

		Tesla, Inc. Service Bulletin		<i>Reseal Trunk Lid to Prevent Water Ingress</i>	
SB-23-10-002 April 27, 2023		R2			
Classification		Section/Group		Mobile Service	Configuration
Repair Bulletin		10 - Body		Can Perform (where permitted)	All
Model Year	Model	Country/Region		Build Location	
2017 - 2023	Model 3	All		Fremont	
The model(s) and model year(s) listed are a general approximation 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.					

Repair Bulletin: This repair bulletin provides instructions on addressing a noted condition or possible customer concern regarding the operation of Tesla vehicles. These instructions should only be performed by trained professionals.

This Service Document supersedes SB-23-10-002 R1, dated 17-Apr-23. This new revision, R2, adds an alternative part number for the sealant to be used in the EMEA region. Each content change is marked by a vertical line in the left margin. Discard the previous version and replace it with this one.

Condition

On some Model 3 vehicles, water may have leaked inside the trunk area through the trunk lid.

Correction

Inspect inside the trunk area for signs of water leaks that came through the trunk lid. If this symptom is present, reseal the trunk lid.

 **Tip:** Click [here](#) to watch a video that shows an overview of this procedure.

Correction Description	Correction	Time
SB-23-10-002 Not Applicable	S012310002	0.00
Reseal Trunk Lid To Prevent Water Ingress	S022310002	2.40

 **NOTE:** If the trunk seal is replaced, add correction code 11702002.

	Part Number	Description	Quantity
Parts Required	1453383-00-A	LIFTGATE LAMP DOUBLE-ENDED STUD GASKET	2
	1453384-00-A	LIFTGATE LAMP CONNECTOR GASKET	2
These parts are available through Grainger/McMaster-Carr/MAVOM (EMEA) eProcurement:			
	1939248-00-A	LOCTITE HYBRID POLYMER 5510 (except EMEA)	1
	1031124-01-A	TEROSON MS 660 (EMEA)	1
	1939249-00-A	CAULK GUN 10OZ-13OZ CARTIDGE	1
	1939250-00-A	3M URETHANE PRIMER DAUBERS	1
If Necessary	1091069-00-E	SEALS, TRUNK, DECKLID	1

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the [Parts Catalog](#).

Shop Supplies Isopropyl Alcohol (IPA) wipes

 **NOTE:** This procedure addresses water ingress through the trunk lid and not due to water entering the vehicle while the trunk was opened in the rain.

 **NOTE:** Although the figures in this procedure highlight one side of the trunk lid, this procedure **must** be performed on both sides (LH and RH) of the trunk lid.

Procedure

1. Remove the trunk lid trim (refer to Service Manual procedure [15111902](#)).
2. Remove the LH and RH rear fog/reverse lights (refer to Service Manual procedure [17402702](#)).
3. Remove and discard the factory foams (x2) (Figures 1–4) located under the LH and RH lamp can panels inside the trunk lid.

