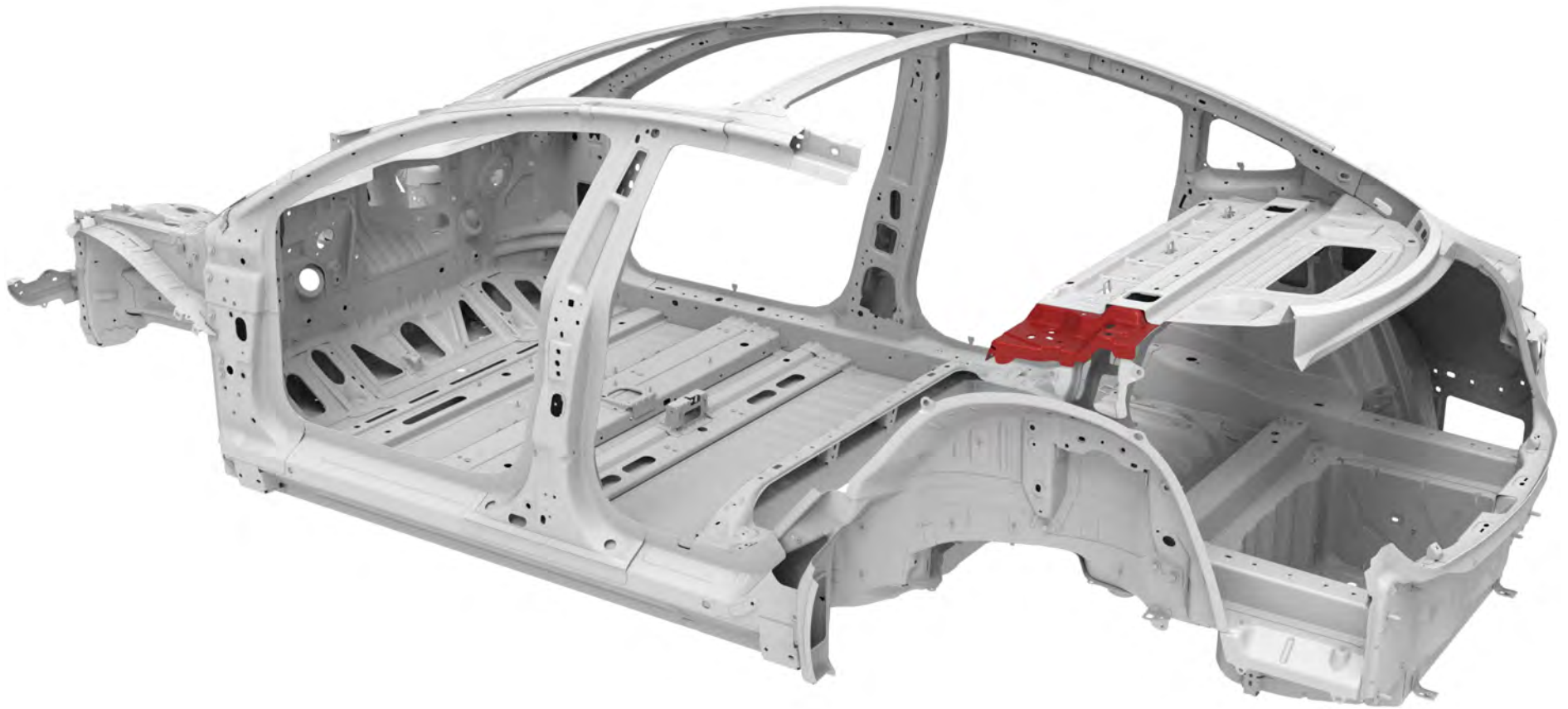




Parcel Shelf Front Extension





Parts List

Quantity	Part Number	Description	Image / Notes
1	1073681-S0-G (LH) 1073682-S0-G (RH)	EXTN, Parcel Shelf Front	
1	1095653-S0-A (LH) 1095654-S0-A (RH)	ASY, Parcel Shelf Retractor	
8 rivets needed; order 10 rivets	1063943-00-A	● Structural Bulb Rivet, 6.5 mm	All rivets come in packages of 10; order all rivets in multiples of 10.
6 rivets needed; order 10 rivets	1069308-00-A	● Countersunk Rivet, 4.8 mm Short	All rivets come in packages of 10; order all rivets in multiples of 10.
6 rivets needed; order 10 rivets	1069329-00-A	★ Flow Form Rivet S18	All rivets come in packages of 10; order all rivets in multiples of 10.
2	1008842-00-A	BOLT PANHEAD FLANGE M6-1.00x12 ZINC ALUMINUM	
2	1016227-00-A	NUT, HEX, FLANGE,M6-1.0x14	



Parts List

Quantity	Part Number	Description	Image / Notes
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.
1	—	Seam Sealer	Source locally; not available from Tesla.

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.	The special tools listed below are required to perform this procedure: • Flow Form Rivet Installation Tool • Countersink Drill Tool



Prerequisites

