

 HYUNDAI Technical Service Bulletin	GROUP RECALL	NUMBER 22-01-051H
	DATE MAY, 2022	MODEL(S) ELANTRA (CN7A) SANTA FE (TMA)
SUBJECT: WINDSHIELD GLASS REPAIR (RECALL 216)		

★ IMPORTANT

***** Dealer Stock & Retail Vehicles *****

As required by federal law, dealer must not deliver new vehicles for sale or for lease to customers until all open recalls have been performed. Dealers must also perform all open recalls on used vehicles, demo, and rental vehicles prior to placing them into customer use and whenever an affected vehicle is in the shop for any maintenance or repair.

When a vehicle arrives at the Service Department, access Hyundai Motor America's "Vehicle Information" screen (VIS) via WEBDCS to identify open Recalls.

Description: Certain 2021MY Elantra (CN7A) and 2020 – 2021MY Santa Fe (TMA) vehicles may have been built with nonconforming clear coat paint, which may lead to inadequate front windshield adhesion to the vehicle body. The windshield may not stay adequately retained in a crash, which may increase the risk of injury to an occupant. This bulletin describes the procedures to repair this condition.



Applicable Vehicles:

Certain 2021MY Elantra (CN7A) vehicles (VINs starting with "5NP") produced between 10/29/2020 and 1/8/2021.

Certain 2020 – 2021MY Santa Fe (TMA) vehicles (VINs starting with "5NM") produced between 10/29/2020 and 12/7/2020.

NOTICE

The windshield is intended to be reused as part of this procedure. Some of the procedures may involve sublet to glass companies or body shops.

Parts Information:

MODEL	PART NAME	PART NUMBER	REMARKS
Elantra (CN7A)	GLASS ASSY-WINDSHIELD	86110-AB020QQH	The windshield glass is intended to be reused. If a new windshield is required, please refer to the parts catalog for the applicable part number to your vehicle. Parts for this recall have an additional 'QQH' added to the part number in the parts catalog. The glass pads are only required if the windshield is reused. They are already included with a new windshield. The upper molding must be replaced, regardless if the windshield is new or reused.
		86110-AB025QQH	
		86110-AB045QQH	
	PAD-WINDSHIELD GLASS	86114-3D000	
	MOLDING-WINDSHIELD, UPPER	86121-AB000	
Santa Fe (TMA)	GLASS ASSY-WINDSHIELD	86110-S2120QQH	
		86110-S2140QQH	
		86110-S2160QQH	
		86110-S2280QQH	
		86110-S2290QQH	
		86110-S2300QQH	
		86110-S2310QQH	
	PAD-WINDSHIELD GLASS	86114-3D000	
	MOLDING-WINDSHIELD, UPPER	86121-S1000	

SST Information

DESCRIPTION	IMAGE	REMARK
Urethane scraper tool		N/A
Pneumatic angle die grinder		N/A
3M Scotch-Brite Roloc Disc		180 – 240 grit (Super Fine or Very Fine)
Sandpaper		180 grit
Collision or window guard wrap		N/A

NOTE: Tools can be purchased at local or online retailers.

Warranty Information:

MODEL	DESCRIPTION	NEW WINDSHIELD?	OP CODE	OP TIME	WINDSHIELD (QTY: 1)	UPPER MOLDING (QTY: 1)	GLASS PADS (QTY: 10)
Elantra (CN7A)	Admin & Front Camera Calibration (New Windshield)	Yes	11DA31A0	0.8 M/H	86110-AB020QQH	86121-AB000	N/A
			11DA31A1		86110-AB025QQH		
			11DA31A2		86110-AB045QQH		
Admin & Front Camera Calibration (Existing Windshield)	No	11DA31A3	N/A		86114-3D000		
Santa Fe (TMA)	Admin & Front Camera Calibration (New Windshield)	Yes	11DA31A9		86110-S2120QQH	86121-S1000	N/A
			11DA31B0		86110-S2140QQH		
			11DA31B1		86110-S2160QQH		
			11DA31B2		86110-S2280QQH		
			11DA31B3		86110-S2290QQH		
			11DA31B4		86110-S2300QQH		
			11DA31B5	86110-S2310QQH			
			Admin & Front Camera Calibration (Existing Windshield)	No	11DA31B6		

