

SERVICE BULLETIN

Reference number:	SB-01-1008	Issued: 6 February, 2018
Subject:	DB11 Front Windscreen Leaks	
Model(s):	DB11 Coupe	
VIN Range:	L00120 to L01993	
Applicable to:	All Dealers	
Distribute to:	After Sales Manager Executive Manager Service Manager Sales Manager	Warranty Staff Technician(s) Parts Staff

Reason for this Service Bulletin

Aston Martin has found that some DB11 vehicles have had water leaks through the windscreen. The primary cause of the problem is that some of the rivets in the body structure were not installed flush. This can cause a failure in the sealant bond for the windscreen.

When the windscreen seal has this defect, water can leak on to the centre stack assembly and/or on to the VIN plate (refer to Figure 1). If there is an indication of a leak, do the workshop procedure that follows.



Figure 1

Workshop Procedure

This workshop procedure has two parts. If the windscreen continues to leak when Part A is complete, you must do Part B.

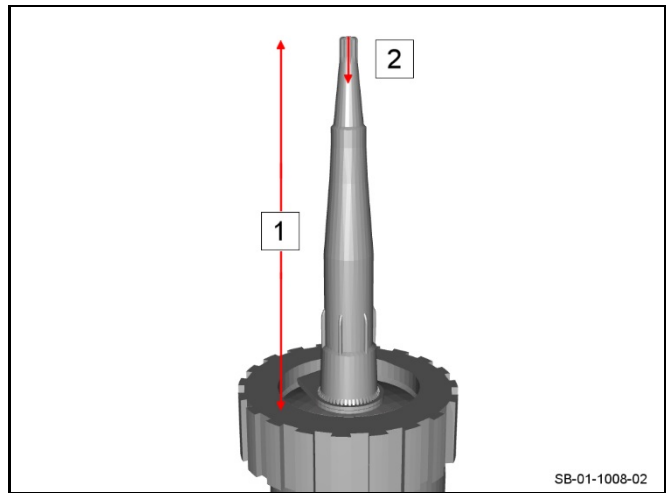
Part A – Seal the windscreen

Part B – Replace the windscreen

Part A – Seal the windscreen

1. Remove the trim panel for the front header (Refer to Workshop Manual procedure 01.05.BB).
2. Put the applicable protective covers on the interior trim adjacent to the windscreen.
3. Use an approved solvent to clean the surfaces between the top of the windscreen and the body.

4. Prepare the nozzle for the sealant tube as shown:
 - Cut the nozzle to 70 mm length (Refer to [1] in Figure 2).
 - Cut a slot into the nozzle that is 8-10 mm long (Refer to [2] in Figure 2).

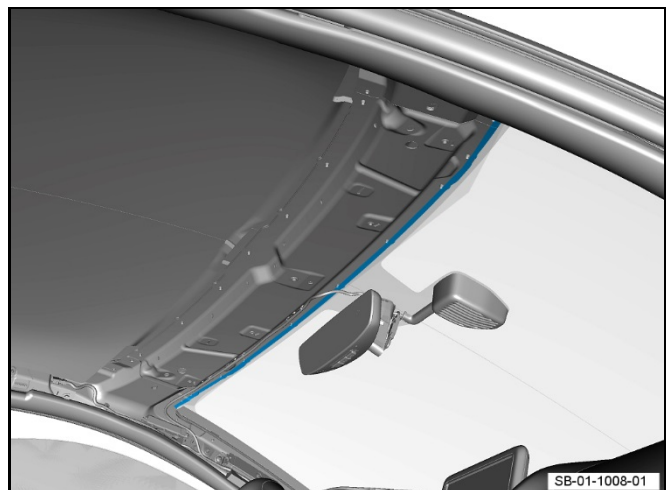
**Figure 2**

5. Assemble the sealant applicator.

WARNINGS: PUT ON PROTECTIVE GLOVES WHEN YOU DO THE STEP THAT FOLLOWS. IF YOU DO NOT, THE SEALANT CAN CAUSE IRRITATION TO SKIN.

MAKE SURE THAT THE WORK AREA IS WELL VENTILATED WHEN YOU DO THE STEP THAT FOLLOWS. IF YOU DO NOT, THE SEALANT CAN CAUSE BREATHING PROBLEMS.

