



Safety Recall Campaign

RC-19-70-01

MODEL: 2018 Karma Revero (All)

DATE: June 2019

Revised - June 2019

TITLE: Front Doors Upper Intrusion Bar Recall Campaign

PRIORITY: Revero vehicles in the attached list (PP. 3~5)

APPLICABILITY: 2018 Karma Revero

MARKET REGIONS: United States and Canada

PURPOSE: This document highlights a procedure to inspect the upper intrusion bars located inside the front vehicle doors. There is a possibility that certain vehicles may have upper intrusion bars which may exhibit a fissure, or crack, in the structure of the material. Follow the procedure outlined below to inspect both front doors for any evidence of this concern.

This document supersedes any and all previous documents in workshop manuals, wiring diagrams, training documents, parts catalog, labor operations, etc. While the method of repair is approved as indicated, performing and verifying the repair is proper is the responsibility of the technician.

Safety Recall Notice (Remedy)

2018 Model Year Karma Revero - Front Doors Upper Intrusion Bar Recall Campaign

IMPORTANT REMINDER ON VEHICLES AFFECTED BY SAFETY & COMPLIANCE RECALLS

New Vehicles in Dealer Inventory: It is a violation of Federal law for a dealer to deliver a new motor vehicle or any new or used item of motor vehicle equipment (including a tire) covered by this notification under a sale or lease until the defect or noncompliance is remedied. By law, dealers must correct, prior to delivery for sale or lease, any vehicle that fails to comply with an applicable Federal Motor Vehicle Safety Standard or that contains a defect relating to motor vehicle safety.

Pre-Owned Vehicles in Dealer Inventory: Dealers should not deliver any pre-owned vehicles in their inventory which are involved in a safety or compliance recall until the defect has been remedied.

IMPORTANT NOTICE!

A borescope kit has been shipped to each Karma authorized dealer. Please use the provided borescope kit to capture images of the concern. These images MUST be attached to the warranty claim, the TSS case, and retained with the repair order.

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TOOLS REQUIRED: All component removal MUST be performed using hand tools.



A camera equipped smartphone



***Boreoscope Kit**



Trim Removal Tools

***The Boreoscope kits were shipped to the attention of the Service Manager at each authorized Karma dealership.**

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50GK41SA3JA000002	50GK41SA5JA000034	50GK41SAXJA000076	50GK41SA7JA000116
50GK41SA5JA000003	50GK41SA7JA000035	50GK41SA1JA000077	50GK41SA9JA000117
50GK41SA7JA000004	50GK41SA9JA000036	50GK41SA3JA000078	50GK41SA0JA000118
50GK41SA9JA000005	50GK41SA0JA000037	50GK41SA5JA000079	50GK41SA2JA000119
50GK41SA0JA000006	50GK41SA2JA000038	50GK41SA1JA000080	50GK41SA9JA000120
50GK41SA2JA000007	50GK41SA4JA000039	50GK41SA3JA000081	50GK41SA0JA000121
50GK41SA4JA000008	50GK41SA0JA000040	50GK41SA5JA000082	50GK41SA2JA000122
50GK41SA6JA000009	50GK41SA2JA000041	50GK41SA0JA000085	50GK41SA4JA000123
50GK41SA2JA000010	50GK41SA4JA000042	50GK41SA2JA000086	50GK41SA6JA000124
50GK41SA4JA000011	50GK41SA6JA000043	50GK41SA4JA000087	50GK41SAXJA000126
50GK41SA6JA000012	50GK41SA8JA000044	50GK41SA6JA000088	50GK41SA1JA000127
50GK41SA8JA000013	50GK41SA3JA000047	50GK41SA8JA000089	50GK41SA3JA000131
50GK41SAXJA000014	50GK41SA5JA000048	50GK41SA4JA000090	50GK41SA5JA000132
50GK41SA1JA000015	50GK41SA7JA000049	50GK41SA6JA000091	50GK41SA7JA000133
50GK41SA3JA000016	50GK41SA3JA000050	50GK41SA8JA000092	50GK41SA9JA000134
50GK41SA5JA000017	50GK41SA5JA000051	50GK41SAXJA000093	50GK41SA0JA000135
50GK41SA7JA000018	50GK41SA9JA000053	50GK41SA1JA000094	50GK41SA2JA000136
50GK41SA9JA000019	50GK41SA0JA000054	50GK41SA3JA000095	50GK41SA4JA000137
50GK41SA5JA000020	50GK41SA2JA000055	50GK41SA5JA000096	50GK41SA6JA000138
50GK41SA7JA000021	50GK41SA4JA000056	50GK41SA7JA000097	50GK41SA8JA000139
50GK41SA9JA000022	50GK41SA6JA000057	50GK41SA9JA000098	50GK41SA4JA000140
50GK41SA0JA000023	50GK41SA8JA000058	50GK41SA5JA000101	50GK41SA8JA000142
50GK41SA2JA000024	50GK41SAXJA000059	50GK41SA9JA000103	50GK41SAXJA000143
50GK41SA4JA000025	50GK41SA6JA000060	50GK41SA0JA000104	50GK41SA1JA000144
50GK41SA6JA000026	50GK41SA8JA000061	50GK41SA6JA000107	50GK41SA7JA000147
50GK41SA8JA000027	50GK41SAXJA000062	50GK41SA8JA000108	50GK41SA9JA000148
50GK41SAXJA000028	50GK41SA1JA000063	50GK41SAXJA000109	50GK41SA0JA000149
50GK41SA1JA000029	50GK41SA3JA000064	50GK41SA6JA000110	50GK41SA9JA000151
50GK41SA8JA000030	50GK41SA5JA000065	50GK41SAXJA000112	50GK41SA0JA000152
50GK41SAXJA000031	50GK41SA2JA000069	50GK41SA1JA000113	50GK41SA2JA000153
50GK41SA1JA000032	50GK41SA2JA000072	50GK41SA3JA000114	50GK41SA4JA000154
50GK41SA3JA000033	50GK41SA6JA000074	50GK41SA5JA000115	

