

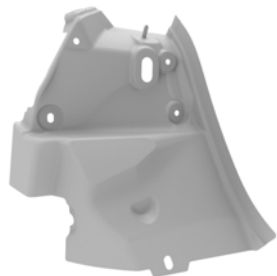


Lamp Can Assembly





Parts List

Quantity	Part Number	Description	Image / Notes
1	111206-S0-B (LH) 111207-S0-B (RH)	ASY, LAMP CAN	  NOTE: If replacing the LH Lamp Can and the LH tail light on the vehicle is revision F or earlier, replace the LH tail light with revision G (or later).
1	1102256-S0-A (LH) 1102259-S0-A (RH)	M3S BIW REAR FASCIA BRKT ASSY	
1	1104978-S0-A	M3S TRUNK TRIM ATTACHMENT BRKT LH ASSY	



Parts List

Quantity	Part Number	Description	Image / Notes
1	1102258-S0-B	M3S BIW TRIM AND AUDIO REAR BRKT ASSY	
1	1102257-S0-A	M3S SUBWOOFER ATTACH BRKT ASSY	
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.
7 or 8 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.
1 rivet 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.
1 rivet needed; order 10 rivets.	1069328-00-A	★ Flow Form Rivet S08	All rivets come in packages of 10; order all rivets in multiples of 10.



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. Installation fasteners that replace factory spot welds in steel-to-steel panel interfaces are specified in this procedure where an approved squeeze-type resistance spot welder with the base welding accessories might not be able to reach. If your approved welder can access a factory spot weld location where this procedure specifies a fastener, an installation spot weld is recommended in place of the specified fastener.	 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. Refer to BR-17-10-005, "Model 3 Body Structure Materials and Allowed Operations," for more information.	The special tools listed below are required to perform this procedure: • Microstop Countersink kit • Resistance Spot Welder Use only an approved resistance spot welder. Refer to BR-16-92-007, "Approved Welders" for a list of current approved resistance spot welders.



Prerequisites

1

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.

2

Left-hand component only: Before working on the vehicle, make sure that high voltage current is not present (refer to the appropriate section in [BR-17-17-004](#), "Disconnecting 12V and High Voltage Power on Model 3").



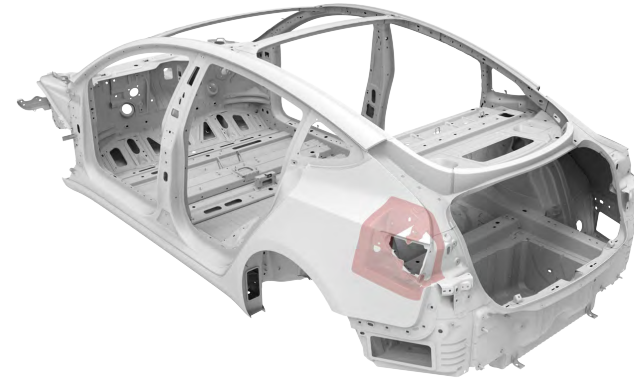
WARNING: Only technicians who have been trained in High Voltage Awareness are permitted to perform the Vehicle Electrical Isolation procedure. Proper personal protective equipment (PPE) and insulating high voltage gloves with a minimum rating of class 0 (1000V) must be worn any time a high voltage cable is handled. Refer to [TN-15-92-003](#), "High Voltage Awareness Care Points" for additional safety information.



Prerequisites

3

Left-hand component only: Remove the Chargeport Housing Assembly.





Removal

Remove the original component.

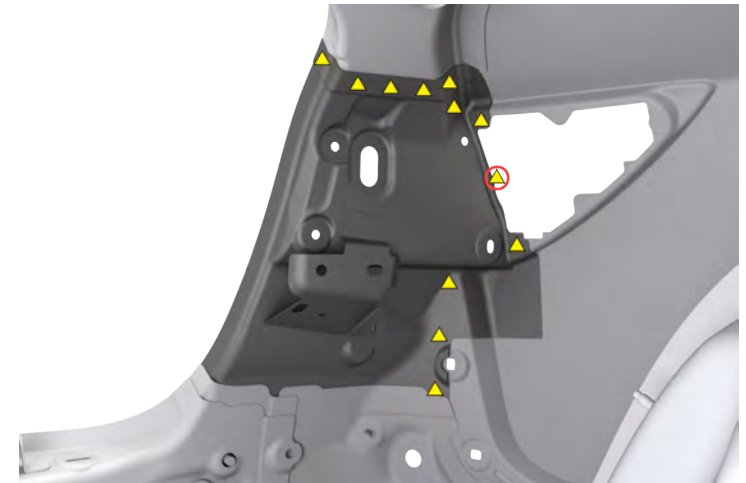
A

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: Spot weld location circled in red is for the right hand side only.