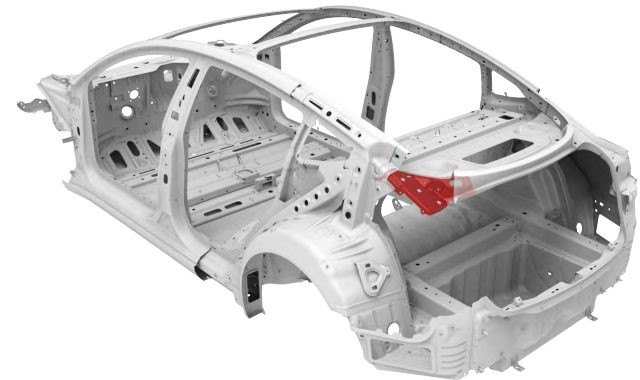
1

Remove the Rear Quarter Inner.



2

Remove the Parcel Shelf Rear Extension.





Prerequisites

3

Left-hand component only: disconnect 12V and high voltage power (refer to the appropriate section in [BR-17-17-004](#), "Disconnecting 12V and High Voltage Power on Model 3").



WARNING: Before disconnecting the 12V power supply, make sure that all windows are at least slightly open. Attempting to open a door with a fully-closed window when the 12V power supply is disconnected could result in door glass shatter.



NOTE: Before disconnecting the 12V power supply, make sure that the driver's door window is fully open. Failure to lower the driver's door window before disconnecting the 12V power supply could result in vehicle lockout.



Removal

1 Remove the original component.

A Use a drill with a spot weld bit to drill out the factory spot welds. Use a belt sander to sand down any factory spot welds that cannot be reached with a drill.

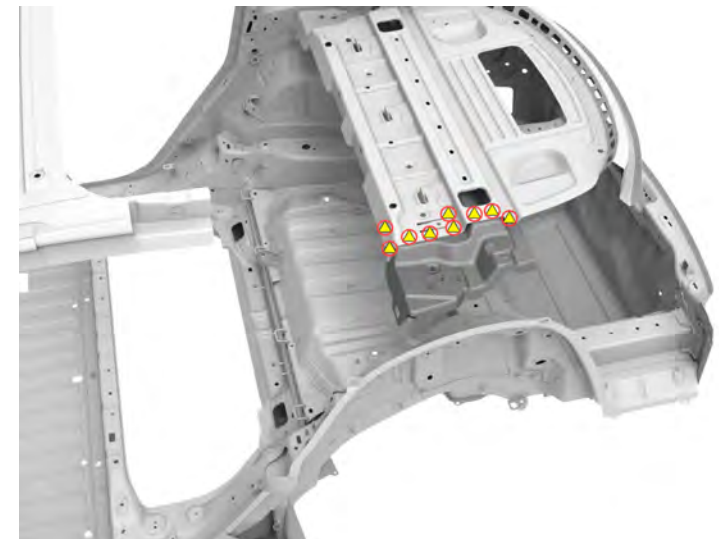
▲ Factory Spot Weld



NOTE: In the following images, the Cantrail Assembly has been removed to enhance clarity. There is no need to remove the Cantrail Assembly when performing this procedure.



