



BENTLEY

Bentley Bulletin

Aftersales

23-023

March 28, 2023

To: Parts & Service

Subject: NON COMPLIANCE RECALL - SEAT AIR BAG MAY TEAR (RE23/03)

NON COMPLIANCE RECALL - SEAT AIR BAG MAY TEAR/FMVSS 214 & 208 (RE23/03)

Overview

On certain vehicles, due to a sharp edge on the air bag deflector bracket, the seat air bags may tear during deployment. As such, these vehicles fail to comply with the requirements of Federal Motor Vehicle Safety Standard numbers 214, "Side Impact Protection," and 208, "Occupant Crash Protection. If this happens, a torn air bag may not adequately protect an occupant in a crash, increasing the risk of injury.

To prevent this, the front seats will be inspected and, if necessary, remove the sharp edge on the airbag deflector bracket rivet.

Customers will be notified week commencing 04/10/2023

Tools and Parts Supply

We will ship the necessary tool and parts needed to carry out this repair week commencing 03/27/2023

Every affected inventory vehicle must be REMEDIED BEFORE DELIVERY TO CONSUMERS.

**IMPORTANT REMINDER: VEHICLES AFFECTED BY SAFETY & COMPLIANCE
RECALLS**

IT IS A VIOLATION OF FEDERAL LAW FOR DEALERS TO DELIVER TO CUSTOMERS VEHICLES IN THEIR INVENTORY AFFECTED BY THIS NOTIFICATION UNTIL THESE VEHICLES ARE REMEDIED.

DEALERS SHOULD NOT SELL, LEASE, RENT, OR LOAN ANY VEHICLES IN DEALER INVENTORY AFFECTED BY THIS NOTIFICATION PRIOR TO REMEDY. DEALERS GROUNDING LEASE RETURNS SHOULD REMEDY ALL AFFECTED GROUNDED VEHICLES.

Please find the TPI attached.

Field campaign

Topic	Left & right front seat airbag deflector bracket-Sharp Edge On Airbag Deflector Bracket Rivet-Recall Campaign (RE23/03)
Market area	Russische Föderation (5RU),Australia E04 Bentley rest Asia and Australia (6E04),China 796 VW Import Comp. Ltd (Vico), Beijing (6796),Germany E02 Bentley rest Europe (6E02),Japan E03 Bentley Japan (6E03),United Arab Emirates E06 Bentley Middle East and Africa (6E06),United Kingdom E01 Bentley UK (6E01),United States E05 Bentley USA and rest America (6E05)
Brand	Bentley
Transaction No.	2069082/1
Campaign number	RC68
Note	
Type	
US code	

Vehicle data

New Continental GTC and Bacalar

Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
3S4*	2019	E		*	*	*
3S4*	2020	E		*	*	*
3S4*	2021	E		*	*	*
3S4*	2022	E		*	*	*

Chassis numbers

Manufacturer	Filler	Type	Filler	MY	Factory	From	To	Prod from	Prod to
SCB	*	*	*	K	C	072176	074994		
SCB	*	*	*	L	C	074969	084694		
SCB	*	*	*	M	C	082355	085702		

Documents

Document name
master.xml
re2303vinlist.pdf

Left & right front seat airbag deflector bracket-Sharp Edge On Airbag Deflector Bracket Rivet-Recall Campaign
(RE23/03)

Notes



Technical background

NOTICE

IMPORTANT NOTICE FOR BENTLEY BACALAR VEHICLES:

Bacalar vehicles should be referred back to the Bentley Motors Headquarters (Mulliner) for special arrangements to check/rework the vehicle



Referring to Figure 1

The left and right hand side front seat airbags are shown at (A)

The left and right hand side front seat airbag deflector brackets are shown at (B)

- The airbags are secured to the left and right hand seat frames by (x1) lower fixing and (x1) locating tab

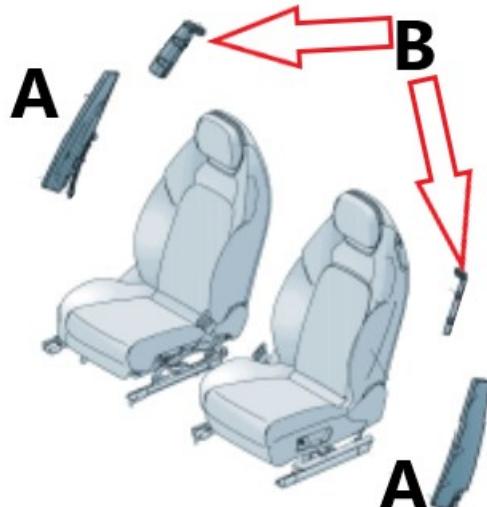


Figure 1

- The deflector brackets are secured to the seat frame using (x2) rivets:

(x1) side rivet

and

(x1) rear rivet

CAUTION

Only the side rivets shown in Figure 2 are affected on the left and right hand side front seats

Checks are required to be conducted on the left and right hand front seat side rivet mandrels (all vehicles)

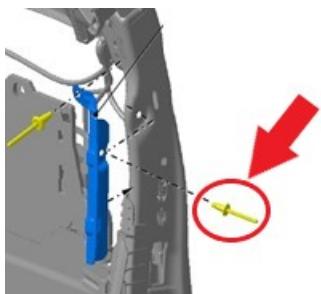


Figure 2

NOTICE

IMPORTANT NOTICE: The rear rivet shown in Figure 3 does not require any checks or rework conducting

