



Apply Threadlocker to 2nd Row Seat Fasteners

Classification	Campaign Bulletin	Section/Group	13 - Seats	Country/Region	United States
Year	2016	Model	Model X	Version	All

Bulletin Classification: *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 range listed. These instructions assume knowledge of motor vehicle and high voltage electrical component 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.*

This Service Bulletin supersedes SB-15-13-003 R1, dated 27-May-16. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.

Condition

The 2nd row seat pitch pivot bolts, shoulder pivot bolts, and pitch mechanism nuts could loosen over time, causing the 2nd row seats to have excessive play or a rocking movement.

Correction

Install new shoulder pivot bolts. Apply threadlocker on the pitch pivot bolts and pitch mechanism nuts, and apply jam nuts, if required.

Correction Description	Correction	Time
Obsolete Correction Codes – Do not use.	S011513003 S151513003	0.00
Install 2 nd Row Seat Shoulder Pivot Bolts (Without Center 2 nd Row Seat)	S161513003	0.20
Install 2 nd Row Seat Shoulder Pivot Bolts (With Center 2 nd Row Seat)	S171513003	0.30
Install 2 nd Row Seat Jam Nuts And Install 2 nd Row Seat Shoulder Pivot Bolts (Without Center 2 nd Row Seat)	S181513003	0.40
Install 2 nd Row Seat Jam Nuts And Install 2 nd Row Seat Shoulder Pivot Bolts (With Center 2 nd Row Seat)	S191513003	0.55
Install 2 nd Row Seat Shoulder Pivot Bolts And Apply Threadlocker on 2 nd Row Seat Pitch Mechanism Nuts (Without Center 2 nd Row Seat)	S201513003	0.30
Install 2 nd Row Seat Shoulder Pivot Bolts And Apply Threadlocker on 2 nd Row Seat Pitch Mechanism Nuts (With Center 2 nd Row Seat)	S211513003	0.50
Install 2 nd Row Seat Jam Nuts, Install 2 nd Row Seat Shoulder Pivot Bolts, And Apply Threadlocker on 2 nd Row Seat Pitch Mechanism Nuts (Without Center 2 nd Row Seat)	S221513003	0.50
Install 2 nd Row Seat Jam Nuts, Install 2 nd Row Seat Shoulder Pivot Bolts, And Apply Threadlocker on 2 nd Row Seat Pitch Mechanism Nuts (With Center 2 nd Row Seat)	S231513003	0.80

Required Part(s):	Part Number	Description	Quantity
	1069153-00-A	BOLT SHLD TRX LK M1216 PC10.9 CZ	4–6
		If required:	
	1011407-00-B	NUT,HEX,M8x1.25,CL10	2–3

Shop supplies:

Loctite Red Threadlocker 262 (2006353)
Loctite 290 Wicking Grade Threadlocker (2004507)

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):	1077189-00-A	SEAT WRENCH, 13MM
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Pitch Pivot Bolts

1. Connect a laptop with Toolbox to the vehicle.
2. Open the LH and RH rear doors.
3. Using Toolbox, select Seat Install mode.

⚠ CAUTION: The seat post trim clips are fragile.

- Carefully pull outward on the outboard LH seat post trim to release the clips that secure it to the 2nd row seat (Figure 2).



Figure 2 (LH seat post trim highlighted)

- Pull the wiring harnesses out of the cavity in the post.

NOTE: The wiring harnesses do not need to be disconnected.

- Inspect the pitch pivot bolt (Figure 3).

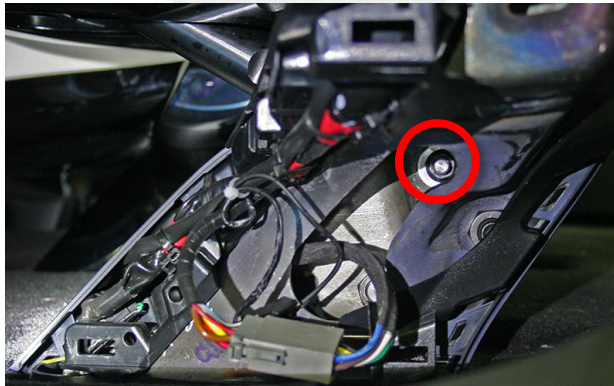
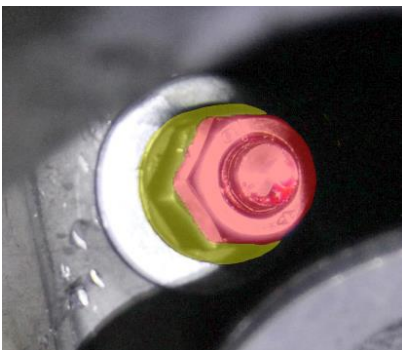


Figure 3

- If there are 2 nuts on the end of the pitch pivot bolt (Figure 4), skip to the “Shoulder Pivot Bolts” section of this procedure.
- If there is 1 weld nut (Figure 5) or 1 standard nut (Figure 6) on the pitch pivot bolt, continue this procedure.



