 <b>Tesla, Inc.</b> <b>Service Bulletin</b>		<h1>Inspect 1<sup>st</sup> Row Seatbelt Bolts</h1>	
<b>SB-21-20-001</b> May 13, 2023		<b>R1</b>	
<b>Classification</b> Recall Bulletin		<b>Section/Group</b> 20 - Safety and Restraint	<b>Mobile Service</b> Can Perform (where permitted)
<b>Model Year</b> 2018 - 2021	<b>Model</b> Model 3, Model Y	<b>Country/Region</b> All	<b>Version</b> All
<small>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.</small>			

Recall Bulletin: Recall Bulletins are mandatory service procedures that must be carried out by Tesla-certified Service Centers. Recall work performed by uncertified technicians could lead to unsafe conditions or voided warranty provisions.

*This Service Document supersedes SB-21-20-001, dated May 27, 2021. This new revision, R1, corrects the drill bit size for the Helicoil insert. 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 3 and Model Y vehicles, the 1st row LH and RH seatbelt D-ring to adjustable top loop bolt and/or adjustable top loop to B-pillar bolt may not have been secured to the correct specifications.

## Correction


Inspect the vehicle for symptoms related to the condition. If symptoms are present, torque the fasteners to the correct specifications and, if necessary, repair the LH/RH B-pillar bolt hole thread(s), replace the LH/RH adjustable top loop(s), and/or replace the fasteners.

Correction Description	Correction	Time
Inspect 1 <sup>st</sup> Row Seatbelts, No Repairs Needed	S012120001	0.10
Inspect 1st Row Seatbelts, Replace LH Adjustable Top Loop	S022120001	0.10
Inspect 1st Row Seatbelts, Replace RH Adjustable Top Loop	S032120001	0.10
Inspect 1st Row Seatbelts, Repair LH B-Pillar Threads	S042120001	0.15
Inspect 1st Row Seatbelts, Repair RH B-Pillar Threads	S052120001	0.15
Inspect 1st Row Seatbelts, Replace LH and RH Adjustable Top Loops	S062120001	0.15
Inspect 1st Row Seatbelts, Replace LH Adjustable Top Loop and Repair LH B-Pillar Threads	S072120001	0.15
Inspect 1st Row Seatbelts, Replace RH Adjustable Top Loop and Repair RH B-Pillar Threads	S082120001	0.15
Inspect 1st Row Seatbelts, Replace LH Adjustable Top Loop and Repair RH B-Pillar Threads	S092120001	0.20
Inspect 1st Row Seatbelts, Replace RH Adjustable Top Loop and Repair LH B-Pillar Threads	S102120001	0.20
Inspect 1st Row Seatbelts, Replace LH and RH Adjustable Top Loops and Repair LH B-Pillar Threads	S112120001	0.20
Inspect 1st Row Seatbelts, Replace LH and RH Adjustable Top Loops and Repair RH B-Pillar Threads	S122120001	0.20
Inspect 1st Row Seatbelts, Repair LH and RH B-Pillar Threads	S132120001	0.25
Inspect 1st Row Seatbelts, Replace LH Adjustable Top Loop and Repair LH and RH B-Pillar Threads	S142120001	0.25
Inspect 1st Row Seatbelts, Replace RH Adjustable Top Loop and Repair LH and RH B-Pillar Threads	S152120001	0.25
Inspect 1st Row Seatbelts, Replace LH and RH Adjustable Top Loops and Repair LH and RH B-Pillar Threads	S162120001	0.25

	Part Number	Description	Quantity
<b>If Necessary</b>			
	1068130-01-B	M3Y 1R SB HEIGHT ADJUSTER	1-2
	1515051-00-A	SBOLT[9x13],7/16x10,[109],G0109[B],PTP	1-2
	1117247-00-A	M3 - M8X1.5 25MM HA70 CAPTURED FASTENER	1-2
These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the <a href="#">Parts Catalog</a> .			
<b>Special Tools</b>			
	1056155-08-A	KIT, THREAD REPAIR, M8 X 1.25	
	1115199-00-A	HAMMER, DEAD BLOW, 48OZ	
<b>Shop Supplies</b> Tesla Cutting Lube			

## Procedure

1. Release the LH B-pillar trim from the vehicle, and then set it aside (refer to Service Manual procedure 20051001; [Model 3](#), [Model Y](#)).

