



# Technical Service Bulletin

SUBJECT:		No: <b>TSB-19-51-002</b>	
<b>UPDATES TO UNDER COVER REMOVAL &amp; INSTALLATION - SERVICE MANUAL REVISION</b>		DATE: <b>June 2019</b>	
		MODEL: <b>2012-13 i-MiEV</b>	
<b>CIRCULATE TO:</b>	<input type="checkbox"/> GENERAL MANAGER	<input checked="" type="checkbox"/> PARTS MANAGER	<input checked="" type="checkbox"/> TECHNICIAN
<input checked="" type="checkbox"/> SERVICE ADVISOR	<input checked="" type="checkbox"/> SERVICE MANAGER	<input type="checkbox"/> WARRANTY PROCESSOR	<input type="checkbox"/> SALES MANAGER

## PURPOSE

This TSB updates the Exterior section of the affected Service Manuals to add materials and detailed steps to Removal and Installation of the under cover. These additional materials and steps are added to prevent corrosion of the battery frame for vehicles produced through June 2012.

## AFFECTED VEHICLES

- 2012 - 2013 i-MiEV produced through June 2012

## AFFECTED SERVICE MANUALS

- 2012 - 2013 i-MiEV Service Manual, Group 51-Exterior



Please make the indicated changes to the 2012 and 2013 i-MiEV Service Manuals, Group 51-Exterior  
 -> Under Cover -> Removal and Installation:  
 Please remove the "<OLD>" information below (2 pages) and add the "<NEW>" information on the  
 pages that follow.

EXTERIOR  
 UNDER COVER

<OLD>

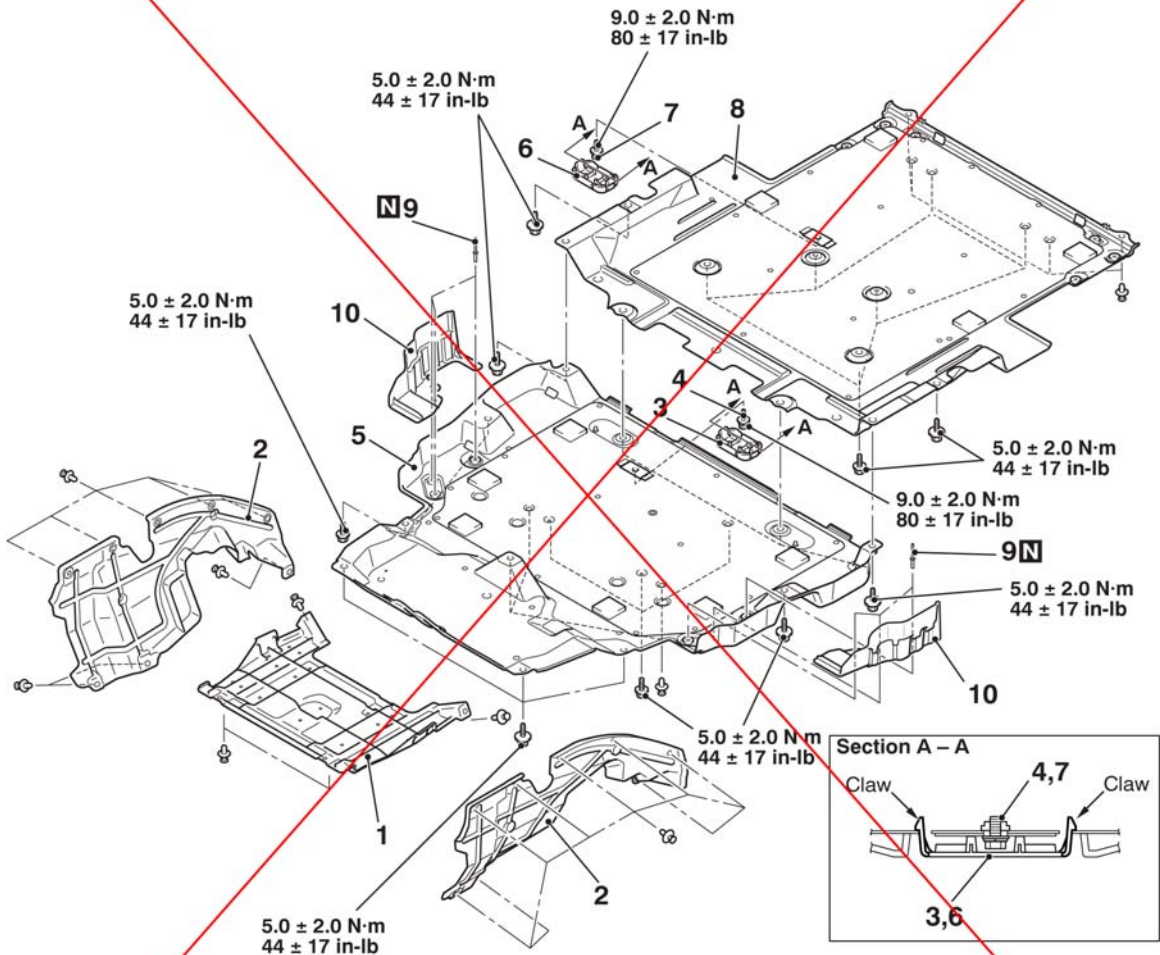
UNDER COVER

REMOVAL AND INSTALLATION

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Pre-removal and post-installation operation

- Splash Shield removal and installation (Refer to GROUP 42, Splash Shield .)