 **CAUTION:** Wear appropriate eye safety glasses and protective earplugs as Personal Protection Equipment (PPE).

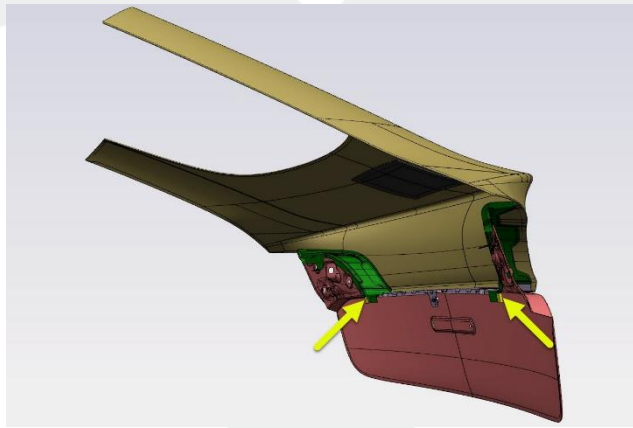


Figure 1 – Some components removed to aid clarity



Figure 2 – LH factory foam inside trunk lid; RH similar

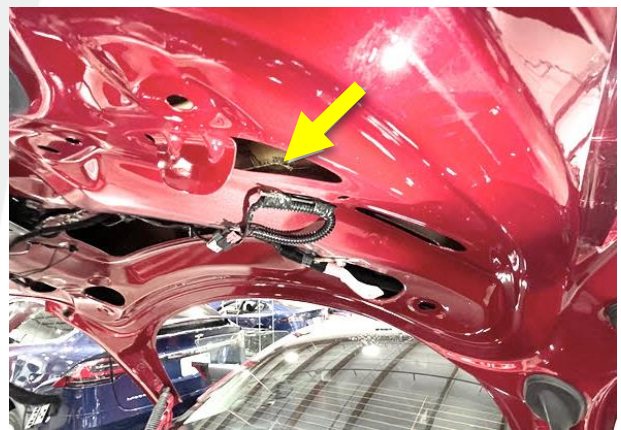


Figure 3 – LH factory foam removed from the trunk lid; RH similar



Figure 4 – Detailed view of a factory foam removed from the trunk

4. Prepare the caulking gun (1939249-00-A) with the 5510 white sealant (1939248-00-A) (Figure 5). Cut an approximately 4 mm wide opening on the sealant dispensing tube (Figure 6) using a retractable blade knife.



Figure 5



Figure 6

5. Apply the sealant on top of the LH and RH lamp can panels located inside the trunk assembly (Figures 7–10), and then spread the sealant bead with your finger (Figures 11 and 12) while wearing a nitrile glove. Apply several sealant beads as needed.

⚠ CAUTION: Use nitrile gloves as PPE for the remainder of this procedure.

📋 NOTE: Make sure to apply the sealant between the panels (Figure 12).

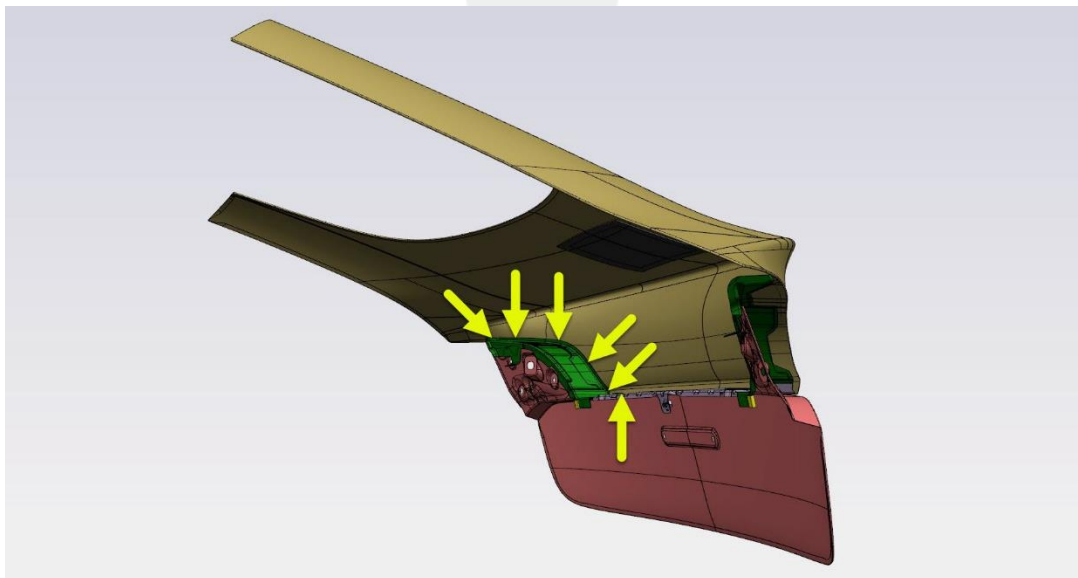


Figure 7 – RH lamp can panel shown, LH similar

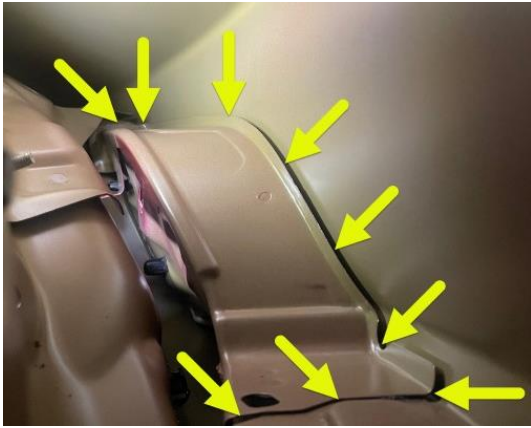


Figure 8



Figure 9



Figure 10



Figure 11



Figure 12

6. Apply the sealant on the sides and the back side of the LH and RH lamp can panels located inside the trunk lid (Figures 13–18). Spread the sealant bead with your finger while wearing a nitrile glove. Apply several sealant beads as needed.