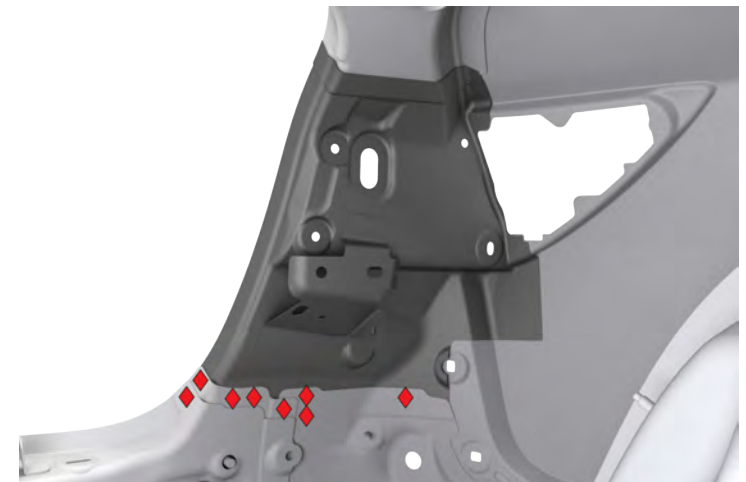


B

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 (x8)





Removal

Remove the original component (continued).

- C** 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 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.

D

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.



Replacement

1 Prepare for installation.

A Put the new component into position and secure it in place.

B Mark the fastener locations on the new component.

▲ Installation Spot Weld (x4)

● Countersunk Rivet, 4.8 mm Short (x7)

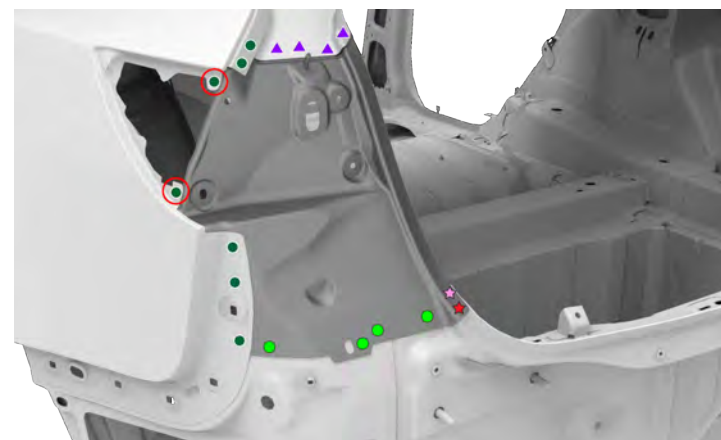
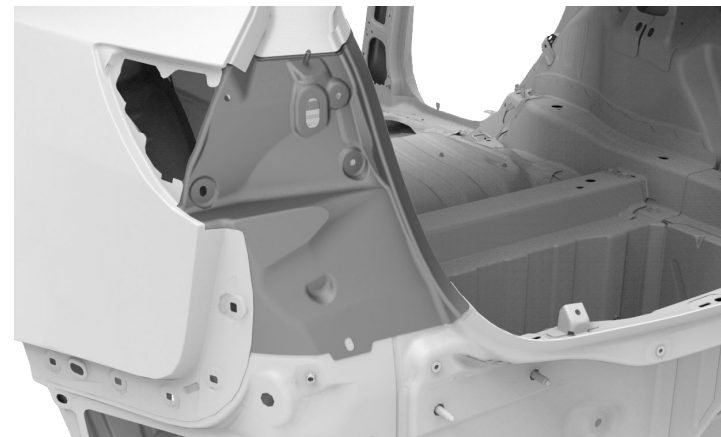
● Structural Rivet, 4.8 mm (x4)

☆ Flow Form Rivet S08 (x1)

★ Flow Form Rivet S18 (x1)



NOTE: Right-hand component only: The rivets in the locations circled in red are installed during installation of the Subwoofer Attachment Bracket.





Replacement

1 Prepare for installation (continued).

C Create 8 mm holes for flow form rivets.

★ Flow Form Rivet S18 (x1)

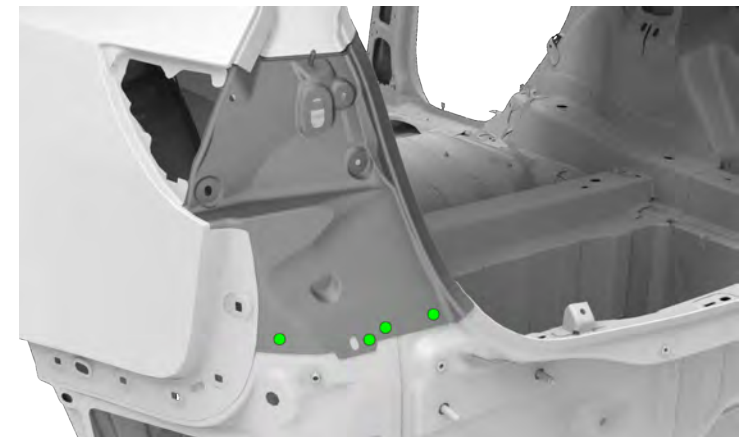
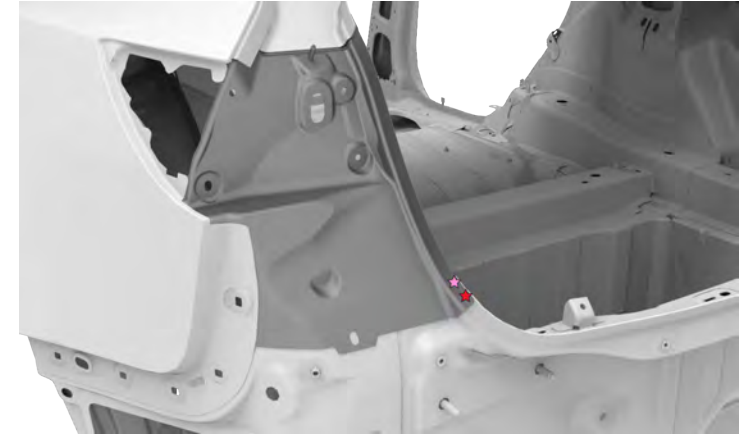
☆ Flow Form Rivet S08 (x1)

D Drill 4.8 mm holes for structural rivets through existing holes in the Rear Body Panel.