6. Apply Beta Seal 1949 between the top of the windscreen and the body (refer to Figure 3).

**Figure 3**

7. Use an applicable tool to fully install the sealant and make it smooth.
8. Install the trim panel for the front header (Refer to Workshop Manual procedure 01.05.BB).

CAUTION: LET THE SEALANT DRY FOR THREE HOURS BEFORE YOU DO THE STEP THAT FOLLOWS. IF YOU DO NOT, THE SEALANT BOND CAN FAIL AND CAUSE LEAKS.

9. Do a check to make sure that the windscreen has no leaks.

Part B – Replace the windscreen

1. Remove the front windscreen (Refer to Workshop Manual procedure 01.11.AA).
2. Put the applicable protective covers on the interior trim adjacent to the windscreen.
3. Remove the sealant from the body.

WARNING: PUT ON PROTECTIVE GLOVES AND EYE PROTECTION WHEN YOU DO WORK ON THE GLASS. THE GLASS CAN BREAK EASILY AND CAUSE INJURY.

4. Install the windscreen finisher to the windscreen.

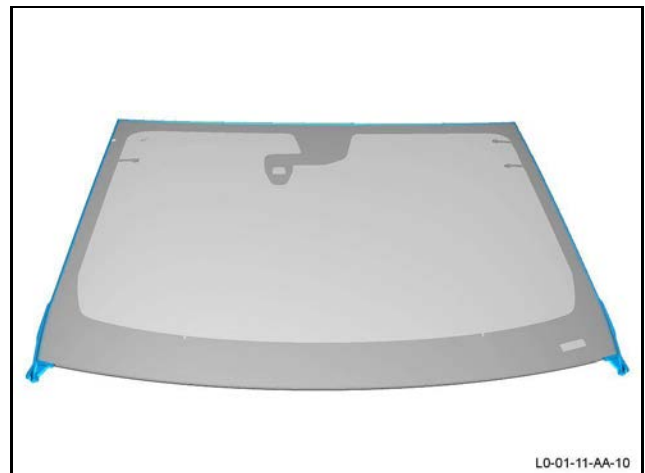


Figure 4

5. Install the lower windscreen strip to the windscreen.

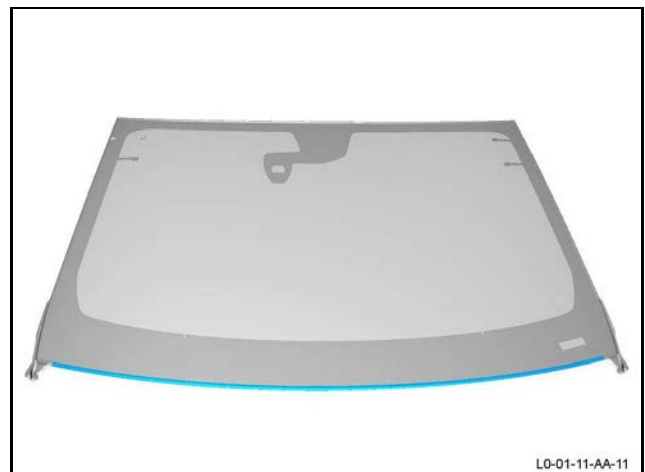


Figure 5

6. Install the windscreen foam to the windscreen.