 **NOTE:** Use the dauber (1939250-00-A) in tight spaces (Figure 16).

 **NOTE:** Make sure to apply the sealant between the panels (Figure 18).

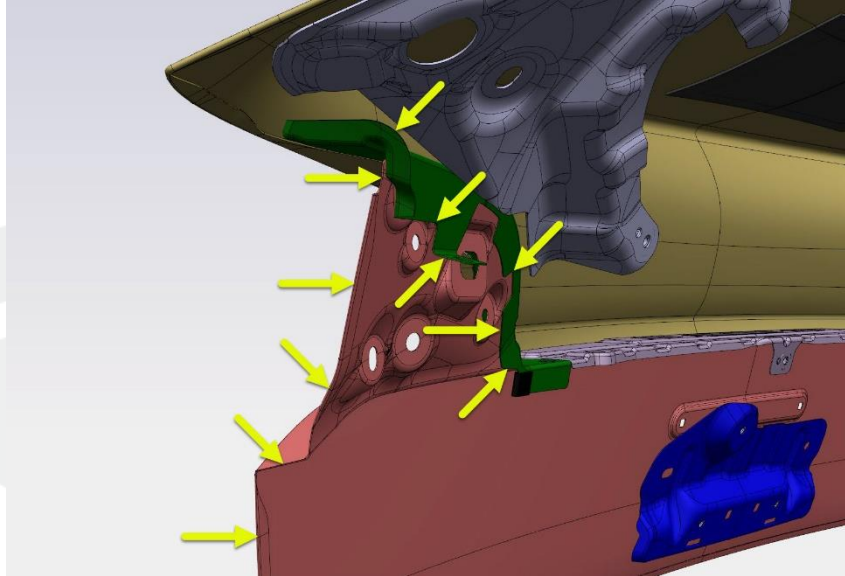


Figure 13

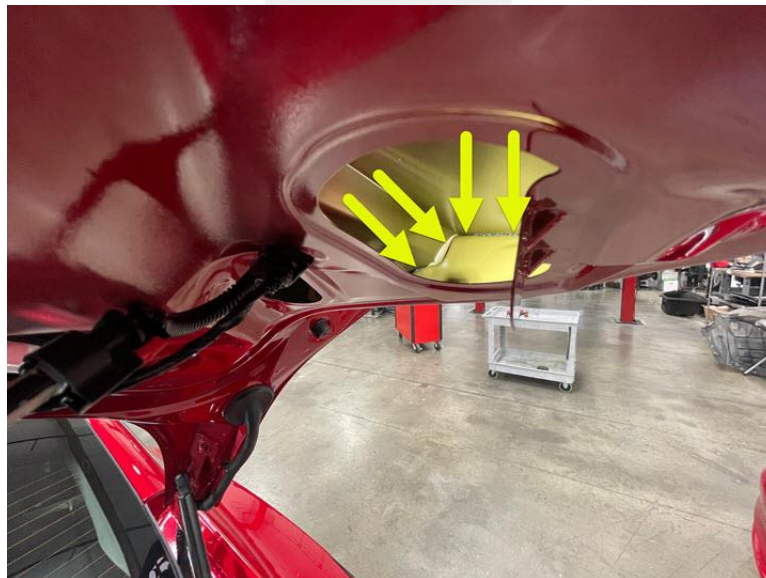


Figure 14



Figure 15



Figure 16



Figure 17



Figure 18

7. Apply the sealant on the bottom side of the LH and RH lamp can panels located inside the trunk lid (Figures 19 and 20). Apply several sealant beads as needed.