 **NOTE:** The B-pillar trim is still attached to the seatbelt.

2. Inspect the bolt that attaches the LH 1<sup>st</sup> row seatbelt retractor D-ring to the adjustable top loop.
  - If bolt threads are not visible between the retractor D-ring and adjustable top loop (Figure 1), the adjustable top loop does not require inspection; take note and skip to step 3

 **NOTE:** Visible bolt collar (Figure 1, yellow arrow) is expected.

- If bolt threads are visible between the retractor D-ring and adjustable top loop (Figure 2, yellow arrow), the bolt and adjustable top loop bolt hole threads require inspection; take note and continue to step 3.

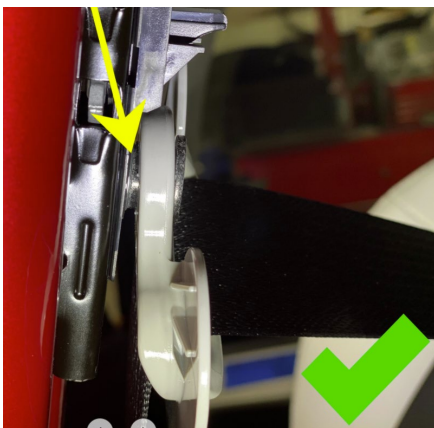


Figure 1 – LH shown; RH similar

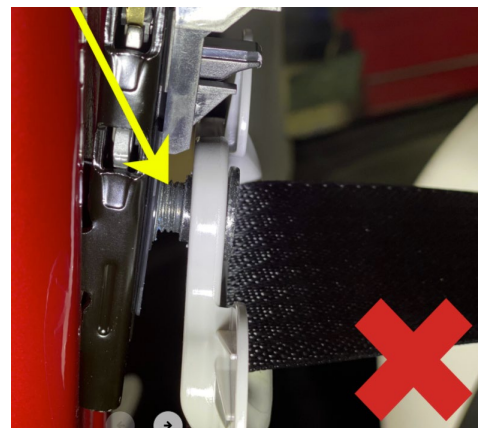


Figure 2 – LH shown; RH similar

3. Wiggle the LH adjustable top loop and inspect for a gap between the adjustable top loop and the B-pillar (Figure 3).



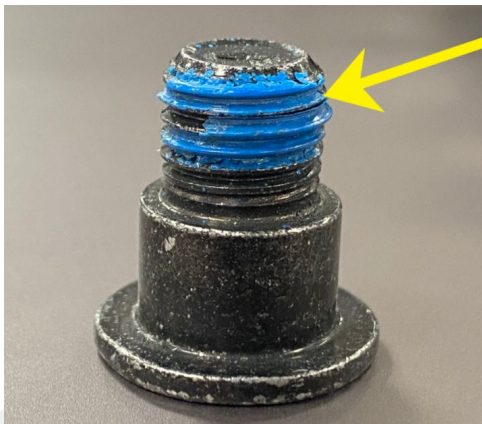
**Figure 3 – LH shown; RH similar**

- If the adjustable top loop does not wiggle and is tight against the B-Pillar, the B-pillar bolt hole threads do not require inspection; take note and skip to step 4.
  - If the adjustable top loop wiggles or is not flush against the B-pillar, the adjustable top loop bolt and B-pillar bolt hole threads require inspection; take note and skip to step 5.
4. If steps 2 **and** 3 determine that no further inspection is required, torque both previously mentioned bolts (torque 20 Nm), take note, and skip to step 10. If further inspection is required, continue to step 5.
  5. If inspection is required, remove the bolt that attaches the LH 1<sup>st</sup> row seatbelt retractor D-ring to the adjustable top loop, and then set the retractor D-ring aside (Figure 4). If inspection is not required, skip to step 8.



**Figure 4 – LH shown; RH similar**

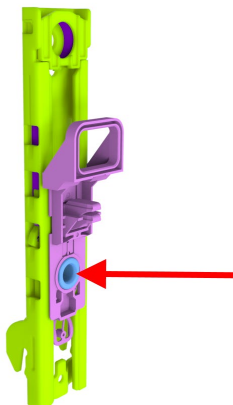
6. Inspect the bolt that attaches the LH 1<sup>st</sup> row seatbelt retractor D-ring to the adjustable top loop (Figure 5).



**Figure 5**

- If any of the bolt threads are damaged, discard the bolt and procure a new bolt.
- If none of the bolt threads are damaged, set the bolt aside for reuse.

