



## Replace High Voltage (HV) Battery

<b>Classification</b>	Campaign Bulletin	<b>Section/Group</b>	16 - Battery System	<b>Country/Region</b>	United States, Canada
<b>Year</b>	2018	<b>Model</b>	Model 3	<b>Version</b>	Dual Motor

**Bulletin Classification:** *This campaign bulletin addresses a known non-safety-related condition and provides recommended technical diagnosis and repair procedures. Apply this procedure to all vehicles in the affected VIN range listed. These instructions assume knowledge of motor vehicle and high voltage electrical component repairs, and should only be executed by trained professionals. Tesla assumes no liability for injury or property damage due to a failure to properly follow these instructions or repairs attempted by unqualified individuals.*

### Condition

The cooling tubes inside the HV battery were not brazed to Tesla's internal standards. This condition might result in a reduction of vehicle driving range.

### Correction

Replace the HV battery.

Correction Description	Correction	Time
SB-18-16-017 Not Applicable	S011816017	0.0
Replace HV Battery Due To Cooling Tubes Not Brazed	S021816017	4.4

Required Part(s):	Part Number	Description	Quantity
	1104422-00-M	ASY,HVBAT,E3,AWD,1PH,M3	1
	1111033-00-D	M3 2R BOLSTER CLIP	2
	1093060-00-A	NUT&WSHR,M8,STL[9],DOUBLE SEMS	2
	1447684-00-A	BOLT,HF,M14-2.0x120,[109],ZNFL,SMAT	2

**Shop supplies:**

Shop towels  
 HV insulating gloves and leather outer gloves  
 Isopropyl alcohol (IPA) wipes

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Manual.

Special Tool(s):	Part Number	Description
	1020566-00-F	ASY, Battery Table, Manual Lift
	1020566-99-A	Top Plate, Battery Table, Manual Lift
	1129166-00-A	Hoist, H-Frame
	1134523-00-A	Kit, Alignment Rods, Battery
	1140311-00-A	Lever Lock, HV Connector
	1053600-00-B	Drive Unit Pressure Test Fixture
	1130942-00-B	Adapter, Coolant Reservoir Pressure Test
	1132185-00-B	Kit, Coolant Leak Test Adapters
	1133843-00-A	Kit, Coolant Drain & Fill Adapters
	1135762-00-A	Kit, Svc Plug, Cooling Hose
	GSN-TL-000564	Kit, Battery Coolant Drain and Fill
	1026636-00-A	Pack Enclosure Leak Tester, HV Battery
	1140501-00-A	Pack Kit, Enclosure, Leak Test, HV Battery, Complete
	1144879-00-A	Kit, Encl Leak Test Adapters, HV Battery
	1108272-00-B	Cap, Logic Conn, Inv, 3DU
	1076921-00-B	Insulation Multimeter, Fluke 1507
	1059330-00-B	Skt, 1/4in Dr, 5-Lobe Torx External
	1133569-00-A	Pliers, Clip Removal
	1050448-00-A	Refiller, Cooling System
	1073363-00-A	Gantry, Adjustable, Aluminum

## Procedure

Replace the HV battery (refer to Service Manual procedure 16010102).

**Affected VIN(s)** Affected Model 3 vehicle built on November 29, 2018.

**NOTE:** This is a simplified summary of the affected VIN list. Refer to the VIN/Bulletin Tracker or Customer/Vehicle profile to determine applicability of this bulletin for a particular vehicle.

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