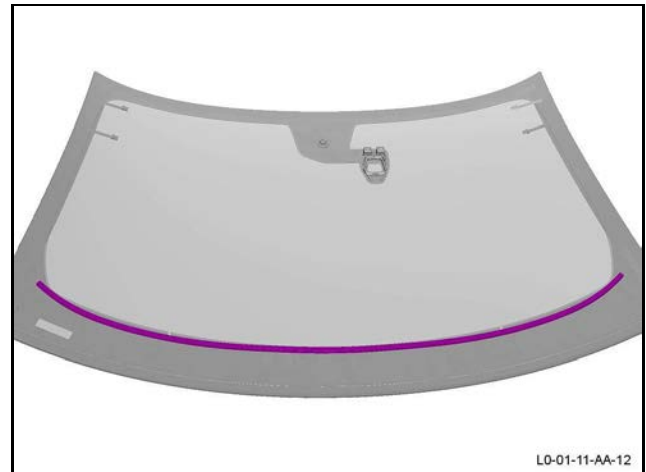


Figure 6

7. Clean and polish the windscreen.
8. Install suction handles to the windscreen.

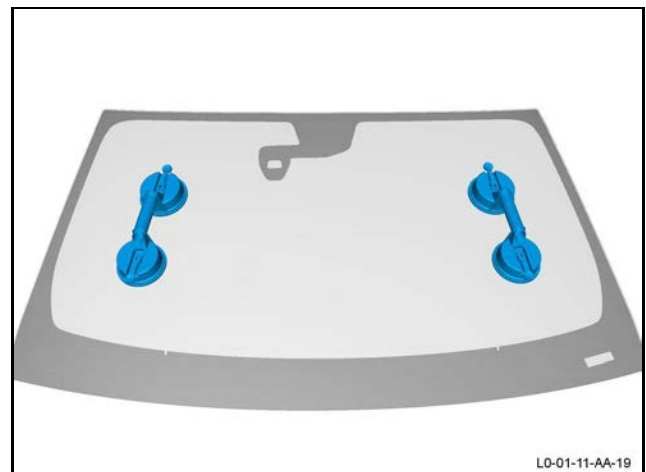


Figure 7

9. Apply etch primer around the windscreen to body contact area.

Notes: *You must wait 10 minutes for the etch primer to dry before you can apply the sealant.*

You must install the windscreen in less than two hours after you apply the etch primer.

10. Assemble the sealant applicator.

Note: *You must install the windscreen in less than 10 minutes after you apply the sealant.*

11. Apply sealant to the windscreen to body contact area (Refer to Figure 8).
Make sure the sealant path goes around the outer rivets (Refer to Figure 9).

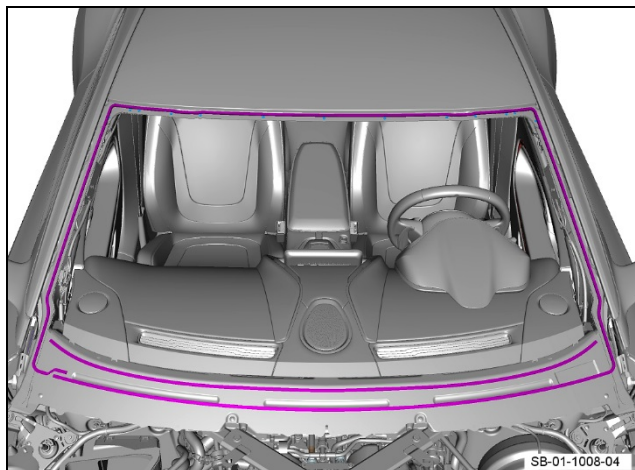


Figure 8

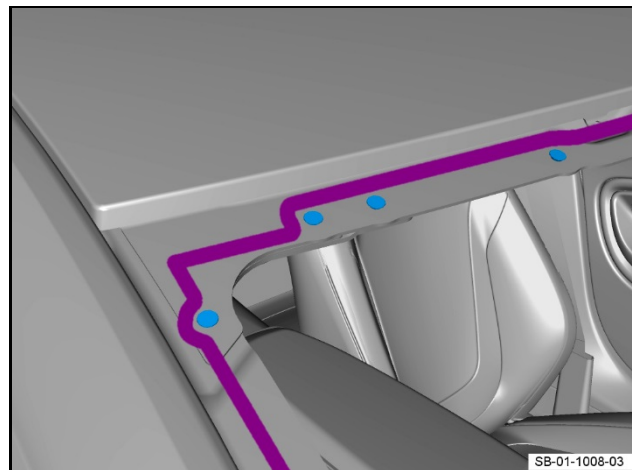


Figure 9

Note: If the height setting blocks are damaged, you must install new height setting blocks.

12. Install the height setting blocks (if applicable) to the position you recorded during the removal procedure.

WARNING: THE WINDSCREEN IS HEAVY. YOU MUST HAVE THE AID OF ONE MORE TECHNICIAN TO DO THE STEP THAT FOLLOWS.