7. Inspect the LH 1<sup>st</sup> row seatbelt retractor D-ring to adjustable top loop bolt hole (Figure 6).



**Figure 6 – LH shown; RH similar**

- If the bolt hole threads are damaged, the adjustable top loop requires replacement; take note and skip to step 8.
- If the bolt hole threads are undamaged, the adjustable top loop does not require replacement; take note and continue to step 8.

8. If inspection is required, remove the bolt that attaches the LH adjustable top loop to the B-pillar (Figure 7) and inspect the B-Pillar bolt hole (Figure 8). If inspection is not required, skip to step 10.



**Figure 7 – LH shown; RH similar**




**Figure 8 – LH shown; RH similar**

- If the B-pillar bolt hole threads are damaged, repair is required; take note and skip to step 9.
  - If the B-pillar bolt hole threads are not damaged, repair is not required; take note and continue to step 9.
9. If the adjustable top loop is being reused, inspect the bolt that attaches the LH adjustable top loop to the B-pillar (Figure 9).




**Figure 9**


- If any of bolt threads are damaged, remove and discard the clip that attaches the bolt to the adjustable top loop, discard the bolt, and install a new bolt.
-  **NOTE:** The clip does not need reuse or replacement.
- If none of the bolt threads are damaged, take note and set the adjustable top loop aside.
10. Repeat steps 1–9 for the RH 1<sup>st</sup> row seatbelt, and after returning to this step, continue to step 11.
11. Repair any damaged B-pillar bolt holes as instructed in section “B-pillar Repair”.
12. Replace or reinstall the adjustable top loop(s) depending on the noted condition of the adjustable top loop bolt hole threads, and then install all components that were removed for access (refer to Service Manual procedure 20051001; [Model 3](#), [Model Y](#)).

 **NOTE:** If upon inspection the seatbelt retractor D-ring bolt was undamaged, it can be reused.


## B-Pillar Thread Repair


 **NOTE:** Refer to [TN-15-92-001](#) for guidelines on using the thread repair kit.

1. Use the 8.3 mm drill bit from the thread repair kit, with cutting oil, to drill out the damaged threads (Figure 10).

 **WARNING:** Wear safety glasses to protect from debris.

 **CAUTION:** Do not drill through the vehicle body. Only drill out the damaged threads.

 **NOTE:** If necessary, start with a smaller drill bit.


 **NOTE:** Back out and re-insert the drill bit as needed.




**Figure 10 – LH shown; RH similar**

2. Use the Heli-Coil tap, with cutting oil, to tap new threads on the B-pillar (Figure 11). Reapply cutting oil as needed.

 **CAUTION:** Make sure the tap remains perpendicular with the bolt hole.

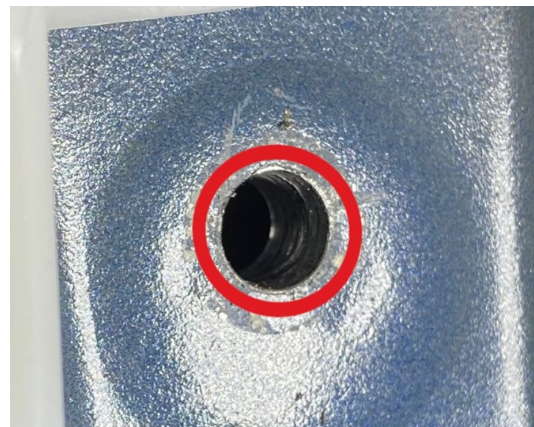
 **CAUTION:** Do not tap past the weld collar nut. Refer to Figure 12 to visualize the depth of the weld collar nut.

 **NOTE:** For every full rotation of the tap, back out ½ a turn to break off any metal shavings.

 **NOTE:** If necessary, completely back out the tap to clean off excess debris.



**Figure 11 – LH shown; RH similar**



**Figure 12**

3. From the thread repair kit, obtain a Heli-Coil insert that matches the depth of the tapped threads.

4. Position a Heli-Coil insert on a threaded handle, and then install the insert in the B-pillar (Figure 13).

**⚠ CAUTION:** Make sure the insert is flush with the surface of the B-pillar and that tapped threads are not visible past the insert (Figure 14).



**Figure 13 – LH shown; RH similar**



**Figure 14**

5. Use the tang break-off tool and a deadblow hammer to break the Heli-Coil tang (Figure 15).



**Figure 15 – LH shown; RH similar**

6. Clean up any excess cutting oil and metal shavings in the cabin.