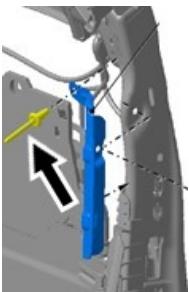


Figure 3

- When the side rivets are installed during the manufacturing process, a small number of side rivet mandrels could protrude as shown in Figure 4



Figure 4

- The example shown in Figure 5, shows a mandrel which is not protruding



Figure 5

NOTICE

Side rivet mandrel protrusion could result in a potential risk of damage to the front seat airbag during deployment therefore an over check and possible rework (depending on findings) is required

Remedy

CAUTION

To ensure the correct rework procedure is conducted, the operative must familiarize themselves with the rework instructions within this document before proceeding with any checks and/or rework

Section 1

Left and right hand front seat side rivet mandrel initial check (All vehicles)

- The initial check is required to be conducted on the left and right hand side front seats, the check **MUST** be conducted on all vehicles

NOTE: The instructions within the Work section are shown using a comfort seat although the instructions are the same for standard seats unless advised

The instructions are also the same regardless of drive derivative

- All photographs shown are included for reference purposes only and do not refer to a particular specification (comfort or standard) unless advised*

NOTICE

In the event the side rivet mandrel is found to be protruding greater than 1mm (>1mm) the operative should refer to Section 2 within the Work section

However

In the event the side rivet mandrel is found to be protruding less than 1mm (<1mm) the mandrel rework procedure within Section 2 does not require conducting, in this scenario only the operative must apply Paraskin tape (x2 strips) over the top of the rivet head

NOTICE

Access to the left and right hand deflector bracket side rivet can be gained without removing the front seats

Section 2

Side rivet mandrel rework - Only to be conducted on mandrels protruding greater than 1mm (>1mm)

The rework of the deflector bracket side rivet mandrel as detailed in Section 2 within the Work section should be conducted in the event the mandrel is protruding greater than >1mm

CAUTION

In the event the side rivet mandrel requires rework, the applicable front seat MUST be removed, the rework instructions MUST be strictly followed

WARNING

Do Not under any circumstances attempt to conduct the rework procedure without removing the following components as per all applicable Rep.Gr instructions:

- Applicable front seat
- Front seat airbag
- Front seat squab cover

WARNING

The Operative MUST ensure that all interior/exterior trim assemblies are suitably protected

Warranty payments will not be considered under any circumstances for damage to trim and/or components

Customer notification

Customers of affected vehicles will be notified in writing by their Bentley retailer to arrange an appointment, make a note of the required action on the workshop order before it is signed by the customer

If it is omitted to perform the work required during a workshop visit, the customer should be notified immediately

You should also pass on this information to your new and used car sales departments so that affected vehicles are checked and repaired immediately

Warranty accounting instructions

WARNING

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Warranty type 710 or 790

Damage service number RC68

Damage code 00 99

Criteria 01

Time to conduct the initial rivet mandrel check on the left and right hand front seats (Section 1) including the fitment of Paraskin tape

Labour operation code 72 19 02 00

Time 100 TU - Time is inclusive for both seats

Time to conduct the mandrel rework procedure (x1) seat (Section 2) right or left hand front seat

Labour operation code 72 19 41 00

Time 70 TU - Time is for (x1) seat only - Submit x2 claims in the event that both side rivet mandrels were reworked

Time to remove minor wrinkles or creases (x1) seat

Labour operation code 74 19 41 00

Time 10 TU (Use 99 index until 28/03/23) Submit x2 claims in the event that both seats required minor wrinkles or creases removing

Genuine parts

Part number	Description	Quantity
36A 881 322	Paraskin tape (70x20x0.9mm)	4 strips per vehicle <i>(x2 strips) left hand side front seat</i> <i>(x2 strips) right hand side front seat</i>

NOTICE

Each retailer will receive (x1) roll of Paraskin tape containing 2000 individual strips

Parts supply

The required replacement parts should be ordered from Bentley Motors Limited Crewe or through your regional Bentley parts distribution centre

Parts despatch control

Not applicable

Questions and answers

What is the specific issue with the affected vehicles?

During quality checks, Bentley has discovered that when riveting the airbag deflector bracket to the seat frame on Continental GTC / Bacalar vehicles, a sharp edge on the rivet could be created. This follows variability in the riveting procedure

What repercussions does the fault have?

In the event of a crash where seat airbags are deployed, it is possible that the airbag material could be torn if a sharp edge is present on the rivet. A tear in the airbag material could reduce the effectiveness of occupant protection

Which vehicles are affected?

Continental GT Convertible vehicles built between 13th December 2018 and 21st January 2021. Bacalar vehicles built between 29th July 2021 and 7th April 2022. The containment was introduced into the seat build process on 26th November 2020 (from VIN SCBDX33S8MC085706)

Are all models affected by the fault?

No, this affects a specific number of Continental GT Convertible and Bacalar vehicles only. The affected vehicles have been identified using manufacturing records. Continental GT Convertible vehicles not included on the recall campaign do not have an exposed sharp edge on the airbag deflector bracket rivet. Continental GT, Flying Spur and Bentayga vehicles are not affected, as they utilise a different side airbag system that is not installed in the seat assembly

Can customers continue to drive the cars?

