



Fender and Lamp Support Bracket





Parts List

Quantity	Part Number	Description	Image / Notes
1	1100382-S0-A (LH) 1100383-S0-A (RH)	Fender and Lamp Support Bracket	
4 rivets needed; order 10 rivets	1028719-00-A	● Structural Rivet, 4.8 mm	All rivets come in packages of 10; order all rivets in multiples of 10.
1	—	Structural Adhesive	⚠ WARNING: Use only Tesla-approved structural adhesive; refer to BR-15-92-008, "Approved Structural Adhesive and Urethane Sealants" for a list of current approved structural adhesives. Refer to BR-17-92-002, "Obtaining Adhesives, Coolant, and Other Chemicals" for information on how to obtain approved structural adhesive.

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



Repair Information

Repair Information	Warnings and Cautions	Special Tools
This procedure is for the left-hand component; the procedure is identical for the right-hand component.	 WARNING: Wear the appropriate personal protective equipment (PPE) when performing this procedure.  CAUTION: This procedure involves only steel components. Use the appropriate tools to avoid cross-contamination.	No special tools are required to perform this procedure.



Prerequisites

No welded, riveted, or bonded panels need to be removed prior to performing this procedure.



Removal

1 Remove the original component.

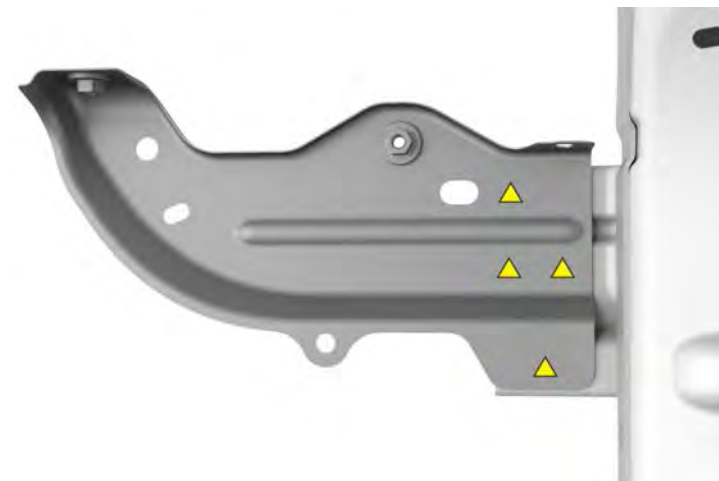
A

Use a drill with a spot weld bit to drill out the factory spot welds.

▲ Factory Spot Weld (x4)



NOTE: Factory spot weld locations shown are approximate. Exact spot weld locations and number vary from vehicle to vehicle.





Removal

1 Remove the original component (continued).

B Remove the original component.

2 If the original Fender Front Inner Bracket is slightly damaged, use a hammer and dolly to straighten the Fender Front Inner Bracket.



NOTE: If the original Fender Front Inner Bracket is too damaged to be successfully straightened, perform the [Fender Front Inner Bracket](#) procedure.





Removal

3

Use a disc sander with a medium-abrasive surface conditioning disc to remove any remaining materials from the bond paths. Use a belt sander with a medium-abrasive belt for any areas that cannot be reached with a disc sander. Vacuum any adhesive dust.



WARNING: Remove the epoxy adhesive in a well-ventilated area. Wear suitable personal protective equipment.





Replacement

1 Prepare for installation.

A

Put the new component into position and clamp it into place.



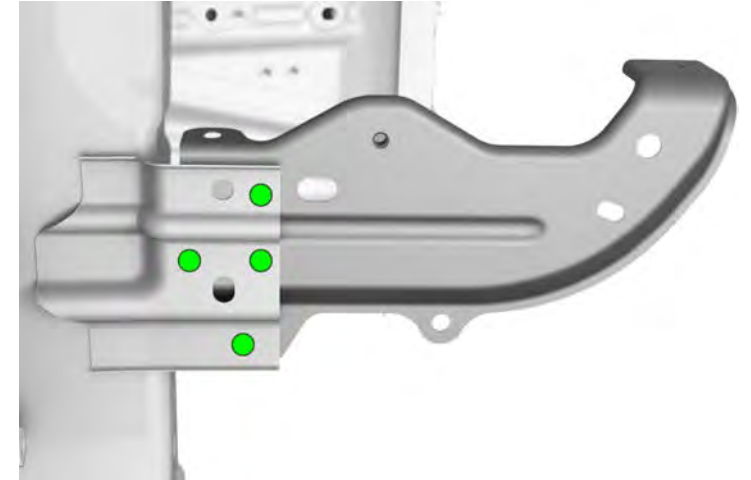
NOTE: All adjacent panels should be temporarily installed to ensure a good fit.





