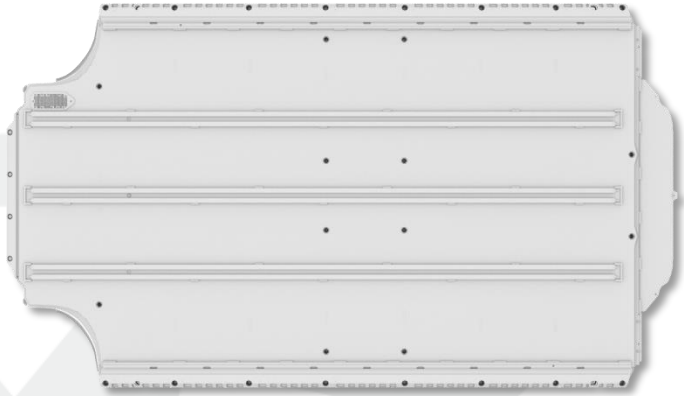


Figure 3 (Underside of HV Battery 1.0/1.5; no fuse cover or discharge port)

Correction Description	Correction	Time
SB-15-16-003 Not Applicable	S011516003	0.0
Replace Aeroshield Support Tab, HV Battery 2.0	S021516003	1.0

Required Part(s):	Part Number	Description	Quantity
	1032871-01-B	AEROSHIELD SUPPORT TAB - 2.0 ENCLOSURE – SERVICE	1
	1060381-00-A	If fastener threads were not stripped: SCREW, M5x10, PAN, TRX, SS, TAP	2
	1064644-00-A	If fastener threads were stripped: SCREW, PN, M6x10, TAPTITE, SS	2
Shop supplies:			
Alcohol wipes			
ThreeBond 1216E Silicone Sealant			
M6 tap (if necessary)			
Paint pen			
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):	1038478-00-A	ASY,COVER,HV RAPID,HVBAT,MDLS	
	1028325-00-A	ASY,COVER,LV RAPID,HVBAT,MDLS	
	1005706-00-C	COVER,PORTS,BATT,COOLANT CX	

Procedure

⚠ WARNING: Only technicians who have been trained in High Voltage Awareness are permitted to perform this procedure. Proper personal protective equipment (PPE) and insulating HV gloves with a minimum rating of class 00 (500V) must be worn any time a high voltage cable is handled. Refer to service bulletin TN-15-92-003, “High Voltage Awareness Care Points” for additional safety information.

1. Remove the HV Battery (refer to Service Manual procedure 16010101).
2. Cover the HV Battery connectors:
 - HV connector with an HV Rapid Mate cover, Tesla P/N 1038478-00-A.
 - Low voltage (LV) connector with a LV Rapid Mate cover, Tesla P/N 1028325-00-A.
 - Coolant connector with a Coolant Rapid Mate cover, Tesla P/N 1005706-00-C.

NOTE: If any of these covers are not available, cover the connector with masking tape.

3. Remove and discard the 2 screws that secure the broken aeroshield support tab to the HV Battery (Figure 4).

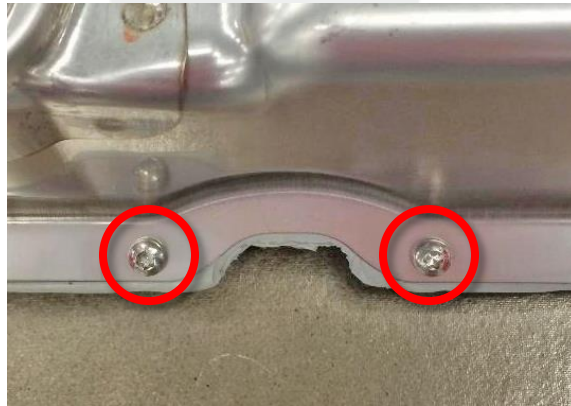


Figure 4

4. Remove the broken aeroshield support tab and discard.

5. Clean the HV Battery with alcohol wipes in the area shown (Figure 5). Allow the alcohol to dry before continuing this procedure.

⚠ CAUTION: Do not use anything other than isopropyl alcohol (IPA) to clean the HV battery enclosure. Using other chemicals, such as brake cleaner, might corrode the coating on the HV battery enclosure.



Figure 5

6. Clean the new aeroshield support tab with alcohol wipes. Allow the alcohol to dry before continuing this procedure.
7. Apply a bead of ThreeBond 1216E Silicone Sealant along the bottom of the new aeroshield support tab (Figure 6).



Figure 6

- Place the new aeroshield support tab in place and install 2 new screws to secure it to the HV Battery (torque 4.5 Nm) (Figure 7). Mark each fastener with a paint pen as it is torqued.

NOTE: If the threads were stripped, use an M6 tap to create new threads.

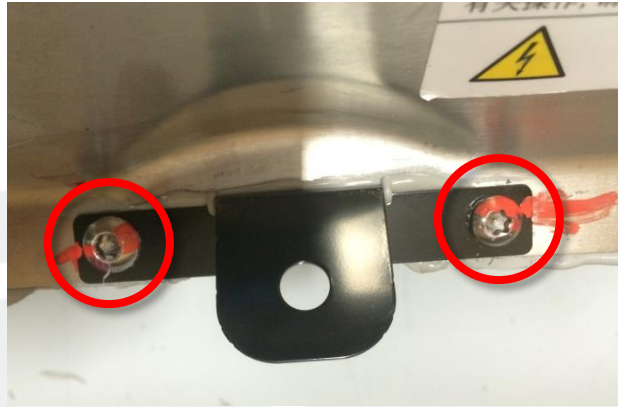


Figure 7

- Remove any excess sealant that squeezed out from under the aeroshield support tab.
- Reinstall the HV Battery (refer to Service Manual procedure 16010101).

Affected VIN(s) All affected vehicles with HV Battery 2.0.

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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