● Structural Rivet, 4.8 mm (x4)



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).

E

Drill 4.8 mm holes for countersunk rivets.

● Countersunk Rivet, 4.8 mm Short (x7)



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.

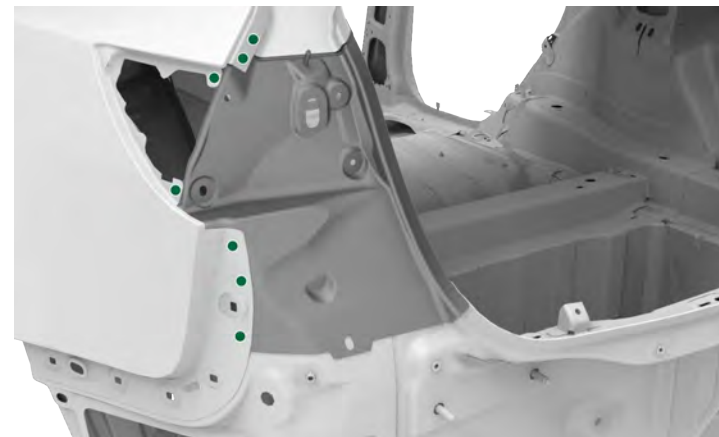
F

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

● Countersunk Rivet, 4.8 mm Short



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.





Replacement

1

Prepare for installation (continued).

G

Mark the surface preparation boundary lines on the new Lamp Can Assembly and the vehicle.

H

Remove the new component.



Replacement

1 Prepare for installation (continued).

I Use a red Scotch-Brite pad or equivalent to scuff the e-coat on the mating surfaces of the new component and the vehicle.

J 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

1 Prepare for installation (continued).

K

Spread a thin coating of structural adhesive as a primer layer on the mating surfaces of the vehicle, the backing plate, and the new component.



CAUTION: If any bare metal mating surfaces have been exposed for two hours or longer, abrade the mating surfaces again to remove oxidation, then clean the mating surfaces 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.

L

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



Replacement

2 Install the new component.

A Put the new component into position.

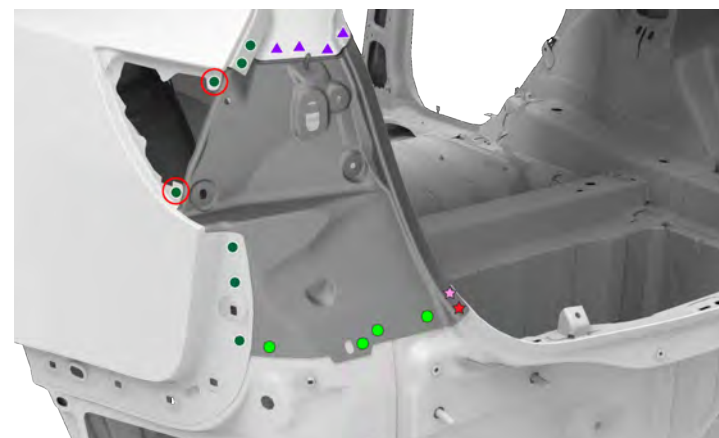
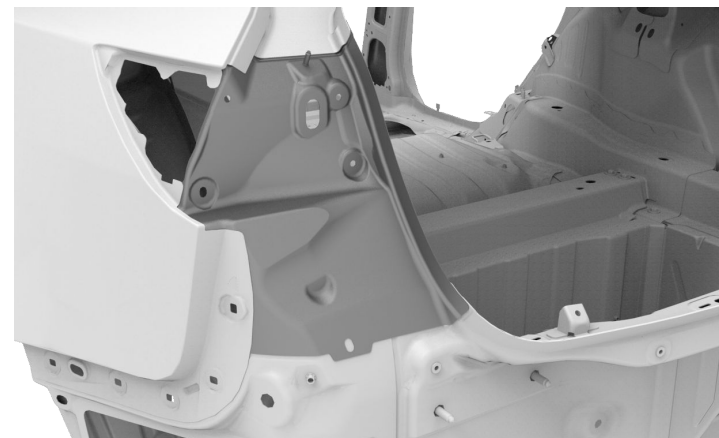
B Insert the structural rivets and Countersunk Rivets.

● Countersunk Rivet, 4.8 mm Short (x7)

● Structural Rivet, 4.8 mm (x4)



CAUTION: Right-hand component only: Do not install the 2 rivets circled in red at this time. These rivets are installed when installing the Subwoofer Attachment Bracket.