Yes, however, we encourage customers to arrange an appointment with their retailer as soon as possible

What is the fix?

Bentley authorised retailers will inspect the affected front seats and, if necessary, remove the sharp edge on the airbag deflector bracket rivet free of charge. If a sharp edge requires rectification, it will take approximately one hour to complete

Do I have to make an appointment?

Yes, that's important. Customers need to contact their retailer immediately

Repair instructions



Technical background

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Referring to Figure 1

The left and right hand side front seat airbags are shown at (A)

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- The airbags are secured to the left and right hand seat frames by (x1) lower fixing and (x1) locating tab

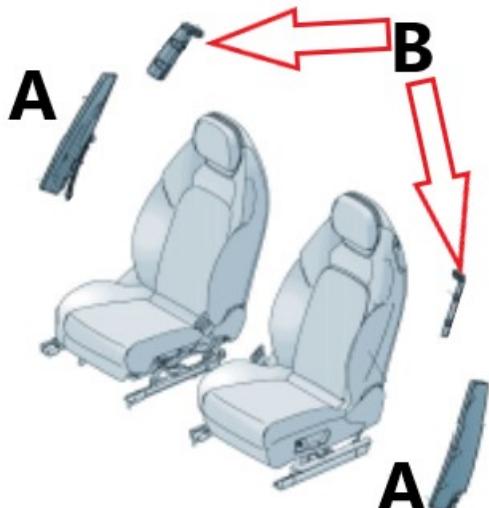


Figure 1

- The deflector brackets are secured to the seat frame using (x2) rivets:

(x1) side rivet

and

(x1) rear rivet

CAUTION

Only the side rivets shown in Figure 2 are affected on the left and right hand side front seats

Checks are required to be conducted on the left and right hand front seat side rivet mandrels (all vehicles)

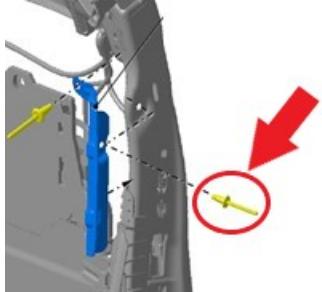


Figure 2

NOTICE

IMPORTANT NOTICE: The rear rivet shown in Figure 3 does not require any checks or rework conducting

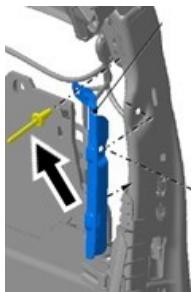


Figure 3

- When the side rivets are installed during the manufacturing process, a small number of side rivet mandrels could protrude as shown in Figure 4



Figure 4

- The example shown in Figure 5, shows a mandrel which is not protruding



Figure 5

NOTICE

Side rivet mandrel protrusion could result in a potential risk of damage to the front seat airbag during deployment therefore an over check and possible rework (depending on findings) is required

Check

If the vehicle is not already listed as repaired in the 'Repair history' section of Elsa Pro, check for the presence of the Recall campaign 'identification' mark (Refer to the Identification section Figure 33)

In the event that the Recall campaign has not been conducted, please carry out the required work in accordance with these instructions.

Genuine parts

Part number	Description	Quantity
36A 881 322	Paraskin tape (70x20x0.9mm)	4 strips per vehicle <i>(x2 strips) left hand side front seat</i> <i>(x2 strips) right hand side front seat</i>

NOTICE

Each retailer will receive (x1) roll of Paraskin tape containing 2000 individual strips

Tools

- Mandrel tool - WT10662 (Figure 6)



Figure 6



The mandrel tool (WT 10662) should be used to conduct the following:

- **Measure the protrusion of the side rivet mandrel**
- **Protect the rivet head during the mandrel rework process**

⚠ CAUTION

In the event the rivet head was damaged during the rework procedure, the Operative MUST raise a DISS query and await feedback before conducting any further work

⚠ CAUTION

In the event that WT10662 was damaged during the rework process or the surface is worn, the tool MUST be replaced and not reused

HINT: The tools are designed to be 1mm in depth, this is to allow the rivet mandrel to be reworked to 1mm and protect the rivet head during the rework procedure



Suitable mandrel finishing tools must be sourced locally in the event that Section 2 is required to be conducted see the example shown in Figure 7



Figure 7

An industrial vacuum cleaner for removing swarf when conducting the rework process is also required and must also be sourced locally (Figure 8)



Figure 8

Work



VERY IMPORTANT: The operative MUST ensure the instructions within the Work section are strictly followed

The instructions/photographs shown within the Work section show the left hand front seat however the instructions are the same for the right hand front seat



TIP: It is recommended to save all photographs in a VIN specific folder titled RC68. The photographs will be required later within the procedure

⚠ NOTICE

Before starting any work, it is advised to take photographs of the following areas:

- Left and right hand front seat squab cover overall condition (highlight/note any damage for reference purposes)
- Left and right hand front seat cushion cover (highlight/note any damage for reference purposes)
- Inner and outer sill tread plates (highlight/note any damage for reference purposes)

- Left and right hand front seat back panels
- Left and right hand front door trims



HINT: The photographs are recommended to be taken/saved to ensure the trim is in the same overall condition once the rework procedure has been conducted