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50GK41SAXJA000157	50GK41SA1JA000192	50GK41SA3JA000226	50GK41SA7JA000262
50GK41SA1JA000158	50GK41SA3JA000193	50GK41SA5JA000227	50GK41SA9JA000263
50GK41SA3JA000159	50GK41SA5JA000194	50GK41SA7JA000228	50GK41SA0JA000264
50GK41SAXJA000160	50GK41SA7JA000195	50GK41SA9JA000229	50GK41SA2JA000265
50GK41SA1JA000161	50GK41SA9JA000196	50GK41SA5JA000230	50GK41SA4JA000266
50GK41SA3JA000162	50GK41SA0JA000197	50GK41SA7JA000231	50GK41SA6JA000267
50GK41SA5JA000163	50GK41SA2JA000198	50GK41SA9JA000232	50GK41SA8JA000268
50GK41SA9JA000165	50GK41SA4JA000199	50GK41SA2JA000234	50GK41SAXJA000269
50GK41SA0JA000166	50GK41SA7JA000200	50GK41SA4JA000235	50GK41SA6JA000270
50GK41SA2JA000167	50GK41SA9JA000201	50GK41SA6JA000236	50GK41SA8JA000271
50GK41SA4JA000168	50GK41SA0JA000202	50GK41SAXJA000238	50GK41SAXJA000272
50GK41SA6JA000169	50GK41SA2JA000203	50GK41SA8JA000240	50GK41SA1JA000273
50GK41SA2JA000170	50GK41SA4JA000204	50GK41SAXJA000241	50GK41SA3JA000274
50GK41SA4JA000171	50GK41SA6JA000205	50GK41SA3JA000243	50GK41SA7JA000276
50GK41SA6JA000172	50GK41SA8JA000206	50GK41SA5JA000244	50GK41SA2JA000279
50GK41SA8JA000173	50GK41SAXJA000207	50GK41SA7JA000245	50GK41SA9JA000280
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50GK41SA3JA000176	50GK41SAXJA000210	50GK41SA2JA000248	50GK41SA4JA000283
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50GK41SA9JA000179	50GK41SA3JA000212	50GK41SA0JA000250	50GK41SA8JA000285
50GK41SA5JA000180	50GK41SA5JA000213	50GK41SA2JA000251	50GK41SAXJA000286
50GK41SA9JA000182	50GK41SA7JA000214	50GK41SA4JA000252	50GK41SA1JA000287
50GK41SA0JA000183	50GK41SA9JA000215	50GK41SA6JA000253	50GK41SA5JA000289
50GK41SA2JA000184	50GK41SA0JA000216	50GK41SA8JA000254	50GK41SA1JA000290
50GK41SA4JA000185	50GK41SA2JA000217	50GK41SAXJA000255	50GK41SA3JA000291
50GK41SA6JA000186	50GK41SA6JA000219	50GK41SA1JA000256	50GK41SA5JA000292
50GK41SA8JA000187	50GK41SA2JA000220	50GK41SA3JA000257	50GK41SA7JA000293
50GK41SAXJA000188	50GK41SA4JA000221	50GK41SA5JA000258	50GK41SA9JA000294
50GK41SA1JA000189	50GK41SA8JA000223	50GK41SA7JA000259	50GK41SA0JA000295
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50GK41SAXJA000191	50GK41SA1JA000225	50GK41SA5JA000261	50GK41SA6JA000298

