

SERVICE BULLETIN

Reference number:	SB-01-1054	Issued: 02 February, 2018
Subject:	DB11 Rear 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 parcel shelf and/or on to adjacent areas of the vehicle interior. If there is an indication of a leak, do the workshop procedure that follows.



Figure 1

Workshop Procedure

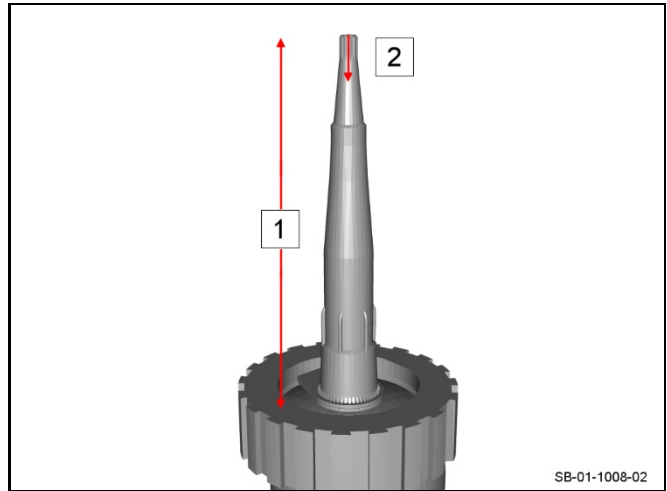
This workshop procedure has two parts. If the windscreen continues to leak when Part A is complete, you must do Part B.

Part A – Seal the windscreen

Part B – Replace the windscreen

Part A – Seal the windscreen

1. Remove the trim panel for the rear header (Refer to Workshop Manual procedure 01.05.BK).
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).

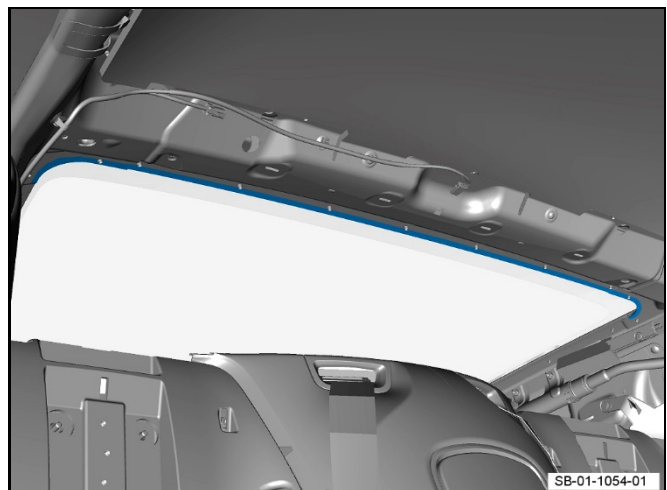
**Figure 2**

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 rear header (Refer to Workshop Manual procedure 01.05.BK).

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 rear windscreen (Refer to Workshop Manual procedure 01.11.CA).
2. Put the applicable protective covers on the interior trim adjacent to the windscreen.
3. Remove the sealant from the body.
4. Install the left side cantrail finisher (Refer to Workshop Manual procedure 01.08.EM).
5. Install the right side cantrail finisher (Refer to Workshop Manual procedure 01.08.EN).
6. Install the high-mounted stop lamp, but **do not** install the finisher for the high-mounted stop lamp yet (Refer to Workshop Manual procedure 17.03.BE).
7. Put the applicable protective covers on the exterior trim adjacent to the windscreen.

