

Field campaign

Topic	Convertible Roof System - Oversize Rivet Hole (SC12/13)
Market area	Bentley: worldwide (2WBE)
Brand	Bentley
Transaction No.	2031420/2
Campaign number	E773
Note	
Type	E773
US code	

Vehicle data

13MY New Continental GTC

Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
39411*	2013	E		*	*	*
39423*	2013	E		*	*	*

Chassis numbers

Manufacturer	Filler	Type	Filler	MY	Factory	From	To	Prod from	Prod to
SCB	GT3	ZA	9	D	C	081607	081607		
SCB	GJ2	3W	6	D	C	081617	081617		
SCB	GT3	ZA	3	D	C	081635	081635		
SCB	GJ2	3W	1	D	C	081637	081637		
SCB	GJ2	3W	5	D	C	081639	081639		
SCB	GT3	ZA	9	D	C	081641	081641		
SCB	GT3	ZA	4	D	C	081644	081644		
SCB	GT3	ZA	3	D	C	081649	081649		
SCB	GH2	3W	1	D	C	081651	081651		
SCB	GJ2	3W	X	D	C	081653	081653		
SCB	GJ2	3W	2	D	C	081680	081680		
SCB	GJ2	3W	6	D	C	081682	081682		
SCB	GT3	ZA	0	D	C	081687	081687		
SCB	GT3	ZA	4	D	C	081689	081689		
SCB	GT3	ZA	X	D	C	081695	081695		
SCB	GT3	ZA	3	D	C	081697	081697		
SCB	GT3	ZA	1	D	C	081701	081701		
SCB	GT3	ZA	5	D	C	081703	081703		
SCB	GT3	ZA	2	D	C	081707	081707		
SCB	GT3	ZA	6	D	C	081709	081709		
SCB	GJ2	3W	2	D	C	081713	081713		
SCB	GT3	ZA	X	D	C	081728	081728		
SCB	GT3	ZA	8	D	C	081730	081730		
SCB	GT3	ZA	4	D	C	081742	081742		
SCB	GJ2	3W	1	D	C	081749	081749		
SCB	GT3	ZA	5	D	C	081751	081751		
SCB	GT3	ZA	5	D	C	081765	081765		
SCB	GJ2	3W	8	D	C	081795	081795		
SCB	GT3	ZA	9	D	C	081817	081817		
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SCB	GT3	ZA	9	D	C	081879	081879		
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SCB	GT3	ZA	7	D	C	081928	081928		
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SCB	GR3	ZA	4	D	C	082078	082078		

SCB	GT3	ZA	4	D	C	082082	082082		
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SCB	GT3	ZA	1	D	C	082086	082086		
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SCB	GJ2	3W	3	D	C	081302	081302		
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SCB	GJ2	3W	2	D	C	081422	081422		

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SCB	GJ2	3W	0	D	C	081435	081435		
SCB	GT3	ZA	1	D	C	081438	081438		
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SCB	GJ2	3W	6	D	C	081455	081455		
SCB	GT3	ZA	9	D	C	081459	081459		
SCB	GT3	ZA	7	D	C	081461	081461		
SCB	GT3	ZA	2	D	C	081464	081464		
SCB	GT3	ZA	6	D	C	081466	081466		
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SCB	GJ2	3W	4	D	C	081549	081549		
SCB	GJ2	3W	2	D	C	081551	081551		
SCB	GH2	3W	5	D	C	081555	081555		
SCB	GT3	ZA	0	D	C	081575	081575		
SCB	GT3	ZA	4	D	C	081577	081577		
SCB	GT3	ZA	8	D	C	081579	081579		
SCB	GJ2	3W	4	D	C	081583	081583		
SCB	GJ2	3W	8	D	C	081585	081585		
SCB	GH2	3W	0	D	C	081592	081592		
SCB	GT3	ZA	3	D	C	081599	081599		
SCB	GH2	3W	8	D	C	081601	081601		
SCB	GT3	ZA	1	D	C	081603	081603		