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Removal steps

1. Front sidemember cover A
  - Front tire
2. Front wheelhouse cover
3. Floor plug
4. Bolt

Removal steps (Continued)

5. Front floor cover A
6. Floor plug
7. Bolt
8. Front floor cover B
9. Rivet
10. Front sidemember cover B

<<A>> >>A<<

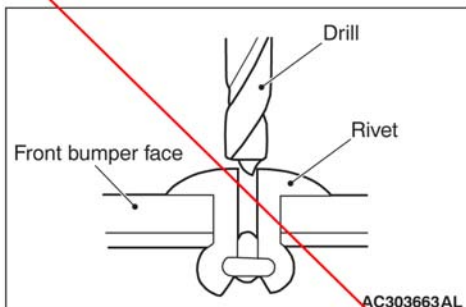
**EXTERIOR  
WINDSHIELD WIPER AND WASHER**

<OLD>

**REMOVAL SERVICE POINT**

**<<A>> RIVETS REMOVAL**

Use a drill [ $\phi$  4.0 mm (0.16in)] to make a hole in the rivet to break it, and remove the rivet.

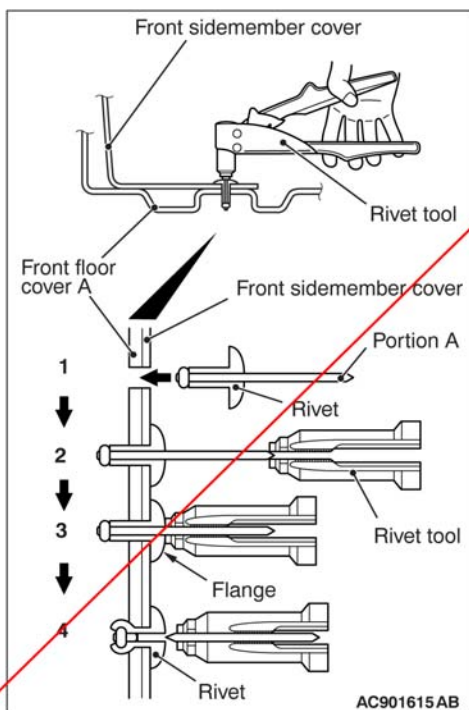


**INSTALLATION SERVICE POINT**

**>>A<< RIVETS INSTALLATION**

Use a rivet tool shown as in the illustration to connect the parts with rivets by the following procedures:

1. Insert the rivet into a corresponding location.
2. Set the rivet tool at a portion A of rivet.
3. While pushing the flange surface of the rivet onto parts to be fixed with the rivet tool, press the handle of the tool.
4. Thin part of portion A of the rivet will be cut off and the parts is fixed in position.



Please add the "<NEW>" information below to the 2012 and 2013 i-MiEV Service Manuals, Group 51-Exterior -> Under Cover.

**EXTERIOR  
UNDER COVER**

<NEW>

**UNDER COVER**

**SERVICE SPECIFICATION**

Items	Standard value
Bus bar resistance $\Omega$	2 $\Omega$ or less

**SEALANT OR ADHESIVE**

Item	Specified sealant or adhesive
Washer	ThreeBond 1741 (0110301) or equivalent
Main drive lithium-ion battery frame	DINITROL 4941250 or equivalent

**LUBRICANT**

Item	Specified lubricant	Quantity
Degrease agent	Parts cleaner (MZ100387 or equivalent)	As required

Please add the "<NEW>" information below (9 pages) to the 2012 and 2013 i-MiEV Service Manuals, Group 51-Exterior -> Under Cover -> Removal and Installation.

