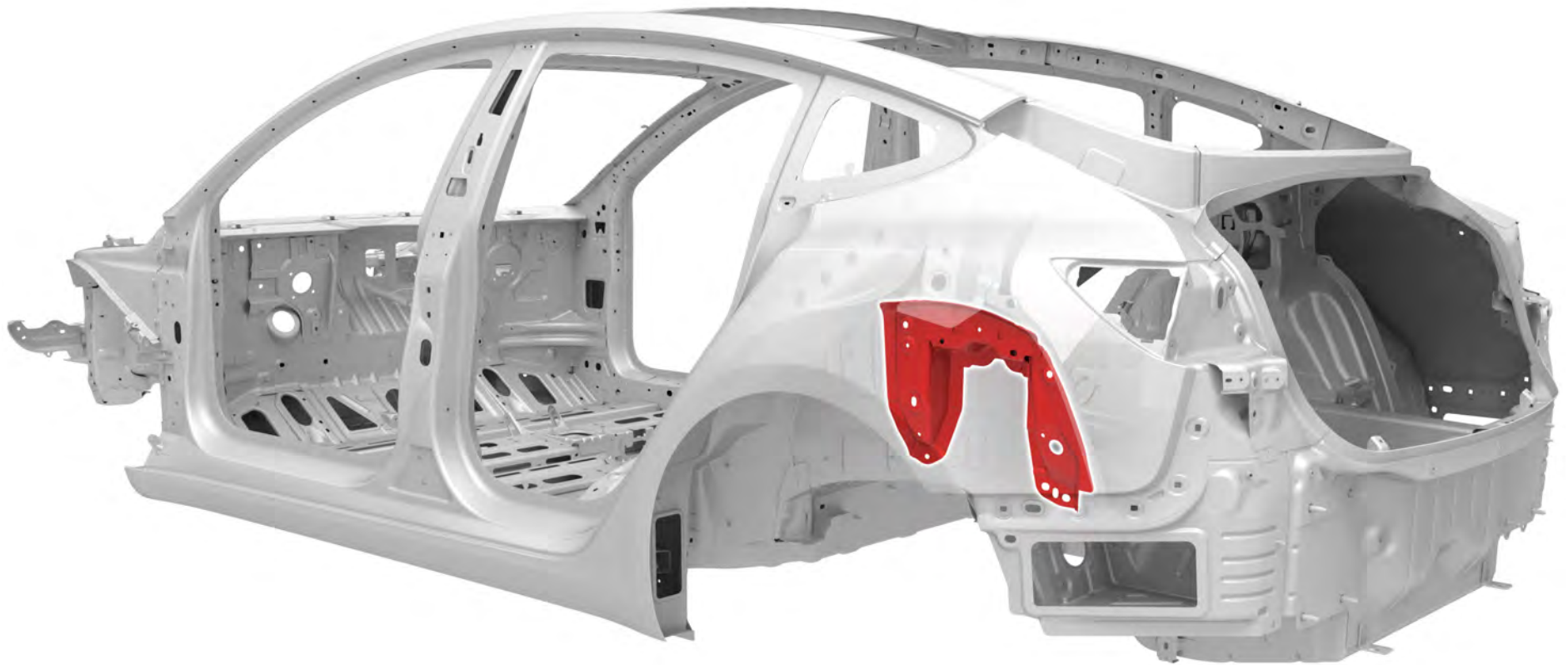




Damper Mount Rear Assembly





Parts List

Quantity	Part Number	Description	Image / Notes
1	1077933-S0-A (LH) 1077934-S0-A (RH)	Rear Damper Mount	
33 rivets needed; order 40 rivets	1028408-00-A	 Structural Rivet, 6.5 mm Short	All rivets come in packages of 10; order all rivets in multiples of 10.
3	1063260-00-C	 Bolt, hex-head, M8x23.5	
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 right-hand component; the procedure is identical for the left-hand component.	 WARNING: Wear the appropriate personal protective equipment (PPE) when performing this procedure.  CAUTION: This procedure involves both steel and aluminum components. Use the appropriate tools at each step to avoid cross-contamination.	The special tool listed below is required to perform this procedure: • Frame bench The vehicle must be properly mounted on an approved frame bench to replace this component. Refer to BR-16-92-006, "Approved Frame Bench Systems" for a list of current approved bench repair systems.