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50GK41SA8JA000299	50GK4LSA2JAA00006	50GK41SA5JA000146
50GK41SA0JA000300	50GK4LSA4JAA00007	50GK41SA7JA000150
50GK41SA2JA000301	50GK4LSA6JAA00008	50GK41SA6JA000155
50GK41SA4JA000302	50GK4LSA4JAA00010	50GK41SA8JA000156
50GK41SA6JA000303	50GK4LSA6JAA00011	50GK41SA7JA000164
50GK41SA8JA000304	50GK4LSA8JAA00012	50GK41SA5JA000177
50GK41SAXJA000305	50GK4LSA1JAA00014	50GK41SA7JA000181
50GK41SA1JA000306	50GK4LSA3JAA00015	50GK41SA4JA000218
50GK41SA3JA000307	50GK41SAXJA000045	50GK41SA6JA000222
50GK41SA5JA000308	50GK41SA1JA000046	50GK41SA0JA000233
50GK41SA7JA000309	50GK41SA7JA000052	50GK41SA8JA000237
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50GK41SA7JA000312	50GK41SA0JA000068	50GK41SA5JA000275
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50GK41SA4JA000316	50GK41SA8JA000075	50GK41SA2JA000296
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50GK41SA8JA000318	50GK41SA9JA000084	50GK4LSAXJAA00013
50GK41SAXJA000319	50GK41SA0JA000099	
50GK41SA6JA000320	50GK41SA3JA000100	
50GK41SA8JA000321	50GK41SA7JA000102	
50GK41SAXJA000322	50GK41SA2JA000105	
50GK41SA1JA000323	50GK41SA4JA000106	
50GK41SA3JA000324	50GK41SA8JA000111	
50GK41SA5JA000325	50GK41SA8JA000125	
50GK4LSA3JAA00001	50GK41SA3JA000128	
50GK4LSA5JAA00002	50GK41SA5JA000129	
50GK4LSA7JAA00003	50GK41SA1JA000130	
50GK4LSA9JAA00004	50GK41SA6JA000141	
50GK4LSA0JAA00005	50GK41SA3JA000145	

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1. Remove the driver's side door panel per the information in the service manual (Fig. 1).

