

LTB00827NAS10



# TECHNICAL BULLETIN

07 NOV 2019

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NOTE: The information in Technical Bulletins is intended for use by trained, professional Technicians with the knowledge, tools, and equipment required to do the job properly and safely. It informs these Technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by 'do-it-yourselfers'. If you are not a Retailer, do not assume that a condition described affects your vehicle. Contact an authorized Land Rover service facility to determine whether this bulletin applies to a specific vehicle.

INFORMATION

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**This reissue replaces all previous versions. Please destroy all previous versions.**

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SECTION:

501-29

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SUBJECT/CONCERN:

Ticking Noise From B-pillar Area

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AFFECTED VEHICLE RANGE:

MODEL:	MODEL YEAR:	VIN:	ASSEMBLY PLANT:
Discovery Sport (LC)	2015-2018	500429-737229	Halewood

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MARKETS:

NORTH AMERICA

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**CONDITION SUMMARY:****SITUATION:**

A 'ticking' noise can be heard coming from the B-pillar area.

**CAUSE:**

B-pillar panels - Incorrect clearances.

**ACTION:**

Follow the instructions below.

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**PARTS:****NOTE:**

An allowance of \$56.26 USD or local equivalent is allocated for locally sourced dry film lubricant, paint, and materials; claim using ZZZ001.

PART NUMBER	DESCRIPTION	QUANTITY
LR066989	Clips - Panoramic roof	7
LR078366	Clips - Rear headliner	1
LR006101	Clips - Overhead console	2
LR013135	Clips - Lantern	6
LR036129	Clips - Metal	4
LR031782	Clips - C-pillar metal	10
LR043932	Break stem fastener - 6.5 X 23.7	6
KYG500410	Bolts - Seatbelt reel	2

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**WARRANTY:****NOTE:**

An allowance of \$56.26 USD or local equivalent is allocated for locally sourced dry film lubricant, paint, and materials; claim using ZZZ001.

**NOTES:**

- Repair procedures are under constant review, and therefore times are subject to change; those quoted here must be taken as guidance only. Use TOPIx to obtain the latest repair time.
- The JLR claims submission system requires the use of causal part numbers. Labor only claims must show the causal part number with a quantity of zero.

DESCRIPTION	SRO	TIME (HOURS)	CONDITION CODE	CAUSAL PART
Repair for B-pillar panel rework - Left	76.11.61	0.1	12	LR061697
Repair for B-pillar panel rework - Right	76.11.62	0.1	12	LR061697
Repair for B-pillar panel rework - Pair	76.11.63	0.2	12	LR061697
Repair for rocker panel and vibration from the front seatbelt retractor - Left	77.40.89.38	0.3	12	LR061697
Repair for rocker panel and vibration from the front seatbelt retractor - Right	77.40.89.39	0.3	12	LR061697
Repair for rocker panel and vibration from the front seatbelt retractor - Pair	77.40.89.40	0.6	12	LR061697
Repair for Cant Rail panel 'creak' noise - Left	76.11.46	0.3	12	LR061697
Repair for Cant Rail panel 'creak' noise - Right	76.11.47	0.3	12	LR061697
Repair for Cant Rail panel 'creak' noise - Pair	76.11.48	0.4	12	LR061697
Repair for noises from door apertures - Pair	76.10.89.24	0.3	12	LR061697
Repair for noises from door apertures - Left	76.10.89.23	0.1	12	LR061697
Repair for noises from door apertures - Right	76.10.89.21	0.1	12	LR061697
Repair for A-pillar front header panel	77.28.31	0.2	12	LR061697
Repair for B-pillar spot weld - Left	76.11.64	0.1	12	LR061697
Repair for B-pillar spot weld - Right	76.11.65	0.1	12	LR061697
Repair for B-pillar spot weld - Pair	76.11.66	0.2	12	LR061697
Repair for seatbelt anchor - Pair	76.11.67	0.5	12	LR061697
Repair for seatbelt anchor - Left	76.10.89.15	0.3	12	LR061697
Repair for seatbelt anchor - Right	76.11.89.07	0.3	12	LR061697

DESCRIPTION	SRO	TIME (HOURS)	CONDITION CODE	CAUSAL PART
Repair for B-pillar upper panel 'creak' - Pair - Paint time included	76.10.89.25	5.3	12	LR061697
B-pillar - Left - Complete - Touch-up (Brush)	79.N.TA7	0.1	12	LR061697
B-pillar - Right - Complete - Touch-up (Brush)	79.N.UA7	0.1	12	LR061697
Aperture - Door - Front - Left - Complete - Touch-up (Brush)	79.N.CA7	0.1	12	LR061697
Aperture - Door - Front - Right - Complete - Touch-up (Brush)	79.N.DA7	0.1	12	LR061697
Aperture - Door - Rear - Left - Complete - Touch-up (Brush)	79.N.FA7	0.1	12	LR061697
Aperture - Door - Rear - Right - Complete - Touch-up (Brush)	79.N.GA7	0.1	12	LR061697
Complete a road test.	10.41.17	0.3	12	LR061697

**NOTE:**

Normal Warranty procedures apply.

## SERVICE INFORMATION

**CAUTION:**

It is important to follow all provided information and instructions in the order shown.

**NOTE:**

To provide clear and accurate information in the following service information / repair procedures, this technical bulletin should be viewed in color.

- To help with the identification and isolation of the squeaks and rattles, first remove from the vehicle, all items that are not supplied as manufactured. For example, CDs, keys, bags, coins, etc. Empty all compartments such as glovebox, glasses case, door pockets etc. Make sure all vehicle accessories are secure, for example, lifting jack, wrench, etc.

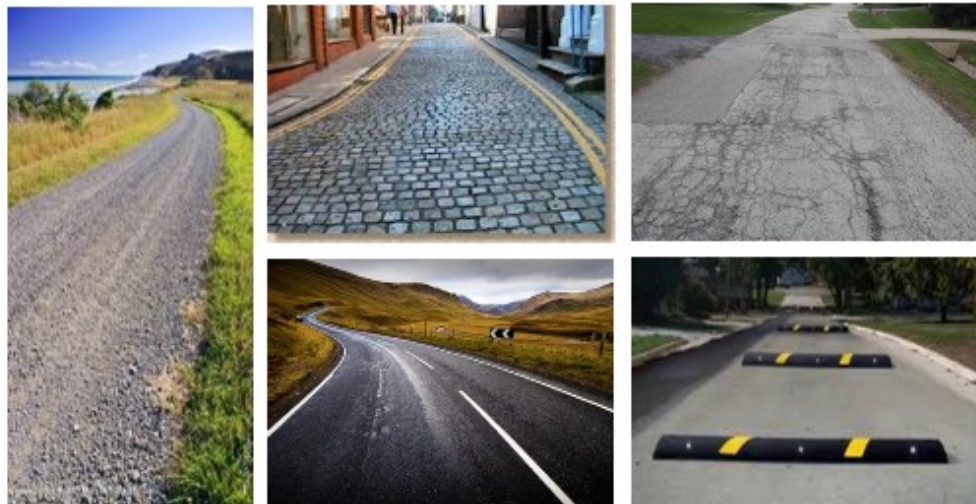
2. The noise is more evident at warmer ambient temperatures. The vehicle should be tested when the engine is warm. It may help to operate the heaters on a high heat setting for a short period of time to increase the interior temperature of the vehicle.

3. A customer may express a concern that there is a 'ticking' noise from the B-pillar area. When this is the customer's perceived symptom, sound can travel throughout the vehicle structure from its point of origin, and appear to originate elsewhere. This bulletin contains known symptoms that have been described as B-pillar ticking.

4.

#### NOTES:

- Examples of road surfaces.
- Every opportunity to trace the origin of the B-pillar noise should be taken. This should include the removal of any interior trim components necessary to allow the technician to gain access to the apparent source of the noise. Pressure should be applied to the panels to see if the noise can be affected or stopped to help locate the source of the noise.



E205587

It may prove beneficial to travel at different speeds over each road surface. For example, one pass at 20 km/h (12 mph) and another at 10 km/h (6 mph). These conditions may need to be varied until the customer symptom can be heard.

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5. There are various sounds generated within the B-pillar system, varying in intensity. Reduce the internal passenger compartment noise to assist in locating any generated sounds. This can be done by reducing the heater blowers to the lowest level, or switching them off, as well as the radio. Closing the windows will also reduce the internal passenger compartment noise. Other noises caused by weather, temperature and road surface should also be taken into consideration.
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6. **WARNING:**

Adhere to safe driving practices at all times.

Ask the customer for details of their concern, taking notes of the conditions. How long does the issue take to occur on any given journey? This should indicate the minimum time required for validation. Where possible, upon the customer's arrival to the retailer, perform a road test with the customer present in the vehicle. This may provide more suitable test conditions and will help to verify the customer's concern. Record the sound where possible and try to determine the location of the sound.

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7. Refer to 'Squeaks and Rattles' (see TOPIx Workshop Manual section 501-00: Body System - General Information - Diagnosis and Testing - Squeaks and Rattles) for other areas of concern.
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8. **WARNING:**

Adhere to safe driving practices at all times.

Hand the vehicle over to the body shop. Perform a road test with the body shop technician in the vehicle to demonstrate the customer concern.

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9. Repeat the road test if required and remove appropriate interior trim if this is necessary to assist in locating the noise.
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SERVICE INFORMATION:

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1.