Prerequisites

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



Removal

1 Remove the original component.

A Remove and discard the original bolts.

■ Bolt, hex-head (x3)



B Use an SPR removal tool or a drill with a high-strength steel bit to remove the factory self-piercing rivets. Use a belt sander for any factory self-piercing rivets that cannot be removed with an SPR removal tool or a drill.

◆ Factory SPR (x3)





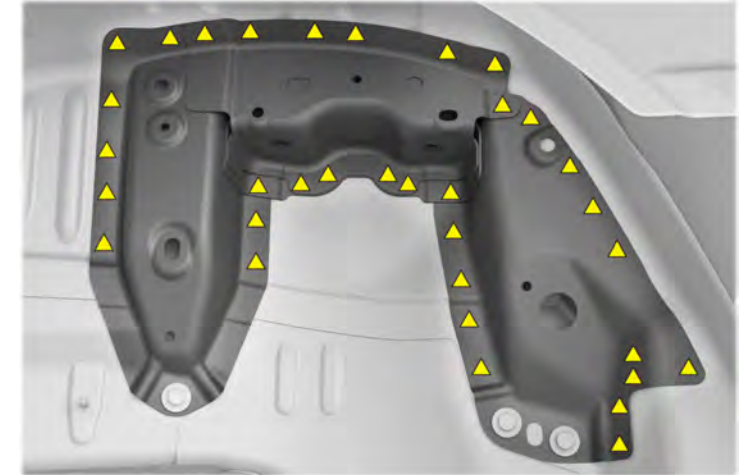
Removal

1 Remove the original component (continued).

C Use a drill with a spot weld bit to drill out the factory spot welds.
▲ Factory Spot Weld (x32)



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



D Use a heat gun to heat the adhesive joints, and then use a hammer and chisel to remove the remaining pieces of the original component.



WARNING: Do not heat the adhesive joints above 100°C (212°F). Heating the adhesive joints above 100°C (212°F) can weaken the aluminum and compromise vehicle crash integrity.



WARNING: Do not heat any adhesive joints of components that are not being removed. Heating adhesive joints weakens the adhesive bond and could compromise vehicle crash integrity.



Removal

2

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.



WARNING: Use only sanding wheels and belts that are 80 grit or finer on aluminum components. Using sanding wheels or belts that are coarser than 80 grit can cause fractures in the aluminum.



CAUTION: Beware of cross-contamination. Do not use the same equipment to remove epoxy from aluminum and steel. Cross-contamination might result in galvanic corrosion.



Replacement

- 1 Prepare for installation.
 - A Put the new component into position and align it to the frame bench jig points.
 - B Temporarily install the bolts but do not torque them at this time.
 - Bolt, hex-head (x3)





Replacement

1 Prepare for installation (continued).

C

Mark the fastener locations on the new component.



CAUTION: Use measurements as shown to avoid interference with the Rear Rail Upper Connector Bracket behind the Rear Wheelhouse Inner panel.



NOTE: Rivets that replace factory SPRs will go through the existing SPR holes in the vehicle.

● Structural Rivet, 6.5 mm Short (x33)

D

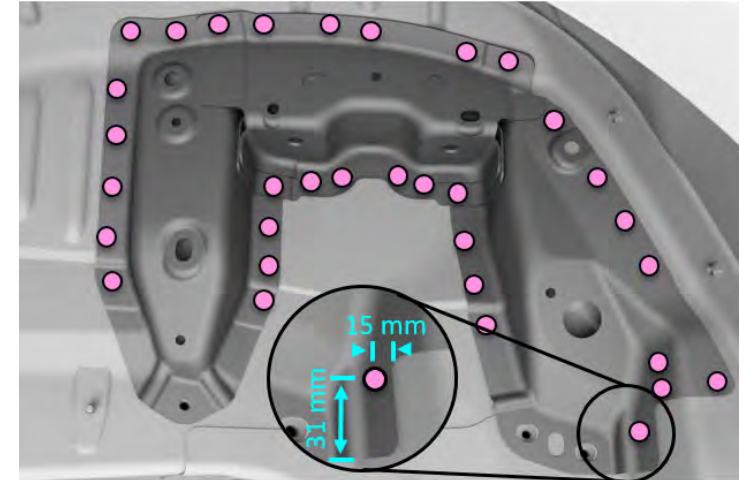
Use a drill with a 6.7 mm (17/64 in) bit to drill holes for structural rivets.



