 Tesla, Inc. Service Bulletin		<h2 style="margin: 0;">Install Rivets to Secure the 12V Battery Bracket Support</h2>	
SB-20-10-002 February 18, 2020			
Classification		Section/Group	Mobile Service
Campaign Bulletin		10 - Body	Cannot Perform
Model Year	Model	Country/Region	Version
2017	Model 3	United States, Canada	RWD
<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 certain Model 3 vehicles, the LH side of the 12V battery bracket support might come loose due to improper welds during manufacture.

Correction

Retrofit the LH side of the 12V battery bracket support with rivets.

Correction Description	Correction	Time
SB-20-10-002 Not Applicable	S012010002	0.00
Install Rivets To Secure LH Side Of 12V Battery Bracket Support	S022010002	1.45

	Part Number	Description	Quantity
Parts Required	1454538-00-A	HIGH STRENGTH RIVET 6.5MM, 2.6MM - 9.5MM (Rivets come in packages of 10).	3
	<small>This part number was current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Catalog.</small>		
Special Tools	1126459-00-A	Spring Loaded Center Punch	
	1531654-00-A	Hydraulic Blind Rivet, Rivet Nut Tool (available through Coupa)	
Shop Supplies	Isopropyl alcohol (IPA) wipes Caulk and adhesive gun Urethane sealant		

Procedure

1. Remove the 12V battery bracket (refer to Service Manual procedure 17014002).
2. Remove the 12V battery beam (refer to Service Manual procedure 17012702).
3. Remove the LH wheel arch liner (refer to Service Manual procedure 12010902).

4. On the LH strut tower, locate the 3 battery bracket support spot welds (Figure 1), and then use the spring loaded center punch tool to mark the center of each spot weld where a new battery bracket support rivet will be installed (Figure 2).

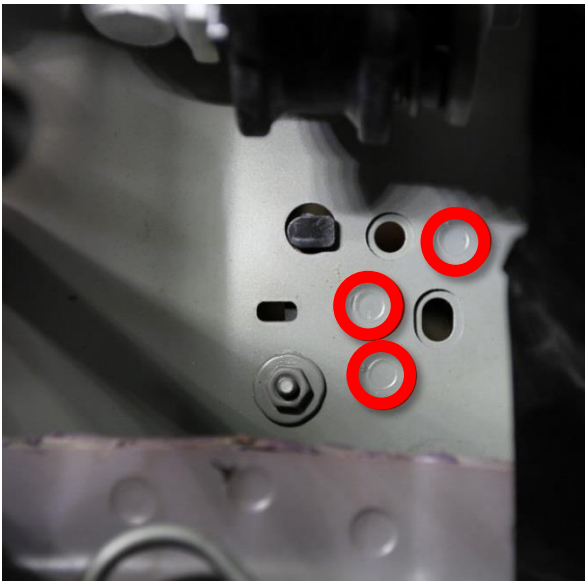


Figure 1



Figure 2

5. Wear eye protection.
6. Drill out the lowest rivet location with a 3/16" (4.76 mm) bit, and then drill out the same rivet location with a 17/64" (2.77 mm) bit (Figure 3).

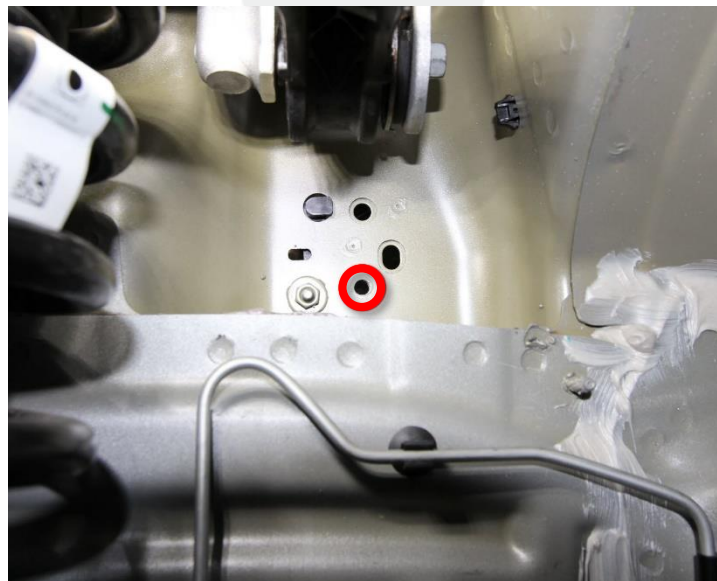



Figure 3

7. Lower the vehicle slightly to access the underhood area.

- Using the rivet nut tool, install a new rivet into the lower rivet hole from inside the underhood area (Figure 4).