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 Use a drill with a 6.7 mm bit to drill completely through the spot welds shown.

 Drill through factory spot welds



NOTE: 6.5mm structural bulb rivets and flow form rivets will be installed in the locations circled in red in a later step.

C Use a heat gun to heat the adhesive joints, and then use a hammer and chisel to remove the remaining piece of the Extension Parcel Shelf Front.



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 mating surfaces. 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.



Replacement

1 Prepare for installation.

A

Put the Parcel Shelf Retractor Reinforcement and Parcel Shelf Front Extension into position and secure them in place.

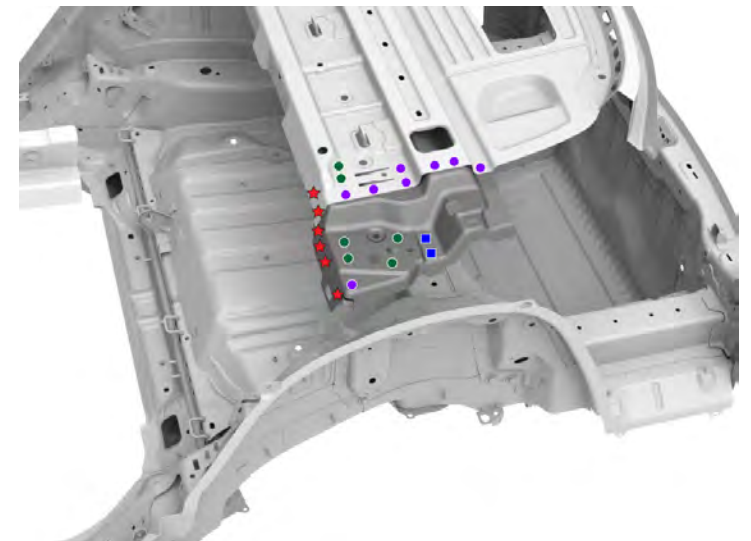
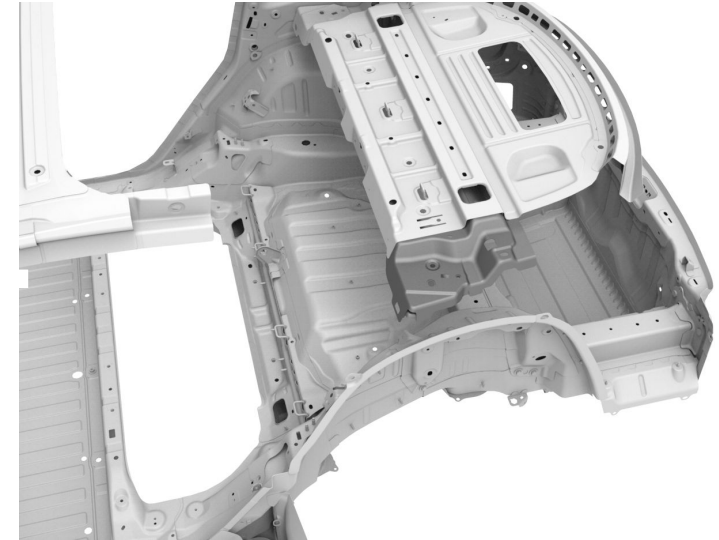


NOTE: In the following images, the Cantrail Assembly has been removed to enhance clarity. There is no need to remove the Cantrail Assembly when performing this procedure.

B

Mark the fastener locations on the new component.

- Structural Bulb Rivet, 6.5 mm (x8)
- Countersunk Rivet, 4.8 mm Short (x6)
- ★ Flow Form Rivet S18 (x6)
- Bolt, Torx-head (x2)