Documents

Document name
master.xml
master.doc



Notes

[Repair instructions](#)

Technical background

A counter bore operation on the left hand twin bow may have been performed incorrectly resulting in an oversize rivet hole and no counter bore. The counter bore is required to enable the rivet to expand and lock into the casting. This rivet hole requires inspection and if found to be oversize the attached rectification measure performed

Remedy

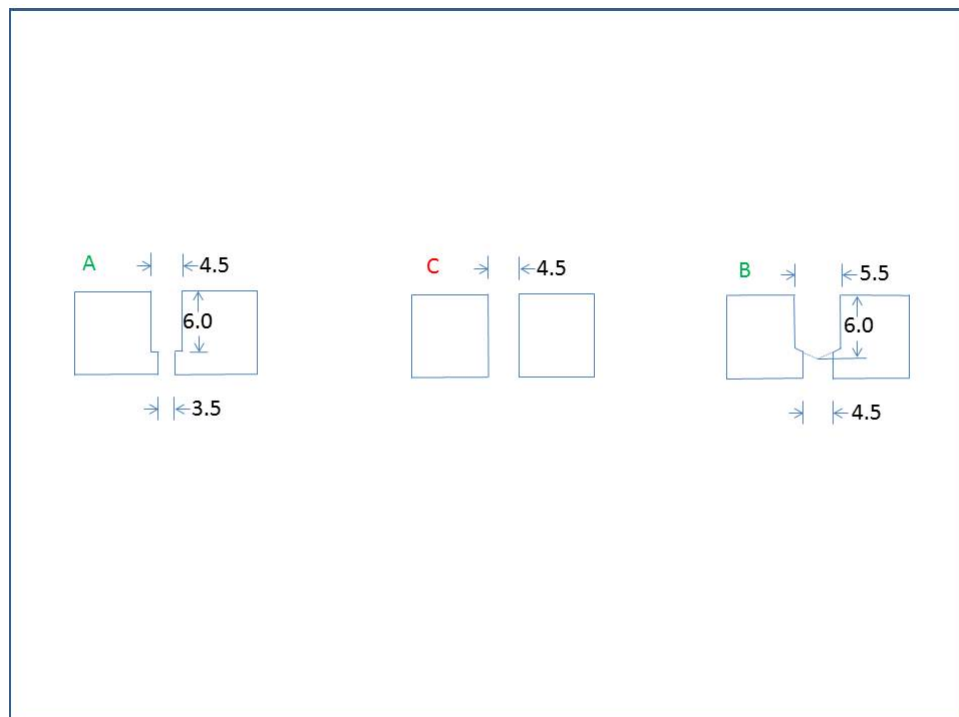


Figure 2

If the rivet hole is found to be standard dimensions (diagram A) then fit a replacement standard rivet. On vehicles where the rivet hole is found to be oversize, that is the counter bore dimension has been drilled all the way through leaving no counter bore (diagram C), then a new larger counter bore has to be drilled, 5.5mm, to produce diagram B and the larger rivet used.

Customer notification

Customers do not need to be informed directly of this campaign. Please ensure that all affected vehicles are checked and repaired during the next service visit. You should also inform your new and used car sales departments so that the vehicles affected can be checked and, if necessary, repaired immediately (and not just before sale)

Warranty

To remove and check or remove, drill and check and re-rivet

Warranty type 790 or 710

Labour Operation Code 61 01 49 99 (for RO open date on or before 13 December 2012)
61 01 49 00 (for RO open date after 13 December 2012)

Damage Service Number E773

Damage Code 00 66

Criteria ID 01

Time 30 TU

Parts

The standard rivet for use where the hole dimensions is found to be correct is 3.2mm x 9.8mm (black) part A

The larger rivet used if the hole is found to be oversize and after the rectification measure has been performed is 4.0mm x 10.5mm (black) part B

