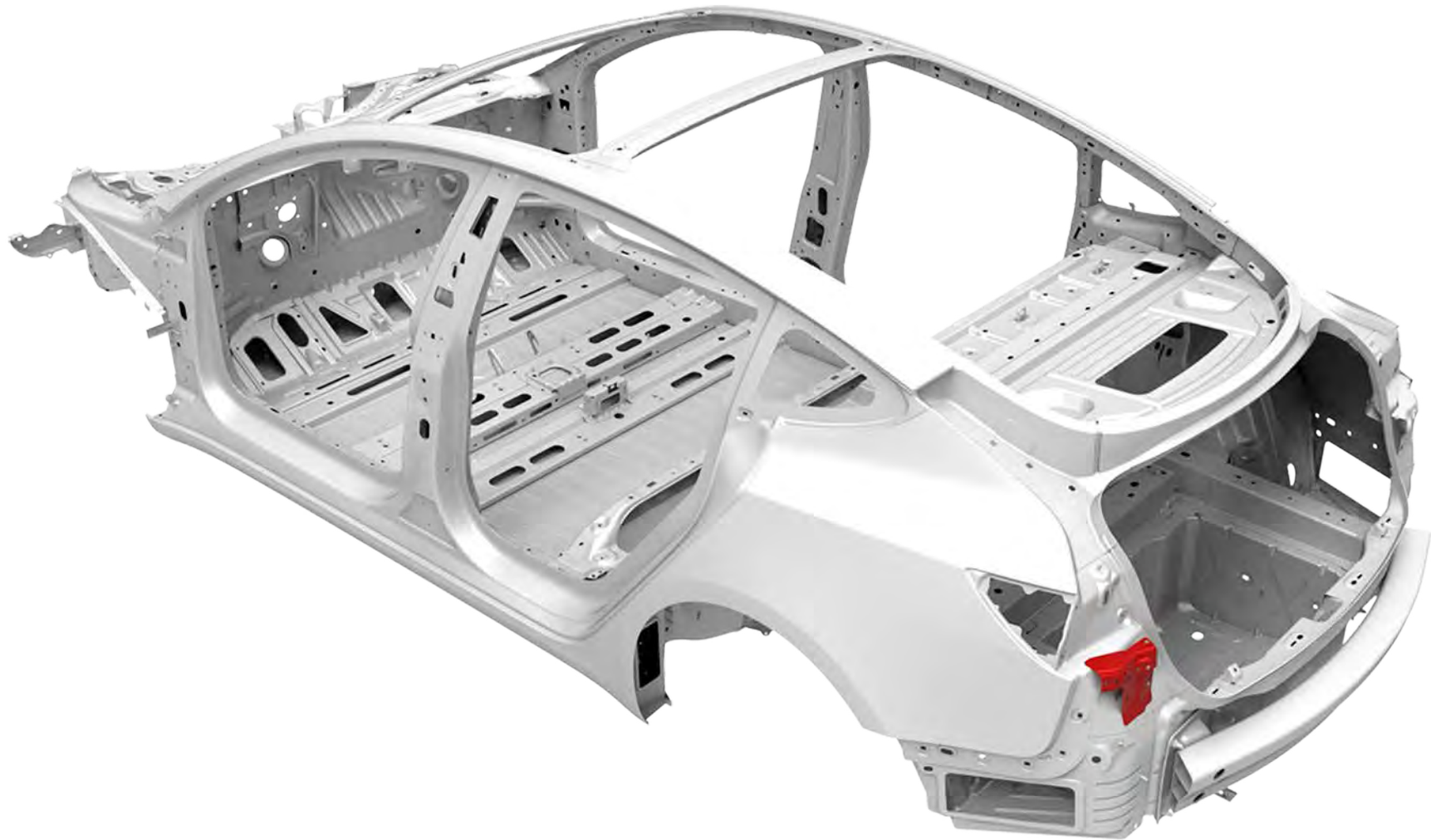


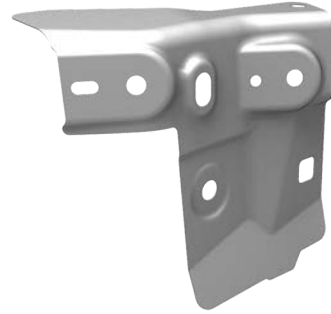


Rear Fascia Bracket





Parts List

Quantity	Part Number	Description	Image / Notes
1	1102256-S0-A (LH) 1102259-S0-A (RH)	Rear Fascia Bracket	
5 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.
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.  CAUTION: This procedure involves only steel components. Use the appropriate tools to avoid cross-contamination.	No special tools are required to perform this procedure.

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Prerequisites

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



Removal

1 Identify the component materials in the repair area.

 Aluminum

 Mild Steel

 High-Strength Steel