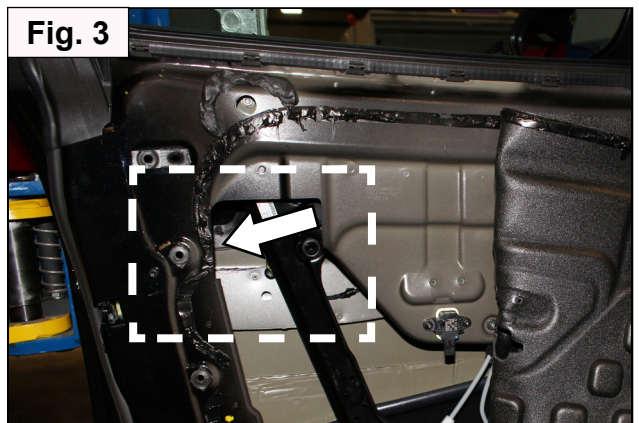
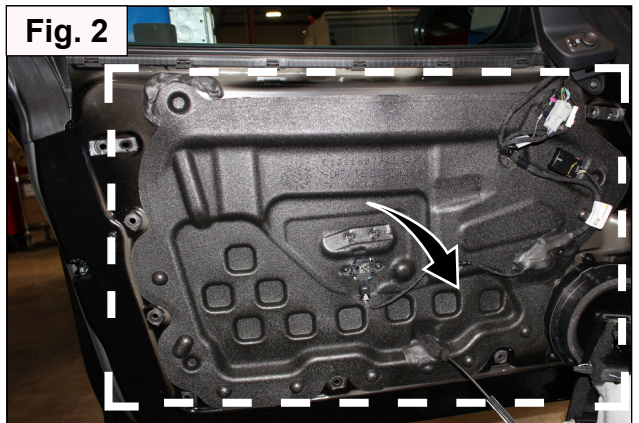


CAUTION!

- Wear disposable gloves throughout this procedure to prevent possible damage to interior trim components.
- To prevent damage to the vehicle, use only non-marring, plastic, trim removal tools.

2. Partially remove the vapor barrier from the door skin (Fig. 2).

3. Identify the location of the insertion point for the borescope by referring to Figure 3.



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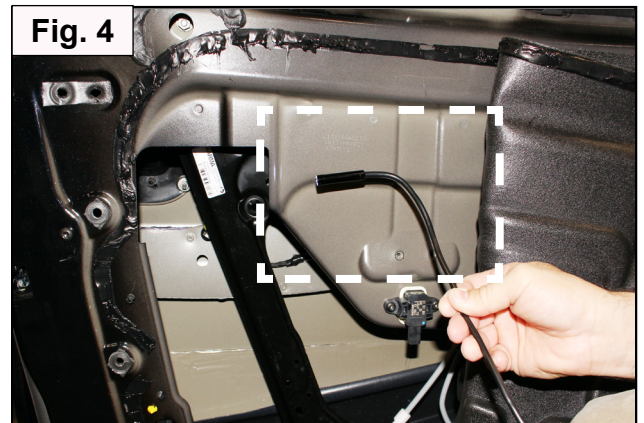
MODEL: 2018 Karma Revero (All)

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4. Bend the borescope tip at right angles to the shaft, as shown in Figure 4.



5. Insert the borescope in the space between the inner and outer door skin structures, as shown in Figure 5.



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6. Refer to the images below to maneuver the borescope to the affected area on the upper intrusion bar.