E220432

For any E-coat repairs, such as 'Repair for noises from door apertures' a dry film lubricant spray should be applied after the panels have been manipulated. This prevents the E-coat from re-bonding and has proven successful particularly in hot markets. The lubricant should be applied with the supplied straw/small nozzle, between the worked panels. An example of a suitable spray is illustrated above.

#### REPAIR FOR B-PILLAR PANEL

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For vehicles up to Vehicle Identification Number (VIN) - H737229

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1.



E220341

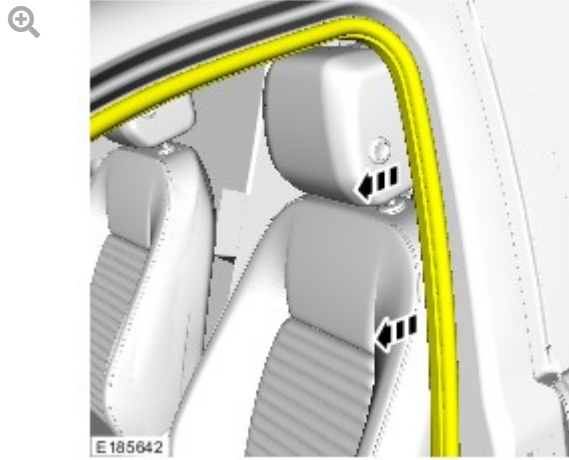
Repair for B-pillar panel.

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2.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Release and position to one side the front door aperture seal from the door aperture.

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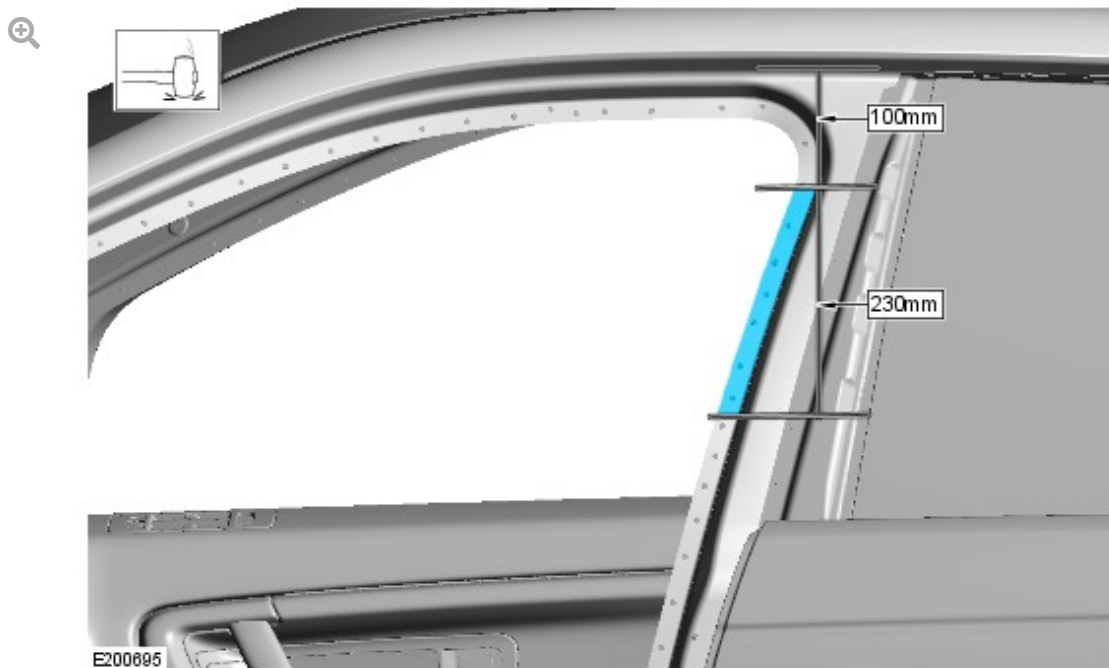
3.

**CAUTIONS:**

- Make sure the surrounding area is protected to avoid damaging the vehicle.
- Make sure to use a blunt and protected suitable tool to prevent damage to the vehicle.
- Any body panels which have been modified/alterd must be returned to their original manufacturing condition.

**NOTES:**

- Repeat this step on both sides of the vehicle if required.
- If necessary, refer to 'Body Repairs' (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



Using a suitable hammer, strike the panel inwards over the highlighted area shown. The panel should be struck with as much force as can safely be applied. Repeat along the highlighted area shown. This can eliminate noises which originate from this area.

4.

**CAUTION:**

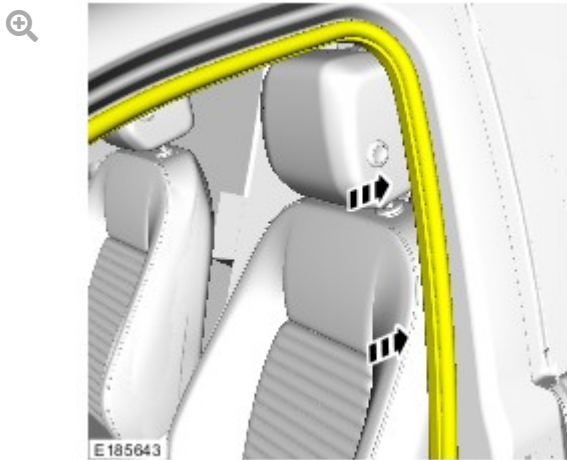
Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

5.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the front door aperture seal to the door aperture.

6. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for rocker panel and vibration from the front seatbelt retractor' service instruction.

REPAIR FOR ROCKER PANEL AND VIBRATION FROM THE FRONT SEATBELT RETRACTOR

For Vehicles up to VIN - Rocker Panel = H737229 and Seatbelt Retractor = H690838

1.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

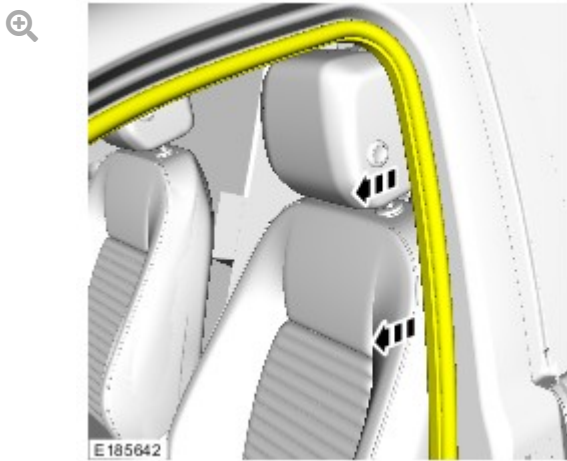
Position the front row seat to the most forward position.

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2.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Release and position to one side the front door aperture seal from the door aperture.

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3.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



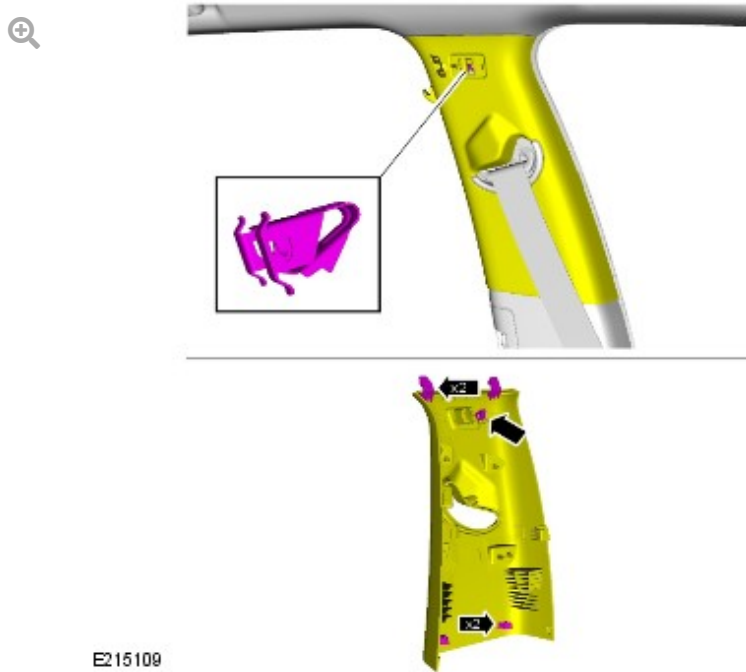
Release and position to one side the rear door aperture seal from the door aperture.

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4.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E215109

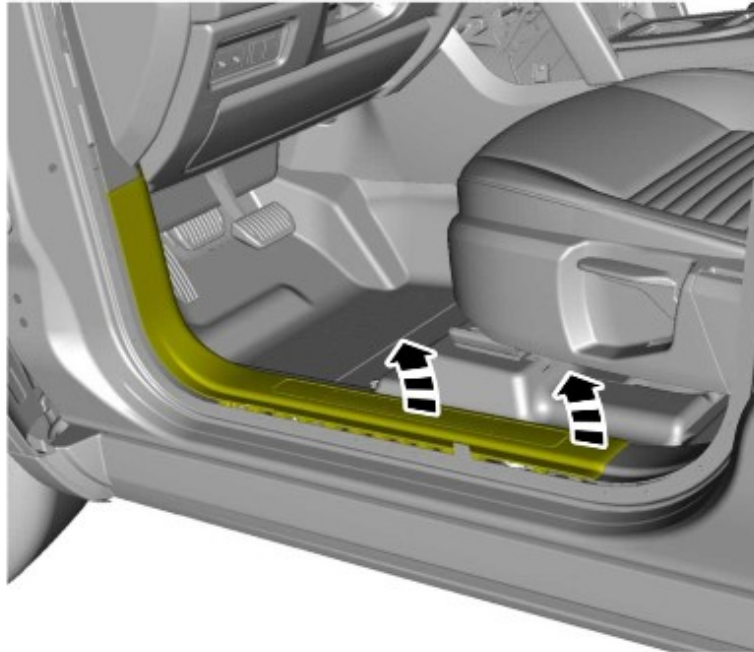
Release and position to one side the B-pillar upper trim panel.