13. Put the windscreen into position.

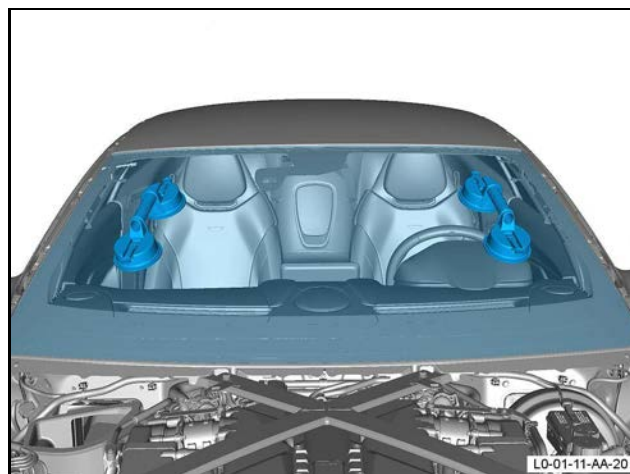
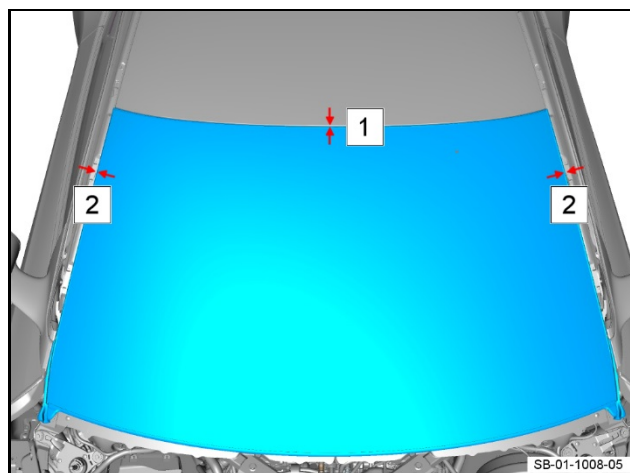
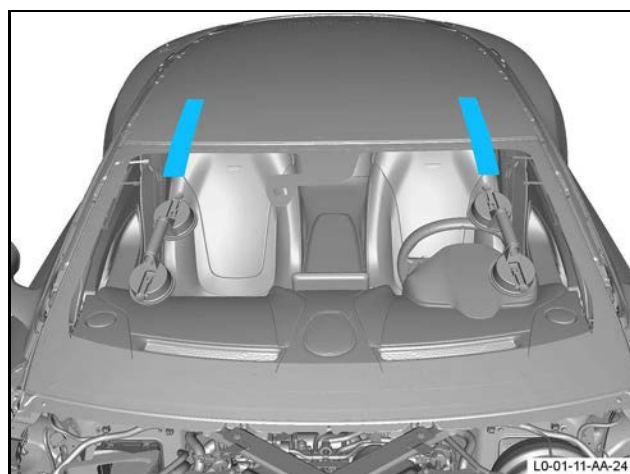


Figure 10

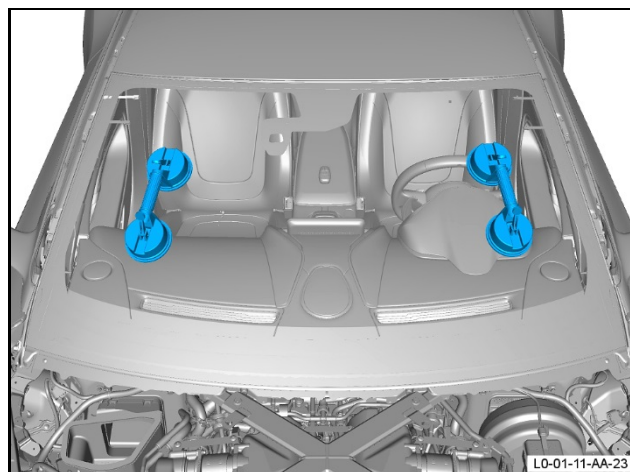
14. Push the windscreen onto the sealant.

