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Subject: RATTLE NOISE FROM FRONT DOOR GLASS	Bulletin No: 09-055/16
	Last Issued: 10/25/2016

BULLETIN NOTE

This bulletin supersedes the previously issued bulletin(s) listed below. The changes are noted in Red beside the change bars.

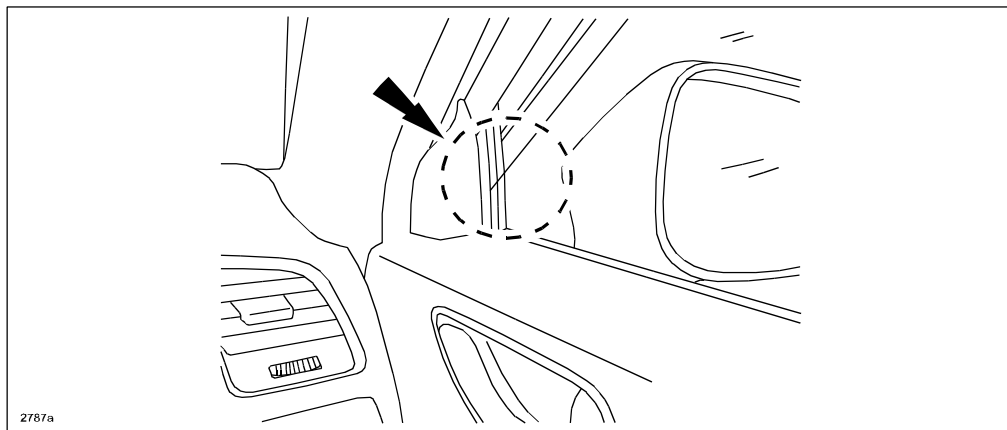
Previous TSBs:	Date(s) Issued:
09-038/16	06/09/16
09-016/15	05/18/15
09-017/14	08/29/14, 03/05/14 and 08/18/14
09-011/13	04/17/13

APPLICABLE MODEL(S)/VINS

2014-2016 Mazda6 vehicles with VINs lower than JM1 GJ ***** 488592 (produced before June 30, 2016)

DESCRIPTION

Some vehicles may experience a rattle noise from the front door glass when driving with the window open approx. 1/2 to 4 inches (1 - 10 cm).



The rattle noise may be caused by insufficient holding force of the glass run channel. To increase the holding force, the shape of glass run channel has been changed and non-woven pads have been attached to the glass run channel.

Customers having this concern should have their vehicle repaired using the following repair procedure.

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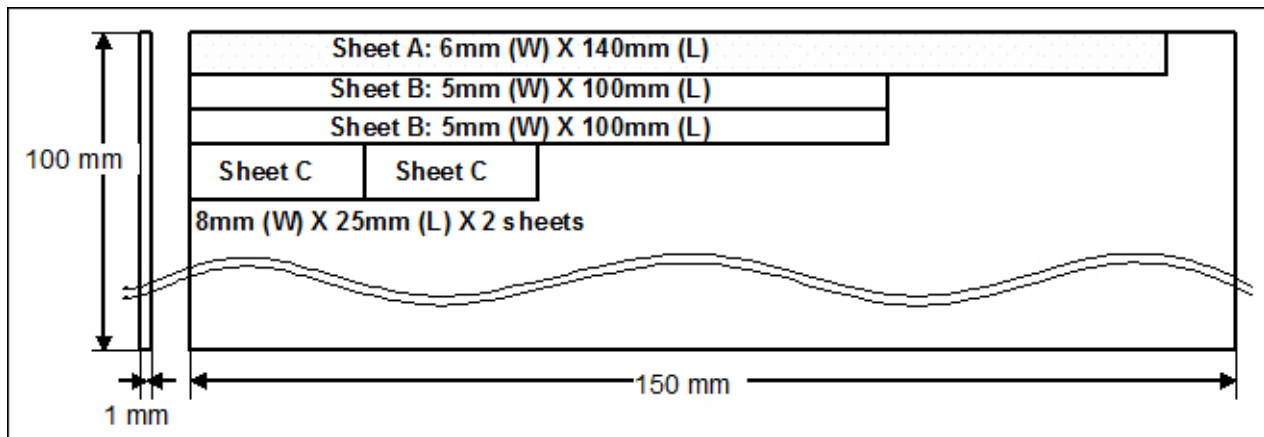
REPAIR PROCEDURE

1. Verify the customer concern. The rattle noise should go away when holding the slightly opened window by hand or when the window is completely closed.
2. Remove the glass run channel at the affected side(s). Refer to MS3 online Workshop Manual FRONT DOOR GLASS REMOVAL/INSTALLATION.