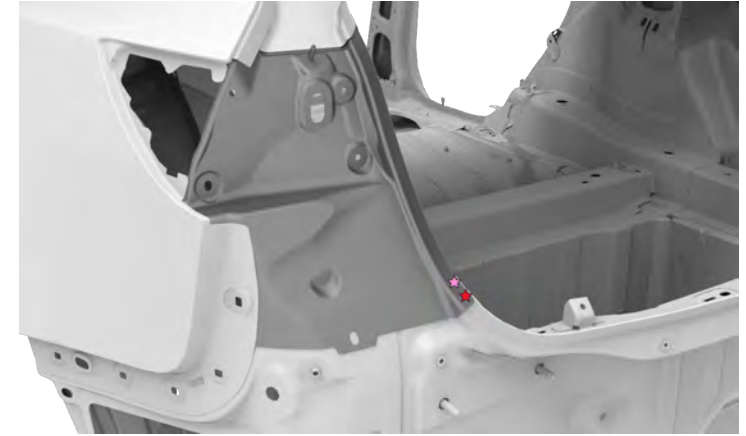


Replacement

2 Install the new component (continued).

- C Insert flow form rivets.
- ☆ Flow Form Rivet S08 (x1)
 - ★ Flow Form Rivet S18 (x1)

- D Clamp all bonded areas that are not secured with a fastener.





Replacement

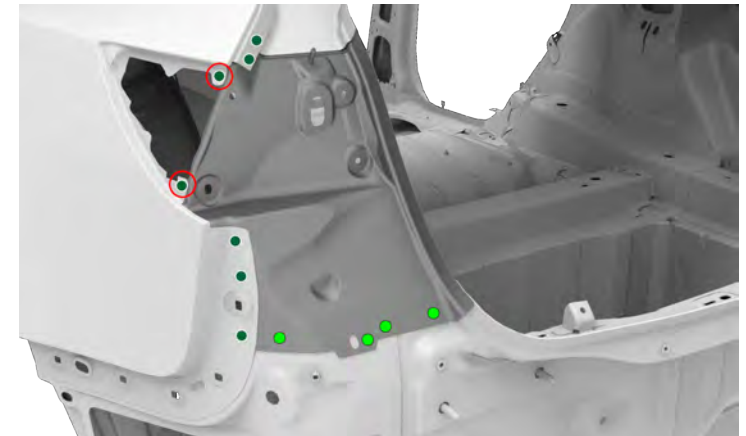
2 Install the new component (continued).

- E Install flow form rivets.
- ★ Flow Form Rivet S08 (x1)
 - ★ Flow Form Rivet S18 (x1)

F Install the structural rivets and Countersunk Rivets.



CAUTION: Right-hand component only: Do not install the 2 rivets circled in red at this time. These rivets are installed when installing the Subwoofer Attachment Bracket.





Replacement

2 Install the new component (continued).

G Perform resistance spot welding.
▲ Installation Spot Weld



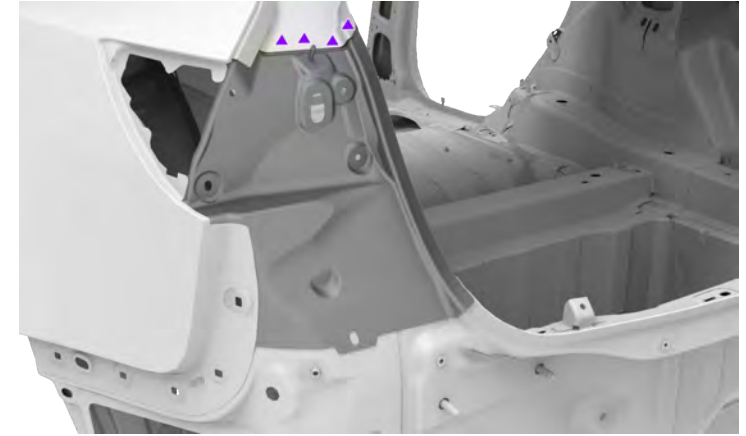
WARNING: Failure to follow all welding safety precautions, including the use of personal protective equipment, could result in serious injury or property damage. Only technicians who have successfully met Tesla's requirements for welding training are authorized to weld structural components on Tesla vehicles.



CAUTION: Do not weld on a Tesla vehicle with an energized high voltage or 12V system. Welding on a Tesla vehicle with an energized high voltage or 12V system might damage vehicle components.

H

Wipe off any excess adhesive.





Replacement

3 Prepare to install the Trunk Trim Attachment Bracket.

A

Put the new component into position and secure it in place.