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5.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E215021

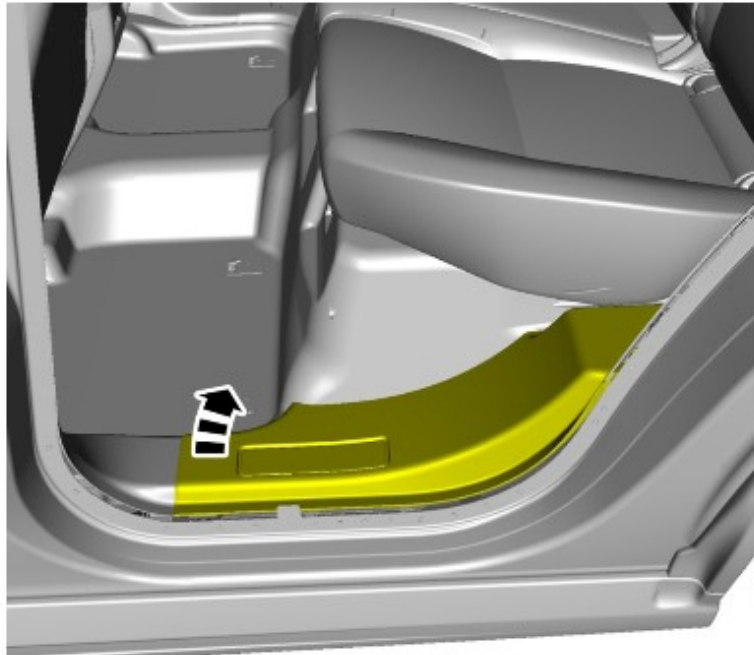
Release the front treadplate.

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6.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



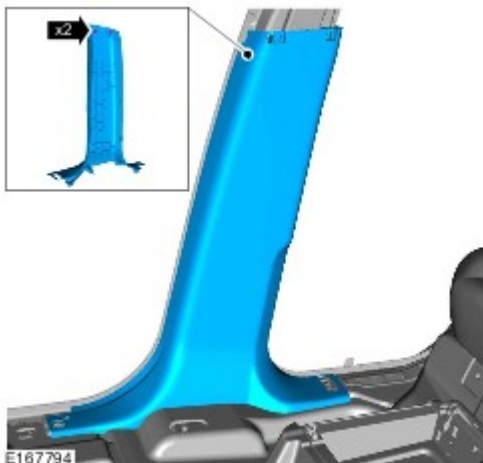
E215020

Release the rear treadplate.

7.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E167794

Remove the B-pillar lower trim panel.

8.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

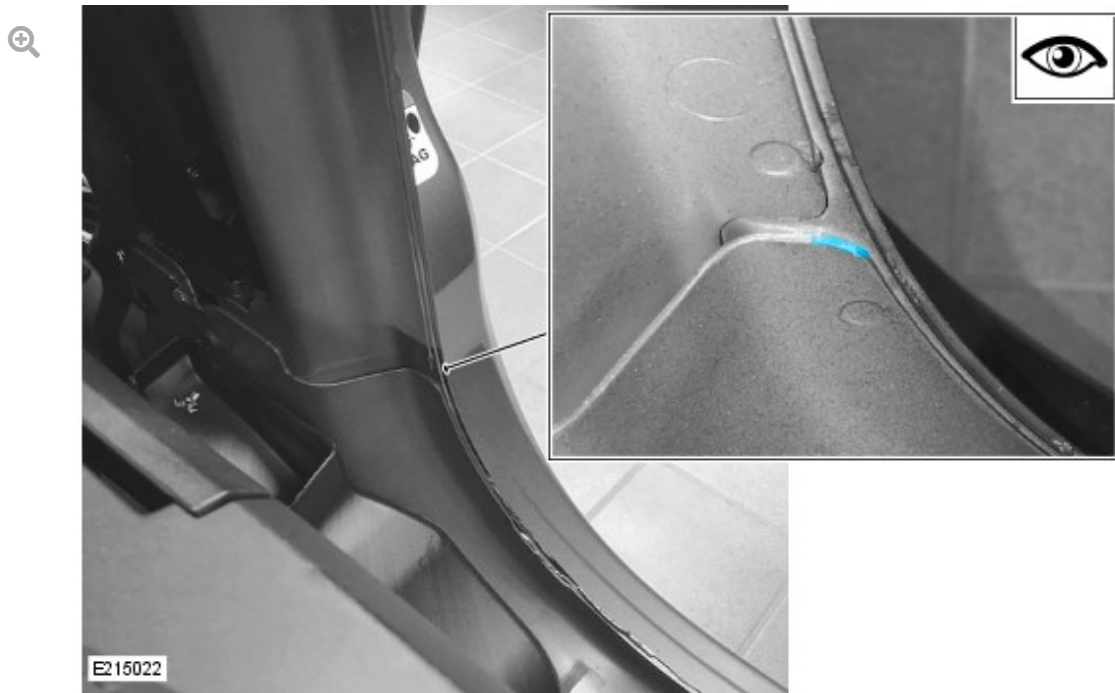
Position the front row seat to the most backward position.

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9.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Locate the area highlighted in the illustration.

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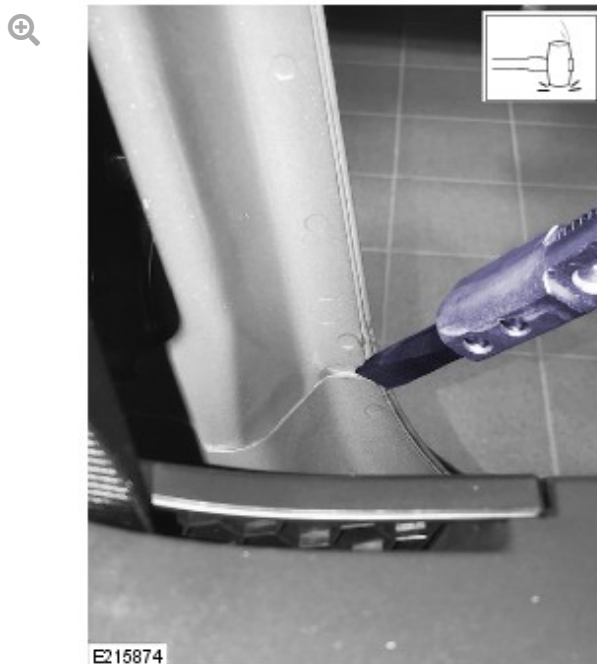
10.

**CAUTIONS:**

- **A suitable chisel with a blade width of no more than 12 mm and a maximum thickness of 5 mm must be used to complete this service instruction.**
- Any body panels which have been modified/altered must be returned to their original manufacturing condition.

**NOTES:**

- Repeat this step on both sides of the vehicle if required.
- If necessary, refer to 'Body Repairs' (see TOPlx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



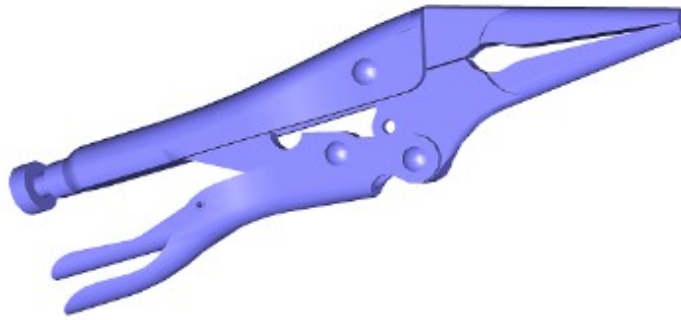
Using a suitable hammer, insert the suitable chisel between the B-pillar and rocker panel. Only 1 or 2 strikes with the suitable hammer should be required.

- ▪ This will cause the B-pillar panel and rocker panel to separate.

11.

**CAUTION:**

Using any other type of tool may cause damage to the vehicle.



E206085

Only use the type of suitable tool shown when completing step 12.

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12.

**CAUTIONS:**

- Make sure no damage is caused to the vehicle.
- Make sure the surrounding area and the suitable tool are protected to avoid damaging the vehicle.
- Any body panels which have been modified/altered must be returned to their original manufacturing condition.

**NOTES:**

- Repeat this step on both sides of the vehicle if required.
- If necessary, refer to Body Repairs (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



Move the panels around the door apertures, first inwards and then outwards as shown until no click can be heard. Complete this step to the areas highlighted. This can eliminate noises which originate from this area.

13.

**CAUTION:**

Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

14.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

Position the front row seat to the most forward position.

15. Make the Supplementary Restraint System (SRS) safe, (see TOPIx Workshop Manual section 100-00: General Information - Description and Operation - Standard Workshop Procedures).