 **NOTE:** Use the dauber to apply the sealant in small spaces.

 **NOTE:** Make sure to apply the sealant between the panels (Figure 21).

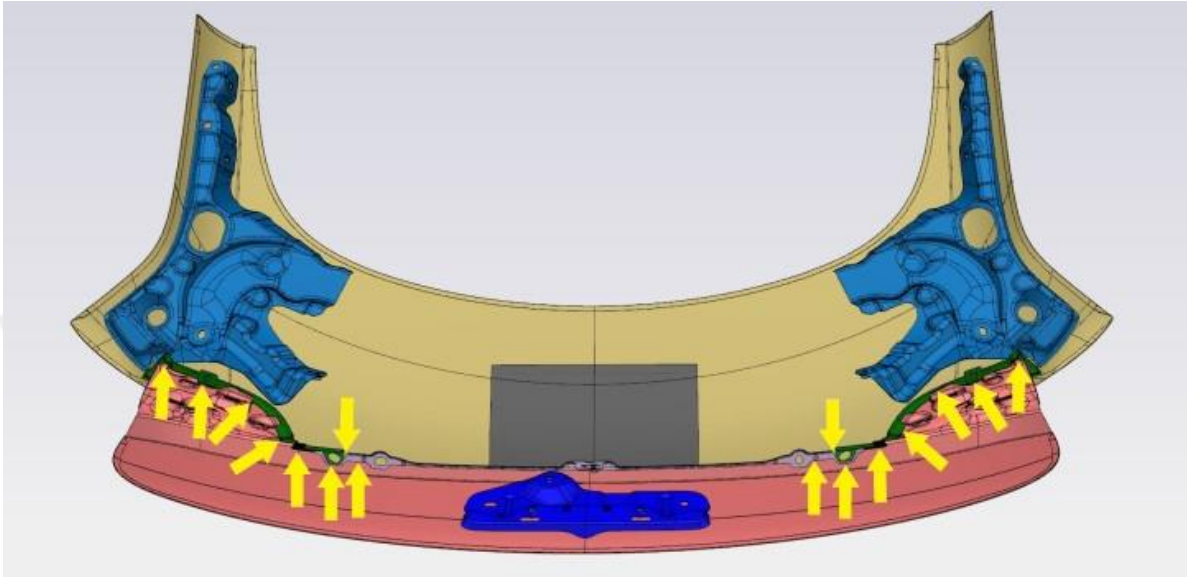


Figure 19



Figure 20



Figure 21

8. Inspect the trunk lid seams: Locate openings and pin holes in the highlighted areas (Figures 22–27).

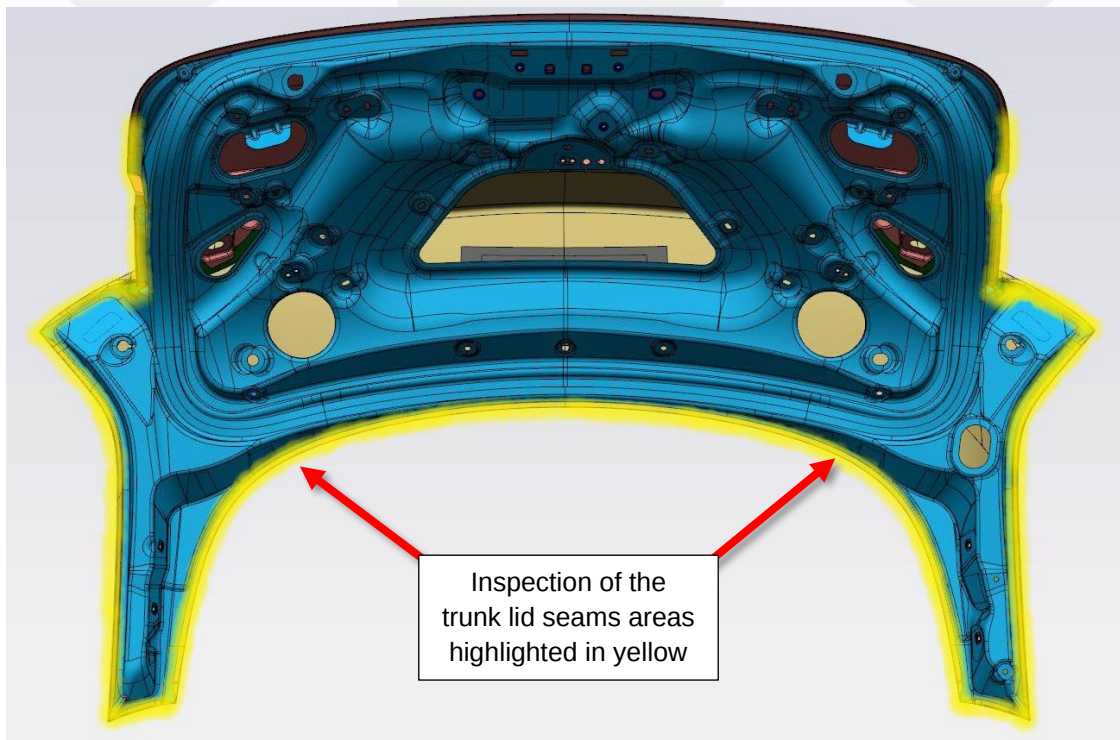


Figure 22



Figure 23



Figure 24 – Example of pin hole

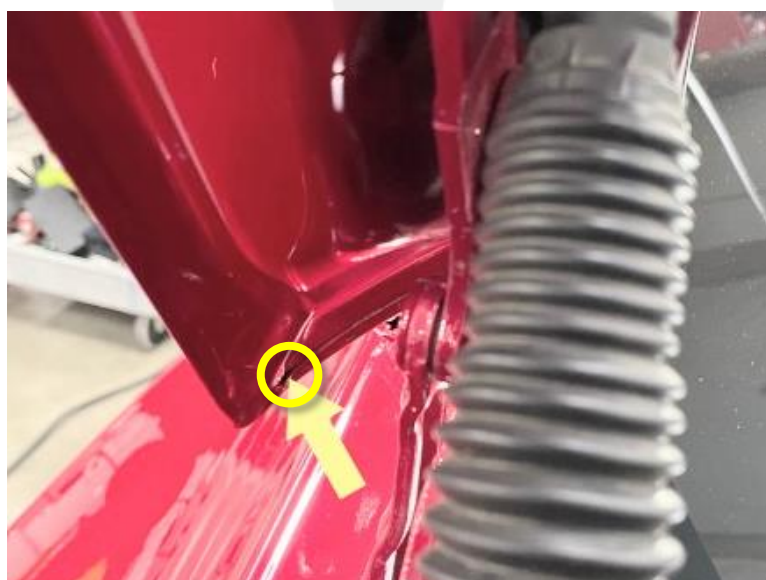


Figure 25 – Example of pin hole



Figure 26 – Example of trunk lid seam



Figure 27 – Example of pin hole

9. Use a plastic trim tool to remove any previously applied **non-factory** sealants in the highlighted areas, if present (Figures 28–31).

⚠ CAUTION: Do **NOT** remove factory sealant. To differentiate between factory sealant and non-factory sealant, factory sealant is painted over and is harder to remove, and non-factory sealant is usually clear and easier to remove than factory sealant.

📋 NOTE: Use adhesive remover, as needed.