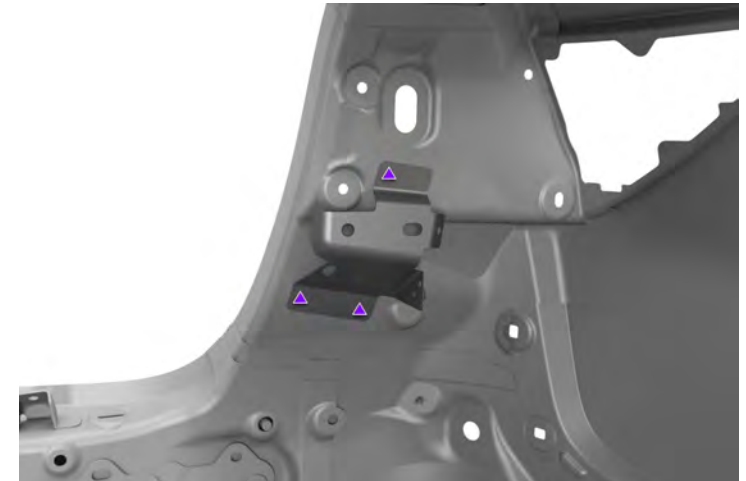
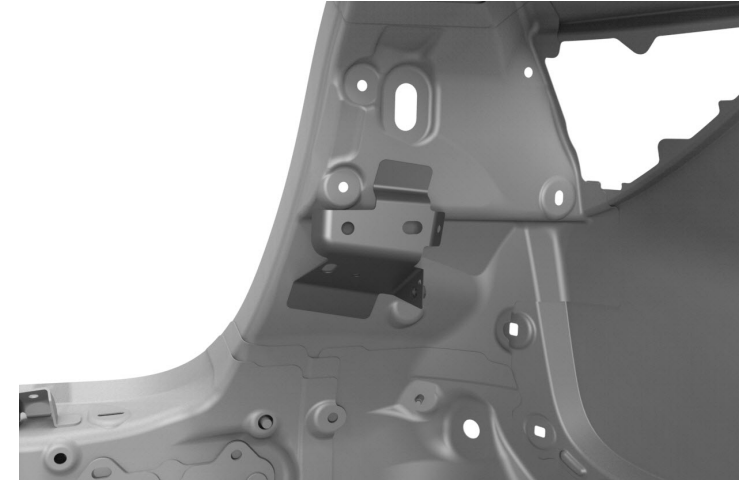


TIP: Temporarily install surrounding components to assist in properly positioning the bracket to the Lamp Can Assembly

B

Left-hand component only: Mark the fastener locations on the new component.

▲ Installation Spot Weld (x3)



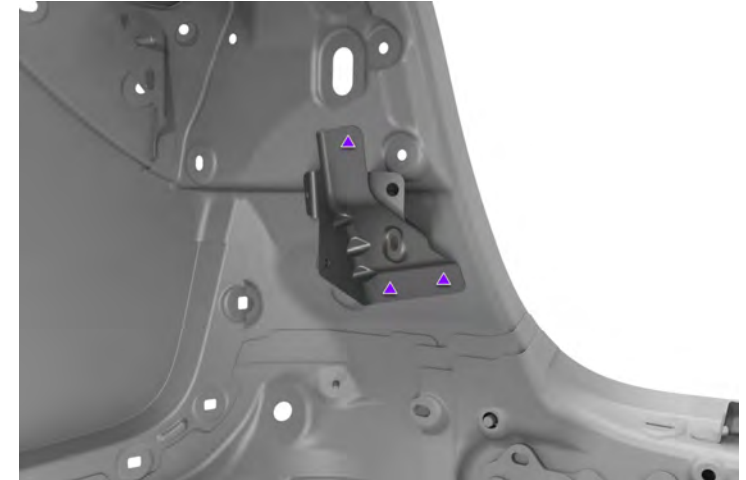


Replacement

3 Prepare to install the Trunk Trim Attachment Bracket (continued).

C **Right-hand component only:** Mark the fastener locations on the new component.

▲ Installation Spot Weld (x3)



D Mark the surface preparation boundary lines on the new Trunk Trim Attachment Bracket and the vehicle.



Replacement

3 Prepare to install the Trunk Trim Attachment Bracket (continued).

E Remove the new component.

4 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 and the vehicle.



Replacement

4 Prepare the surfaces (continued).

B Use a disc sander with a medium-abrasive surface conditioning disc to remove the e-coat from the mating surfaces and weld areas of the new components and the vehicle. Use a belt sander with a medium-abrasive belt for any areas that cannot be reached with a disc sander.

▲ Installation Spot Weld

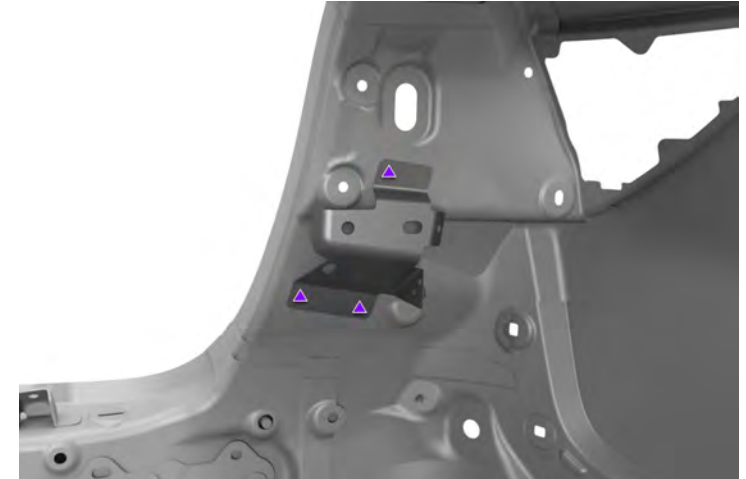


WARNING: Remove the e-coat in a well-ventilated area. Wear suitable personal protective equipment.