 **NOTE:** Make sure that the rivet is aligned flat on the 12V battery bracket support, before setting the rivet.

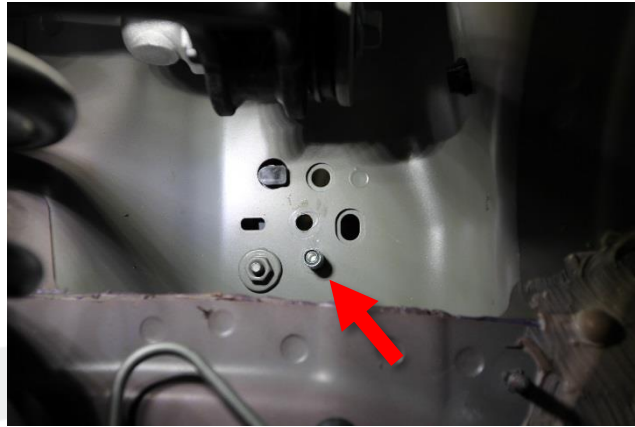


Figure 4

- Raise the vehicle to a comfortable working height.
- Drill out the middle rivet location with a 3/16" (4.76 mm) bit, and then drill out the same rivet location with a 17/64" (2.77 mm) bit (Figure 5).

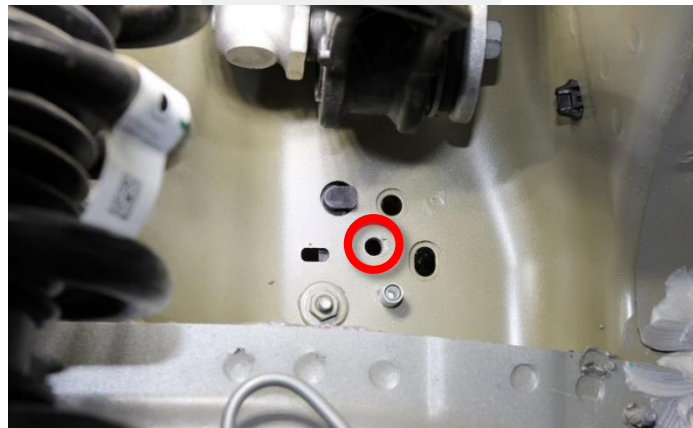


Figure 5

- Lower the vehicle slightly to access the underhood area.
- Using the rivet nut tool, install a new rivet into the middle rivet hole from inside the underhood area.



Figure 6

- Raise the vehicle to a comfortable working height.

14. Drill out the upper rivet location with a 3/16" (4.76 mm) bit, and then drill out the same rivet location with a 17/64" (6.75 mm) bit (Figure 7).

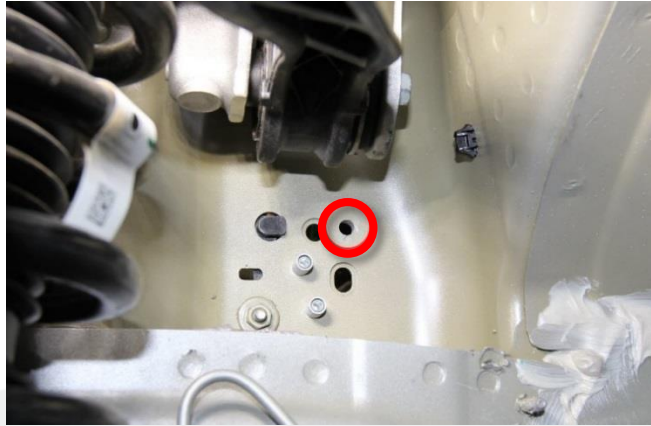


Figure 7

15. Lower the vehicle slightly to access the underhood area.
16. Using the rivet nut tool, install a new rivet into the upper rivet hole from inside the underhood area (Figure 8).