Replacement

1 Prepare for installation (continued).

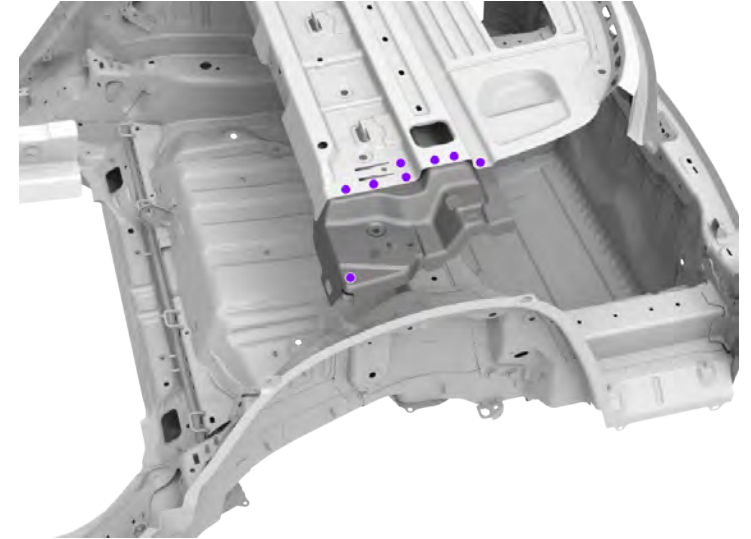
- C Drill 6.7 mm holes for structural bulb rivets.
- Structural Bulb Rivet, 6.5 mm (x8)



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



NOTE: Drill holes in the new component through any existing holes on the vehicle created during removal.





Replacement

1 Prepare for installation (continued).

D

Drill 4.8 mm holes for countersunk rivets.

● Countersunk Rivet, 4.8 mm Short (x6)



CAUTION: Drill holes for countersunk rivets far enough away from the corners and any other obstructions to provide enough clearance (approximately 18 mm) for the Microstop countersink cage assembly.



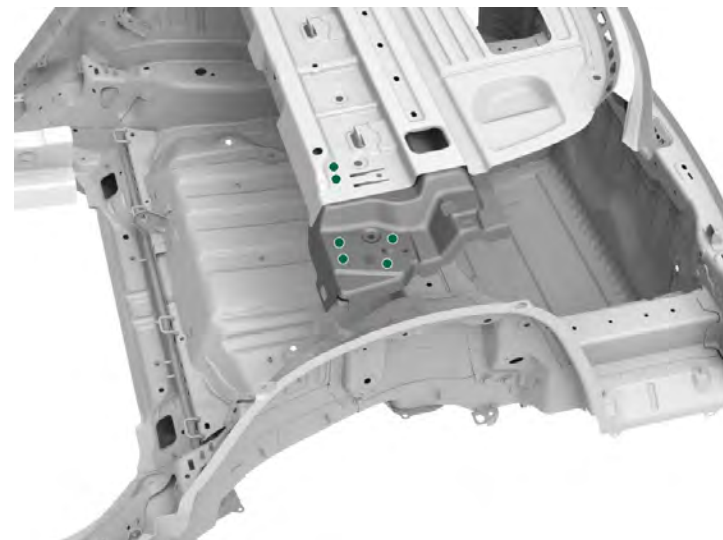
NOTE: Install a grip screw after drilling each hole to keep the panel aligned while drilling the remaining holes.



NOTE: If the depth adjustment for the Microstop countersink cage assembly has not already been set, do the procedure in the [Microstop Countersink Kit tool instructions](#) to adjust the tool.

E

Use a drill with the Microstop countersink cage assembly and the appropriate-sized countersink bit to countersink the hole (Microstop Countersink Kit, Tesla p/n 1133101-00-A).