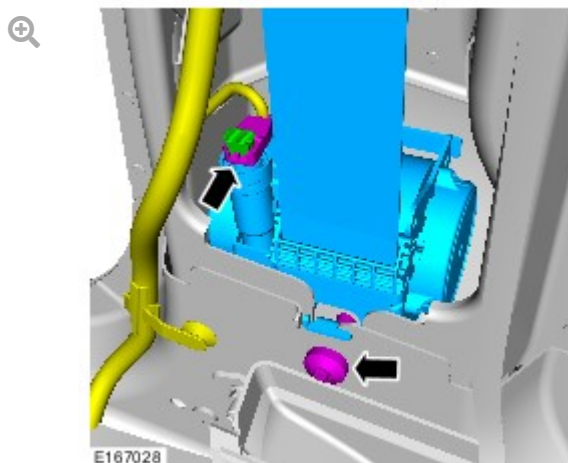
16.

**CAUTION:**

Discard the seatbelt retractor bolt.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

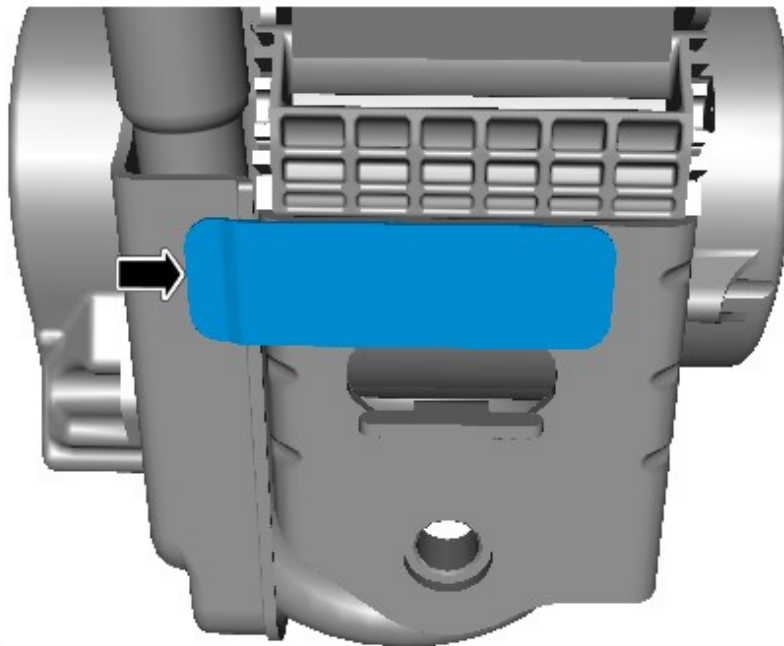


Release the seatbelt retractor.

17.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E214427

Install a 150 mm x 550 mm rectangular piece of 0.5 mm foam (from the Land Rover squeaks and rattles kit, or a similar 250g density, 30% wool 70% viscose felt), as shown in the illustration.

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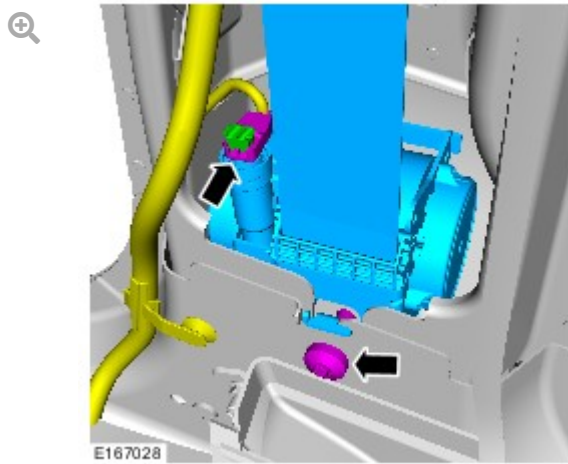
18.

**CAUTION:**

Install a new seatbelt retractor bolt.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the seatbelt retractor.

- ■ **Torque: 40 Nm**

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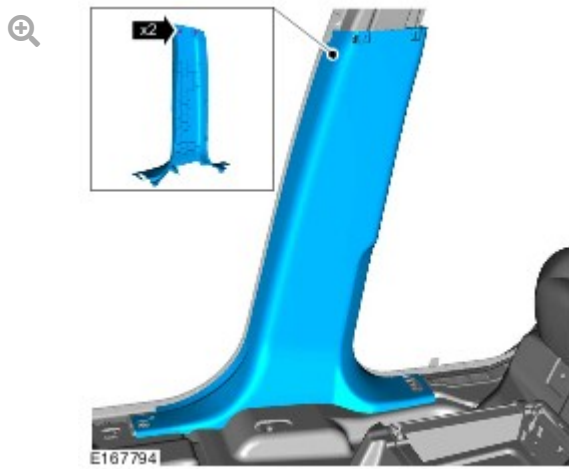
19. Reconnect the startup battery.

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20.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

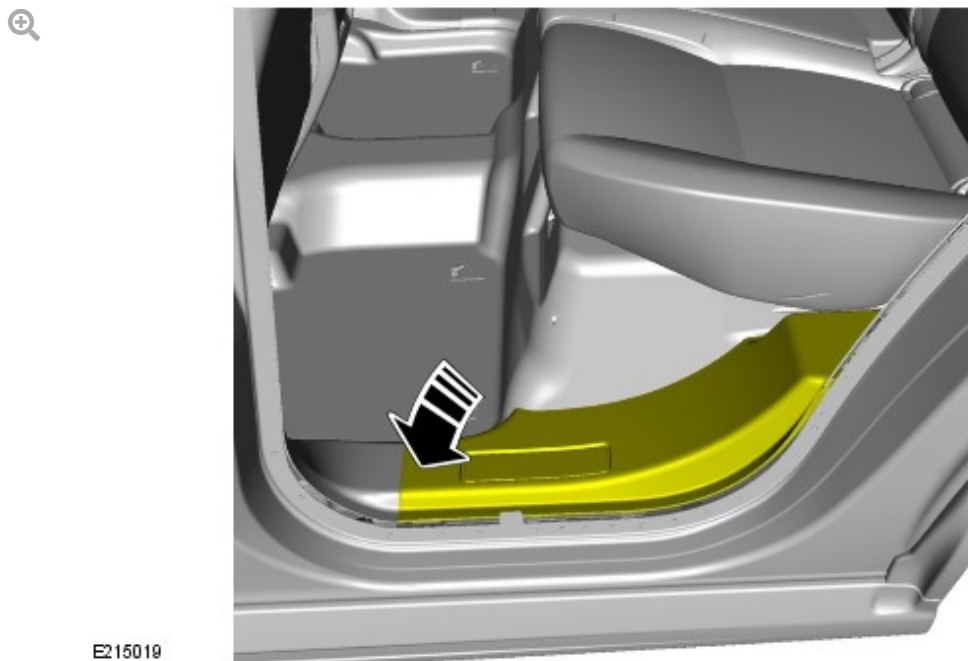


Install the B-pillar lower trim panel.

21.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

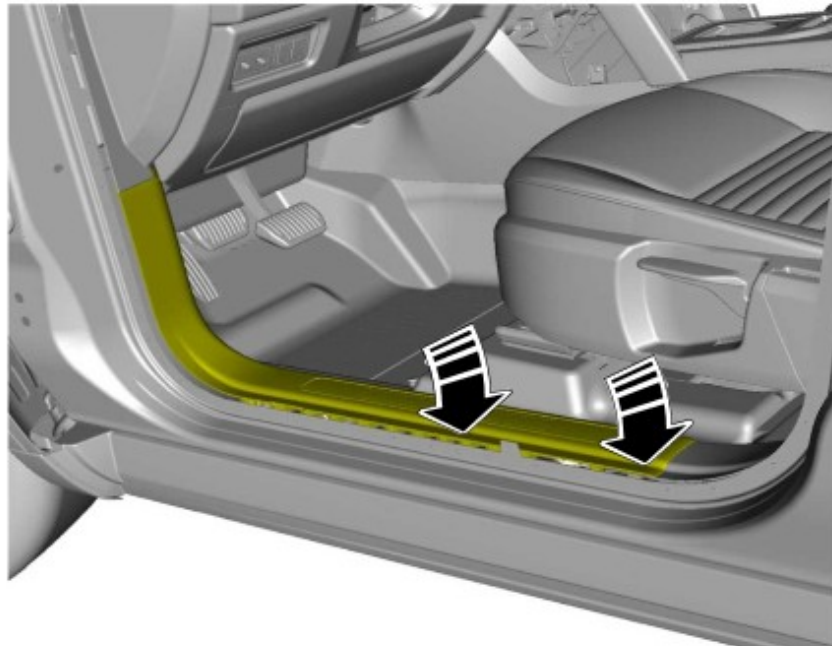


Install the rear treadplate.

22.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E213587

Install the front treadplate.

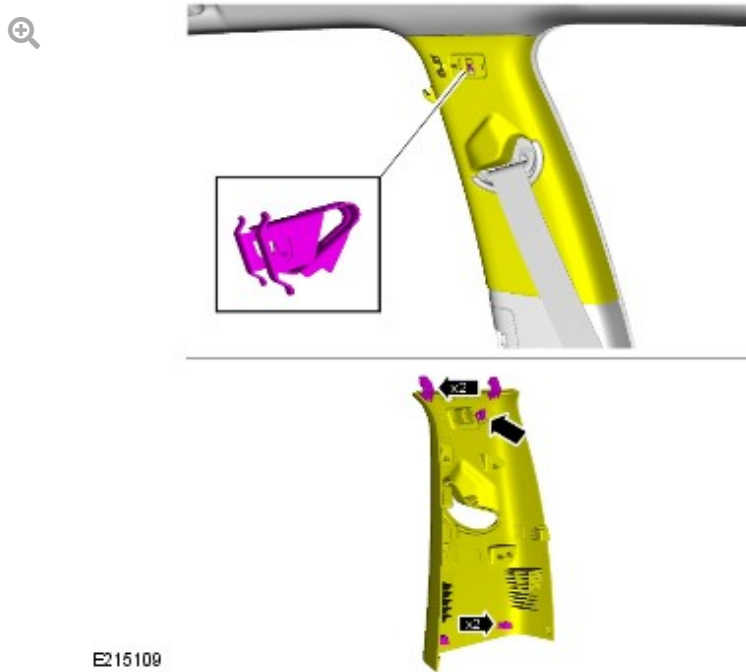
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23.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



E215109

Install the B-pillar upper trim panel.