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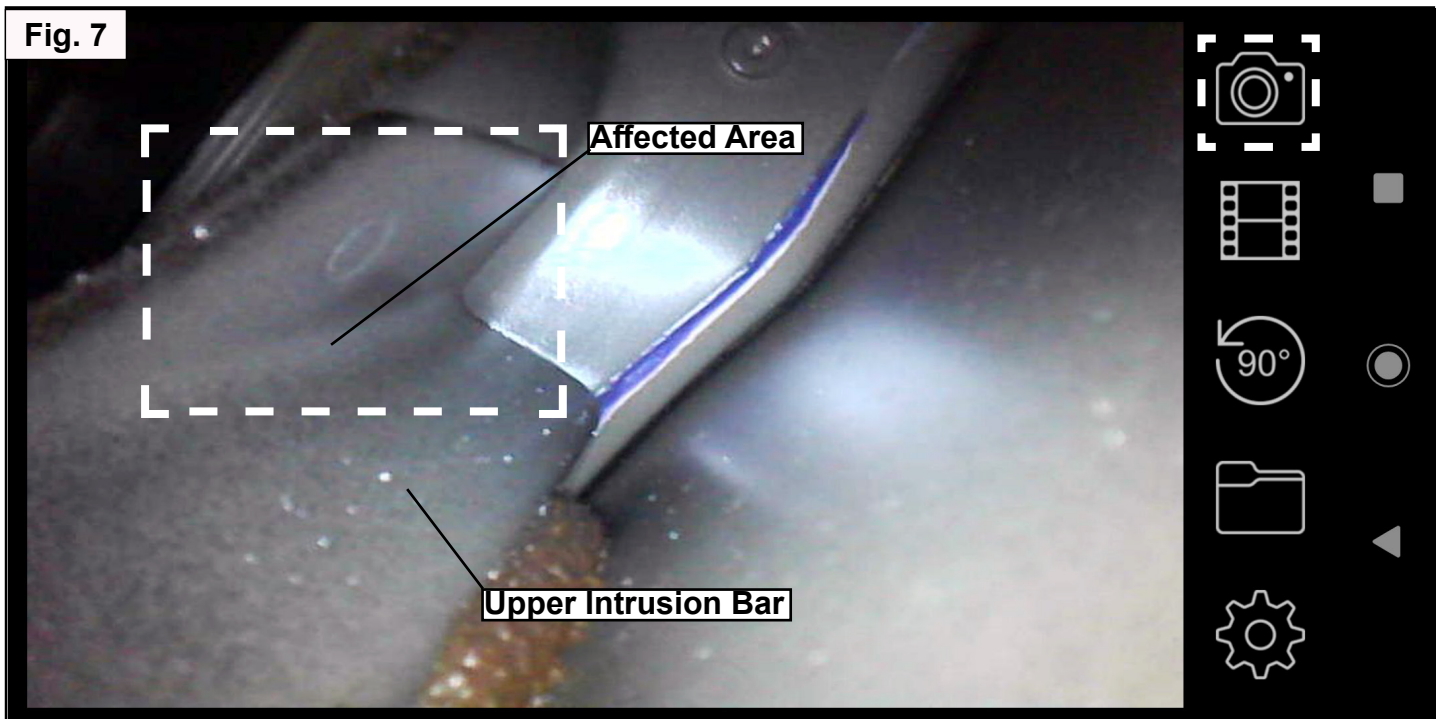
MODEL: 2018 Karma Revero (All)

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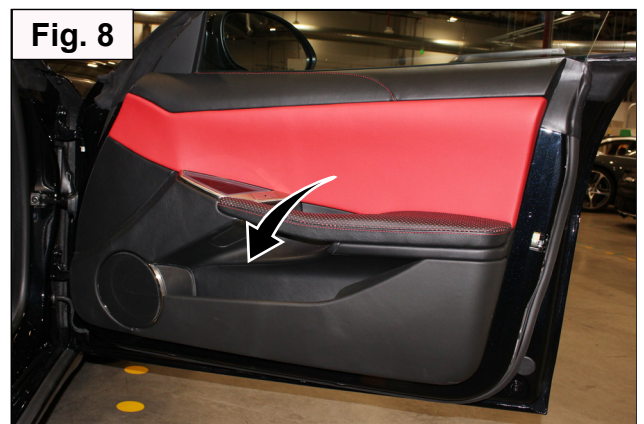
Revised - June 2019

TITLE: Front Doors Upper Intrusion Bar Recall Campaign

7. Use the borescope camera to capture a clear image showing the condition of the upper intrusion bar in the affected area, as shown in Figure 7. **NOTE: This image MUST be attached to the warranty claim, the TSS case, and retained with the repair order.**