✓ Figure 4 (Nuts highlighted)



✗ Figure 5



✗ Figure 6

7. Pull outward on the RH seat post trim to release the clips that secure it to the 2nd row seat (Figure 7).



Figure 7

8. If there is a weld nut on the pitch pivot bolt, skip to step 12. If there is a standard nut, continue to the next step.
 9. Remove the existing pitch pivot nut.
 10. Apply Loctite 262 threadlocker to the threads of the nut.
- ⚠ CAUTION:** Ensure that the washer is centered on the bolt (Figure 8).
11. Use a wrench to hold the bolt on the RH side of the seat while tightening the nut (torque 15 Nm).



✗ Figure 8 (Washer not centered)

12. Apply Loctite 262 threadlocker to the threads of a new jam nut.

13. Install the jam nut on the end of the bolt next to the existing welded nut or standard nut (torque 40 Nm).
 - If the seat has a weld nut, use a wrench to hold the bolt on the RH side of the seat while tightening the nut.
 - If the seat has a standard nut, use the seat wrench to hold the existing standard nut while tightening the jam nut (Figure 9).



Figure 9

14. Push the wiring harnesses into the cavity.
15. Press the Easy Entry button located on the 2nd row seat LH backrest to move the center and LH 2nd row seats forward.
16. Move the RH 2nd row seat to the rearmost position.
17. Repeat steps 4-14 on the RH 2nd row seat.
18. If the vehicle is equipped with the 2nd row center seat:
 - a. Press the Easy Entry buttons located on the 2nd row LH and RH backrests to move the seats forward.
 - b. Press the Easy Entry button located on the 2nd row LH backrest to move the 2nd row LH and center seats rearward.
 - c. Use the control on the front of the 2nd row center seat to move the seat fully rearward (Figure 10).



Figure 10

- d. Press the Easy Entry button located on the LH backrest to move the LH seat forward enough to access the seat post trim panels on the center seat.
- e. Repeat steps 4-14 on the 2nd row center seat.

Shoulder Pivot Bolts

1. Loosen the LH shoulder pivot bolt on the LH 2nd row seat (Figure 11):



Figure 11

NOTE: Do not remove the LH shoulder pivot bolt at this time.

2. Use a shop cloth to temporarily support the left side of the seat frame (Figure 12).



Figure 12

3. Loosen the RH shoulder pivot bolt on the LH 2nd row seat (Figure 13).

NOTE: Do not remove the bolt at this time.



Figure 13

4. Use another shop cloth to temporarily support the right side of the seat frame.
5. Remove and discard the LH shoulder pivot bolt.
6. Hand tighten a new LH shoulder pivot bolt. Do not fully torque the bolt at this time.
7. Remove and discard the RH shoulder pivot bolt.
8. Tighten the new LH and RH shoulder pivot bolts (torque 55 Nm).
9. Remove the shop cloths from underneath the seat frame.
10. Reinstall the LH and RH seat post trim panels.
11. Press the Easy Entry button located on the 2nd row seat LH backrest to move the center and LH 2nd row seats forward.
12. Move the RH 2nd row seat to the rearmost position.
13. Loosen the RH 2nd row seat LH shoulder pivot bolt. Do not remove the bolt at this time.
14. Repeat steps 2–10 for the RH 2nd row seat shoulder pivot bolts.
15. If the vehicle is equipped with the 2nd row center seat:
 - a. Press the Easy Entry buttons located on the 2nd row LH and RH backrests to move the seats forward.
 - b. Use the control on the front of the 2nd row center seat to move the seat fully rearward (Figure 10).
 - c. Loosen the center 2nd row LH shoulder pivot bolt. Do not remove the bolt at this time.
 - d. Perform steps 2–10 for the 2nd row center seat.

Pitch Mechanism Nuts

1. Move the LH 2nd row seat fully rearward.
2. Recline the LH 2nd row seat fully rearward.
3. Use a pick to release the 2 plastic covers that conceal the screws on the bottom of the seat (Figure 15).