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

8. Put the windscreen finishers into position.

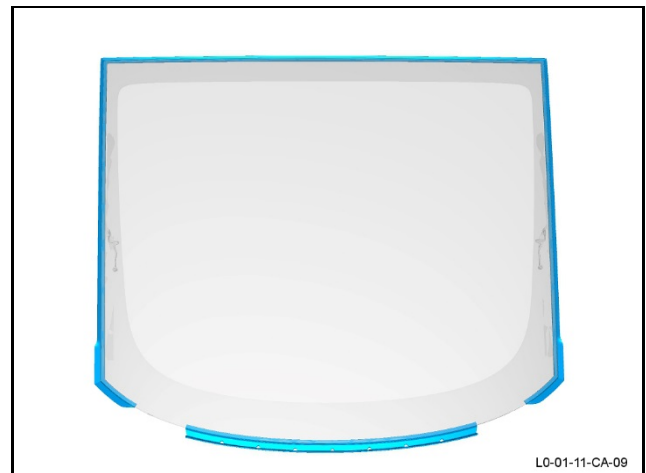


Figure 4

9. Install the adhesive strips that attaches the windscreen finishers to the windscreen.

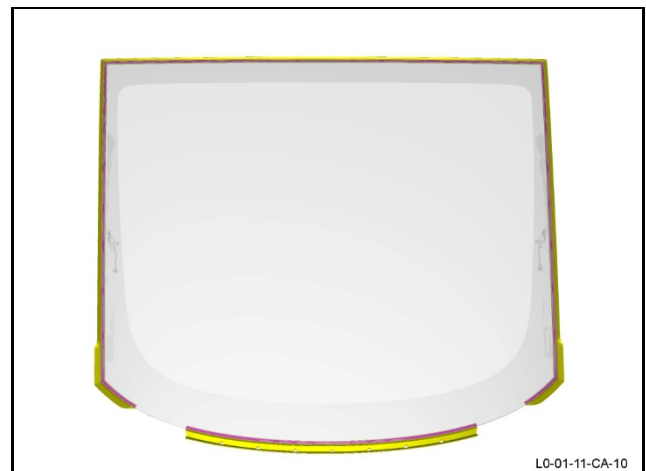


Figure 5

10. Clean and polish the windscreen.

11. Install suction handles to the windscreen.

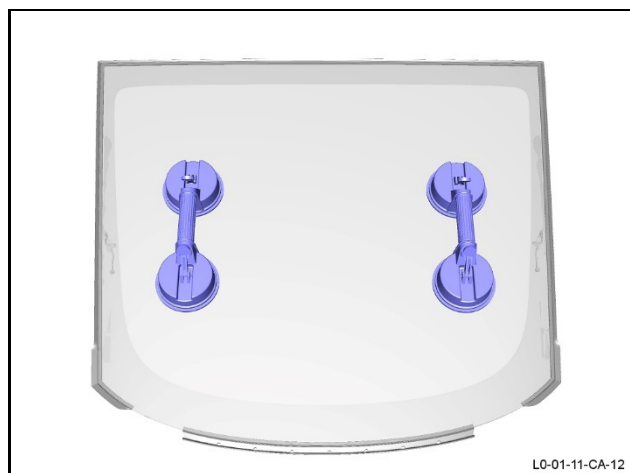


Figure 6

12. 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.

13. Assemble the sealant applicator.

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

14. Apply sealant to the body as shown (Refer to Figure 7).
Make sure the sealant path goes around the outer rivets (Refer to Figure 8).

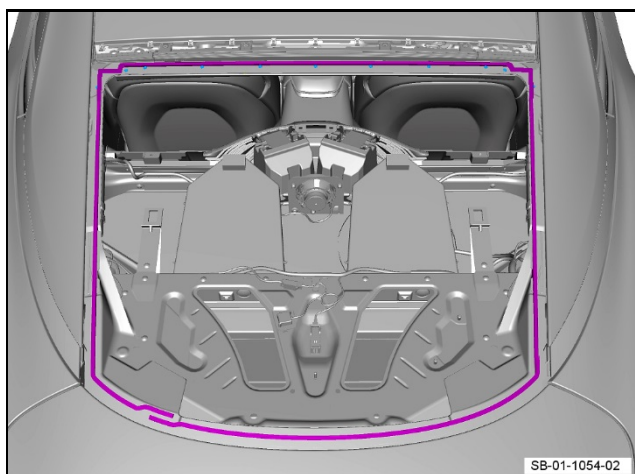


Figure 7

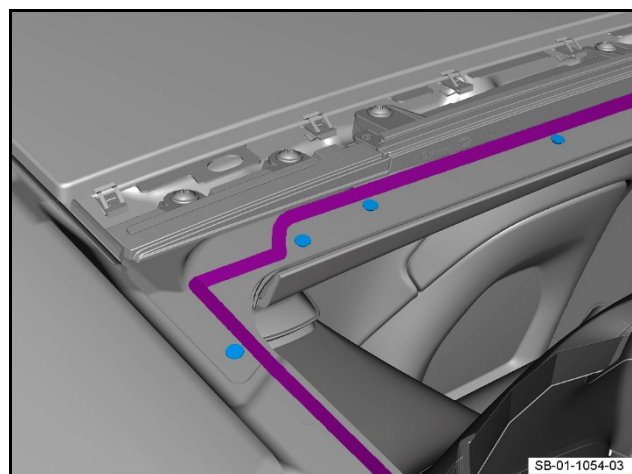


Figure 8

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

15. 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.**

16. Put the windscreen into position.

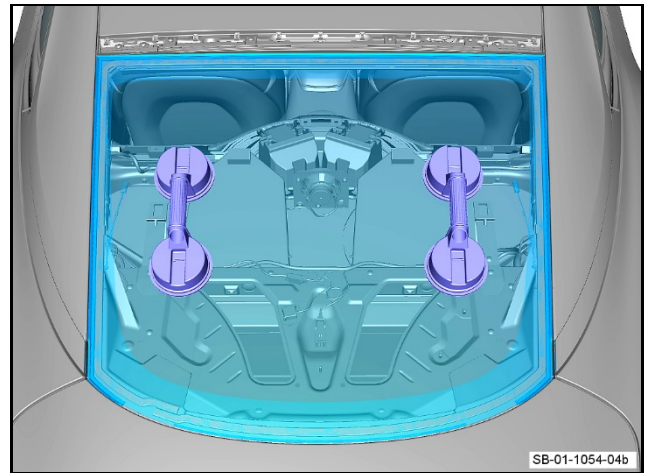


Figure 9

17. Push the windscreen onto the sealant.
18. Install the finisher for the high-mounted stop lamp (Refer to Workshop Manual procedure 01.08.DL).