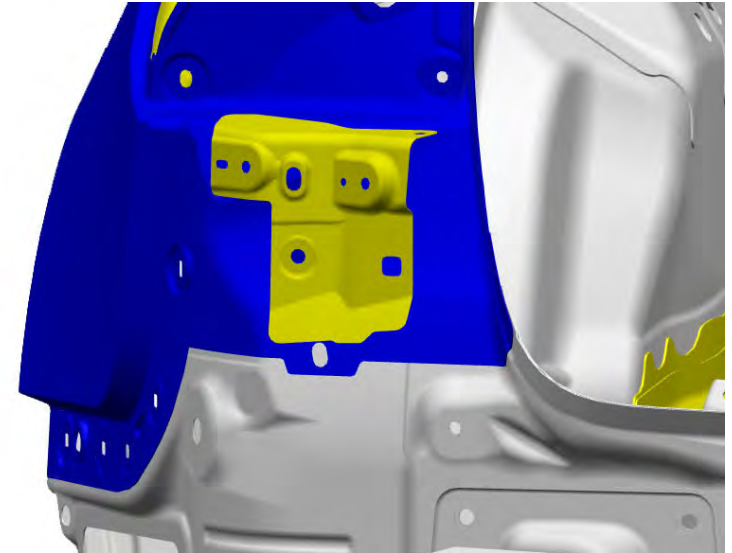
CAUTION: Take the appropriate steps to minimize the cross-contamination of steel and aluminum components during the repair.



NOTE: Refer to [BR-17-10-005](#), “Model 3 Body Structure Materials and Allowed Operations”, for information about the material each structural component is made from and the operations that are allowed on each type of material.

2 Remove the original component.

A Remove any seam sealer as necessary to identify the factory spot welds.





Removal

2 Remove the original component (continued).

B Trace the outline of the original component to aid in installation in a later step.

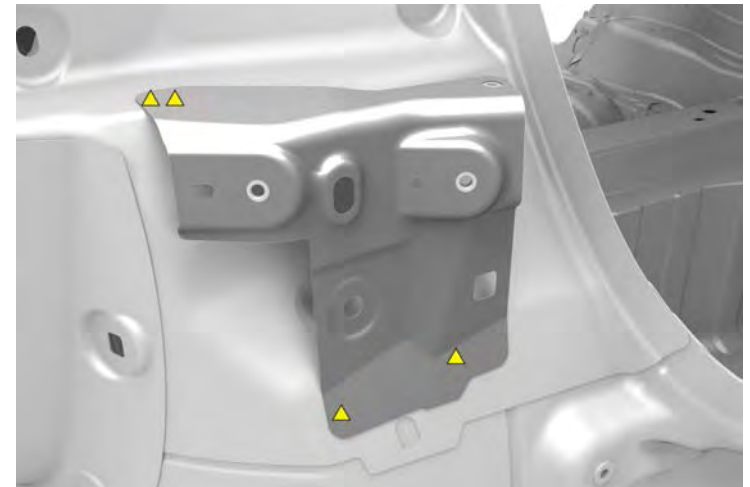


C Use a drill with a spot weld bit to drill out the factory spot welds.