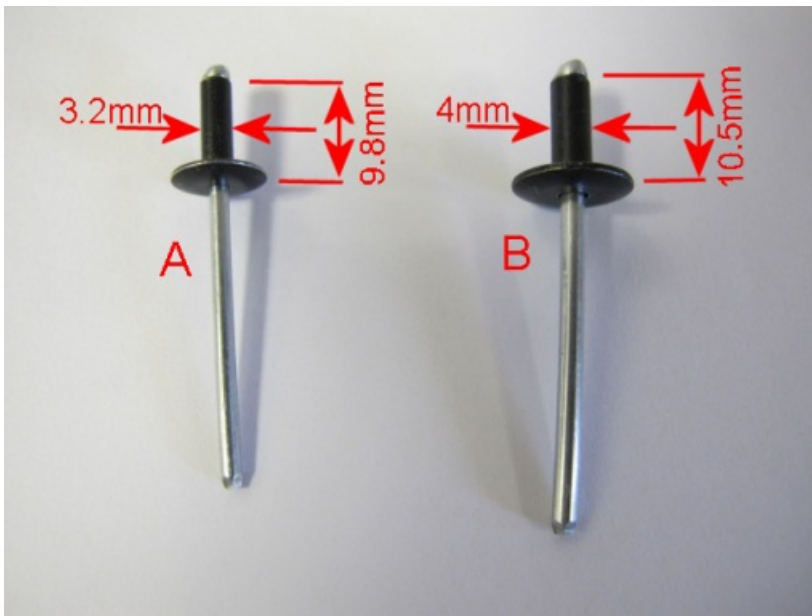


Figure 1

Both these rivets are contained in hood kit 3W7898025

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

Repair instructions

□ **Notes**

Technical background

A counter bore operation on the left hand twin bow may have been performed incorrectly resulting in an oversize rivet hole and no counter bore. The counter bore is required to enable the rivet to expand and lock into the casting. This rivet hole requires inspection and if found to be oversize the attached rectification measure performed

Check

If the vehicle is not already listed as repaired in the "Repair history" (in Elsa pro), check for the campaign identification mark, white spot adjacent to rivet (see Figure 9), should neither be evident carry out the required work in accordance with these instructions

Parts

The standard rivet for use where the hole dimensions is found to be correct is 3.2mm x 9.8mm (black) part A

The larger rivet used if the hole is found to be oversize and after the rectification measure has been performed is 4.0mm x 10.5mm (black) part B

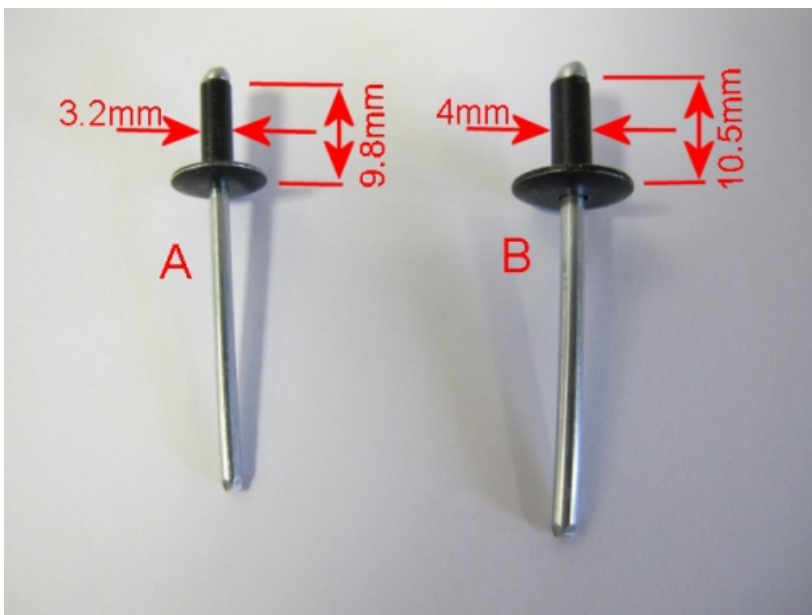


Figure 1

Both these rivets are contained in hood kit 3W7898025

Work

□
Warning: There is no anti-trap feature fitted to the linkage flaps, front header panel, tension bow or tonneau cover. Ensure all persons are clear of the mechanism, and there are no obstructions in the vicinity during the operation of the roof.