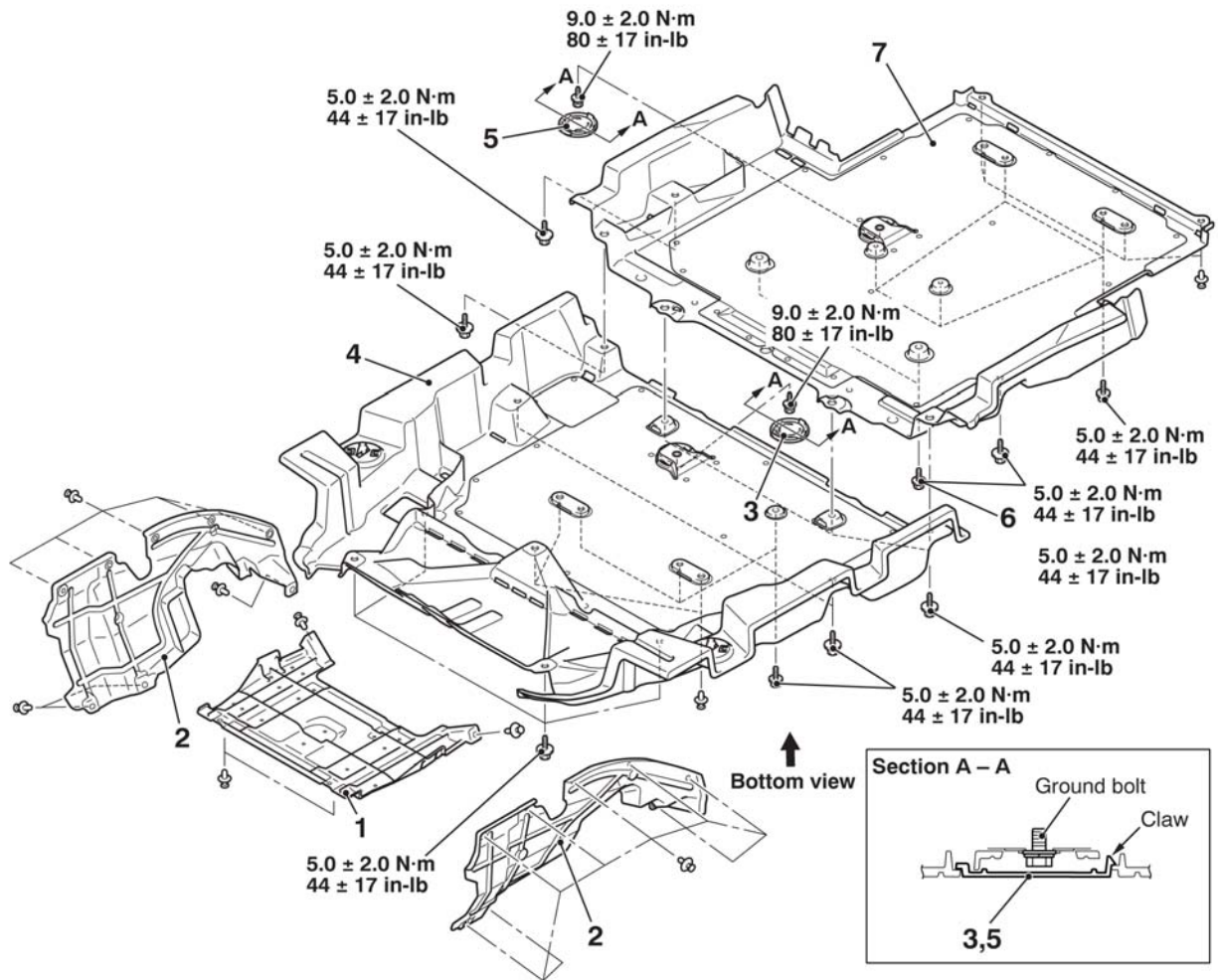
**EXTERIOR  
UNDER COVER**

<NEW>

**REMOVAL AND INSTALLATION <NO ANTI-CORROSION>**

**Pre-removal and post-installation operation**

- Front wheelhouse cover extension removal and installation (Refer to GROUP 42, Splash Shield ).

