| Tesla, Inc.<br>Service Bulletin | | *Inspect and Rework Liftgate Sealant* | |
|---|---|---|---|
| **SB-24-10-008**<br>November 6, 2024 | **R1** | | |

| **Classification** | **Section/Group** | **Mobile Service** | **Configuration** |
|---|---|---|---|
| Repair Bulletin | 10 - Body | Cannot Perform | All |

| **Model** | **Model Year** | **Country/Region** | **Build Location** |
|---|---|---|---|
| Model Y | 2023–2024 | Europe, Middle East, Africa, Taiwan | Giga Berlin |

The model(s) and model year(s) listed are a general approximation of the affected VIN list. Refer to the VIN/Bulletin Tracker or Customer/Vehicle profile to determine applicability of this bulletin for a particular vehicle.

Repair Bulletin: This repair bulletin provides instructions on addressing a possible customer concern regarding the operation of Tesla vehicles. These instructions should only be performed by trained professionals.

*This Service Document supersedes SB-24-32-004 R2, dated November 1, 2024. This new revision, R1, adds Taiwan to the Country/Region field. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.*

## Condition

On some Model Y vehicles built in Giga Berlin, the liftgate body panels in the LH and/or RH rear fog/reverse light areas may not be sealed according to Tesla standards, which may cause water ingress.

## Correction

Upon customer complaint of moisture in the liftgate or trunk area, inspect the vehicle for symptoms related to the condition. If the symptoms are present, rework the liftgate sealant.

| **Correction Description** | **Correction** | **Time** |
|---|---|---|
| SB-24-10-008 Not Applicable | S012410008 | 0.00 |
| Inspect Liftgate Sealant, No Symptoms Found | S022410008 | 0.12 |
| Inspect And Rework Liftgate Sealant | S032410008 | 0.42 |

| | **Part Number** | **Description** | **Quantity** |
|---|---|---|---|
| **If Necessary** | 1453384-00-A | M3 LIFTGATE LAMP CONNECTOR GASKET | 2 |
| | 1453383-00-A | M3 LIFTGATE LAMP DOUBLE-ENDED STUD GASKET | 2 |
| **Special Tools** | 1080593-00-A | TOOL, CAULKING & ADHESIVE GUN, M18 | |
| **Shop Supplies** | 1597715-00-A | SEAM SEALER, 3M, 310ML | |
| | | ISOPROPYL ALCOHOL (IPA) WIPES | |

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Catalog.

## Inspection

1. Remove the liftgate upper and lower trim (refer to Service Manual procedure 15111302).

2. Shake a soapy water solution in a plastic bottle to build up bubble mass, and then apply a small amount of soapy water along the edge of the LH and RH rear fog/reverse lights (Figure 1).

**Figure 1 – RH shown, LH similar**

3. Blow pressurized air at the inside of the liftgate, at the rear of the LH and RH rear fog/reverse lights, and along the edges of the body panels on LH and RH side (Figure 2).

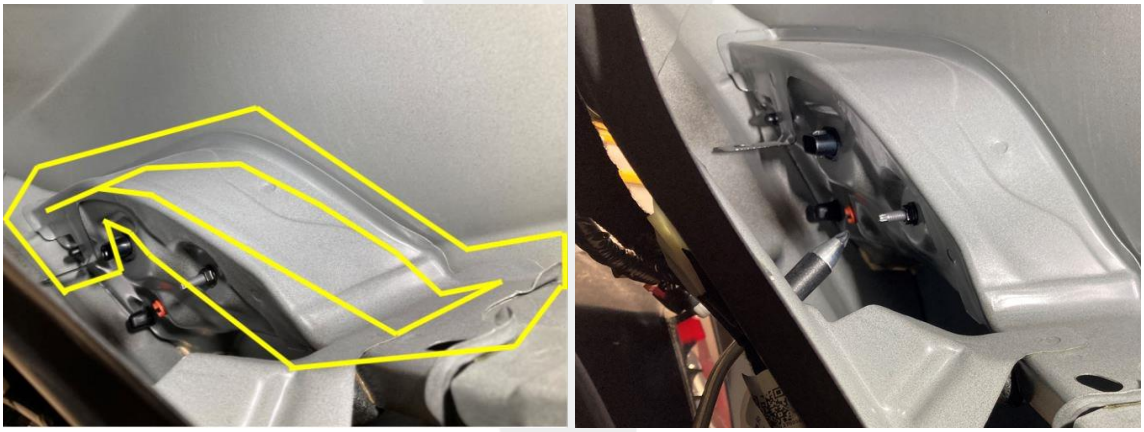

**Figure 2 – RH shown, LH similar**

4. Inspect the outside of the liftgate for large bubbles (Figure 3) and for foam being blow away (Figure 4).

**Figure 3 – RH shown, LH similar**

**Figure 4 – RH shown, LH similar**

- If a leak was detected on one or both sides of the liftgate, skip to the Rework section.
- If no leaks were detected on either side of the liftgate, proceed with the next step.