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24.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

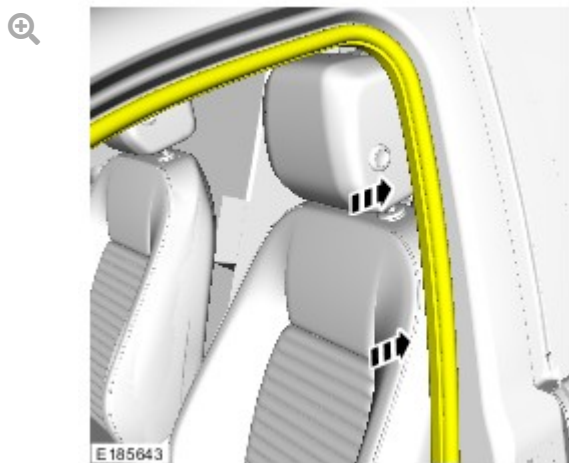


Install the rear door aperture seal to the door aperture.

25.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the front door aperture seal to the door aperture.

26.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

Return the front row seat to the original position.

---

27. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for cant rail panel 'creak' noise' service instruction.

## REPAIR FOR CANT RAIL PANEL 'CREAK' NOISE

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For Vehicles up to VIN - H737229

**CAUTIONS:**

- **A suitable chisel with a blade width of no more than 12 mm and a maximum thickness of 5 mm must be used to complete this service instruction.**
  - Using any other type of tool may cause damage to the vehicle.
- 

1.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

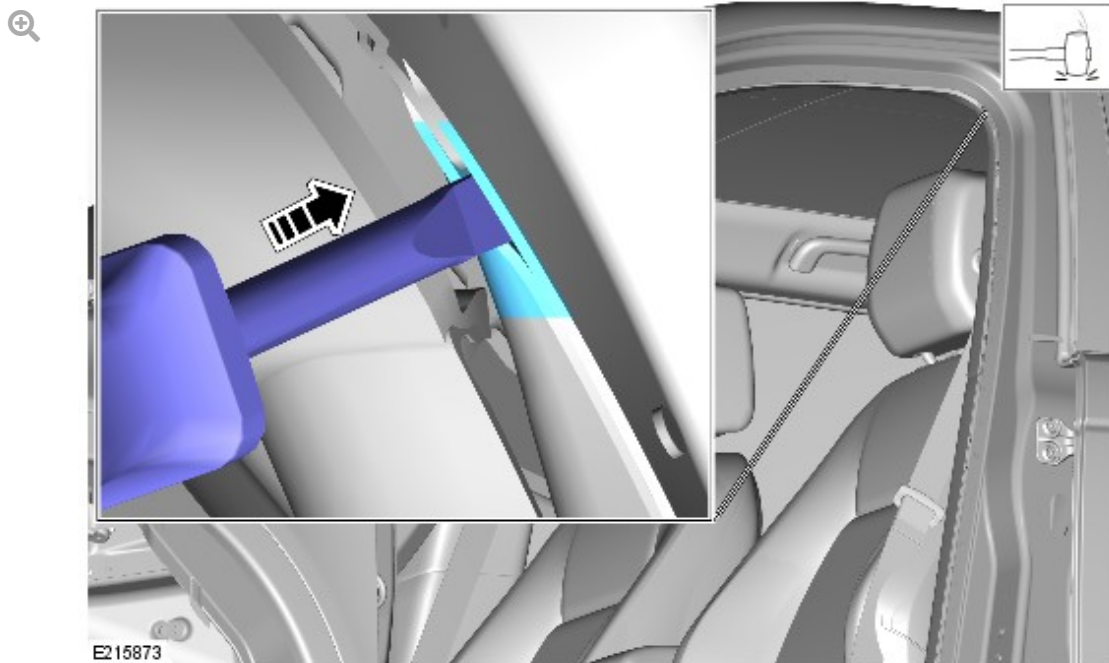
Release and position to one side the front door aperture seal from the door aperture.

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2.

**NOTE:**

If necessary, refer to Body Repairs (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



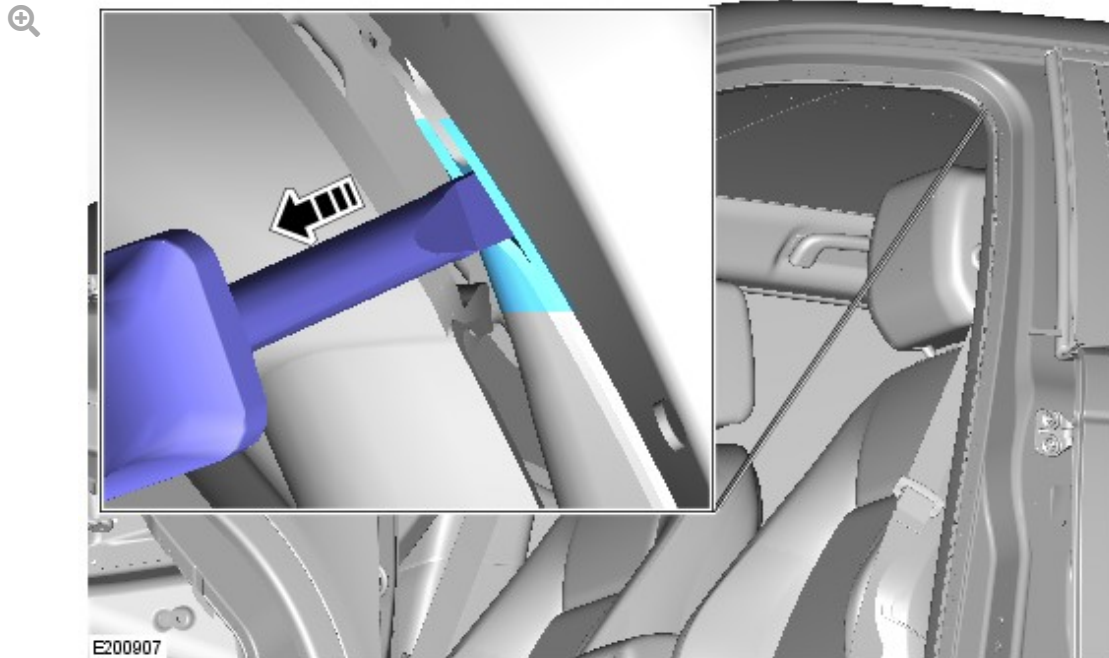
Using a suitable hammer, insert the suitable chisel between the inner B-pillar and the cant rail, to a maximum depth of 20 mm. This can eliminate noises which originate from this area.

- ■ This will cause the inner B-pillar panel and the cant rail to separate.

3.

**CAUTION:**

Any body panels which have been modified/alterd must be returned to their original manufacturing condition.



Remove the suitable chisel.

4.

**CAUTION:**

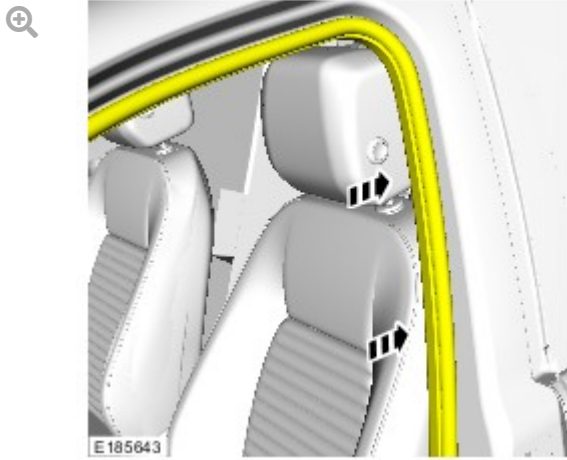
Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

5.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the front door aperture seal to the door aperture.

---

6. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for noises from door apertures' service instruction.

REPAIR FOR NOISES FROM DOOR APERTURES

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1.



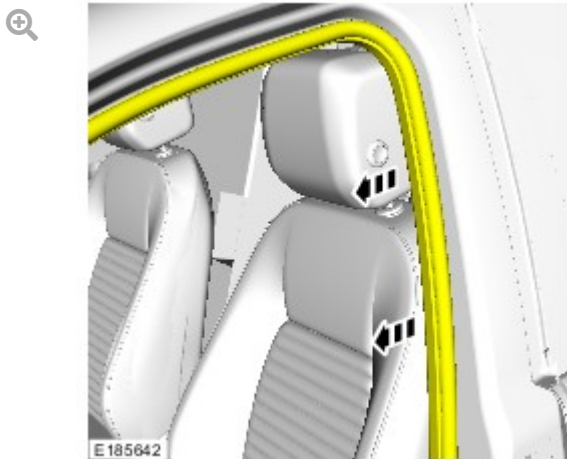
E220341

Repair for noises from door apertures.

2.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Release and position to one side the front door aperture seal from the door aperture.

3.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Release and position to one side the rear door aperture seal from the door aperture.