8. Follow steps 1~7 to perform the inspection procedure on the front passenger door (Fig. 8).



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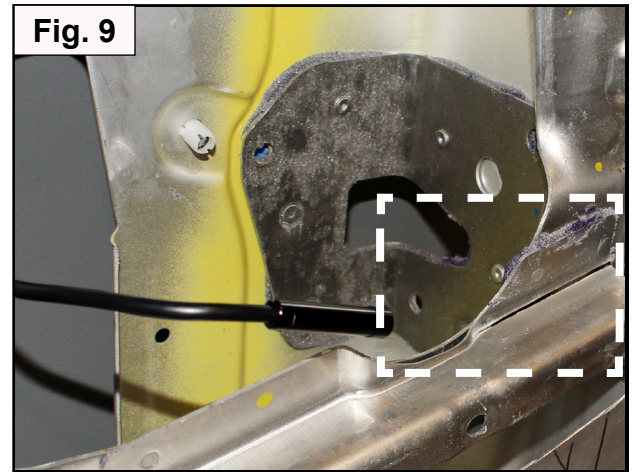
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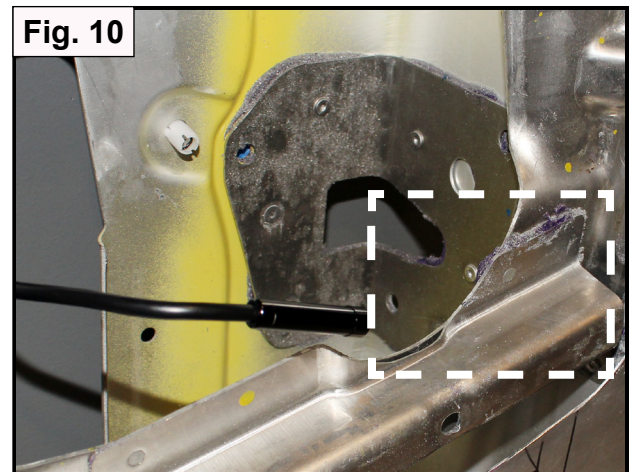
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9. If signs of the concern are evident on either front door upper intrusion bar, contact Technical Support to open a TSS case (Fig. 9).



10. If the upper intrusion bar on either front door shows no evidence of the concern (Fig.10), proceed to step 11.



11. Once both doors have been inspected for the concern, reinstall all removed components by reversing the order of removal.

12. Upon finishing vehicle reassembly, all interior trim panels should be wiped cleaned with the appropriate cleaning solution.

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! NOTICE!

Clean the shock tower area, thoroughly, to promote proper campaign completion label adhesion.

13. Fill out and adhere the recall campaign completion label (Fig. 11) to either shock tower, as (Fig. 12). This will serve as a clear indication that the recall has been performed and is **REQUIRED** to ensure compliance with the Front Doors Upper Intrusion Bar Safety Recall Campaign.

! NOTICE!

Do **NOT** place the campaign completion label on top of an existing label. Look for clear space on the shock tower.

14. Follow instructions from TSS representative on how to properly destroy the original door, prior to disposal.

Fig. 11

KARMA AUTOMOTIVE, LLC

Campaign No.: _____

Description: _____

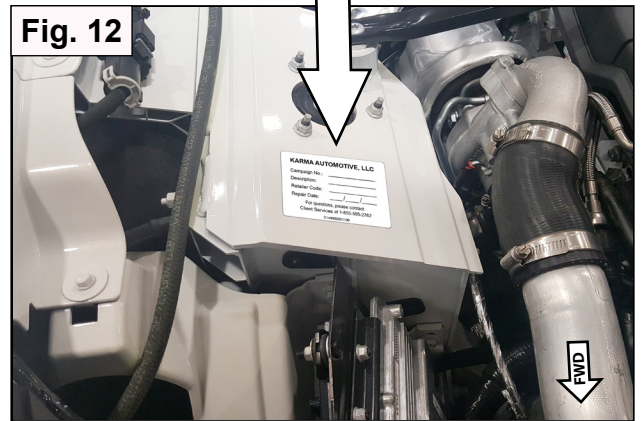
Retailer Code: _____

Repair Date: ____/____/____

For questions, please contact
Client Services at 1-855-565-2762

C149950001100

Fig. 12





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PARTS REQUIRED (If Required):

PART NUMBER	DESCRIPTION	QTY
C161160001100	Door Assembly - LH Front Door in Primer	1
C161160001200	Door Assembly - RH Front Door in Primer	

SHOP SUPPLIES:

DESCRIPTION
N/A

SPECIAL TOOLS:

DESCRIPTION
N/A

CAUSAL PART:

PART NUMBER	DESCRIPTION
C131160001101	Front Door-in-White LH

LABOR CODES:

CODE	DESCRIPTION	TIME	DEFECT CODE
RC-00-00-09	*Front Doors Inspection (RH/LH)	1.0	70-50-01-17
RC-00-00-10	RH FT Door R&R	6.0	
RC-00-00-11	LH FT Door R&R	6.0	

SUBLET:

CODE	DESCRIPTION	AMOUNT
N/A		

*Op Code time of one hour covers inspection for both front doors.

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