▲ Factory Spot Weld (x4)



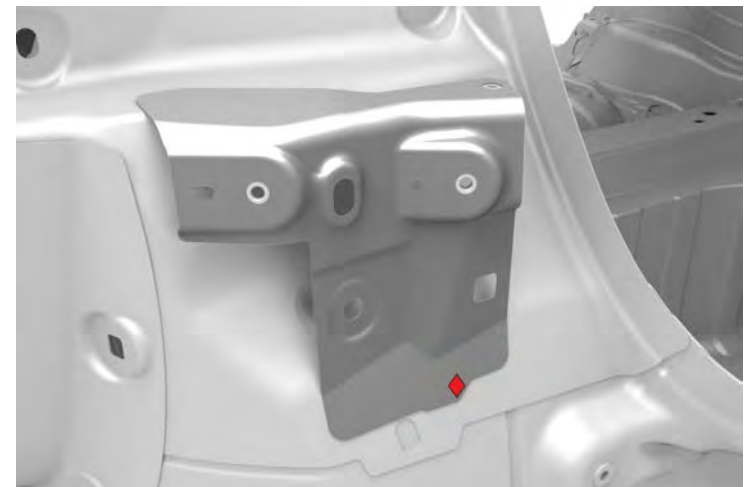
NOTE: Factory spot weld locations shown are approximate. Exact spot weld locations and number vary from vehicle to vehicle.





Removal

- 2 Remove the original component (continued).
- C Use a drill with a spot weld bit to drill out the factory spot welds (continued).
- D Use an SPR removal tool or a drill with a high-strength steel bit to remove the factory self-piercing rivet.
 - ◆ Factory SPR (x1)





Removal

2 Remove the original component (continued).

D Use an SPR removal tool or a drill with a high-strength steel bit to remove the factory self-piercing rivet (continued).



E Use a heat gun to heat the adhesive joints, and then use a hammer and chisel to remove the original component.



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 Remove the original component (continued).

E Use a heat gun to heat the adhesive joints, and then use a hammer and chisel to remove the original component (continued).





Removal

3

Grind down any remaining fastener remnants and remove any coatings in the bond path areas on the vehicle.



WARNING: Remove the e-coat or paint 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.



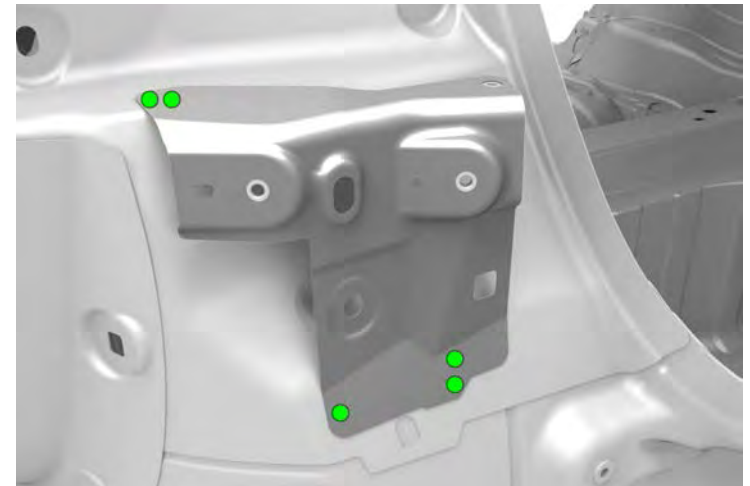
NOTE: Use the outline traced in an [earlier step](#) to aid in installation.



B

Mark the fastener locations on the new component.