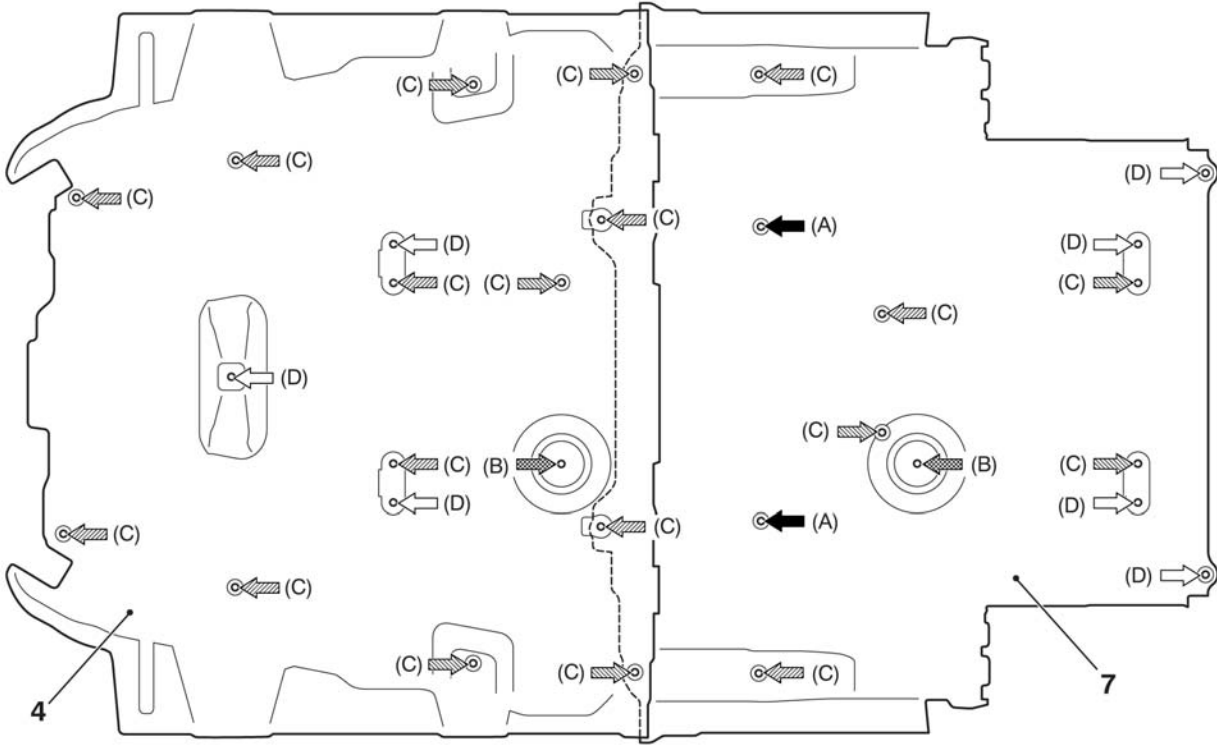


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**EXTERIOR  
 UNDER COVER**

<NEW>

Bottom view (The bolt and clip which are used.)



← (A) : Isolation bolt (A)   ← (B) : Ground bolt (B)   ← (C) : Standard bolt (C)   ← (D) : Clip (D)

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**Removal steps**

1. Front side member cover A
  - Front tire
2. Front wheelhouse cover
3. Floor plug
4. Front floor cover A

**Removal steps (Continued)**

5. Floor plug
  6. Isolation bolt
  7. Front floor cover B
    - Pre-installation
- >>A<<

<NEW>

EXTERIOR  
UNDER COVER

REASSEMBLY SERVICE POINT

>>A<< PRE-INSTALLATION

1. Use Parts Cleaner MZ100387 or equivalent to degrease the portion where the anti-corrosion agent should be applied on the main drive lithium-ion battery frame [approx. 15 to 30 mm (0.6 in to 1.2 in) range around the floor cover seating surface].

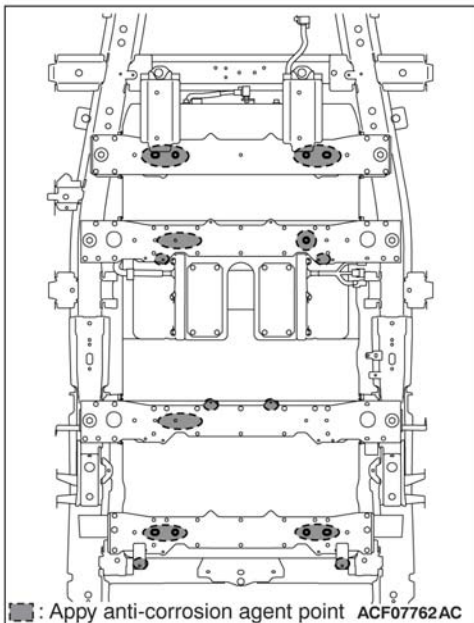
**⚠ CAUTION**

- Be careful not to apply the anti-corrosion agent to the high-voltage cables or plastic parts.
  - If yes, wipe off the anti-corrosion agent immediately or replace relevant parts.
2. Apply the specified anti-corrosion agent to the specified range on the main drive lithium-ion battery frame [approx. 15 to 30 (0.6 in to 1.2 in) mm range around the floor cover seating surface].

**Anti-corrosion agent: DINITROL 4941250 or equivalent**

**NOTE:**

- Apply the agent with two or three strokes while ensuring that no agent can drip.