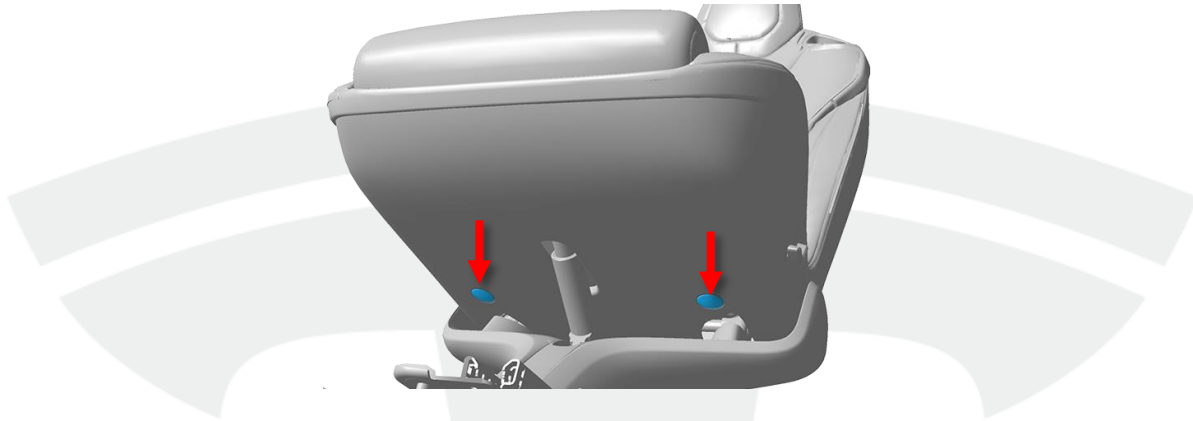


Figure 15

4. Remove the 2 screws that secure the plastic trim to the bottom of the seat frame.
5. Release the 4 clips that secure the plastic trim to the bottom of the seat frame (Figure 16).



Figure 16

6. Tighten the nuts that secure the pitch mechanism to the seat frame (torque 20 Nm) (Figure 17). If the nuts continuously spin, stop this procedure and contact Service Engineering.

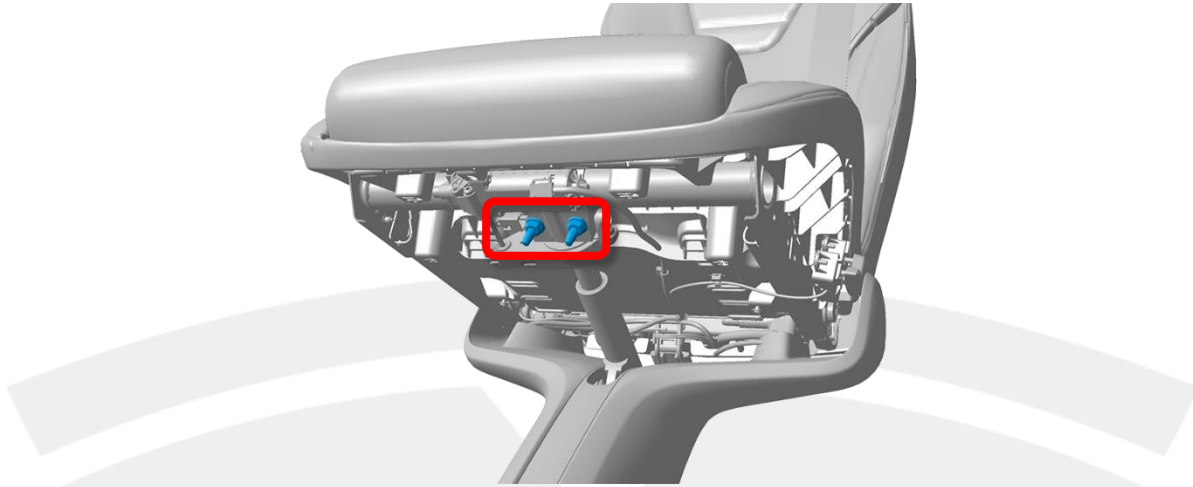


Figure 17

7. Put a shop cloth on the lower trim to catch any excess Loctite that might drip during the next step.
8. Apply Loctite 290 wicking grade threadlocker at the nut-thread interface on the 2 nuts (Figure 18).



Figure 18

9. Remove the shop cloth.
10. Reinstall the lower seat trim.
11. Install the 2 screws that secure the lower seat trim to the bottom of the seat frame.
12. Reinstall the 2 plastic covers that conceal the screws on the bottom of the seat.
13. Repeat steps 1–10 for the RH 2nd row seat fasteners.
14. Repeat steps 1–10 for the center 2nd row seat fasteners, if equipped.
15. Move the 2nd row seats into their original positions and close the doors.
16. Using Toolbox, disable Seat Install mode.

17. Calibrate the 2nd row seats using Toolbox.
18. Disconnect the laptop from the vehicle.
19. Step on the brake pedal and shift into Drive or Reverse. Ensure that there are no seat warnings on the touchscreen.

Affected VIN(s) Affected Model X vehicles built before approximately December 7, 2015.

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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