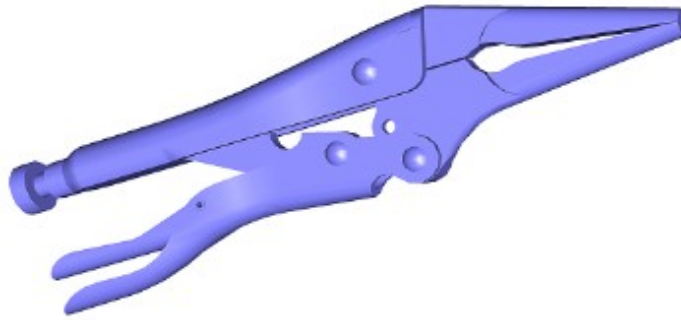
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4.

**CAUTION:**

Using any other type of tool may cause damage to the vehicle.



E206085

Only use the type of suitable tool shown when completing step 5.

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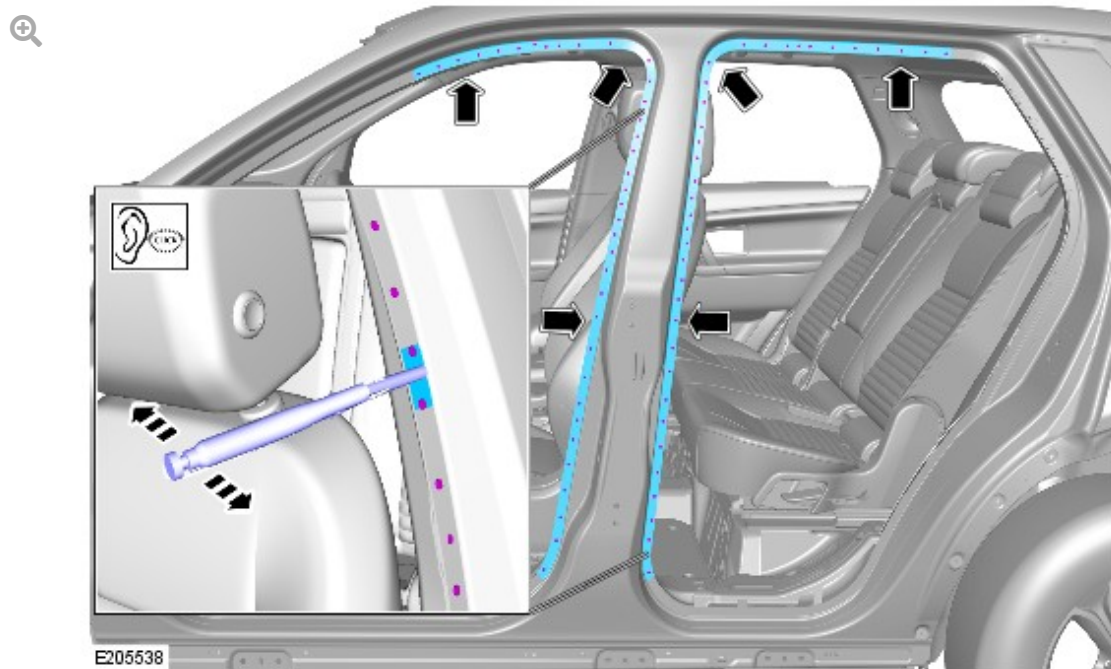
5.

**CAUTIONS:**

- Make sure no damage is caused to the vehicle.
- Make sure the surrounding area and the suitable tool are protected to avoid damaging the vehicle.
- Any body panels which have been modified/altered must be returned to their original manufacturing condition.

**NOTES:**

- Repeat this step on both sides of the vehicle if required.
- If necessary, refer to Body Repairs (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



Move the panels around the door apertures, first inwards and then outwards as shown until no click can be heard. Complete this step to the areas highlighted. This can eliminate noises which originate from this area.

6.

**CAUTION:**

Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

7.

**NOTE:**

Repeat this step on both sides of the vehicle if required.

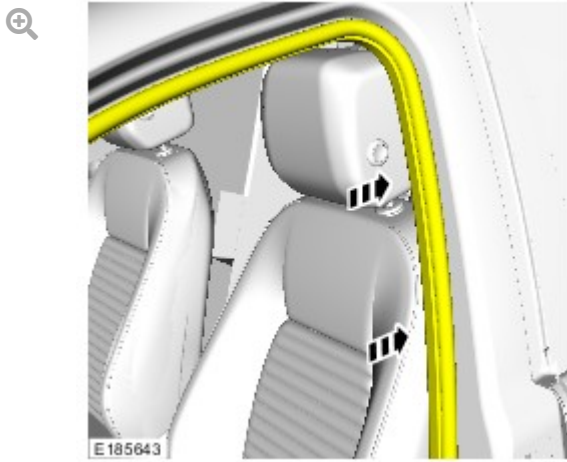


Install the rear door aperture seal to the door aperture.

8.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the front door aperture seal to the door aperture.

---

9. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for A-pillar front header panel ' service instruction.

REPAIR FOR A-PILLAR FRONT HEADER PANEL

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1.



E220341

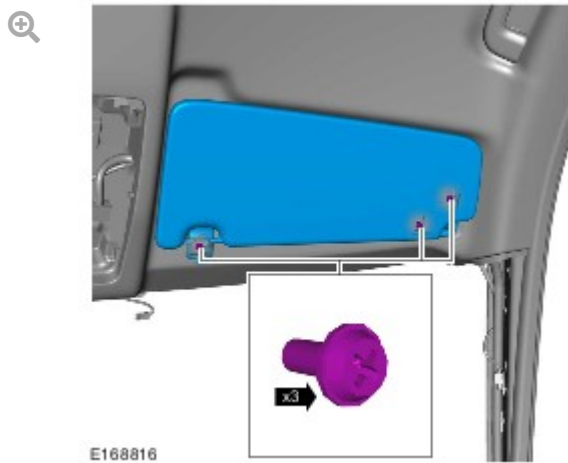
Repair for A-pillar front header panel

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2.

**NOTE:**

Right shown, left similar.



Remove the 3 bolts and remove the sun visor.

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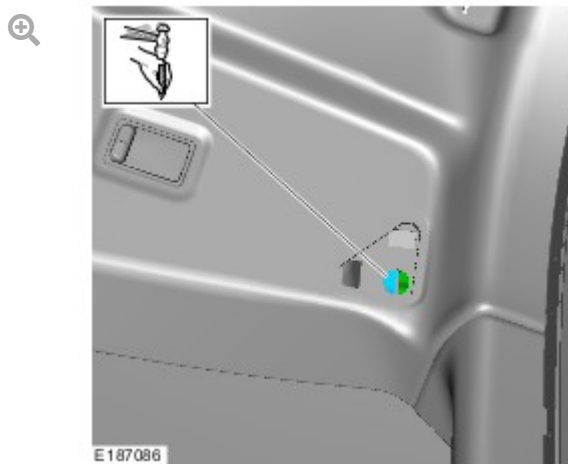
3.

**CAUTION:**

Do not use a punch which has a point as this will damage the vehicle.

**NOTE:**

Right shown, left similar.



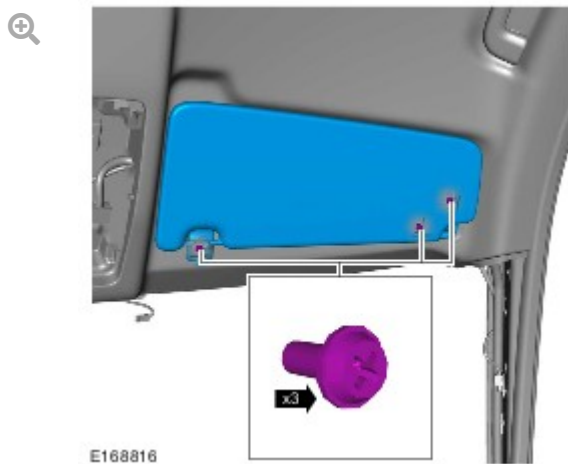
Insert a parallel pin punch with a minimum diameter of 16 mm, through the sun visor bracket aperture. Using a hammer, strike the punch in an upward motion several times. This allows the panels to be distorted away from the sun visor bracket aperture. This can eliminate noises which originate from this area.

---

4.

**NOTE:**

Right shown, left similar.



Install the sun visor and tighten the 3 bolts.

- ■ Torque: **9 Nm**

---

5. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for B-pillar Spot Weld' service instruction.

REPAIR FOR B-PILLAR SPOT WELD

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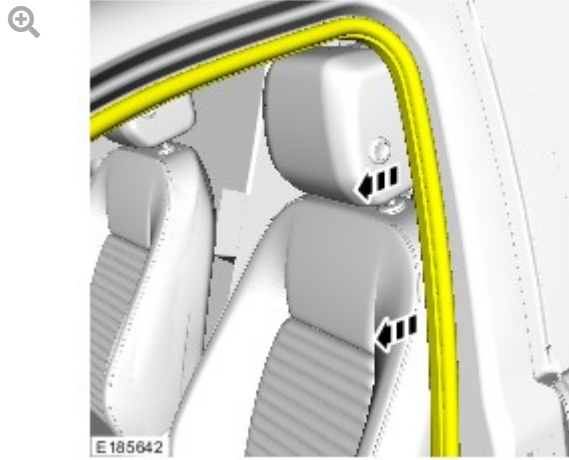
For Vehicles up to VIN - H737229

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1.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Release and position to one side the front door aperture seal from the door aperture.