C 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

5 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 the bare metal mating surfaces on the vehicle have been exposed for longer than two hours, they must be abraded again to remove any oxidation before applying structural adhesive.



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

6 Install the Trunk Trim Attachment Brackets.

A Put the new component into position and secure it in place.

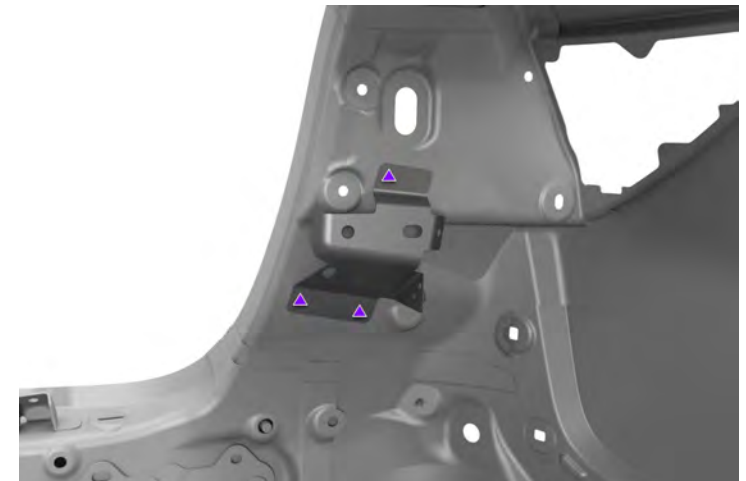
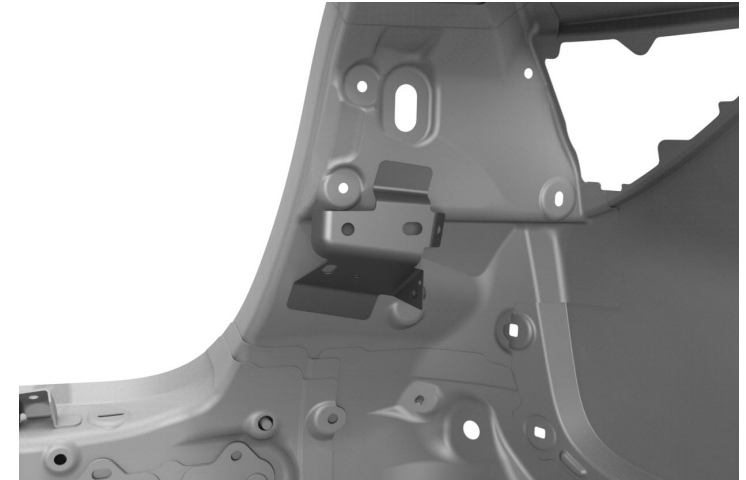
B **Left-hand component only:** Perform resistance spot welding.
▲ Installation Spot Weld (x3)



WARNING: Failure to follow all welding safety precautions, including the use of personal protective equipment, could result in serious injury or property damage. Only technicians who have successfully met Tesla's requirements for welding training are authorized to weld structural components on Tesla vehicles.



CAUTION: Do not weld on a Tesla vehicle with an energized high voltage or 12V system. Welding on a Tesla vehicle with an energized high voltage or 12V system might damage vehicle components.





Replacement

6 Install the Trunk Trim Attachment Brackets (continued).

- C** **Right-hand component only:** Perform resistance spot welding.
▲ Installation Spot Weld (x3)

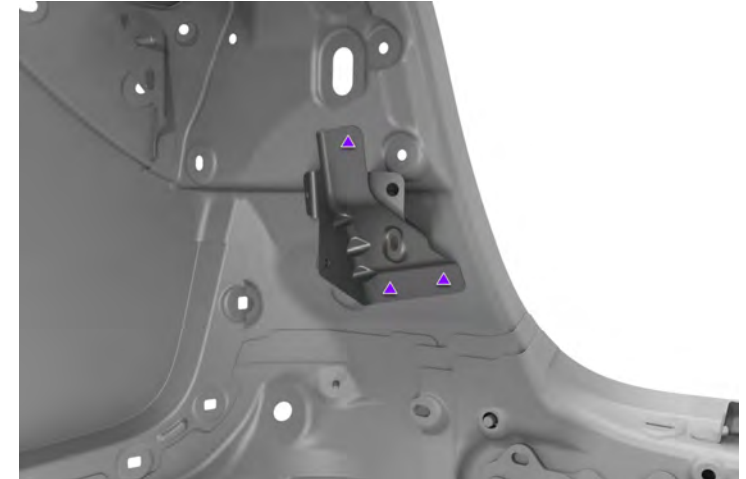


WARNING: Failure to follow all welding safety precautions, including the use of personal protective equipment, could result in serious injury or property damage. Only technicians who have successfully met Tesla's requirements for welding training are authorized to weld structural components on Tesla vehicles.



CAUTION: Do not weld on a Tesla vehicle with an energized high voltage or 12V system. Welding on a Tesla vehicle with an energized high voltage or 12V system might damage vehicle components.

