



Replace Huck BOM Fastener on Front Seats

Classification Repair Bulletin **Section/Group** 13 - Seats **Country/Region** All

Year 2015-2018 **Model** Model S, Model X **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 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-17-13-005 R3, dated 24-Mar-19. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.

Condition

On some Model S and Model X front seats, the forward inboard Huck BOM fastener and pivot bushing (nearest to the center console) used on the front lift links may develop an interactive clearance condition, which might result in a rocking motion in the seat. This does not affect performance, but may result in customer dissatisfaction.

Correction

Upon customer complaint of front seats that rock when occupied, remove and discard the original Huck BOM fastener, and install a new pivot bolt and bushing.

Correction Description	Correction	Time
SB-17-13-005 Not Applicable	S011713005	0.00
Remove Huck BOM Fastener, Install Bushing And Pivot Bolt On LH Front Seat	S021713005	1.05
Remove Huck BOM Fastener, Install Bushing And Pivot Bolt On RH Front Seat	S031713005	1.05
Remove Huck BOM Fastener, Install Bushing And Pivot Bolt On LH and RH Front Seats	S041713005	2.10

Required Part(s):	Part Number	Description	Quantity
	1452393-00-B	SERVICE KIT - HUCKBOM REPAIR	1
		If the kit is not available, order parts individually:	
	1133688-00-B	BOLT, FH, SHLDR[4x14], M8x20, STL[109], ZN	1
	1448315-00-A	LOCKNUT M8X1.25MM	1
	1448316-00-A	LOCK WASHER FOR M8	1
	1448317-00-A	NORGLIDE BUSHING	1

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): 1137575-00-A Kit, Huck BOM Replacement

Procedure

⚠ WARNING: To reduce the risk of personal injury, eye protection and cut-resistant gloves must be worn while performing this procedure.

⚠ CAUTION: To make sure the new fastener fits properly, use only drill bits from the Huck BOM Replacement kit and apply drilling compound to the drill bit while performing this procedure.

1. Remove the affected front seat (refer to Service Manual procedure 13040101).
2. Move the seat to a clean, flat work area.
3. Remove the front seat memory module (refer to Service Manual procedure 13010602).
4. Remove the seat track (refer to Service Manual procedure 13010102).
5. Remove the Huck BOM fastener:
 - a. Locate the Huck BOM rivet on the inboard side (closest to the center console) of the seat frame (Figure 1).



Figure 1

- b. Get a 1/4 in drill bit from the Huck BOM Replacement kit, and insert it in a drill.

⚠ CAUTION: To make sure the new fastener fits properly, use only drill bits from the Huck BOM Replacement kit while performing this procedure.

- c. Apply drill compound to the bit.

- d. Position the 1/4 in drill jig over the head of the Huck BOM (Figure 2).



Figure 2

- e. Using the jig as a guide, drill a pilot hole through the Huck BOM (Figure 3).



Figure 3

- f. Insert the 21/64 in drill bit from the Huck BOM Replacement kit in a drill.
- g. Apply drill compound to the bit.
- h. Position the 21/64 in drill jig over the head of the Huck BOM fastener.
- i. Using the jig as a guide, drill until the Huck BOM body detaches from the head (Figure 4).



Figure 4

6. Remove and discard the Huck BOM body and head.
7. Remove any debris from the Huck BOM body and head from the work area.
8. Move the inner seat arm out of the working area (Figure 5).



Figure 5

9. Install the new bushing:
 - a. Insert the 39/64 in drill bit from the Huck BOM Replacement kit in a drill.
 - b. Drill out the bushing (Figure 6).



Figure 6

TIP: If the bushing starts to spin, stop drilling and remove the bushing by hand.

- c. Remove the flare tool from the Huck BOM Replacement kit.

NOTE: The main parts of the flare tool (Figure 7) are:

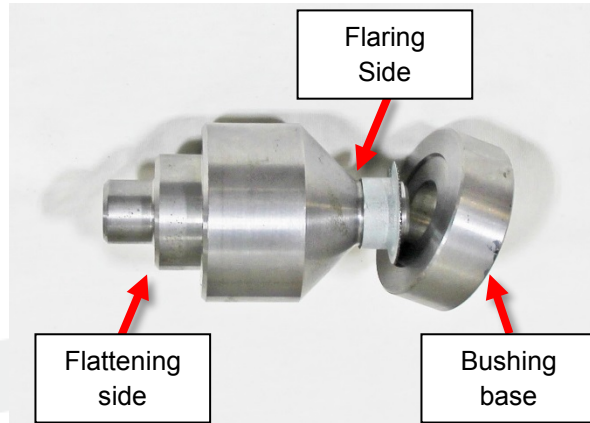


Figure 7

- d. Insert a new bushing with the flange on the inboard side of the seat track (Figure 8).



Figure 8

- e. Insert the flaring side of the tool into the outboard side of the bushing body, and place the bushing base over the bushing flange on the inboard side of the seat track (Figure 9).



Figure 9

- f. Apply the C-clamp (Figure 10) and continue to tighten until the flared part of the bushing body overlaps the edge of the hole (Figure 11).



Figure 10



Figure 11

- g. Remove the C-clamp and put the end of the flattening side of the tool into the flared part of the bushing body (Figure 12).



Figure 12

- h. Apply the C-clamp and tighten to flatten the flared part of the bushing body to form a flange on the outboard side of the seat track (Figure 13).



Figure 13

NOTE: The newly formed flange might or might not be split, as shown in Figure 13.

- i. Remove the C-clamp.
10. Realign the inner seat arm with the seat frame.
11. Install a new pivot bolt, with the head of the bolt on the outboard side of the seat frame.
12. Install a star lock washer and Nyloc nut on the pivot bolt.
13. Hold the Nyloc nut in position, then use a T-40 socket to torque the bolt to 30 Nm (Figure 14).

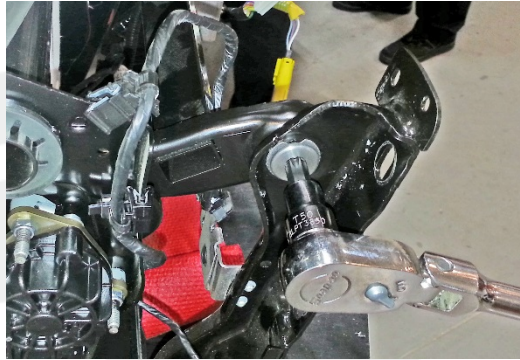


Figure 14

⚠ CAUTION: Use only a hand-held torque wrench to tighten the pivot bolt. Do not exceed 30 Nm of torque on the pivot bolt.

14. Reinstall the seat track (refer to Service Manual procedure 13010102).
15. Reinstall the front seat memory module (refer to Service Manual procedure 13010602).
16. Reinstall the seat (refer to Service Manual procedure 13040101).
17. If necessary, repeat this procedure on the other seat.

Affected VIN(s) Affected Model X and Model S vehicles built before approximately February 14, 2018.

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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