NOTE: Discard the old glass run channel.

3. Install pieces of the non-woven fabric (KAY0-58-871) to the new glass run channel.
 - a. Cut the non-woven fabric sheet (100mm X 150mm X 1mm) into the following sizes and pieces.

NOTE: 1 piece of the non-woven fabric sheet (KAY0-58-871) can repair 4 doors.



Sheet A:	6mm X 140mm	1 piece
Sheet B:	5mm X 100mm	2 pieces
Sheet C:	8mm X 25mm	2 pieces

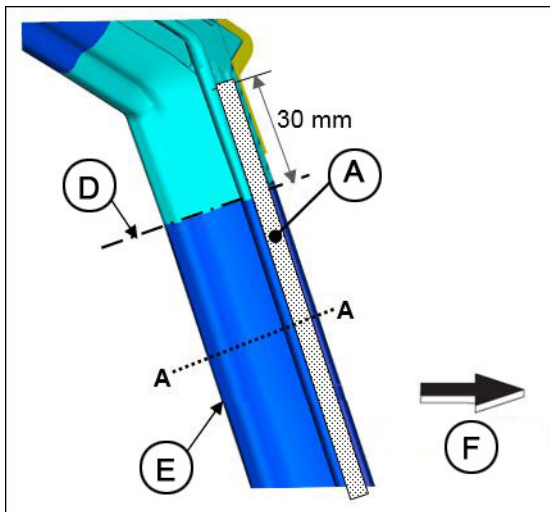
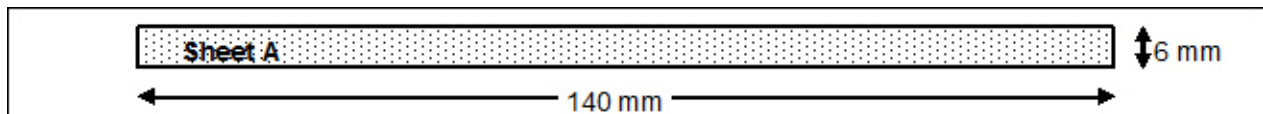
b. Modify the new glass run channel by attaching the sheets to the positions shown in the illustrations.

NOTE:

- Degrease the glass run channel and apply primer (silicone remover) to the area where the sheets will be attached.
- Obtain adhesion promoter locally.
- Recommended adhesion promoter: 3M K-540NT, K500 or 4298UV. If these products cannot be obtained, any adhesion promoter suitable for plastic can be used.
- Illustrations show the right-side glass run channel. The same procedure is applicable to the left side.

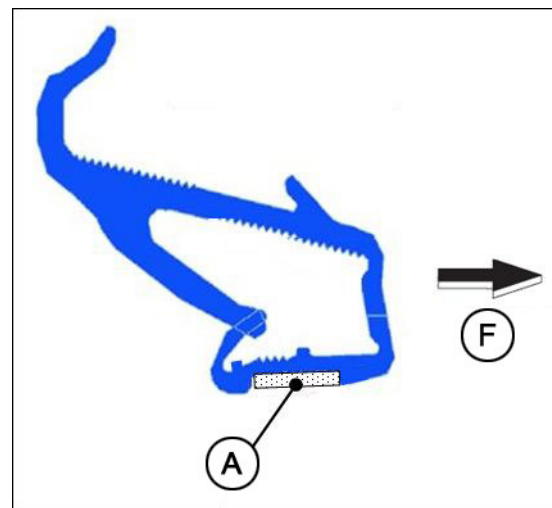
Attach Sheet A

Attach Sheet A to the outside groove of the new glass run channel as shown.



A: Sheet A - Attach 30mm above the joint line (D).
D: Molded Joint Line
E: New Glass Run Channel
F: Vehicle Front