---



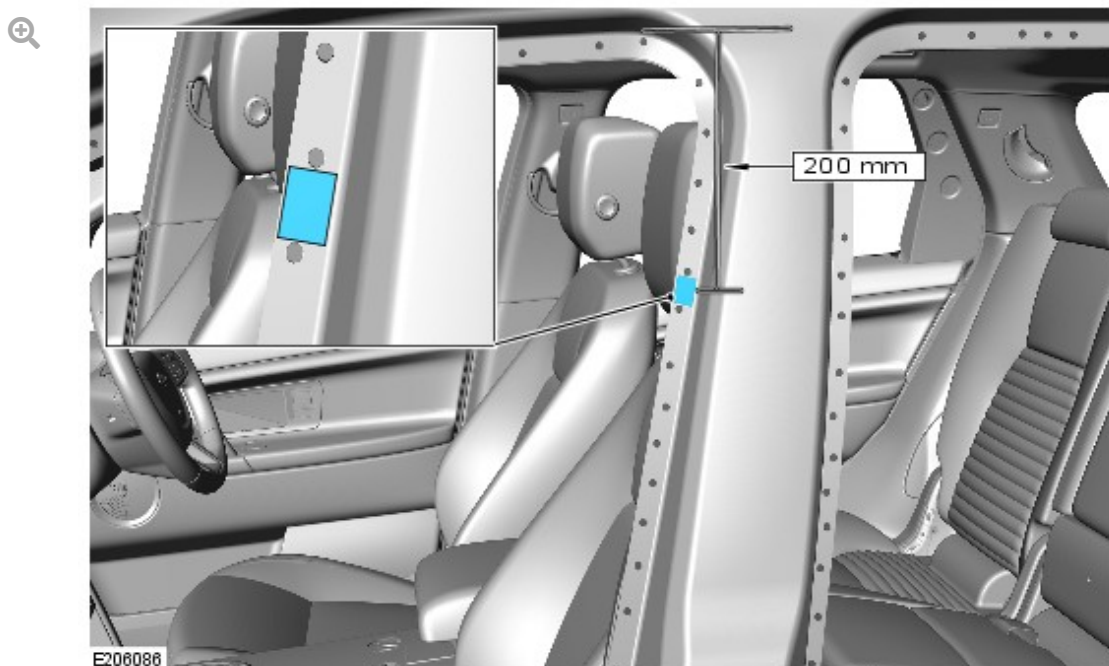
2.

**CAUTIONS:**

- Use suitable welding blankets to protect the vehicle from any damage before continuing with this service instruction.
- Any body panels which have been modified/altered must be returned to their original manufacturing condition.

**NOTES:**

- Spot welding is the only approved method for this repair.
- Paint the area that has been spot welded.
- Repeat this step on both sides of the vehicle if required.
- The measurement shown may vary slightly from vehicle to vehicle.
- If necessary, refer to Body Repairs (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.



Place a single spot weld within the highlighted area shown. This can eliminate noises which originate from this area.

3.

**CAUTION:**

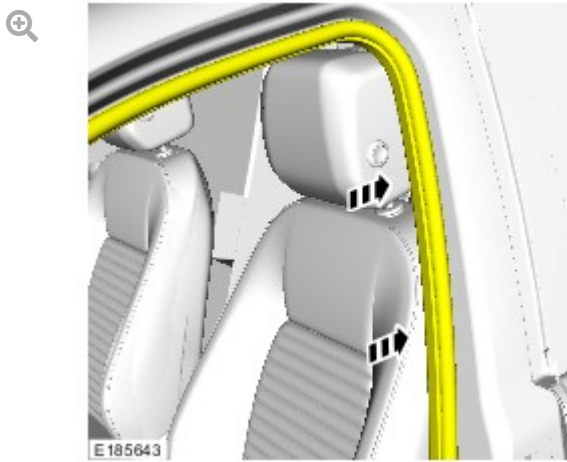
Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

4.

**NOTE:**

Repeat this step on both sides of the vehicle if required.



Install the front door aperture seal to the door aperture.

5. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the noise **can** still be heard, continue to the 'Repair for seatbelt anchor' service instruction.

REPAIR FOR SEATBELT ANCHOR

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1.

**NOTES:**

- This service instruction is only applicable to Halewood manufactured Discovery Sport vehicles up to VIN 638999. Do not complete this service instruction on Halewood manufactured Discovery Sport vehicles with VIN 639000 - Onwards.
- This service instruction is only applicable to Pune manufactured Discovery Sport vehicles up to VIN 961545. Do not complete this service instruction on Pune manufactured Discovery Sport vehicles with VIN 961546 - Onwards.
- This service instruction is only applicable to Brazil manufactured Discovery Sport vehicles up to VIN 201050. Do not complete this service instruction on Brazil manufactured Discovery Sport vehicles with VIN 201051 - Onwards.

Remove the B-pillar upper trim panel (see TOPIx Workshop Manual section: 501-05: Interior Trim and Ornamentation - B-pillar Upper Trim Panel).

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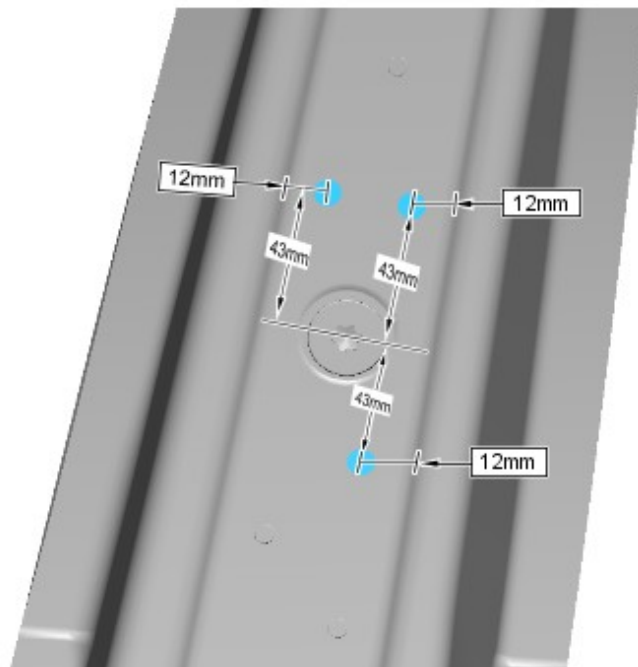
2.

**CAUTION:**

Any body panels which have been modified/altered must be returned to their original manufacturing condition.

**NOTES:**

- Do not drill to a depth of more than 6 mm as this can damage the outer body.
- Make sure the seatbelt retractor bolt is in place and has been torque checked to 40 Nm, before installing rivets



E197180

Drill three 6.5 mm diameter holes in the areas shown to a depth of 6 mm. This can eliminate noises which originate from this area.

3.

**CAUTION:**

Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.

Rectify any paint defects if required.

4. Install the new rivets.

5. Install the B-pillar upper trim panel (see TOPIx Workshop Manual section: 501-05 - Interior Trim and Ornamentation - B-pillar Upper Trim Panel).
- 
6. Road test the vehicle.
    - ■ If the 'ticking' noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
    - ■ If the 'ticking' noise **can** still be heard, continue to the 'Repair for B-pillar Upper Panel 'creak' Noise' service instruction.

#### REPAIR FOR B-PILLAR UPPER PANEL 'CREAK' NOISE

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For vehicles up to VIN - H737229

#### CAUTIONS:

- Make sure a locally sourced zinc-rich primer is applied to any bare metal surfaces.
- Any body panels which have been modified/altered must be returned to their original manufacturing condition.

#### NOTES:

- Any joints sealed during vehicle manufacturing must be sealed as part of the repair.
  - If necessary, refer to Body Repairs (see TOPIx Workshop Manual section 501-25A: Body Repairs - General Information - Description and Operation - Body Repairs) for further information on body panel repairs.
-

1.



E220341

Repair for B-pillar upper panel 'creak' noise.

- 
2. Before commencing this procedure, make sure that you are aware of all Health and Safety requirements. For additional information, refer to: (See TOPIx Workshop Manual section 100-00: General Information - Description and Operation - Health and Safety Precautions).

3.

**CAUTIONS:**

- Use suitable welding blankets to protect the vehicle from any damage before continuing with this bulletin.
- Make sure no damage is caused to any part of the vehicle.

Remove the side air curtain module (see TOPIx Workshop Manual section 501-20: Supplemental Restraint System - Removal and Installation - Side Air Curtain Module).

4.



Identify the 3 spot welds to be drilled.

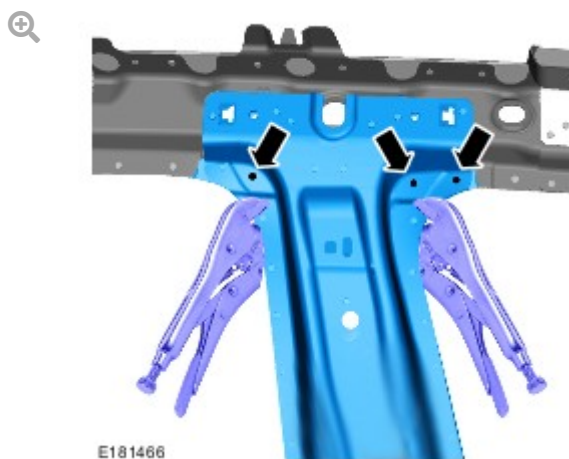
5.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTE:**

Repeat this step on both sides of the vehicle.



Make sure when installing the suitable tools to clamp the B-pillar, the spot welds that are to be drilled remain visible.