NOTE 1: Submit 2 or 3 claims as needed:

1. **Submit one claim as Campaign** from the op code table listed above. The Campaign claim will include reimbursement of the following:
 - Camera calibration (existing or new windshield)
 - Administrative time
 - If existing windshield is used: Glass pads (QTY: 10) & upper molding (QTY: 1)
 - If new windshield is used: Windshield (QTY: 1) & upper molding (QTY: 1)
2. **Submit the 2nd claim as Warranty** using the same repair order as the Campaign claim. Include all sublet items under op code 86110AZZ with the following information:

Repair Order	OP Code	Sublet Code	Nature Code	Causal Code	Causal Part
Same as Campaign claim	86110AZZ	G1	I11	ZZ8	QQH or OE windshield

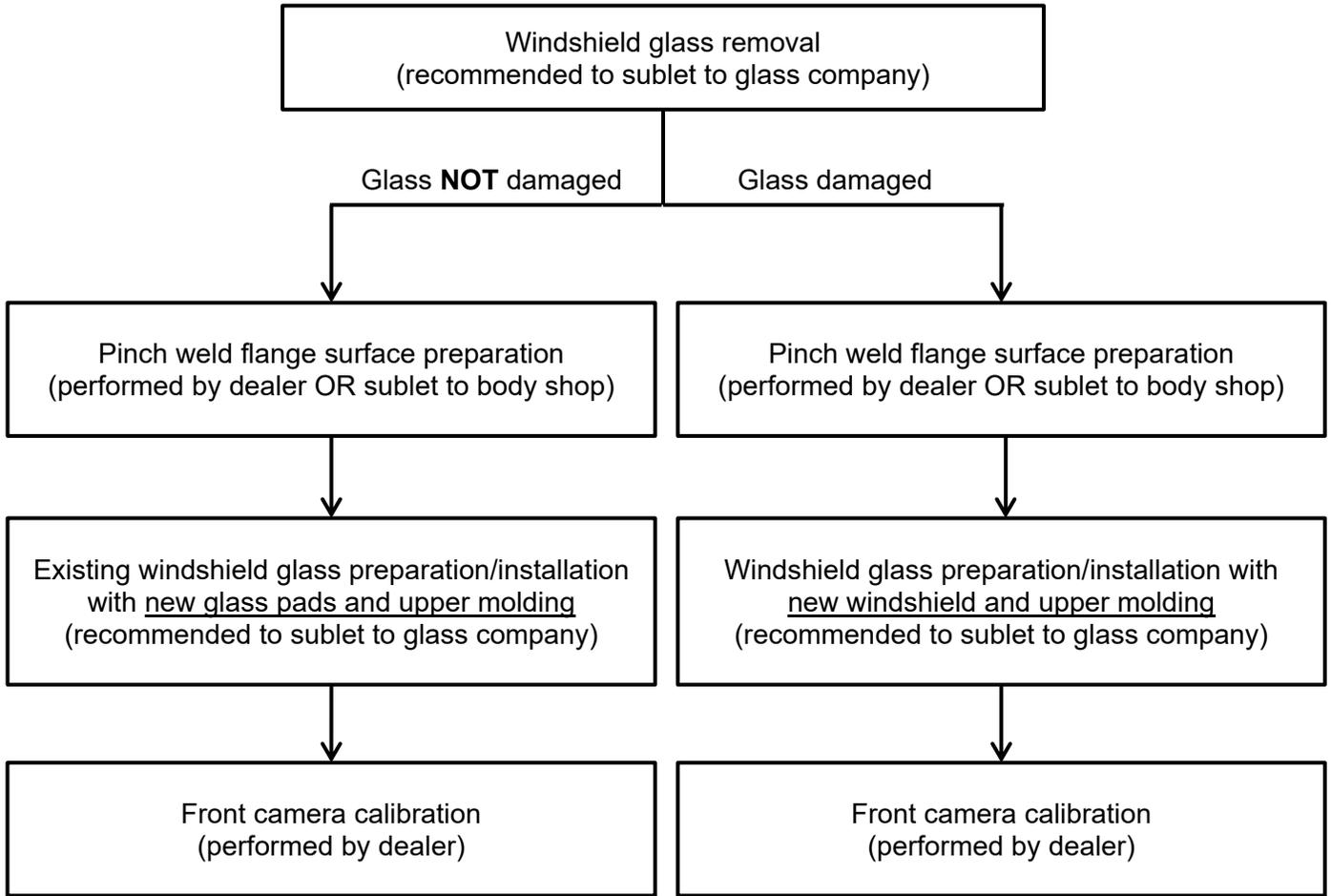
The Warranty claim will include the following:

- Labor for windshield glass removal
 - Labor for pinch weld flange surface preparation
 - Labor for existing/new windshield glass preparation & installation
 - Any miscellaneous materials for repair (sealant, shop supplies, etc.)
3. If a rental is needed, use the same repair order as the Campaign claim and submit as a separate claim.

NOTE 2: If a part that is not covered by this recall is in need of replacement while performing this recall, and the affected part is still under warranty, please submit a separate claim using the same repair order. If the part is out of warranty, submit a prior approval request for goodwill consideration prior to performing the work. This claim must be submitted separately from the one noted above in Note 1, #2. Do not combine them.

Service Procedure:

A. Repair Procedure Overview



Refer to the QR code or link below for guided video information:
[Hyundai Service Learning – Recall 216 Service Procedure](#)

B. Windshield Glass Removal (Recommended to Sublet to Glass Company)

1. It is recommended to sublet the vehicle to an automotive glass company to perform the windshield glass removal.
2. Remove the windshield glass using a rotating wire removal tool to minimize damage to the glass.

Refer to the shop manual for the complete windshield removal procedure:

Body (Interior and Exterior) > Windshield Glass > Repair Procedures

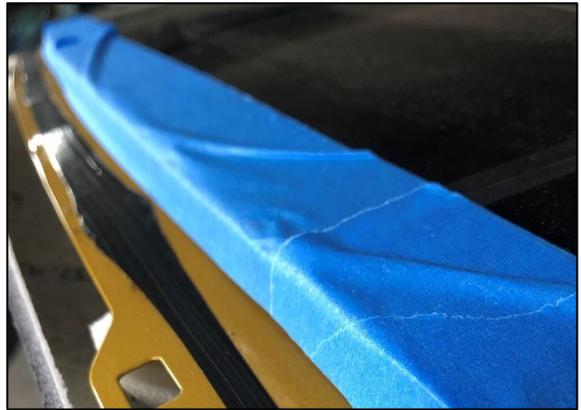
NOTICE

The existing windshield is intended to be reused as part of this procedure. Be extremely careful not to damage the windshield during removal.



C. Pinch Weld Flange Surface Preparation (Performed by Dealer or Sublet to Body Shop)

1. Apply masking tape to the areas around the flange to prevent unnecessary damage.
 2. Apply collision wrap or window guard wrap to prevent debris from entering the interior of the vehicle.
 3. With a razor blade or a urethane scraper, make a cut through the urethane (rubber sealant) on the flange.
 4. Pry up a side of the urethane and peel it away from the flange.
 5. Use the scraper tool to cut through the urethane while continuously peeling it away.
- Remove as much urethane as possible without scratching or damaging the flange surface.



6. In the areas where the urethane did not adhere properly to the flange surface, the urethane will be easier to peel off as shown in the photo.

After removing any remaining urethane with a scraper, use 180 grit sandpaper to scuff these areas of the flange surface until it appears hazy.

NOTICE

Only scuff the areas where the urethane was previously or will be applied.



7. In the areas where the urethane is adhered properly to the flange surface, the urethane will be more difficult to remove by hand.

After trimming off as much urethane as possible, use a 180 – 240 grit (Super Fine or Very Fine) 3M Scotch-Brite Roloc disc to remove all remaining urethane in these areas.

NOTICE

Excessive abrasion will cause damage to the clear coat and base paint. Use light pressure to minimize damage to the flange surface.

Only scuff the areas where the urethane was previously or will be applied.