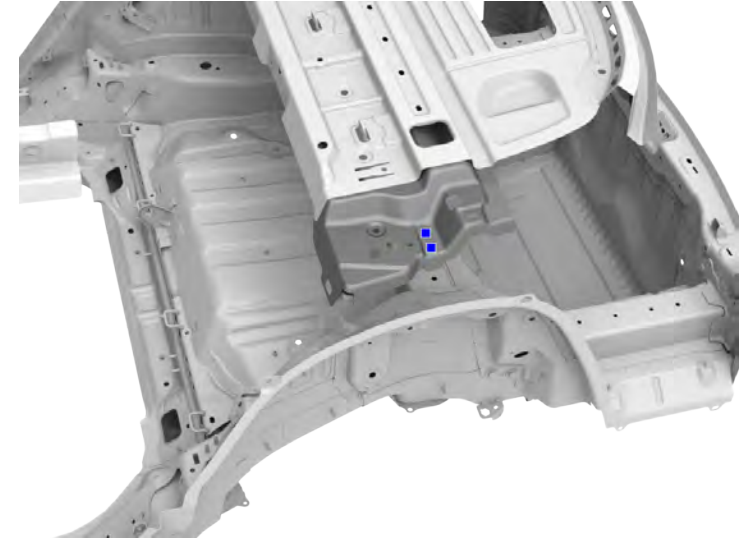




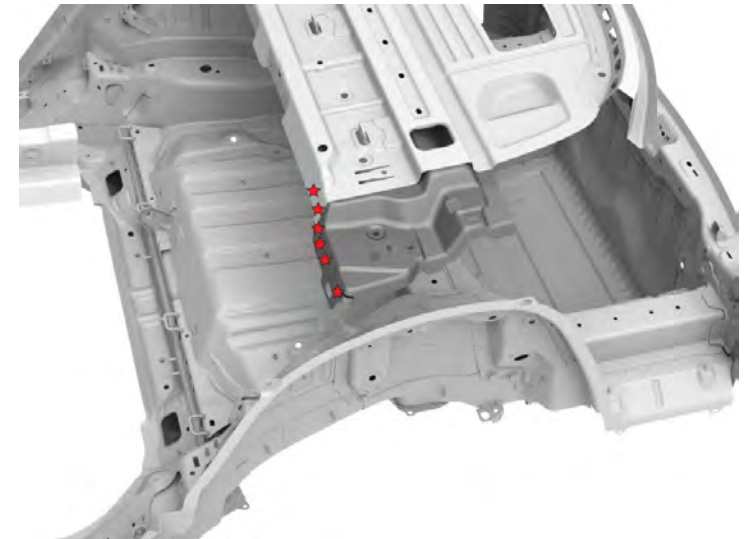
Replacement

1 Prepare for installation (continued).

F Drill 6 mm holes for the M6 bolts.
■ Bolt, Torx-head and Nut (x2)



G Create 8 mm holes for flow form rivets.
★ Flow Form Rivet S18 (x6)





Replacement

1

Prepare for installation (continued).

H

Mark boundary lines along all mating surfaces between the new component and the vehicle for surface preparation.

I

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 mating surfaces of the new component.

B Clean all the mating surfaces and weld areas of the new component or components and 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 mating surfaces of 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 vehicle.



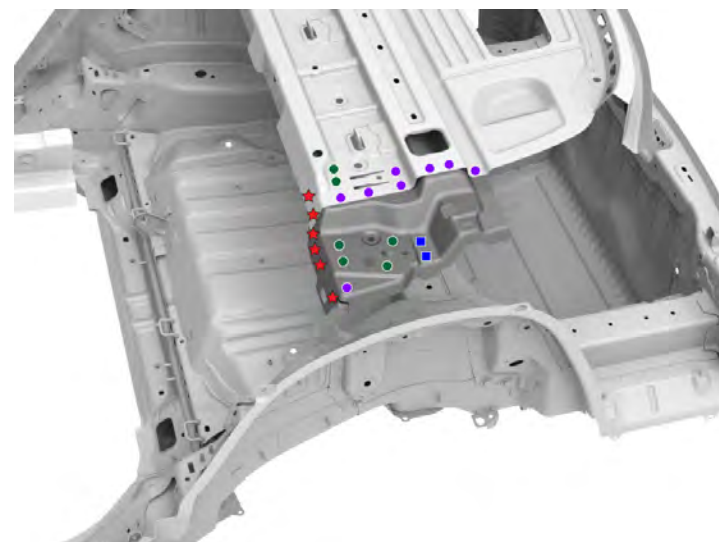
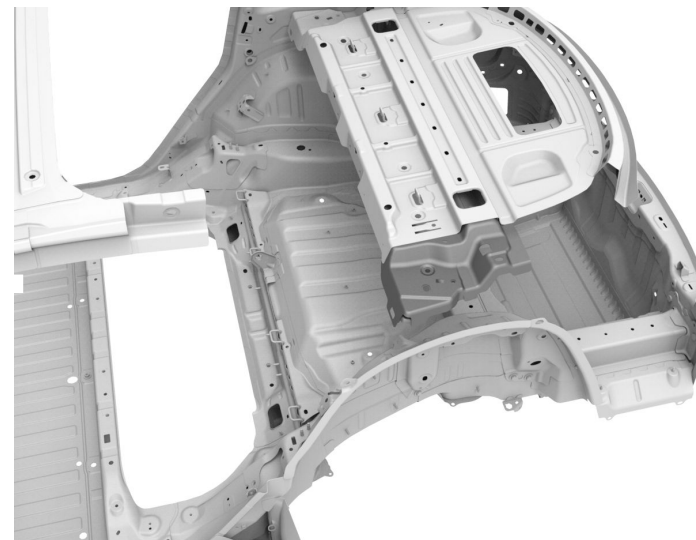
Replacement