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



NOTE: Rivets that replace factory SPRs will go through the holes in the vehicle created during component removal.





Replacement

1

Prepare for installation (continued).

E

Remove the new component.

F

Mark the bond path areas on the new component. These areas will be prepared for bonding in a later step.



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.

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.



CAUTION: If any bare metal bond paths have been exposed for two hours or longer, abrade the bond paths again to remove oxidation, then clean the bond paths with isopropyl alcohol (IPA).



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 align it to the frame bench jig points.

B Install the bolts but do not torque them at this time.

■ Bolt, hex-head (x3)



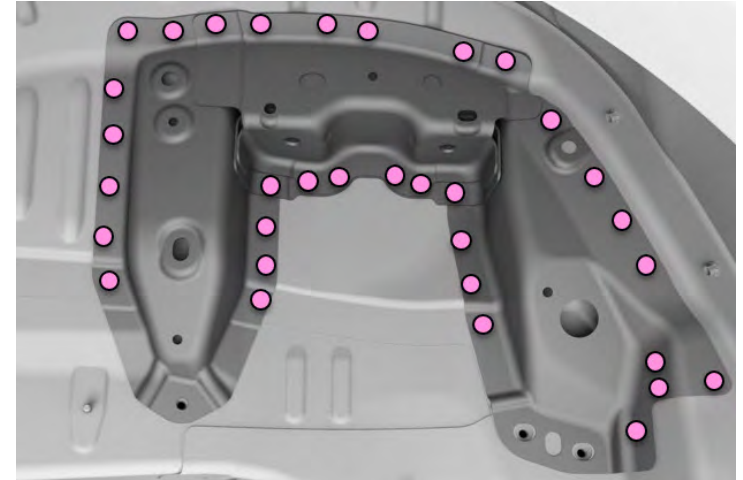


Replacement

4 Install the new component (continued).

C Insert the structural rivets.
● Structural Rivet, 6.5 mm Short (x33)

D Install the structural rivets.





Replacement

- 4 Install the new component (continued).
- E Torque the bolts to 24 Nm (18 ft lbs).
- F Wipe off any excess adhesive.



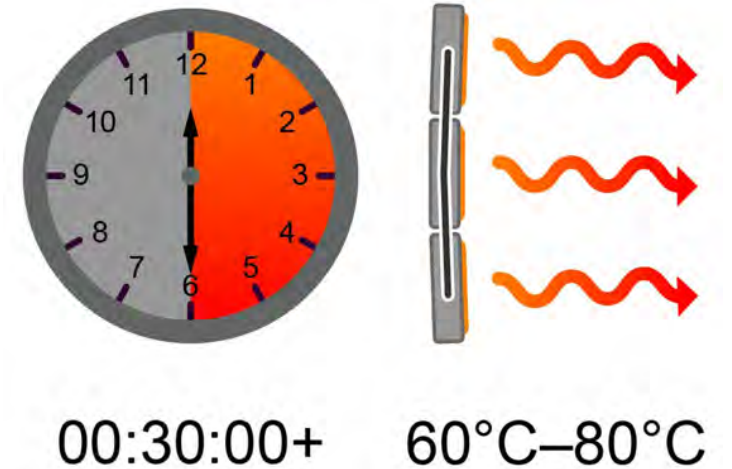
Replacement

4 Install the new component (continued).

G 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.



H Seal the seams in the factory locations, and as necessary.