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

- The distance between the top of the windscreen and the high-mounted stop lamp cover (Refer to [1] in Figure 10) should be:
 - Nominal: 2.0 mm
 - Minimum: 0.5 mm
 - Maximum: 4.0 mm
- The distance between the sides of the windscreen and the cantrail finishers (Refer to [2] in Figure 10) should be:
 - Nominal: 4.0 mm
 - Minimum: 1.5 mm
 - Maximum: 5.5 mm
- The distance between the sides of the windscreen and the cantrail finishers should be equal. The maximum variation should be 2 mm.

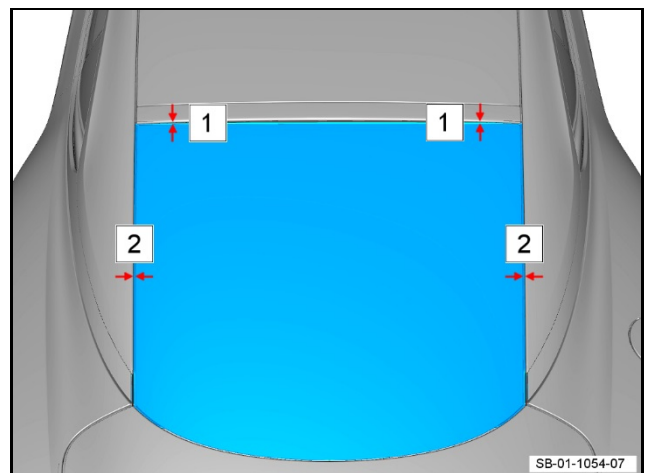


Figure 10

20. Attach the applicable tape on to the windscreen and body.

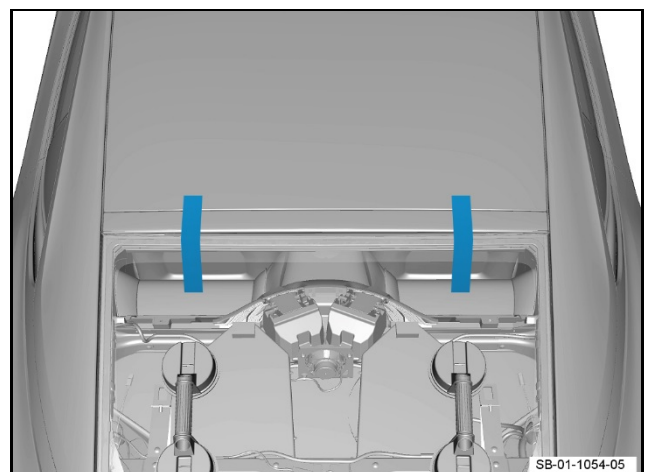


Figure 11

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

21. Remove the suction handles from the windshield.

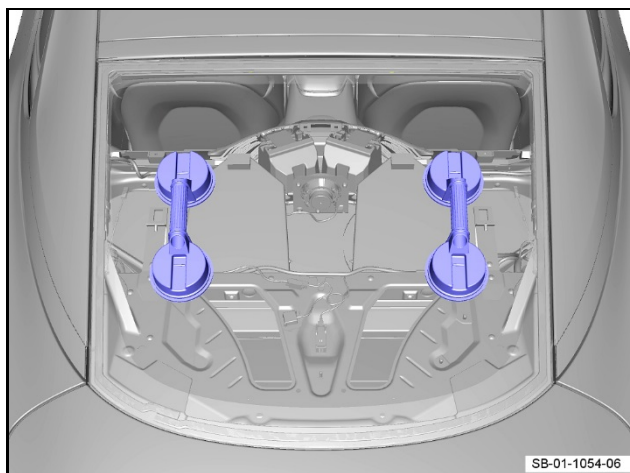


Figure 12

22. Remove unwanted sealant from around the windshield.
23. Remove all of the protective covers and tape.

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.**

24. Do a check to make sure that the windshield has no leaks.
25. Connect the electrical connector for the Amplitude Modulation (AM) antenna.