□
Caution: To avoid a clash of panels it is important that the luggage compartment and tonneau cover assembly are not opened at the same time. One of these must be fully closed at all times

□
Note: To carry out the following procedures, the power operated roof assembly will have to be positioned partially open in a transient state. With the ignition on any transient roof position will only be maintained for 10 minutes after which a warning will sound prior to the roof assembly gradually folding down as the hydraulic pressure decays. Therefore to enable the following operations to be carried out the roof has to be secured using 2 ratchet straps linked together (part number T10038) (see inset Figure 3)

□
Caution: Whenever air tools are employed or compressed air is used to remove debris it is imperative that the air is clean and dry and does not contain any lubricants. The exhaust from an air tool supplied with lubricated air is likely to stain the hood



Figure 3

Note: Only check and if necessary repair the rivet on the left hand twin bow as shown in figure 3. There are no known issues with the similar rivet on the right hand twin bow

1. With the ignition on, use the power operated roof open and close buttons to position the roof partially open. It is recommended that the roof position is maintained primarily with the ignition still on, and secured using a pair of tensioning straps (T10038) linked together.
2. **Note:** The vehicle must be adequately protected from the swarf that will be produced during the following operation. When removing rivets a 6mm drill is best suited to remove the rivet head before extracting the centre of the rivet with a 3mm parallel drift. **Eye protection must be worn**



Figure 4

3. Referencing figure 3, identify the lower rivet on the left hand twin bow. With the roof positioned as shown in figure 3. Drill out the rivet (see Figure 4), **ensure no trim or cords are in contact with the rotating surfaces of the drill.**