**EXTERIOR  
 UNDER COVER**

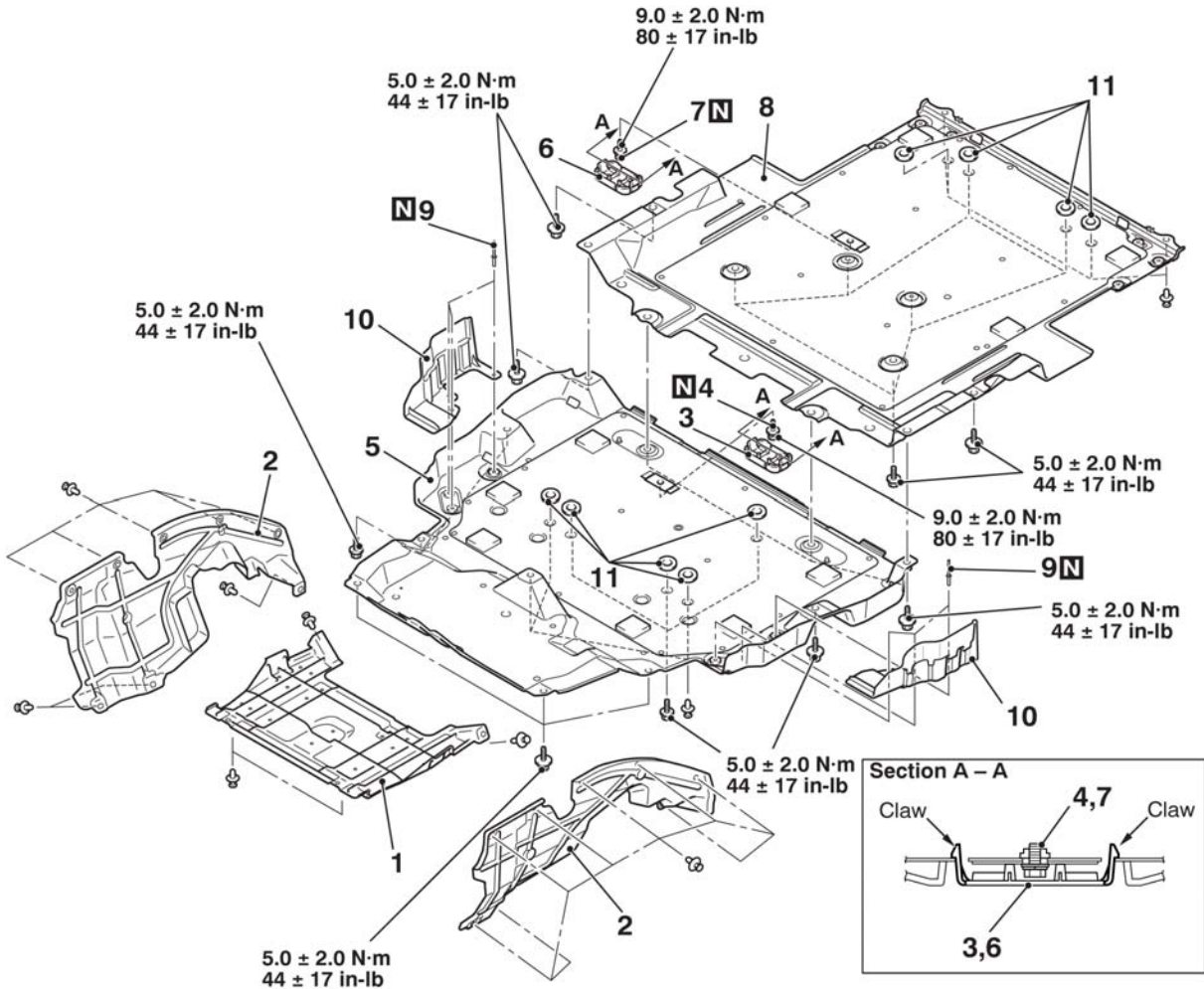
<NEW>

**REMOVAL AND INSTALLATION <ANTI CORROSION>**

**Pre-removal and post-installation operation**

- Front wheelhouse cover extension removal and installation (Refer to GROUP 42, Splash Shield ).

**When the ground bolt is NOT broken**



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**Removal steps**

1. Front side member cover A
  - Front tire
2. Front wheelhouse cover
3. Floor plug
4. Ground bolt
5. Front floor cover A