WARNING
The Operative MUST ensure that all interior/exterior trim assemblies are suitably protected

Warranty payments will not be considered under any circumstances for damage to any trim and/or components

TIP: In the event that damage is evident on any of the afore mentioned components, the operative must make the customer aware before proceeding as any damaged trim identified after the rework instructions has been conducted will not be covered under warranty

Section 1

Left hand front seat side rivet mandrel - Initial check



NOTICE
The onward instructions should be conducted without removing the front seats

- 1) Referring to Rep.Gr 69 - Remove the airbag fuse



CAUTION
When conducting the onward instructions the operative must ensure their hands are clean, extreme care must be taken to ensure no damage or dirt is transmitted to any of the vehicles interior or exterior trim

- 2) Remove the left hand front seat back panel assembly as follows:



Access to the front seat back panel straps (x2) and fixings (x3) can be done without removing the front seats



TIP: To ease removal and refitting of the straps/fixings it is recommended to use an inspection mirror and a suitable inspection lamp to assist with locating the straps/fixings (Figure 9)



Figure 9

- Referring to Figure 10 - Release the straps from the points on the underside of the cushion frame



Figure 10

HINT: Take note of the points before removal to ensure the straps are refitted in the same location on completion, see the example shown in Figure 11

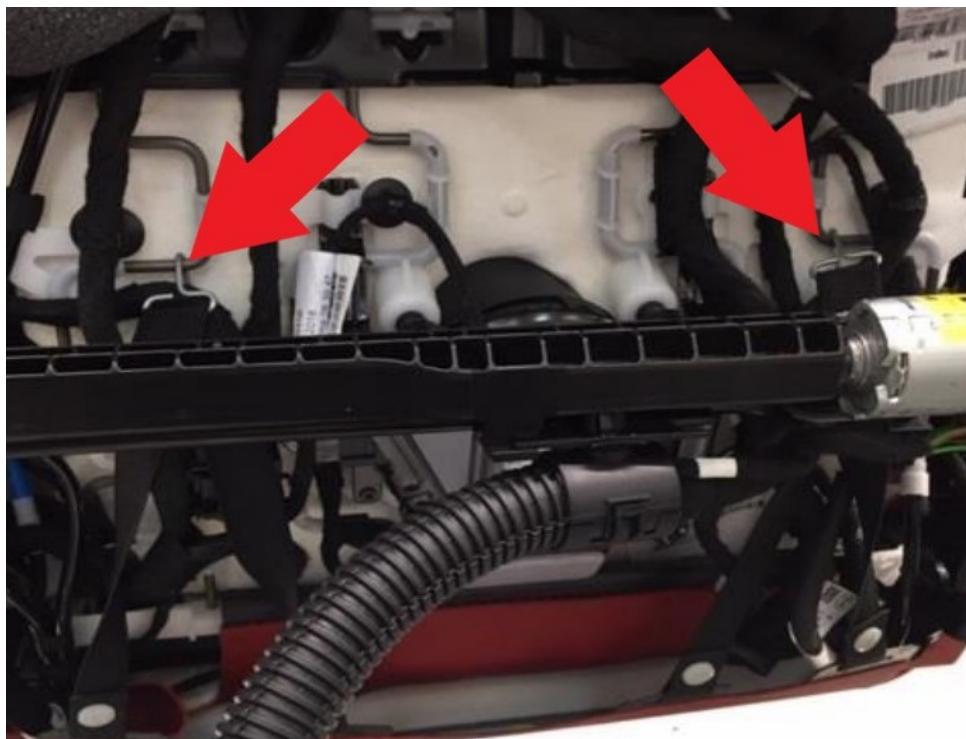


Figure 11

3) Remove the (x3) fixings (3.5 Nm) at the base of the back panel (Figure 12)

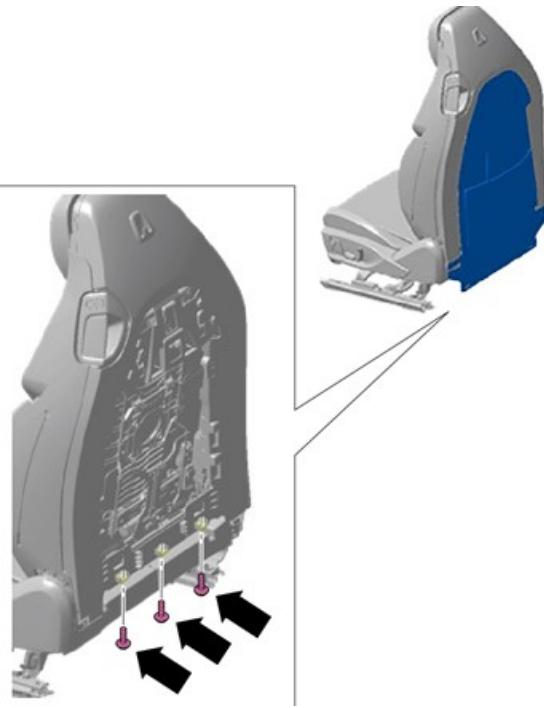


Figure 12

4) Slide the back panel downwards and remove (Figure 13)



Once removed, the back panel should be stored in a safe and clean environment



Figure 13

5) Referring to Rep,Gr 74 - Refer to the chapter which details the removal of the release handle and surround