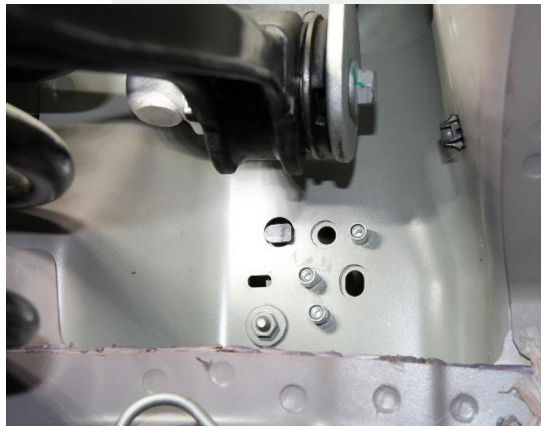


Figure 8

17. Clear away any metal shavings from the cavity beneath the rivets using a shop vacuum.
18. Wipe the 12V battery bracket support and the rivets with an IPA wipe. Allow the area to dry for at least 1 minute (Figure 9).



Figure 9

19. Use a caulking gun to apply urethane sealant and cover the heads of each rivet to seal the rivets to the bracket support (Figure 10).

TIP: Use a wetted gloved finger to make sure the urethane completely covers the rivet heads.

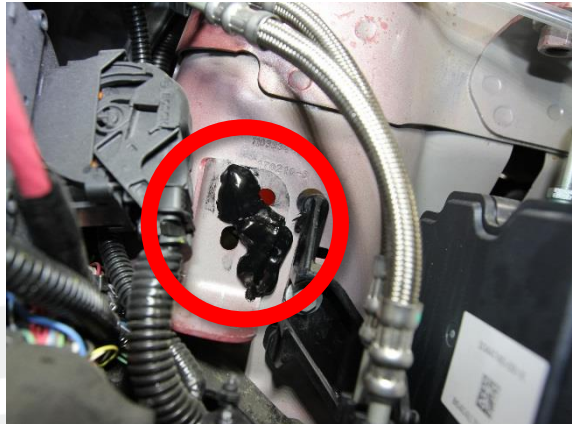


Figure 10

20. Raise the vehicle to a comfortable working height.

21. Wipe the bracket support and the back side of the rivets with an IPA wipe, and then allow the area to dry for at least 1 minute (Figure 11).



Figure 11

22. Apply urethane sealant to cover the end of each rivet to seal the rivets to the shock tower (Figure 12).

TIP: Use a wetted gloved finger to make sure the urethane completely covers the rivet heads.

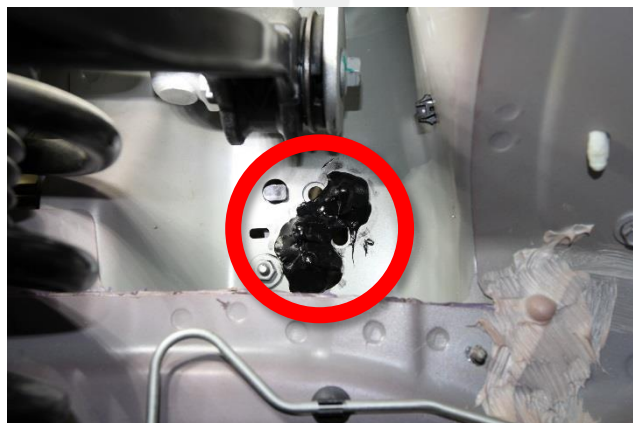


Figure 12

23. Install the LH wheel arch liner (refer to Service Manual procedure 12010902).
24. Install the 12V battery beam (refer to Service Manual procedure 17012702).
25. Install the 12V battery bracket (refer to Service Manual procedure 17014002).