**Removal steps (Continued)**

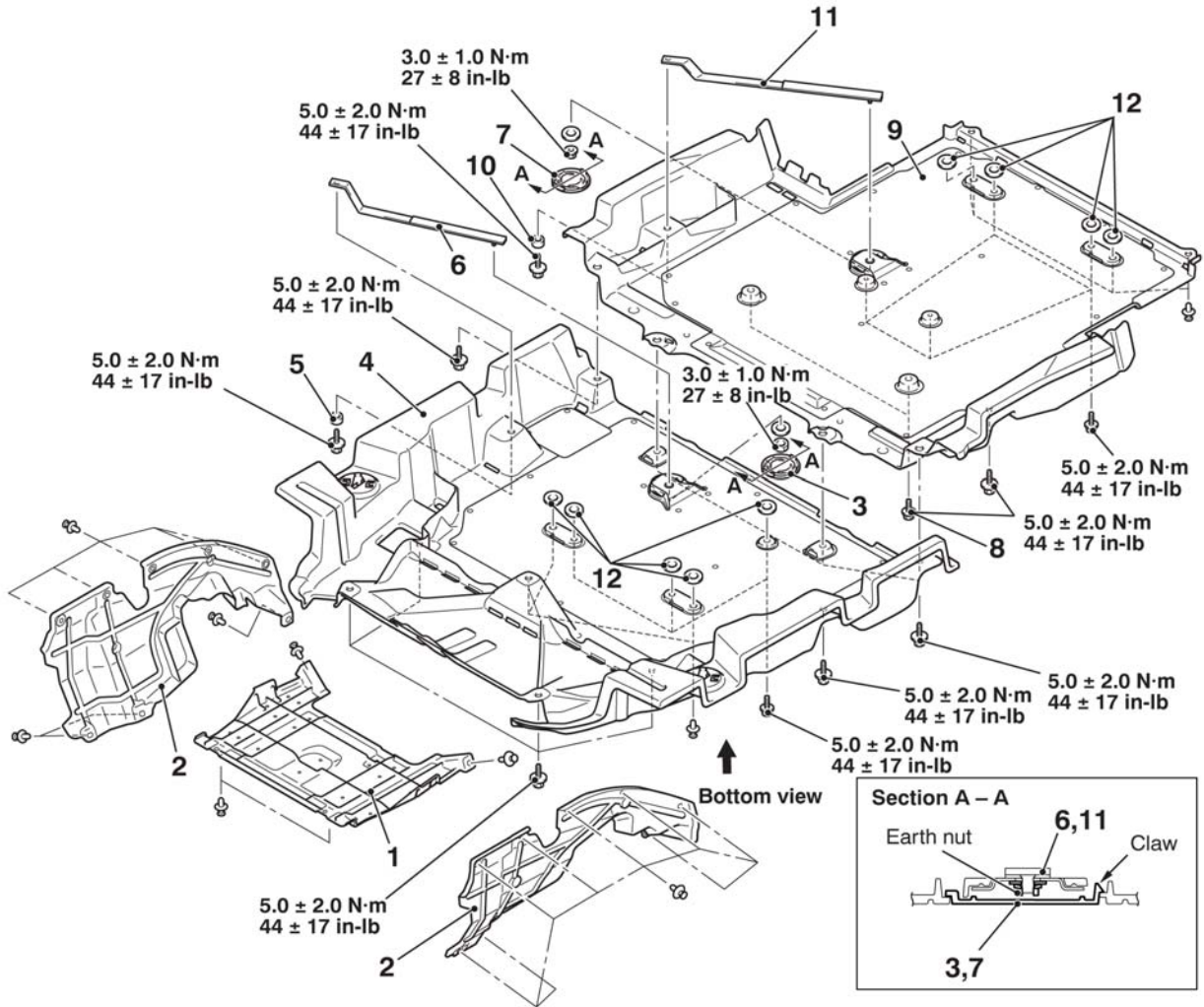
6. Floor plug
  7. Ground bolt
  8. Front floor cover B
  9. Rivet
  10. Front side member cover B
  11. Washer
- <<A>> >>B<<  
 >>A<<



