

Technical Instructions

Safety Recall SR-23-03-0

Wiper Arm Torque

Model: Air

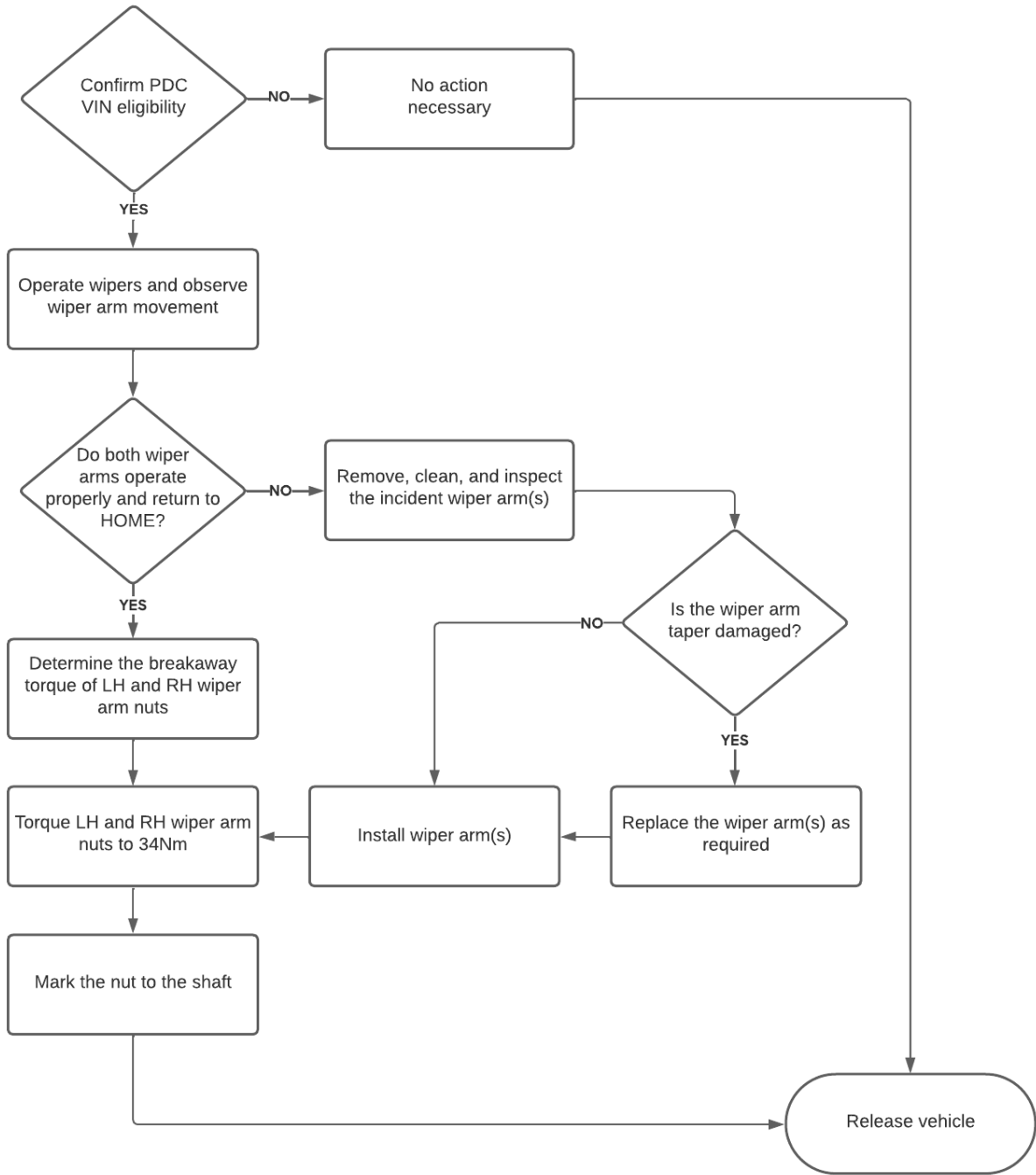
Year: 2022 / 2023

Market: USA / CAN / KSA

Rev 1

Release Date: 09/15/2023

I. PROCESS OVERVIEW



II. VIN ELIGIBILITY

Model	Year	Market
Air	2022 / 2023	USA / CAN / KSA

III. WORK ORDER DOCUMENTATION

Include the following information in the work order:

Concern	Wiper arm(s) could become loose on the drive motor
Cause	Insufficient torque on LH and RH wiper arm securing nuts
Correction	Torque LH and RH wiper arm nuts to the updated specification (34 Nm)

IV. DOCUMENTATION DETAILS

To ensure that vehicle campaign repairs are documented correctly, please reference the following when creating work orders for SR-23-03-0:

Job Code	SR-23-03-0 Wiper Arm Torque
Pay Type	Campaign [Customer Cars]
	Rectify [Lucid Internal Vehicles]
Defect Code	Campaign
Causal PN	P11-E621DL


Select the Labor Op Code that best reflects the procedure performed on the vehicle:

Labor Op Code	Description	FRT*
96.230301	SR-23-03-0 Inspect; Torque both sides	0.2
96.230302	SR-23-03-0 Inspect; Remove one wiper arm and clean the splines; torque both sides	0.2
96.230303	SR-23-03-0 Inspect; Remove both wiper arms and clean the splines; torque both sides	0.3
96.230304	SR-23-03-0 - Inspect; Remove one wiper arm and clean splines, replace wiper arm; torque both sides	0.2
96.230305	SR-23-03-0 - Inspect; Remove both wiper arms and clean splines, replace wiper arms; torque both sides	0.3

*Flat Rate Time (FRT) is subject to change

NOTE: Safety Recall Campaign claim should be submitted as “**CAMPAIGN**” Pay Type

V. SPECIAL TOOLS

Tool Part Number	Tool Name	Tool Picture
T0S-Z62500-00	3/8" Digital Torque Adapter	

VI. PARTS

Part Number	Side	Name	Qty
P11-E620DL	LH	HEATED WIPER ARM DS LHD	As required
P11-E621DL	LH	NON HEATED WIPER ARM DS LHD	
P11-E620PL	RH	HEATED WIPER ARM PS LHD	
P11-E621PL	RH	NON HEATED WIPER ARM PS LHD	

VII. IMPORTANT INFORMATION

⚠ CAUTION: Ensure the use of all appropriate PPE when performing this repair.

VIII. REPAIR INSTRUCTIONS

- 1. Use latest Technical Instructions (TI)**
Use the latest revision Technical Instructions (TI) by checking the revision (REV) number displayed on the title page and in the document footer.
- 2. Confirm VIN Eligibility**
Eligible VIN will have an open Service Campaign Asset in Salesforce.
Title: SR-23-03-0 Wiper Arm Torque

IX. WIPER ARMS OPERATIONAL INSPECTION

- 1. Operate Wiper Arms**
Operate the wipers to determine if they function properly and return to the HOME position when turned off.
 - **If the wipers function properly and return to the HOME position, proceed to section X. TORQUE WIPER ARM NUTS**
 - **If the wiper arm(s) are slipping on the drive motor shaft, proceed to section: XI. WIPER ARM(S) REMOVAL**

X. TORQUE WIPER ARM NUTS

1. Remove Rear Underhood Apron

Follow the instructions in the Service Manual to remove the Rear Underhood Apron:

Service Manual / Body Exterior / Frunk Trim System / [Rear Underhood Apron – LH Remove and Replace](#)

2. Remove the LH and RH Wiper Nut Caps



3. Determine the Breakaway Torque of LH and RH Wiper Arm Nuts

The breakaway torque of the wiper arm nuts (LH and RH) will need to be recorded on the Work Order. To determine the breakaway torque, watch the reading of the digital torque adapter and note the value when the nut starts to rotate.

- a) Set the digital torque adapter to 34Nm
- b) Place the digital torque adapter onto the wiper arm nut
- c) Securely hold the wiper arm with one hand
- d) SLOWLY tighten the nut while watching the digital display
- e) Note the Nm torque value when the nut starts to rotate
- f) Torque to 34Nm
- g) Perform steps (a) to (f) for both LH and RH wiper arm nuts

4. Record LH and RH Breakaway Values

Record the LH and RH breakaway torque values for each nut in the Work Order.



5. Mark LH and RH Nuts to Shaft

Using a paint pen, mark a line between the nut and shaft.



<p>6. Install the LH and RH Wiper Nut Caps</p>
<p>7. Install Rear Underhood Apron</p> <p>Follow the instructions in the Service Manual to install the Rear Underhood Apron:</p> <p>Service Manual / Body Exterior / Frunk Trim System / Rear Underhood Apron – LH Remove and Replace</p>
<p>8. No further action required. The campaign is complete. Release vehicle.</p>

XI. WIPER ARM(S) REMOVAL (only if Wiper Arms Operational Inspection failed)

<p>1. Remove Incident Wiper Arm(s)</p> <p>Follow the instructions in the Service Manual for wiper arm R&R and alignment:</p> <ul style="list-style-type: none"> • Driver Side (LH): Driver Side Heated Wiper Arm • Passenger Side (RH): Passenger Side Heated Wiper Arm Remove and Replace
<p>2. Inspect Wiper Arm Tapered Surface</p> <p>Check condition of tapered surface for damage. If damaged (scored, grooves, etc.) replace the wiper arm assembly. If tapered surface is not damaged, clean thoroughly.</p> 
<p>3. Clean Shaft Spline(s)</p> <p>Use a stainless-steel hand-brush to clean the splines and ensure there is no paint/aluminum debris within the splines.</p> 

4. Install the Wiper Arm(s)

Continue following the instructions in the Service Manual for wiper arm R&R and alignment:

- Driver Side (LH): [Driver Side Heated Wiper Arm](#)
- Passenger Side (RH): [Passenger Side Heated Wiper Arm Remove and Replace](#)

5. Torque LH and RH Nuts to 34Nm.

6. Mark LH and RH Nuts to Shaft

Using a paint pen, mark a line between the nut and shaft.



7. Install the LH and RH Wiper Nut Caps

8. Install Rear Underhood Apron

Follow the instructions in the Service Manual to install the Rear Underhood Apron:

Service Manual / Body Exterior / Frunk Trim System / [Rear Underhood Apron – LH Remove and Replace](#)

9. No further action required. The campaign is complete. Release vehicle.