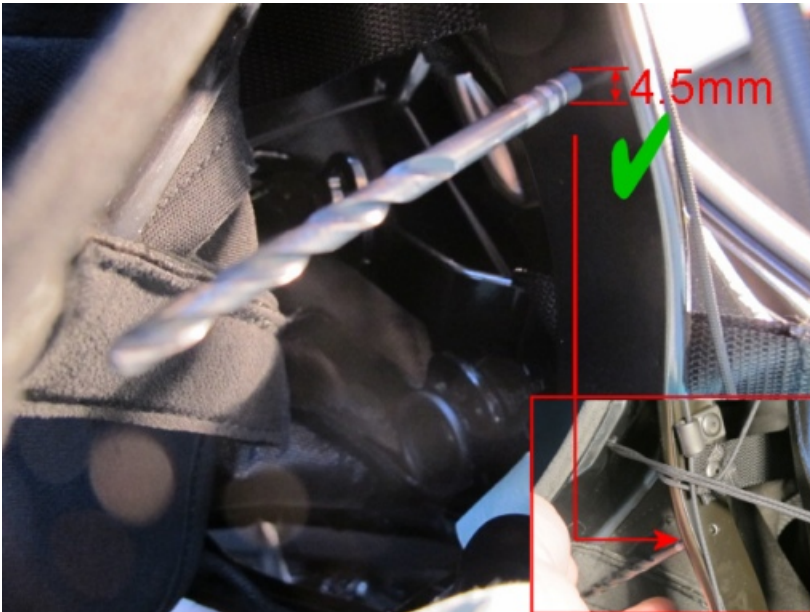


Figure 5

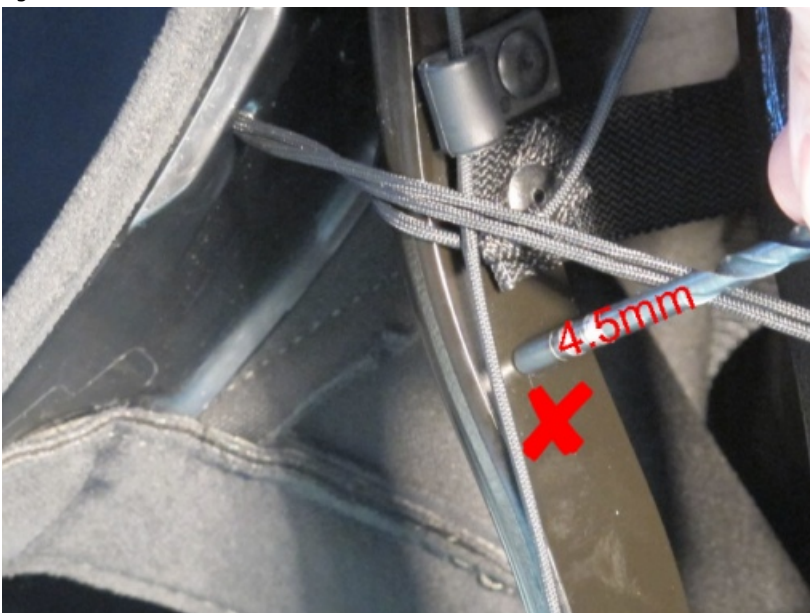


Figure 6

4. Referencing figure 2A use a 4.5mm drill to gauge the size of hole, the 4.5mm drill should enter the 4.5mm bore from the rear (see Figure 5) but not enter the front of the bore indicating that the front part of the bore is the correct size at 3.5mm (see Figure 6). If this is the case re attach

the strap with a new standard rivet (part 'A' figure 1) and apply a green campaign completion mark to the rear of the bow adjacent to the replaced rivet. If the drill gauges the hole as 4.5mm at both ends indicating the hole has been counter bored at 4.5mm through its entire length as shown in figure 2 C, then the following rectification measure is required

Rectification measure

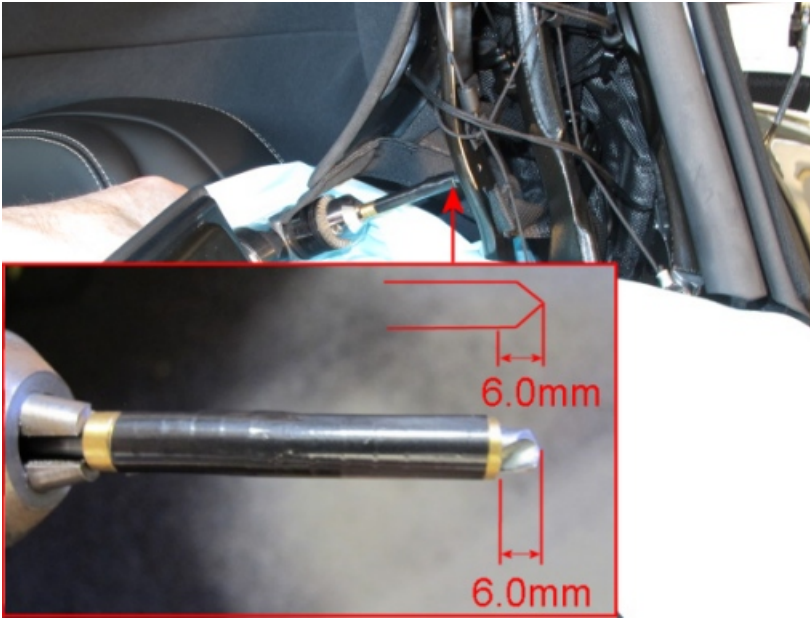


Figure 7

1. A hole 5.5mm in diameter and 6mm in depth has to be drilled from the rear face of the bow to produce figure 2B. Using a method of ensuring a depth of 6mm is not exceeded, measured from the drill tip, produce the 5.5mm counter bore from the rear of the bow (see Figure 7)
2. Apply a coat of black paint to the hole, both for cosmetic and oxidation suppression purposes



Figure 8

3. Re attach the strap with a new oversize rivet (part 'B' figure 1) (see Figure 8)

Identification



Figure 9

On completion apply a campaign completion mark to the rear of the bow adjacent to the replaced rivet. If the part used is the standard rivet (A) then apply a green completion mark.

If the rectification measure had to be performed and therefore the larger rivet (B) was used then apply a white completion mark (see Figure 9)