EXTERIOR  
UNDER COVER

<NEW>

When the ground bolt is broken

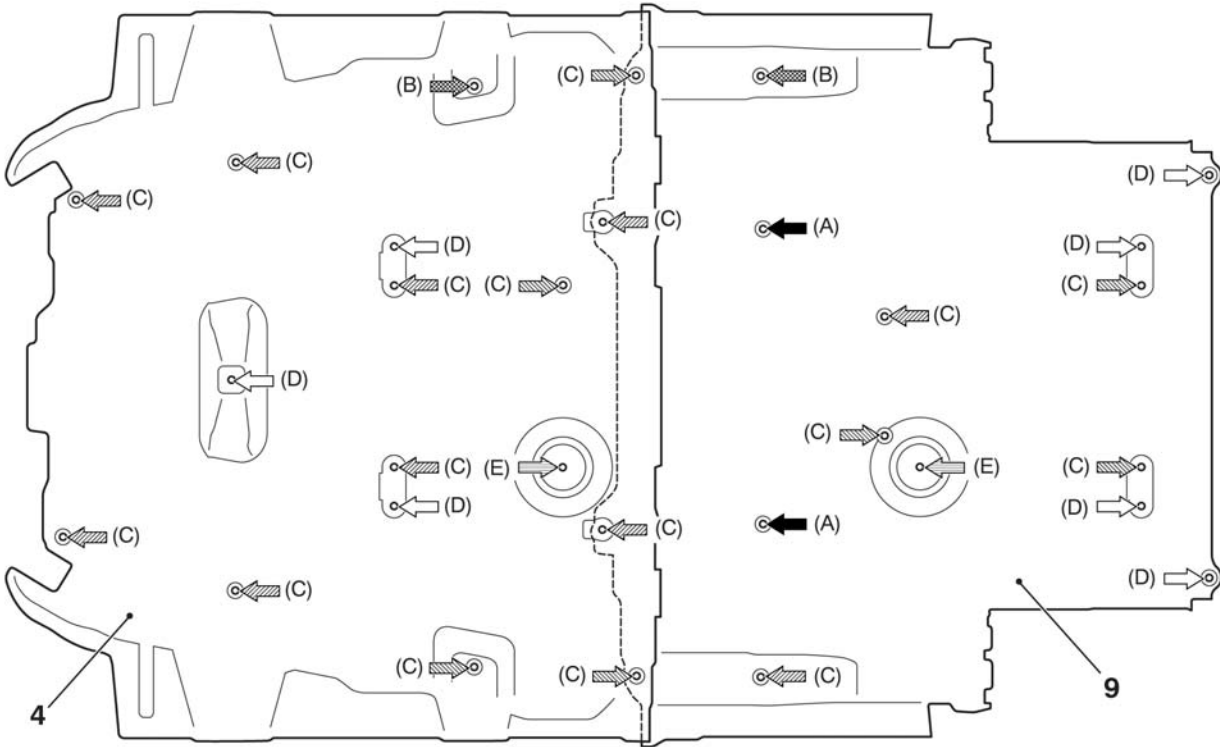


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**EXTERIOR  
 UNDER COVER**

<NEW>

Bottom view (The bolt and clip which are used.)



← : Isolation bolt (A)   ← : Ground bolt (B)   ← : Standard bolt (C)   ← : Clip (D)   ← : Ground nut (E)

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**Removal steps**

- >>D<<
- Post-installation inspection
  - 1. Front side member cover A
  - Front tire
  - 2. Front wheelhouse cover
  - 3. Floor plug
  - 4. Front floor cover A
  - 5. Collar

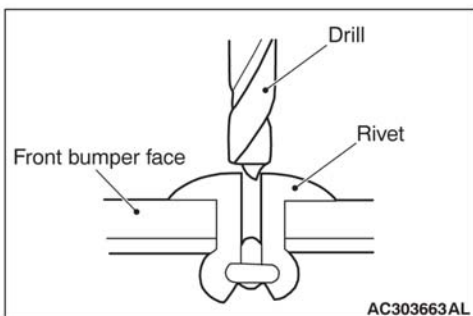
**Removal steps (Continued)**

- >>C<<
- 6. Bus bar
  - 7. Floor plug
  - 8. Isolation bolt
  - 9. Front floor cover B
  - 10. Collar
- >>C<<
- 11. Bus bar
- >>A<<
- 12. Washer

**DISASSEMBLY SERVICE POINT**

**<<A>> RIVETS REMOVAL**

Use a drill [ $\phi$  4.0 mm (0.16in)] to make a hole in the rivet to break it, and remove the rivet.



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<NEW>

EXTERIOR  
UNDER COVER

REASSEMBLY SERVICE POINT

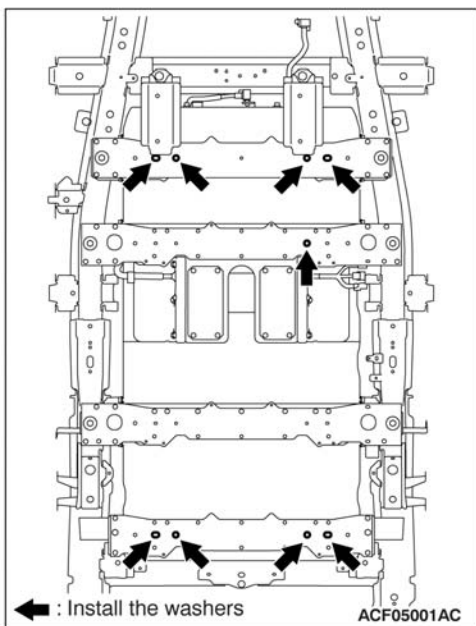
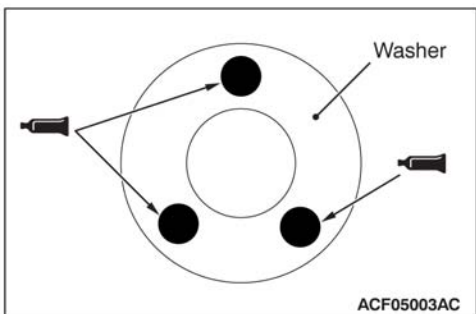
>>A<< WASHER INSTALLATION

1. Use Parts Cleaner MZ100387 or equivalent to degrease the washer seating surface.
2. Apply the specified adhesive to the washer as shown.