4 Install the new component.

A Put the Parcel Shelf Retractor Reinforcement and the Parcel Shelf Front Extension into position and secure them in place.

B Insert all structural rivets, countersunk rivets, Flow Form rivets, and bolts.

- Structural Bulb Rivet, 6.5 mm (x8)
- Countersunk Rivet, 4.8 mm Short (x6)
- ★ Flow Form Rivet S18 (x6)
- Bolt, Torx-head (x2)



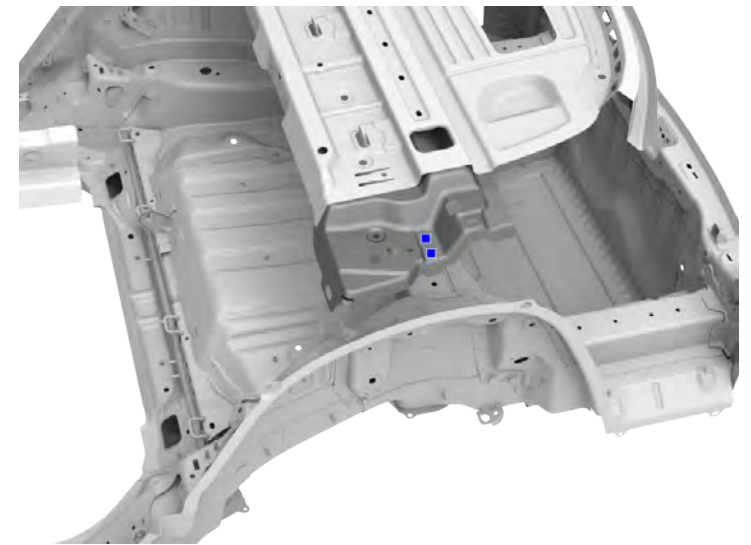


Replacement

4 Install the new component (continued).

C Install all structural rivets, countersunk rivets, and Flow Form rivets.

D Torque the bolts shown to 16 Nm.
■ Bolt, Torx-head and Nut (x2)





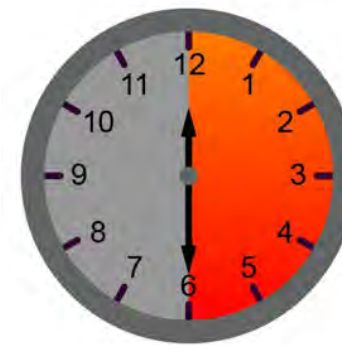
Replacement

- 4 Install the new component (continued).
- E Wipe off any excess adhesive.

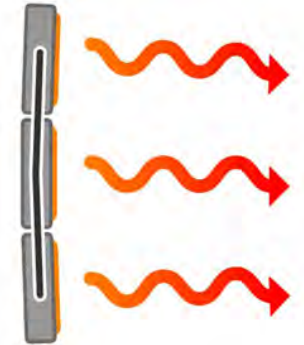
- F Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



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



Replacement

5

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

6

Install the [Rear Quarter Inner](#).





Replacement

7

Install the [Parcel Shelf Rear Extension](#).