- Remove the release handle and surround

 **CAUTION**

Ensure the surround is suitably protected during the process (Figure 14) as any damage will not be covered under Warranty



Figure 14

Referring to Figure 15 - Release the squab cover from the clipping points -dotted lines- at the rear

- Release the squab cover from the squab clamshell at the lower corners -arrows-

 **WARNING**

Take extreme care when removing the squab clamshell at the lower corners as damage can easily be caused, any damage caused within this area will not be covered under Warranty

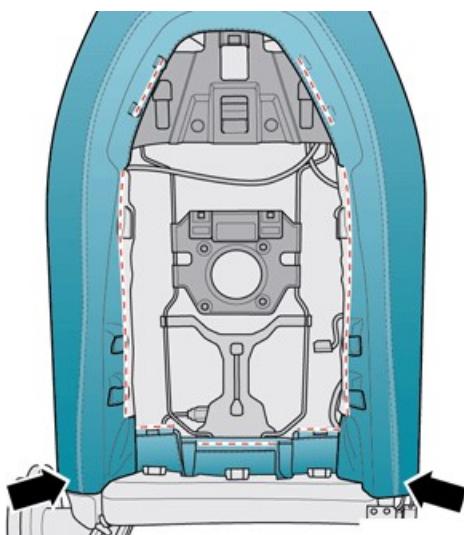


Figure 15

 **NOTICE**

COMFORT SEAT SPECIFICATION ONLY:

- Referring to Figure 16 - Use a non-metallic trim tool, release the squab finisher -1- which is secured by four clips
- The trim does not require removing completely, the trim requires releasing from the clipping points to allow the squab cover to relax (Figure 17) during the next part of the procedure

NOTE: Headrest shown removed for illustration purposes only and does not require removal



Figure 16



Figure 17

- For guidance - The side rivet is located at the approximate point shown in Figure 18 (approximately 170mm downwards from the release handle)



Figure 18



When conducting this step take note of the original position of the following:

- **Seat foam**
- **Front seat airbag sock**

The operative **MUST** ensure the position of the foam and front seat airbag sock is as shown within Figure 19 (Not damaged or twisted)



Figure 19

6) Referring to Figure 20 - With extreme care the operative should manoeuvre the front seat squab cover as shown

 **WARNING**

VERY IMPORTANT:

Take care not to stretch or damage the seat squab cover when conducting the onward check, the location shown in Figure 20 (upper corner of the seat clam) has a pointed edge, in the event care is not taken, damage can be caused to the seat squab cover, any damage caused within this area will not be covered under Warranty

- With extreme care the operative can now locate the rivet

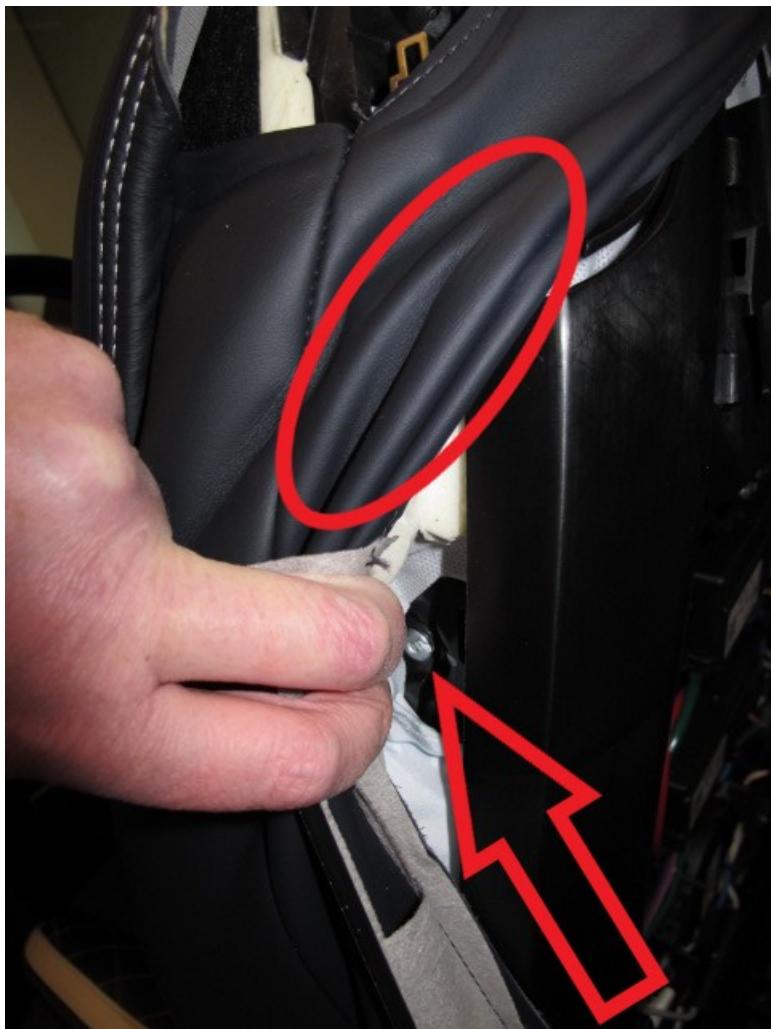


Figure 20

7) Referring to Figure 21 - Using WT10662 the operative should measure the protrusion of the rivet mandrel as follows:

- Position WT10662 over the rivet head/mandrel as shown

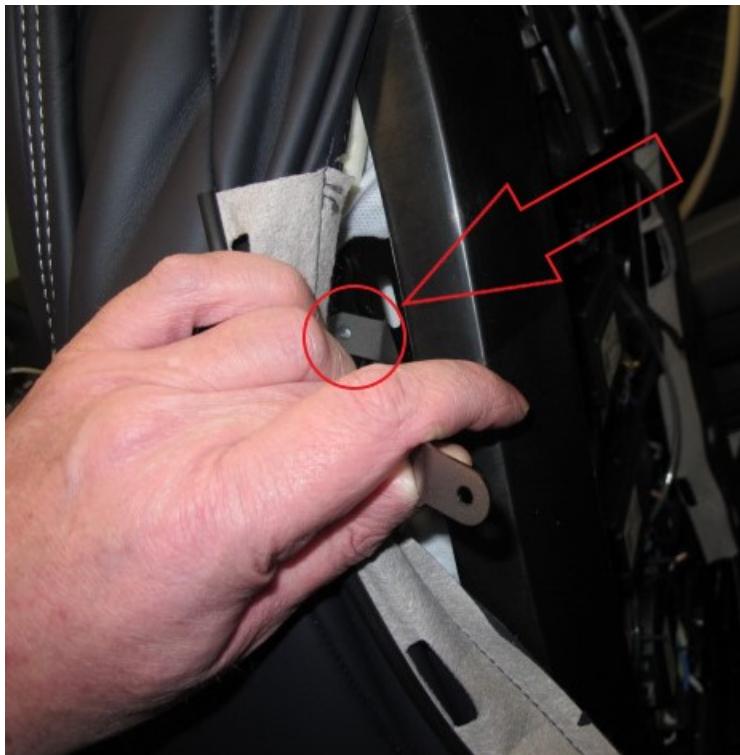


Figure 21

- In the event the mandrel is protruding <1mm (Less than or equal to 1mm) as shown in Figure 22 - Proceed to step 8

Or

- The mandrel is not protruding Figure 23 - Proceed to step 8

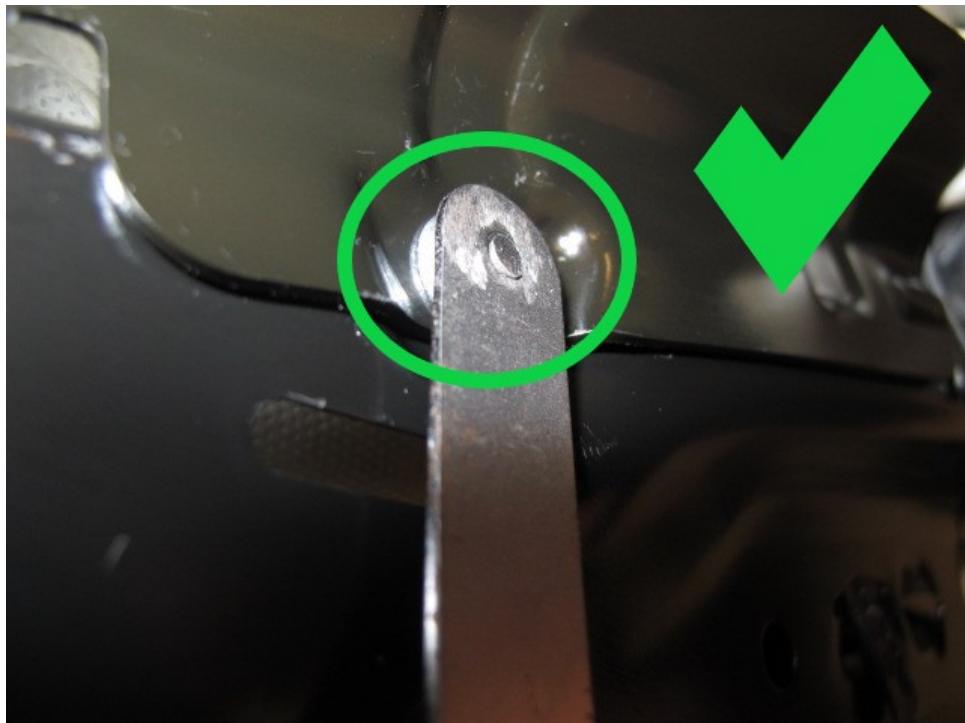


Figure 22



Figure 23

However

⚠️ WARNING

In the event the mandrel is protruding as shown in Figure 24 >1mm (greater than 1mm) the operative must conduct the mandrel rework procedure within Section 2 to completion