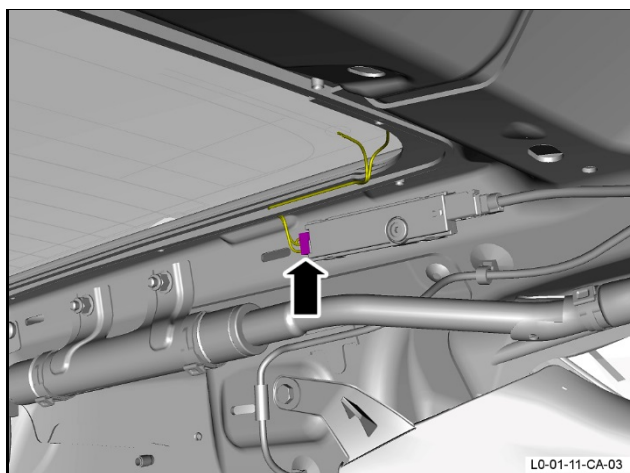


Figure 13

- 26. Connect the electrical connector for the wavetrap filter.

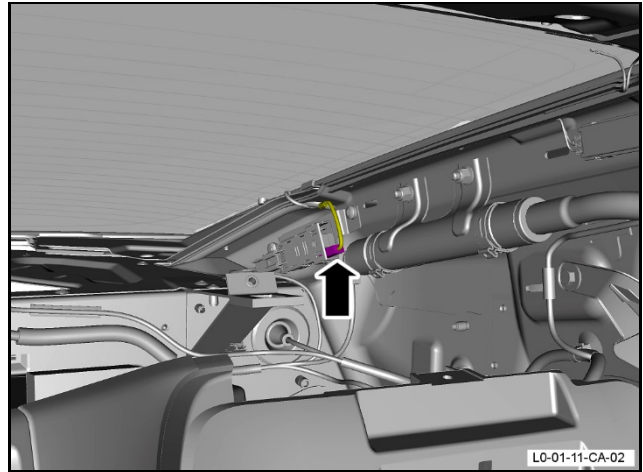


Figure 14

- 27. Connect the electrical connector for the wavetrap filter.

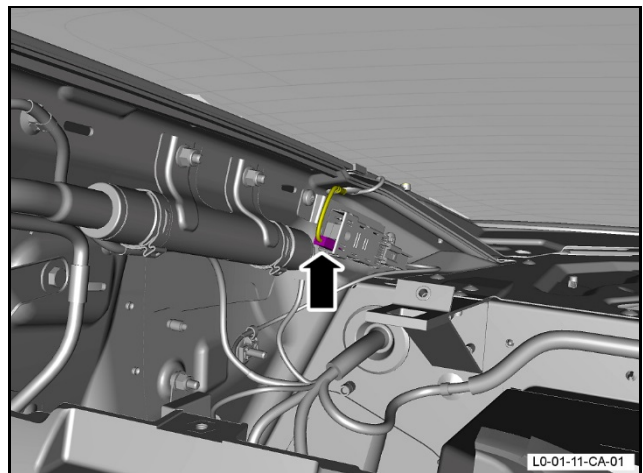


Figure 15

- 28. Remove the tape.

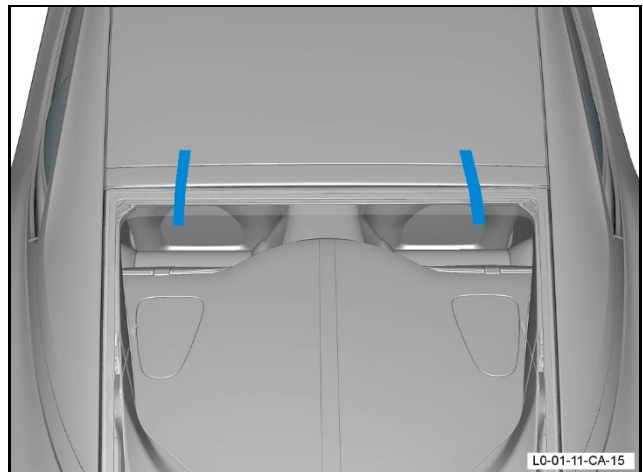


Figure 16

Part Data

Description	Part Number	Quantity
Beta Seal 1949 300 ml (or Beta Seal 1949 1F 300 ml)	706378	1
Windscreen without seals (up to 18.5MY)	HY53-42004-AA	1
Windscreen Finisher Top and Sides	HY53-77-10041	1
Windscreen Finisher Lower	HY53-77-10042	1
Bumpon-Rectangle Black (Height Setting Blocks)	4G43-03836-AB-PK	Pack of 10

Warranty Data**Procedure and Labour Time**

Part A:

Description	Labour Time	ROT Code
Seal the windscreen	1.75 hours	01.11.CB

Part B:

Description	Labour Time	ROT Code
Replace the rear windscreen	4.45 hours	01.11.CA

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 - WINDOW / SCREEN - REAR	- REAR - WINDOW / SCREEN - 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™.