**Adhesive: ThreeBond 1741 (0110301) or equivalent**

**⚠ CAUTION**

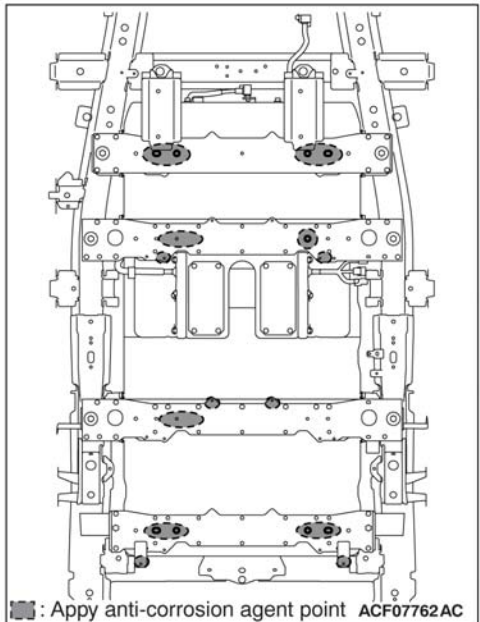
Position the washer so that the hole on the main drive lithium-ion battery frame is not hidden.



3. Attach the washer to the main drive lithium-ion battery frame as shown and hold it for at least one minute.

<NEW>

## EXTERIOR UNDER COVER



4. Use Parts Cleaner MZ100387 or equivalent to degrease the portion where the anti-corrosion agent should be applied on the main drive lithium-ion battery frame [approx. 15 to 30 mm (0.6 in to 1.2 in) range around the floor cover seating surface].

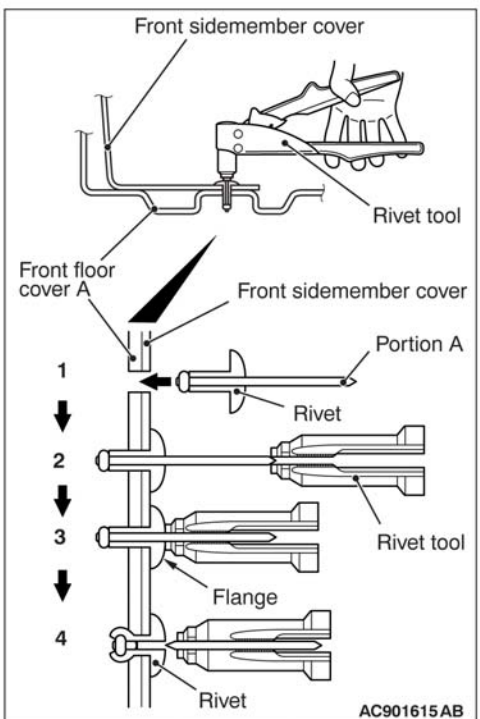
### ⚠ CAUTION

- Be careful not to apply the anti-corrosion agent to the high-voltage cables or plastic parts.
  - If yes, wipe off the anti-corrosion agent immediately or replace relevant parts.
5. Apply the specified anti-corrosion agent to the specified range on the main drive lithium-ion battery frame [approx. 15 to 30 (0.6 in to 1.2 in) mm range around the floor cover seating surface].

**Anti-corrosion agent: DINITROL 4941250 or equivalent**

### NOTE:

- Apply the agent with two or three strokes while ensuring that no agent can drip.



### >>B<< RIVETS INSTALLATION

Use a rivet tool shown as in the illustration to connect the parts with rivets by the following procedures:

1. Insert the rivet into a corresponding location.
2. Set the rivet tool at a portion A of rivet.
3. While pushing the flange surface of the rivet onto parts to be fixed with the rivet tool, press the handle of the tool.
4. Thin part of portion A of the rivet will be cut off and the parts is fixed in position.

**EXTERIOR  
UNDER COVER**

**<NEW>**

**>>C<< BUS BAR INSTALLATION**

**⚠ CAUTION**

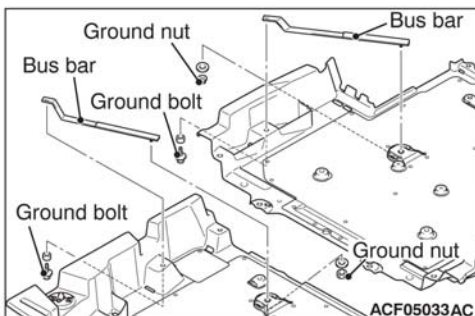
- **Remember to install the washer.**

1. Tighten the ground nut by hand to allow the bus bar to move.
2. Install the floor cover to the vehicle body.
3. Assemble the collar with the ground bolt on the bus bar, and then tighten the ground bolt by hand.
4. Tighten the ground nut on the bus bar to the specified torque.

**Tightening torque:  $3.0 \pm 1.0$  N·m ( $27 \pm 8$  in·lb)**

5. Tighten the ground bolt on the bus bar to the specified torque.

**Tightening torque:  $5.0 \pm 2.0$  N·m ( $44 \pm 17$  in·lb)**



**>>D<< POST-INSTALLATION INSPECTION**

1. Measure the resistance across the bus bar ground nuts as shown.

**Standard value:  $2 \Omega$  or less**

2. If it exceeds the standard value, remove the floor cover and install the relevant bus bar again.