15. Make sure that the windscreen is aligned as shown:

- The distance between the top of the windscreen and the roof (Refer to [1] in Figure 11) should be:
 - Nominal: 5.0 mm
 - Minimum: 4.0 mm
 - Maximum: 5.5 mm
- The distance between the sides of the windscreen and the body should be equal (Refer to [2] in Figure 12). The maximum variation should be 2 mm.

**Figure 11****16.** Attach the applicable tape on to the windscreen and body.**Figure 12**

Note: *The tape will help to prevent movement of the windscreen. Do not remove the tape until the last step of the procedure.*

17. Remove the suction handles from the windscreen.**Figure 13****18.** Remove unwanted sealant from around the windscreen.**19.** Remove all of the protective covers and tape.**20.** Install the leaf screen (Refer to Workshop Manual procedure 01.08.AE).

21. Install the left side cantrail finisher (Refer to Workshop Manual procedure 01.08.EM).
22. Install the right side cantrail finisher (Refer to Workshop Manual procedure 01.08.EN).

CAUTION: LET THE SEALANT DRY FOR THREE HOURS BEFORE YOU DO THE STEP THAT FOLLOWS. IF YOU DO NOT, THE SEALANT BOND CAN FAIL AND CAUSE LEAKS.

23. Do a check to make sure that the windscreen has no leaks.
24. Connect the electrical connector for the Digital Audio Broadcast (DAB) amplifier.

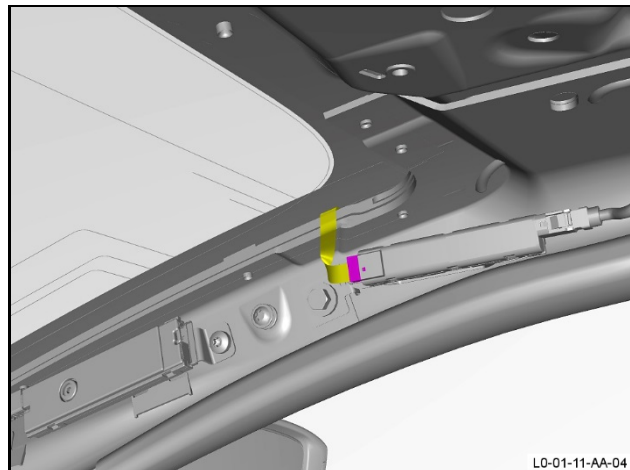


Figure 14

25. Connect the electrical connector for the Frequency Modulation (FM) antenna.

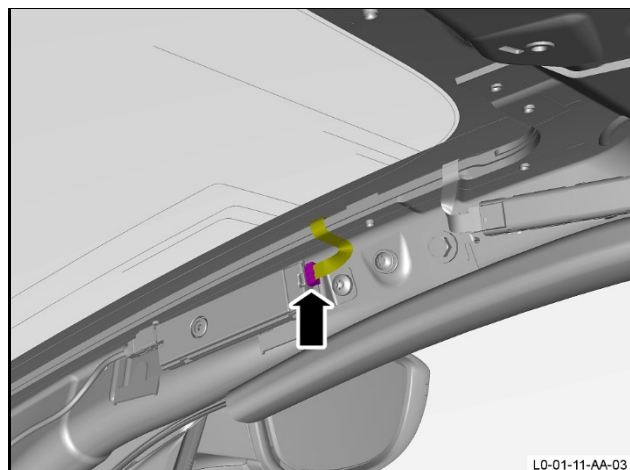


Figure 15

26. Connect the electrical connector for the DAB amplifier.

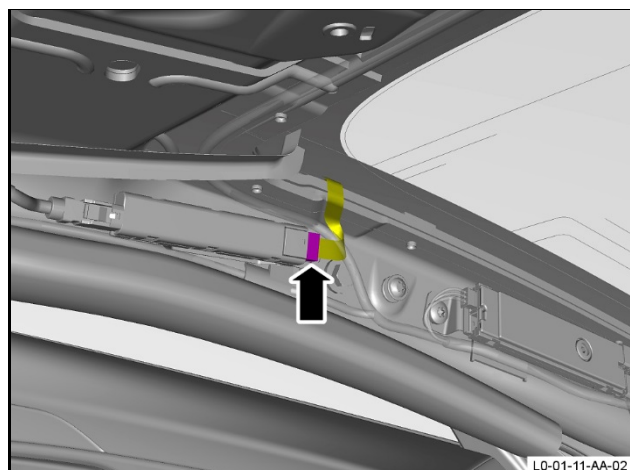


Figure 16

- 27. Connect the electrical connector for the Amplitude Modulation (AM) and the Frequency Modulation (FM) antenna.