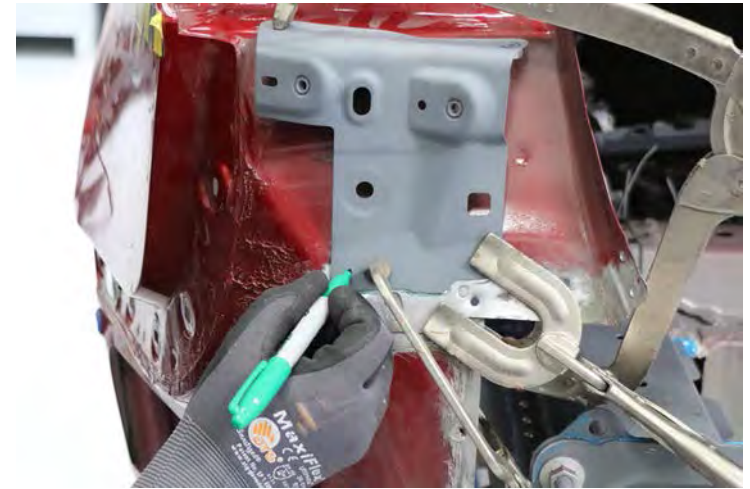
● Structural Rivet, 4.8 mm (x5)





Replacement

- 1 Prepare for installation (continued).
- B Mark the fastener locations on the new component (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).
- C Use a drill with a 4.8 mm (3/16 in) bit to drill holes for structural rivets (continued).



- D Remove the new component.





Replacement

1 Prepare for installation (continued).

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



2 Prepare the surfaces.

A Use a disc sander with a medium-abrasive surface conditioning disc to remove the e-coat on the new component in the bond path areas. Use a belt sander with a medium-abrasive belt for any areas that cannot be reached with a disc sander.



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



CAUTION: Within two hours of removing the e-coat or paint, cover the abraded aluminum areas in the bond path with a thin primer layer of structural adhesive. If the abraded aluminum areas are not primed within two hours, they must be abraded again to remove any oxidation.





Replacement

2 Prepare the surfaces (continued).

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.



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.





Replacement

3 Apply structural adhesive (continued).

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



4 Install the new component.

A Put the new component into position.

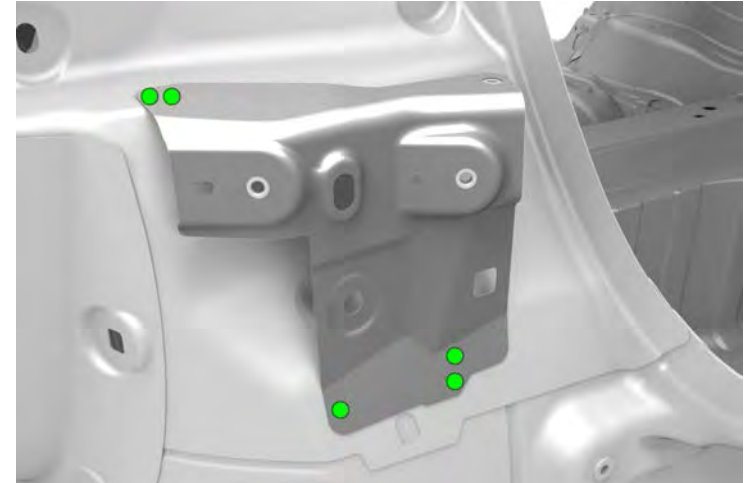




Replacement

4 Install the new component (continued).

B Insert the structural rivets.
● Structural Rivet, 4.8 mm (x5)





Replacement

4 Install the new component (continued).

C Install the structural rivets.

D Wipe off any excess adhesive.





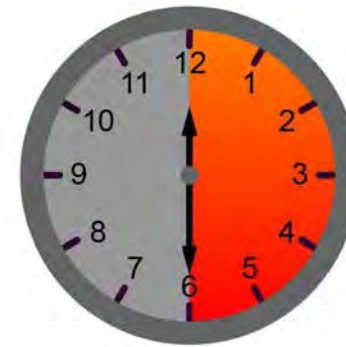
Replacement

4 Install the new component (continued).

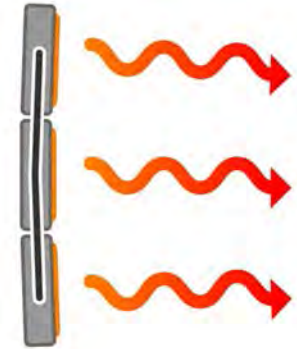
E Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



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