- D** Wipe off any excess adhesive.





Replacement

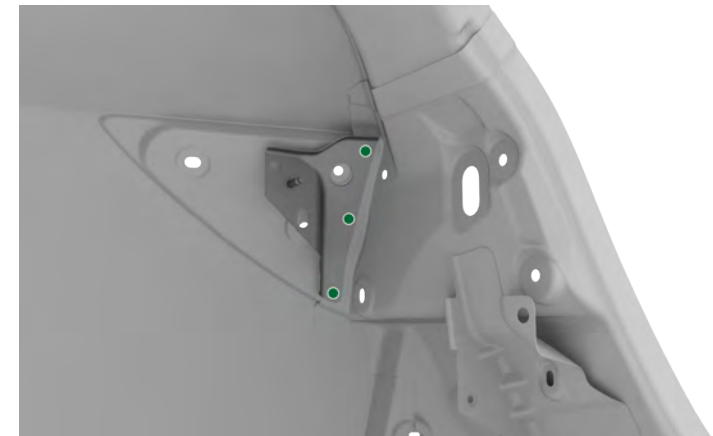
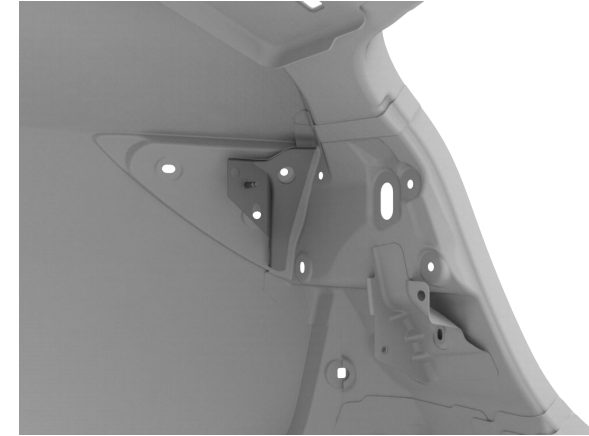
7 Right-hand component only: Prepare to install the Subwoofer Attachment Bracket.

A Put the new component into position and secure it in place.

B Mark the fastener locations on the new component.
(x3)



NOTE: When marking locations for the upper and lower Countersunk Rivet holes, use the holes drilled in an earlier step as guides.





Replacement

7 Right-hand component only: Prepare to install the Subwoofer Attachment Bracket (continued).

C Drill a 4.8 mm hole for a countersunk rivet.
(x3)



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: When drilling the holes for the upper and lower Countersunk Rivets, use the holes drilled in an earlier step as guides.



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

D

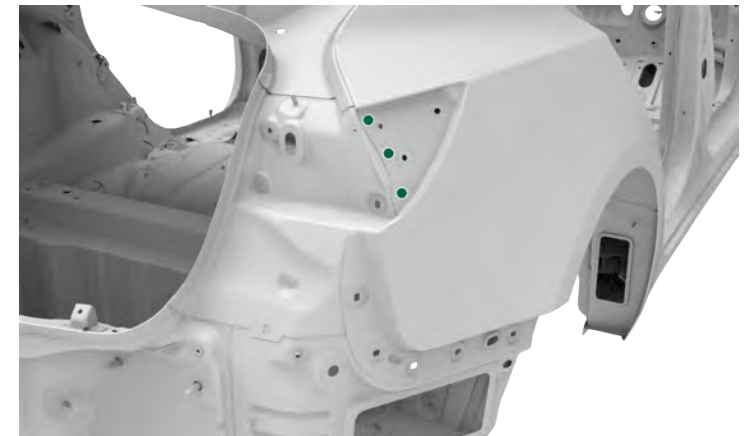
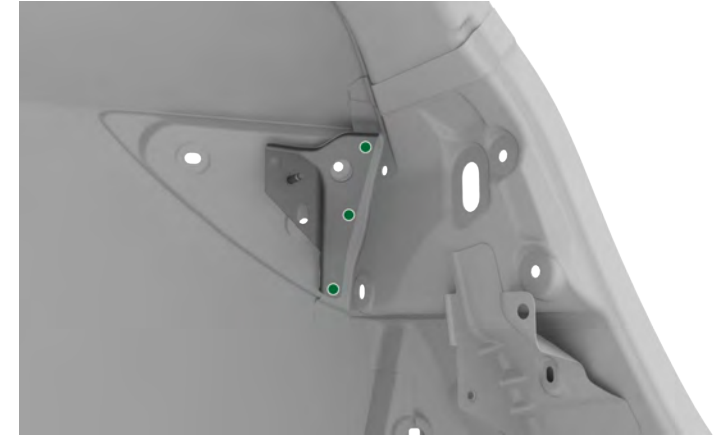
Use a drill with the Microstop countersink cage assembly and the appropriate-sized countersink bit to countersink the holes for countersunk rivets (Microstop Countersink Kit, Tesla p/n 1133101-00-A).
(x3)



NOTE: Countersink the drilled hole from outside of the vehicle, these rivets will be installed from outside the vehicle in a later step.



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.