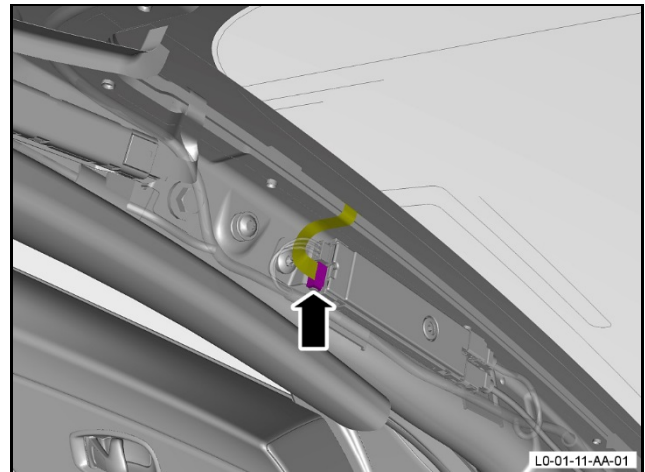


Figure 17

- 28. Install the rear dipping mirror (refer to Workshop Manual procedure 01.09.AA).
- 29. Remove the tape.

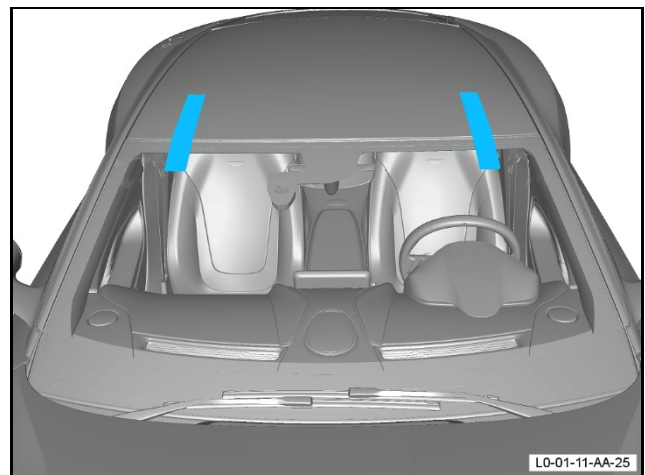


Figure 18

Part Data

Description	Part Number	Quantity
Beta Seal 1949 300 ml (or Beta Seal 1949 1F 300 ml)	706378	1
Windscreen without seals (LHD, Rest of World (ROW))	HY53-03804-BB	1
Windscreen without seals (RHD, up to VIN L01484)	HY53-03804-AA	1
Windscreen Finisher	HY53-03296-AA	1
Lower Windscreen Strip	HY53-030A44-AA	1
Bumpon-Rectangle Black (Height Setting Blocks)	4G43-03836-AB-PK	Pack of 10

Notes: *At the time of publication there are six of the Windscreen Finisher (HY53-03296-AA) parts in stock.*

Aston Martin will have more stock of the Windscreen Finisher (HY53-03296-AA) part on 1 March, 2018.

Warranty Data**Procedure and Labour Time**

Part A:

Description	Labour Time	ROT Code
Seal the windscreen	1.5 hours	01.11.AB

Part B:

Description	Labour Time	ROT Code
Replace the front windscreen	4.2 hours	01.11.AA

Failure Mode Description

Select the failure modes that follow when you make a claim through the Warranty system:

Subsystem	Location	Component	Mode of Failure
WATER LEAKS	- BODY - WINDSCREEN - FRONT	- WINDSCREEN - GLASS	- WATER INGRESS - SEALANT FAILURE

If you have any questions related to this Service Bulletin, please contact: Aston Martin Technical Services
on: +44 (0) 1926 644720, email: askamtech@astonmartin.com,
Or contact your After Sales Manager.

The English version of this Service Bulletin is written in
Simplified Technical English to ASD-STE100™.