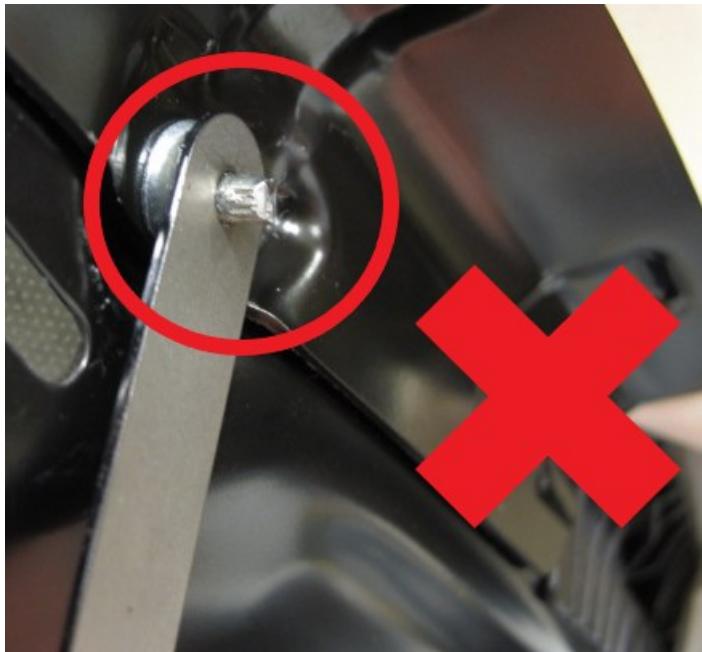


Figure 24

8) Take a photograph of the left hand seat side rivet head/mandrel

NOTE: The photographs are required to be uploaded to a non technical DISS query on completion

- Using a suitable degreasing agent for example MYKAL high performance wipes - De-grease the area shown within in Figures 25 and 26



Figure 25



Figure 26

 **NOTICE**

Allow the area to air dry before applying the (x2) Paraskin tape strips

- 9) Referring to Figure 27 - Apply the first Paraskin strip at the location shown

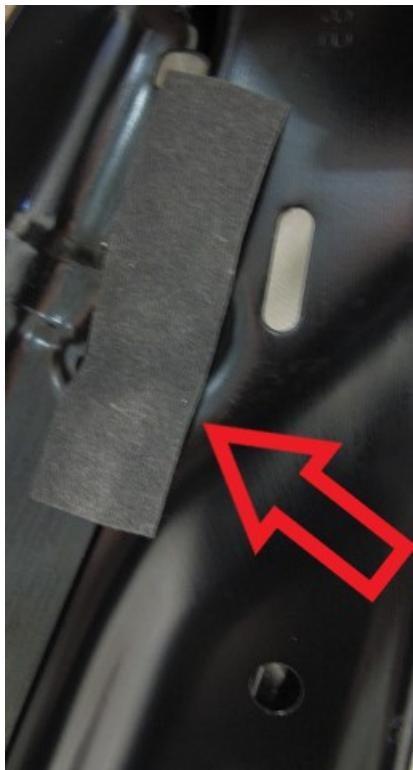


Figure 27

- Referring to Figure 28 - Apply the second Paraskin strip at the location shown

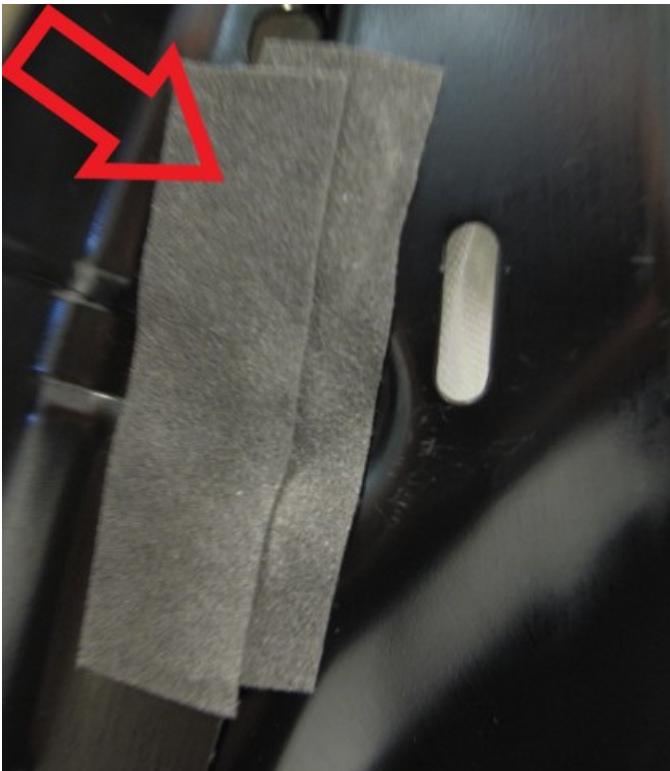


Figure 28

10) Once complete and both Paraskin strips have been correctly applied - Refit all previously removed components

- Referring to Rep.Gr 74 - **Seat trim repairs - Best practice guide** - Remove any minor creases or wrinkles



IMPORTANT: Ensure the seat back panel straps are located in the correct position

THE STRAPS MUST ONLY BE ATTACHED TO THE SEAT CUSHION SPRINGS AS SHOWN IN FIGURE 11

11) Repeat steps 2 through to 10 on the right hand front seat



WARNING

In the event the mandrel is protruding as shown in Figure 24 >1mm (greater than 1mm) on the right hand front seat the operative must conduct the mandrel rework procedure within Section 2 to completion

12) Refit the air bag fuse Rep.Gr 69

13) On completion conduct the instructions within Section 3

Section 2

Side rivet mandrel rework - Only to be conducted on mandrels protruding greater than 1mm (>1mm)

1) Referring to Rep.Gr 72 - Remove the applicable front seat

2) Referring to Rep.Gr 72 - Remove the front seat cushion cover

- **Ensure the front seat airbag is removed as per all instructions within Rep.Gr 69 and Rep.Gr 74**