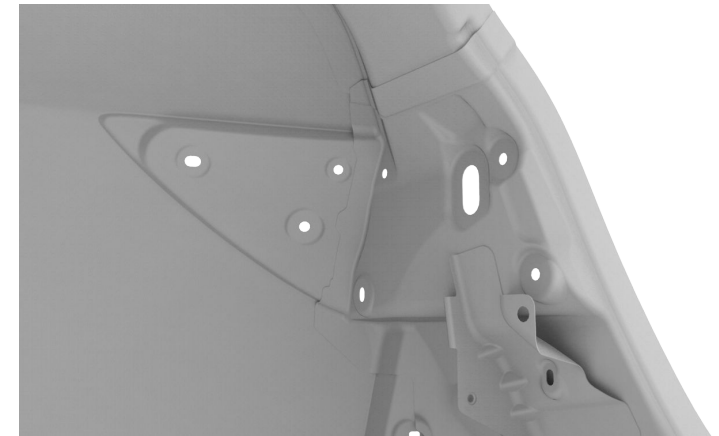


Replacement

7 Right-hand component only: Prepare to install the Subwoofer Attachment Bracket (continued).

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

F Remove the new component.





Replacement

8 **Right-hand component only:** Prepare the surfaces of the Subwoofer Attachment Bracket.

A Use a red Scotch-Brite pad or equivalent to scuff the e-coat on the mating surfaces of the new component and the vehicle.

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

9 Right-hand component only: Prepare the surfaces of the Subwoofer Attachment Bracket.

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 mating surfaces have been exposed for two hours or longer, abrade the mating surfaces again to remove oxidation, then clean the mating surfaces 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

10 Right-hand component only: Install the Subwoofer Attachment Bracket.

A

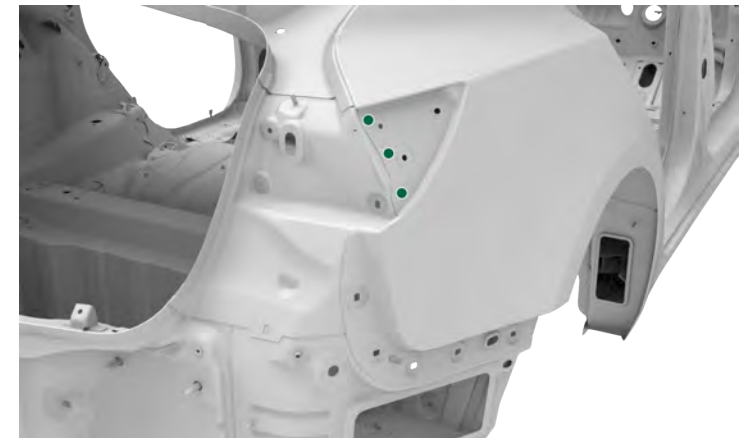
Put the new component into position and secure it in place.

B

Insert the countersunk rivet.
(x3)



NOTE: Insert the countersunk rivets from outside the vehicle.





Replacement

10 Right-hand component only: Install the Subwoofer Attachment Bracket (continued).

C

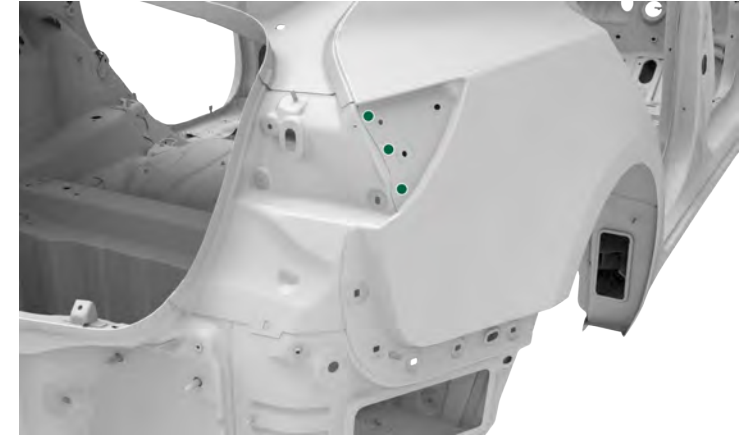
Install the countersunk rivet.



NOTE: Insert the countersunk rivets from outside the vehicle.

D

Clamp all bonded areas that are not secured with a fastener.





Replacement

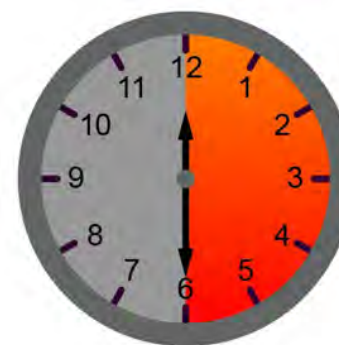
10 Right-hand component only: Install the Subwoofer Attachment Bracket (continued).

E Wipe off any excess adhesive.

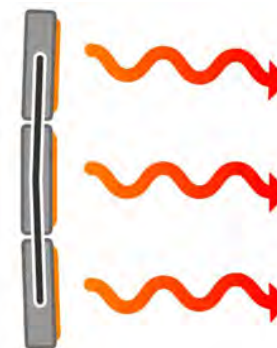
F Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



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

11

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

12

Install the Rear Fascia Bracket.





Replacement

13

Left-hand component only: Install the Charge Port Housing Assembly.