5. Clean the inspected area, and then reinstall the liftgate trim (refer to Service Manual procedure 15111302). Use correction code S022410008.

## Rework

**CAUTION:** Only technicians who have been trained in working with diisocyanates and have completed all required certification courses are permitted to perform procedures using urethane and other products containing diisocyanates. Proper Personal Protective Equipment (PPE) must be worn when working with products containing diisocyanates.

**NOTE:** Perform all steps below on the LH and RH side of the liftgate.

1. Remove the LH and RH rear fog/reverse lights from the liftgate (refer to Service Manual procedure 17402701).
2. Use a small flashlight and look for visible gaps to determine the location of the leak(s) in the indicated areas (Figure 5).

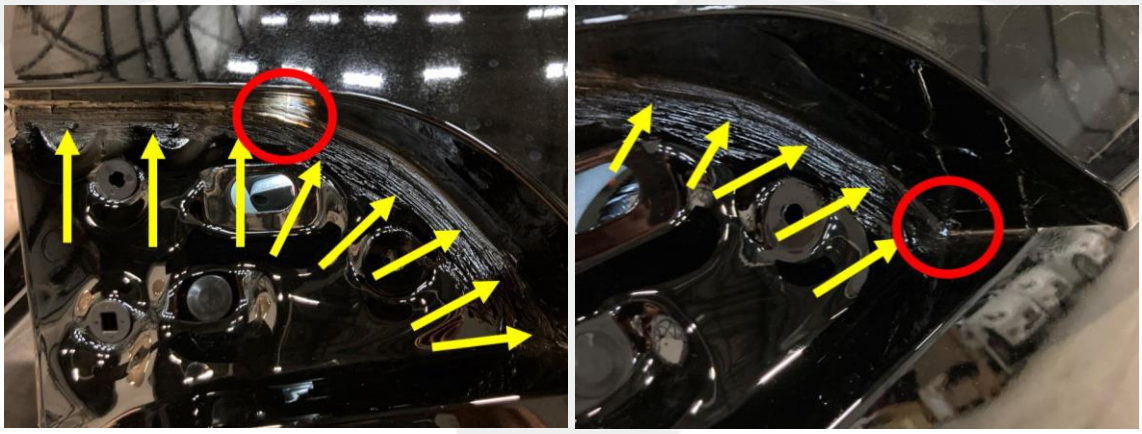

**Figure 5 – LH shown, RH similar; Red circles are examples, location may vary**

3. If the visual inspection is not successful due to very small gaps, apply a small amount of soapy water in the indicated areas (Figure 5), and then blow pressurized air from the inside of the liftgate to determine the location of the leak(s).
4. Clean the areas with a shop towel, and then use IPA wipes to clean the affected surface of the liftgate.

   **NOTE:** Allow 1 minute for the IPA to dry.

5. Prepare the caulking gun, and cut the sealant tube just above the threads of the cap.

   **CAUTION:** Do not cut the nozzle to create a larger nozzle opening.

   **CAUTION:** Use the appropriate Personal Protection Equipment (PPE) when working with sealant.

6. Apply sealant to the affected areas of the liftgate, using the lowest speed setting on the caulking gun.

7. Flatten the beads of sealant using gloves or a cotton dauber if needed, and make sure that the affected areas are filled completely (Figure 6).

**Figure 6 – LH shown, RH similar.**

8. Allow time for the sealant to dry. Refer to the label on the sealant tube for work time and full cure time.

   **NOTE:** Work time and full cure time may vary per region and product.

9. Clean the rework areas with IPA wipes, and then allow 1 minute for the IPA to dry.
10. Apply touch up paint to the rework areas of the liftgate, and then allow the paint to dry.
11. Reinstall both rear fog/reverse lights and the liftgate trim (refer to Service Manual procedure 17402701). Use correction code S032410008.