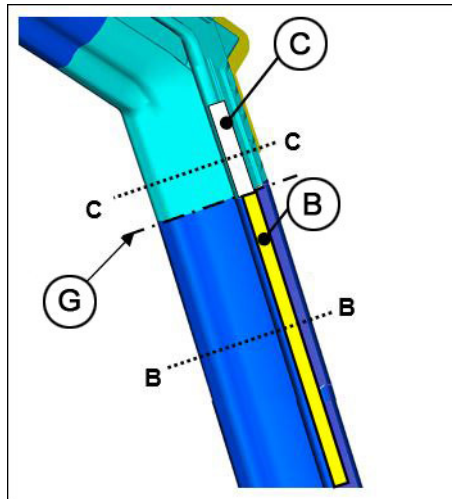
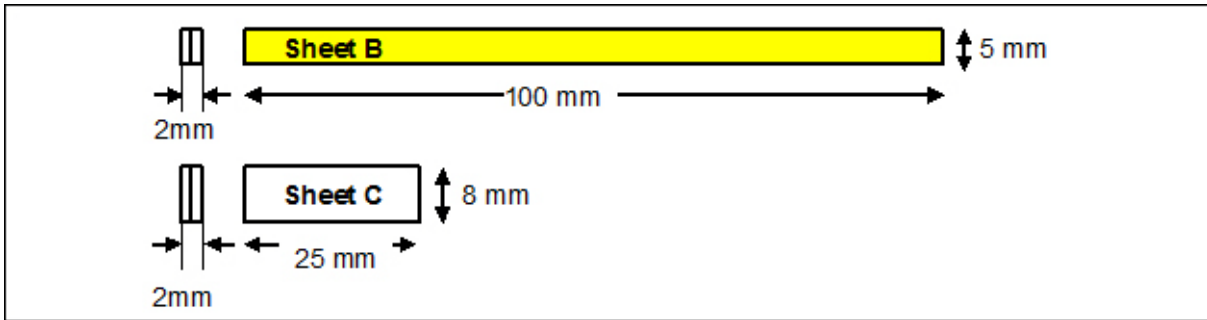
Cross Section A-A



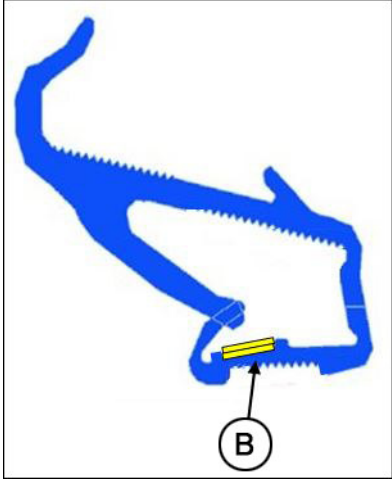
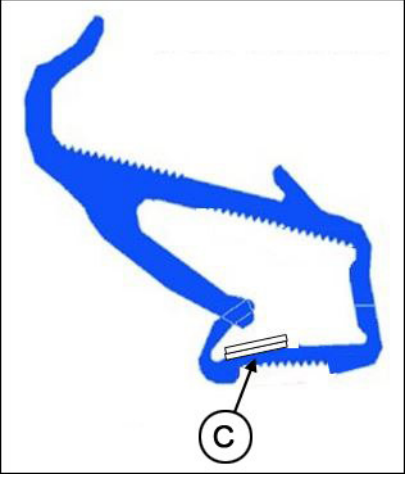
A: Sheet A - Attach in the groove of the outside of the new glass run channel.
F: Vehicle Front

Attach Sheet B and C

Attached Sheet B and Sheet C to the inner side of the glass run channel as shown.
Note: Sheet B and Sheet C are double stacked.



B: Sheet B - Attach under joint line (G).
C: Sheet C - Attach above joint line (G).
G: Joint Line

Cross Section B-B	Cross Section C-C
	
<p>B: Sheet B - Attach to the groove of the new glass run channel inner side.</p>	<p>C: Sheet C - Attach to the inner side of new glass channel.</p>

4. Install the new glass run channel at the affected side(s). Refer to MS3 online Workshop Manual FRONT DOOR GLASS REMOVAL/INSTALLATION.
5. Operate the door glass up and down to verify proper operation.
6. Repeat the repair on the glass run channel on the other side if necessary.
7. Verify repair.

PART(S) INFORMATION

Part Number	Description	Qty.	Notes
KAY0-58-871	Non-Woven Fabric	1	Size: 1mm (thick) X 100mm (width) X 150mm (length) One sheet can repair 4 doors.
GHP9-58-605J	Glass Run Channel (R)	1	RH
GHP9-59-605J	Glass Run Channel (L)	1	LH
Locally Sourced	Adhesion Promoter	1	3M K-540NT, K500, 4298UV or equivalent

WARRANTY INFORMATION

NOTE:

- This warranty information applies only to verified customer complaints on vehicles eligible for warranty repair.
- This repair will be covered under Mazda's New Vehicle Limited Warranty term.
- Additional diagnostic time cannot be claimed for this repair.

Warranty Type	A
Symptom Code	82
Damage Code	97
Part Number Main Cause	GHP9-58-605J or GHP9-59-605J NOTE: Enter the part number of glass run channel at the affected side. If both sides are replaced, enter other side in Related Part Number.
Quantity	1
Operation Number / Labor Hours	XXM9AARX / 0.5 Hrs (one side) XXM9ABRX / 0.9 Hrs (both sides)

NOTE: Claim the non-woven fabric sheet (KAY0-58-871) in Related Part. The amount of adhesion promoter used for this repair is included in the labor payment.