Replacement

- 1 Prepare for installation (continued).
 - B Mark the locations for structural rivets.
 - Structural Rivet, 4.8 mm (x4)





Replacement

1 Prepare for installation (continued).

C Use a drill with a 4.8 mm (3/16 in) bit to drill holes for structural rivets.



NOTE: Install a grip screw after drilling each hole to keep the panel aligned while drilling the remaining holes.





Replacement

- 1 Prepare for installation (continued).
- D** Mark the bond path areas on the new component and the vehicle. These areas will be prepared for bonding in the next step.



- E** Remove the new component.



Replacement

2 Prepare the surfaces.

A Use a red Scotch-Brite pad or equivalent to scuff the e-coat on the new component and on the vehicle in the bond path areas.



NOTE: Remove any oxidation that might have formed on any bare metal in the bond path areas on the vehicle.

B Clean all the bond paths on the new component or components and on the vehicle with isopropyl alcohol (IPA).



WARNING: Wipe off the remaining isopropyl alcohol with a clean, dry towel immediately after application. Do not let the remaining isopropyl alcohol air dry. Allowing the remaining isopropyl alcohol to air dry can compromise the adhesive bond.





Replacement

3 Apply structural adhesive.

A Spread a thin coating of structural adhesive as a primer layer on the bond paths on the vehicle and the new component.



NOTE: Assembly must be performed while the primer layer is still wet. The drying time of the adhesive varies depending on temperature and humidity.

B While the primer layer is still wet, apply a bead of structural adhesive on top of the primer layer on the new component.





Replacement

4 Install the new component.

A

Put the new component into position and clamp it into place.



NOTE: All adjacent panels should be temporarily installed to ensure a good fit.

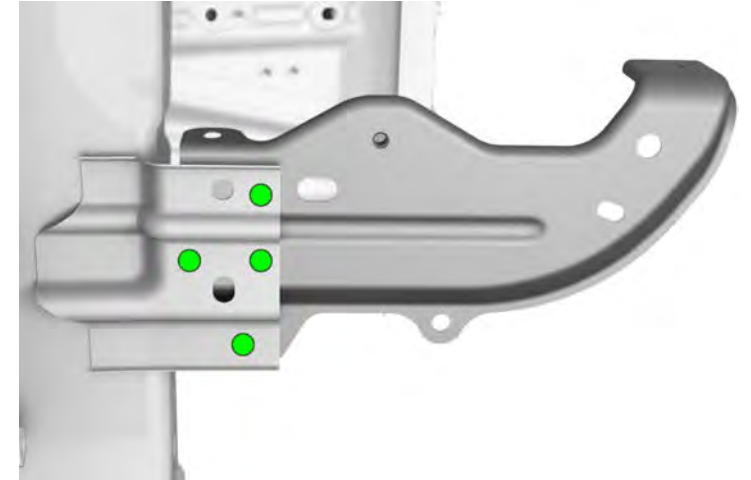




Replacement

4 Install the new component (continued).

B Insert the structural rivets.
● Structural Rivet, 4.8 mm (x4)





Replacement

4 Install the new component (continued).

C Install the structural rivets.

D Wipe off any excess adhesive.





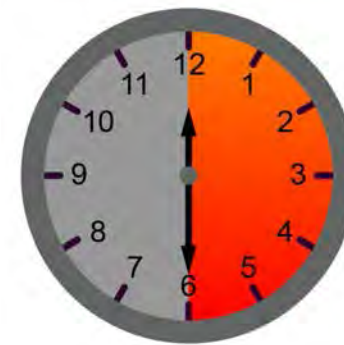
Replacement

4 Install the new component (continued).

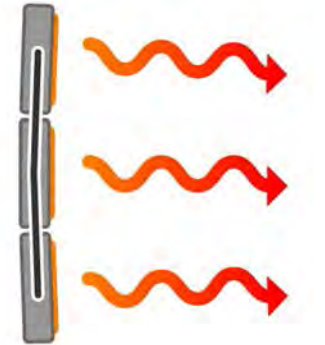
E Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



WARNING: Do not allow the High Voltage Battery to reach a temperature above 74°C (165°F). Heating the High Voltage Battery above 74°C (165°F) for an extended period could result in injury to personnel and/or damage to the battery.



00:30:00+



60°C–80°C