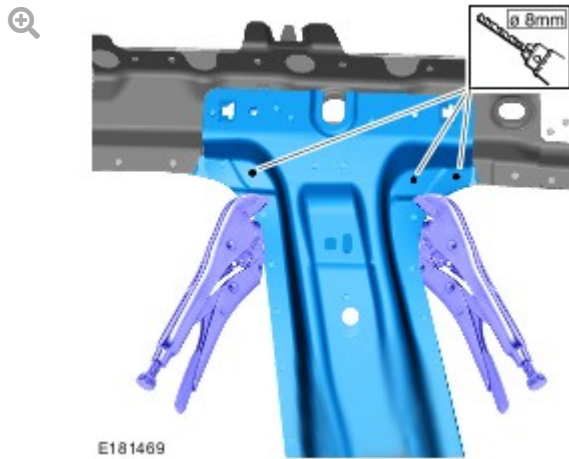
6.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTE:**

Repeat this step on both sides of the vehicle.



Drill the 3 spot welds to the correct depth of 2.5 mm.

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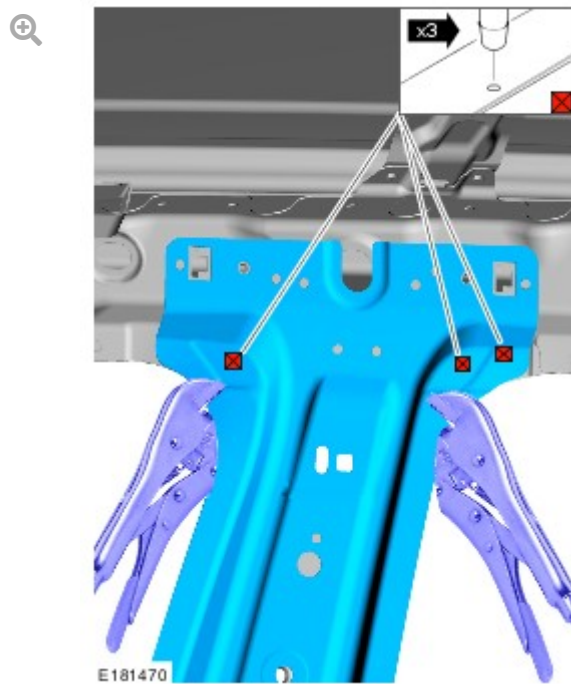
7.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTES:**

- Repeat this step on both sides of the vehicle.
- Make sure corrosion protection is applied to all areas affected by the repair.



Metal Inert Gas (MIG) weld the 3 drilled holes.

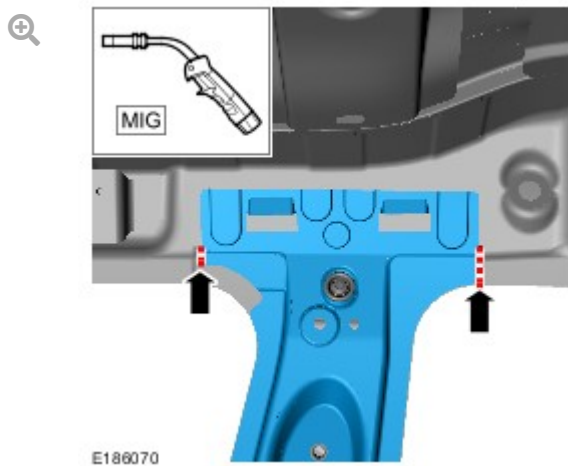
8.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTES:**

- Repeat this step on both sides of the vehicle.
- Make sure corrosion protection is applied to all areas affected by the repair.



MIG seam weld the B-pillar in the area shown. This can eliminate noises which originate from this area.

- ■ Make sure the area between the B-pillar and the inner B-pillar is completely MIG welded in the area shown.

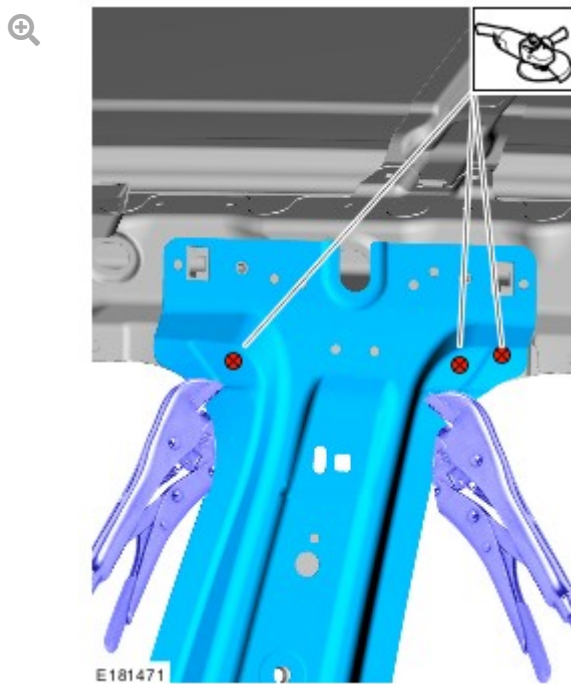
9.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle when grinding.

**NOTES:**

- Repeat this step on both sides of the vehicle.
- Make sure corrosion protection is applied to all areas affected by the repair.



Grind away any excess material where the vehicle has been MIG welded.

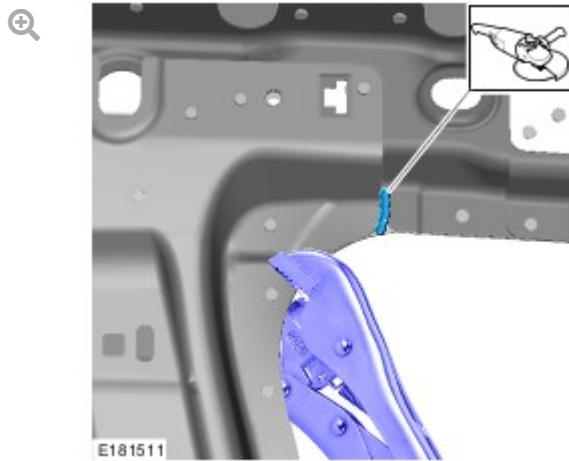
10.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTE:**

Repeat this step on both sides of the vehicle.



Grind away any excess material where the vehicle has been MIG welded.

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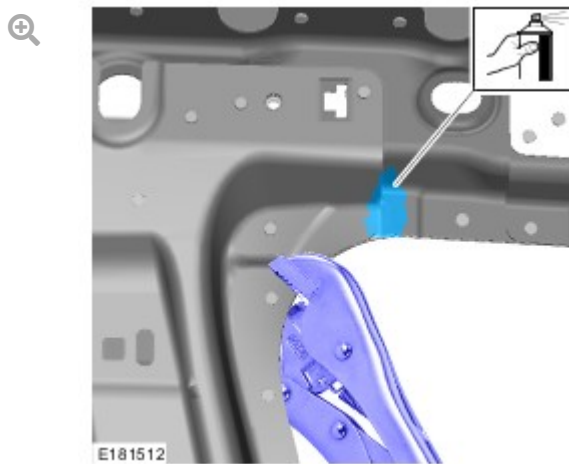
11.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTES:**

- Repeat this step on both sides of the vehicle.
- Make sure corrosion protection is applied to all areas affected by the repair.



Use a suitable corrosion protection to cover the repaired area.

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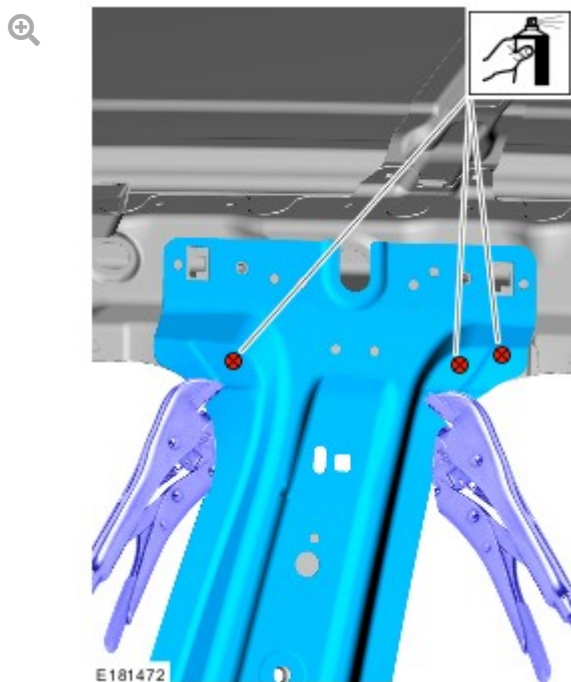
12.

**CAUTION:**

Make sure no damage is caused to any part of the vehicle.

**NOTES:**

- Repeat this step on both sides of the vehicle.
- Make sure corrosion protection is applied to all areas affected by the repair.



Use a suitable corrosion protection to cover the repaired area.

- 
13. Install the side air curtain module (see TOPIx Workshop Manual section 501-20: Supplemental Restraint System Removal and Installation - Side Air Curtain Module).
-

## 14. Road test the vehicle.

- ■ If the noise **cannot** be heard, return the vehicle to the customer. Confirm with the customer that the originally reported noise has been rectified, a further road test with the customer may be required.
- ■ If the customer concern is still present raise a Technical Assistance (TA) including details of all repairs completed, photos, videos and sound recordings. This information will be reviewed and further instruction given to resolve the customer concern.