IMPORTANT: Ensure the front seat airbag is stored in a safe location away from the vehicle

3) Referring to Rep.Gr 72 - Remove the clamshell

NOTE: Please beware there are two specifications of seat when removing the clamshell as follows:

- Comfort seat
- Standard seat



WARNING

Before conducting the next section please ensure the following:

- Eye protection MUST be worn (Figure 29)



Figure 29

- Ensure the airbag connection is suitably protected to ensure swarf cannot enter the airbag plug (Figure 30)



Figure 30

- 4) Referring to Figure 31 - Position WT10662 as shown

⚠ CAUTION

The operative must use a suitable vacuum cleaner to ensure all swarf is removed whilst conducting the linishing procedure

HINT: A second operative is required for this part of the process

- Using a suitable tool linish the rivet mandrel to 1mm as shown in Figure 31

⚠ WARNING

DO NOT linish the protruding mandrel without WT10662 being in place as damage can easily be caused to the rivet head

⚠ NOTICE

Linishing the mandrel flush to the tool will give 1mm protrusion, the tool will prevent any damage to the rivet head (Figure 32)



Figure 31



Figure 32

- 5) Using the vacuum cleaner remove any swarf debris from the seat frame and surrounding components
 - 6) Take a photograph of the reworked side rivet head/mandrel confirming the protrusion of the mandrel is 1mm (post finishing)
- NOTE: The photographs are required to be uploaded to a non technical DISS query on completion
- 7) Using a suitable degreasing agent - De-grease the areas shown in Figures 25 and 26

 **NOTICE**

Allow the area to air dry before applying the Paraskin tape

- 8) Refer back to Figure 27 - Apply the first Paraskin tape strip in the location shown
- 9) Refer back to Figure 28 - Apply the second Paraskin tape strip in the location shown
- 10) Once complete - Refit all previously removed components
 - Referring to Rep,Gr 74 - **Seat trim repairs - Best practice guide** - Remove any minor creases or wrinkles

 **i**

IMPORTANT: Ensure the seat back panel straps are located in the correct position

THE STRAPS MUST ONLY BE ATTACHED TO THE SEAT CUSHION SPRINGS AS SHOWN IN FIGURE 11

11) Refit the airbag fuse - Refer to Rep.Gr 69

12) On completion conduct the instructions within Section 3

Section 3 - Non technical DISS query requirements

1) Raise a non- technical DISS query ensuring the following is attached (depending on the work conducted)

- The left and right hand mandrels were to specification < 1mm (less than 1mm)

Or

- The left hand mandrel was to specification < 1mm (less than 1mm) however the right hand side required reworking as Section 2

Or

- The right hand mandrel was to specification < 1mm (less than 1mm) however the left hand side required reworking as Section 2

Or

- The left and right hand side mandrels both required rework as Section2

2) Photographs of the left and right hand side rivet head/mandrel prior to installing the Paraskin tape

3) Apply a blue paint completion mark on the driver's side inner seat rail refer to the Identification section

Identification

Blue paint completion mark on the left side inner seat rail (Figure 33)



Figure 33

SCBDG4ZG8LC083722	SCBDB4ZG9LC084070	SCBDJ33S9LC084516	SCBDG4ZG4MC084836	SCBDG4ZG4MC085176	SCBDX33SXMLC085481
SCBDS33S6LC083725	SCBDS33SXLC084084	SCBDF33S2LC084519	SCBDG4ZG3MC084844	SCBDG4ZG3MC085184	SCBDG4ZGXMLC085487
SCBDF33S0LC083739	SCBDB4ZG8LC084108	SCBDJ33S6LC084523	SCBDG4ZG9MC084850	SCBDG4ZG9MC085190	SCBDX33S5MC085498
SCBDB4ZG5LC083742	SCBDG4ZG7LC084120	SCBDF3ZGXLC084531	SCBDG4ZG8MC084872	SCBDG4ZG2MC085192	SCBDX33SXMC085500
SCBDB4ZG0LC083745	SCBDG4ZG3LC084132	SCBDJ33SXLC084539	SCBDG4ZG9MC084878	SCBDG4ZG8MC085200	SCBDX33S3MC085502
SCBDG4ZG6LC083752	SCBDG4ZG3LC084146	SCBDC33S8LC084548	SCBDG4ZG4MC084884	SCBDG4ZG5MC085204	SCBDX33S7MC085504
SCBDG4ZG5LC083757	SCBDB4ZG3LC084159	SCBDJ33S0LC084565	SCBDG4ZG3MC084892	SCBDX33S1MC085210	SCBDX33S0MC085506
SCBDG4ZG1LC083769	SCBDG4ZG7LC084165	SCBDS33S8LC084570	SCBDG4ZG2MC084897	SCBDZ33SXMC085216	SCBDX33S4MC085508
SCBDS33SXLC083792	SCBDJ33S1LC084168	SCBDS33S1LC084586	SCBDG4ZG3MC084911	SCBDG4ZG5MC085221	SCBDG4ZG0MC085563
SCBDG4ZGXLC083818	SCBDG4ZG3LC084180	SCBDJ33S3LC084592	SCBDG4ZG7MC084927	SCBDG4ZG8MC085228	SCBDG4ZGXMLC085568
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