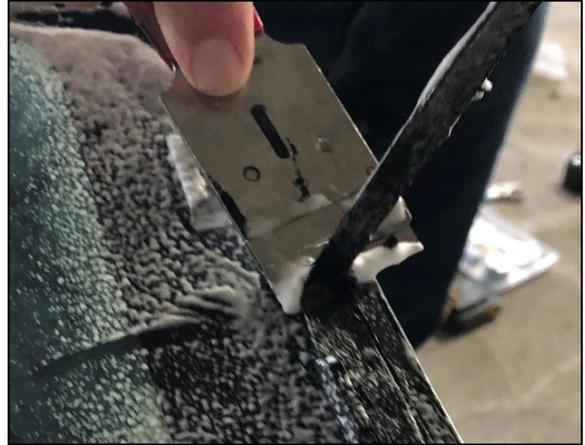
D. Windshield Glass Preparation (Recommended to Sublet to Glass Company)

1. If the windshield was damaged upon removal and a new windshield is required, skip to the next section.

It is recommended to sublet the vehicle to an automotive glass company to perform the windshield glass surface preparation.

2. With a razor blade, make a cut through the urethane (rubber sealant) on the windshield glass.

A glass cleaner may be used to assist with the removal of the urethane.



3. Pry up a side of the urethane and peel it away from the windshield glass.
4. Use the scraper tool to cut through the urethane while continuously peeling it away.

Remove as much urethane as possible without scratching or damaging the windshield glass.

NOTICE

Remove any glass pads that are embedded in the urethane. Do not remove glass pads that are outside of the urethane.

5. Install new glass pads on the windshield glass where they were previously located.

NOTICE

Existing glass pads should be reused if they are not embedded in the urethane or in the path of the urethane bead.



E. Windshield Glass Installation (Recommended to Sublet to Glass Company)

1. Thoroughly remove any debris/contamination from the pinch weld flange and wipe it clean.
2. Apply 2 coats of primer to the entire flange surface where the urethane was previously applied.

Allow time for the primer to dry per the manufacturer's instructions.

NOTICE

Allow each coat to dry before applying the next coating.



3. If the windshield was damaged from the removal procedure, proceed to the next step to prepare the new windshield for installation.

If the windshield was not damaged and is being reused, skip to step 5.

4. Use a glass cleaner and a lint-free cloth to clean off the windshield glass surface.
5. Apply one coat of glass primer to the windshield glass.

Allow the primer to dry according to the manufacturer specifications.

6. Install the new windshield upper molding.



7. Open the door windows to prevent sudden air pressure spikes from closing vehicle doors, which may affect the urethane adhesion.

NOTICE

The door windows must be left open during the adhesive curing process.

8. Use a power caulk gun to apply a continuous and uniform urethane bead on the flange surface where the primer was applied.

NOTICE

The urethane bead should be approximately 1/2 in (14 mm) high and 5/16 in (8 mm) wide.

The windshield glass must be installed within 10 minutes of applying the urethane adhesive.



9. Install the windshield on the vehicle.

NOTICE

When installing the windshield glass, press it down firmly on all edges to ensure a good bond.

Secure the windshield glass in position with tape until the urethane adhesive has cured.

NOTICE

Wait approximately 30 minutes for the urethane to cure before moving the vehicle.

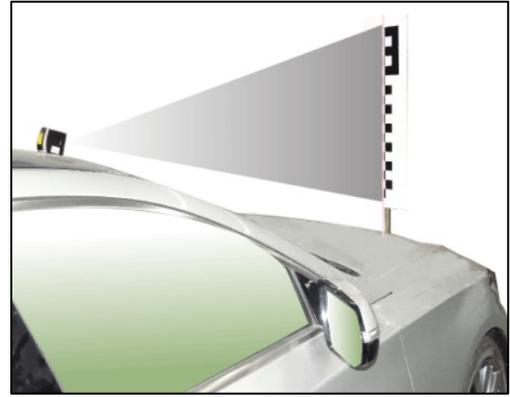


F. Front Camera Calibration (Performed by Dealer)

1. Perform the SPTAC (Service Point Target Auto Calibration) for the front view camera.

Refer to the shop manual for the complete calibration procedure:

**Advanced Driver Assistance System (ADAS)
> Front View Camera System > Repair
Procedures > Service Point Target Auto
Calibration (SPTAC)**



2. The service procedure is now complete.