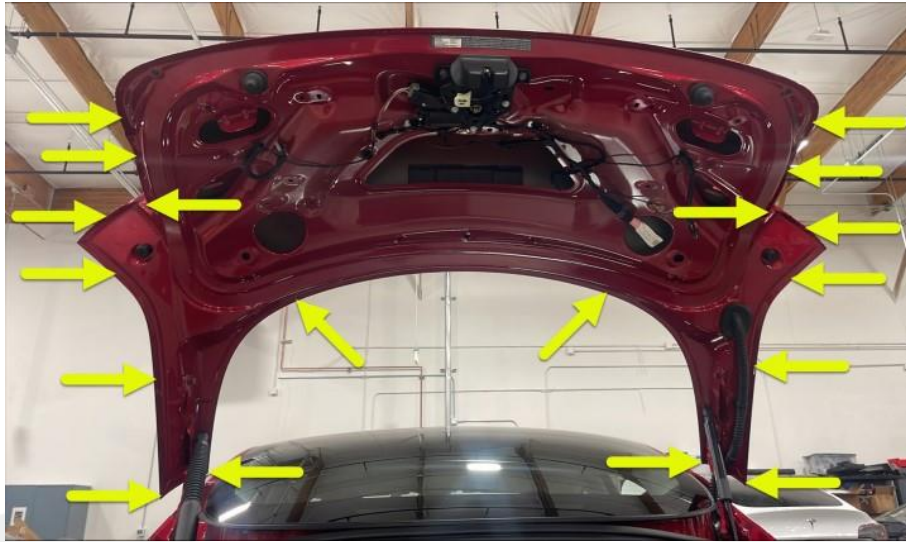


Figure 28



Figure 29



Figure 30



Figure 31

10. Clean the trunk lid seams areas with Isopropyl Alcohol (IPA) wipes (Figures 32 and 33).



Figure 32

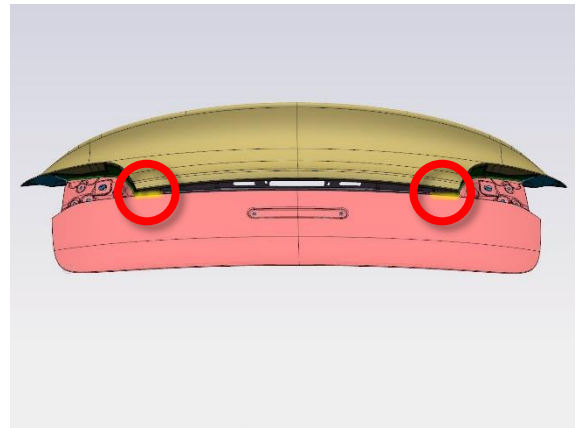


Figure 33

11. Apply sealant **ONLY** on the openings and pin holes found during the inspection (Figures 34 and 35).

! CAUTION: Do **NOT** apply sealant to the entire trunk lid.



Figure 34



Figure 35

12. Remove excess sealant with a clean, dry microfiber cloth. Allow 1 hour for the sealant to fully cure (Figures 36–41).

! CAUTION: Do not use chemicals to remove excess sealant.

NOTE: The sealant must be allowed to cure for 1 hour because touch-up paint will be applied onto it later in this procedure.



Figure 36



Figure 37



Figure 38



Figure 39



Figure 40

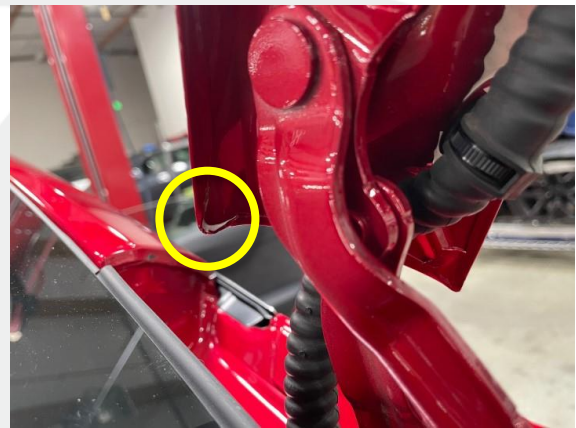


Figure 41

13. Apply sealant on the upper and lower panel mating surfaces for the LH and RH sides (Figures 42–45). Allow 1 hour for the sealant to fully cure.

 **NOTE:** Apply sealant with your finger while wearing a nitrile glove, and then work sealant onto the factory sealant.

 **NOTE:** Make sure to apply the sealant between the panel mating surfaces (Figure 45).

 **NOTE:** The sealant must be allowed to cure for 1 hour because touch-up paint will be applied onto it later in this procedure.

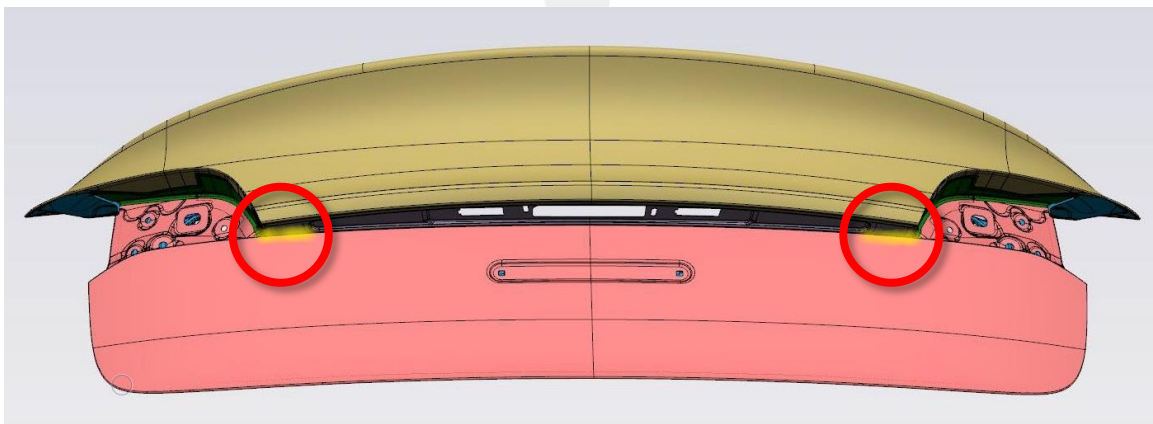


Figure 42

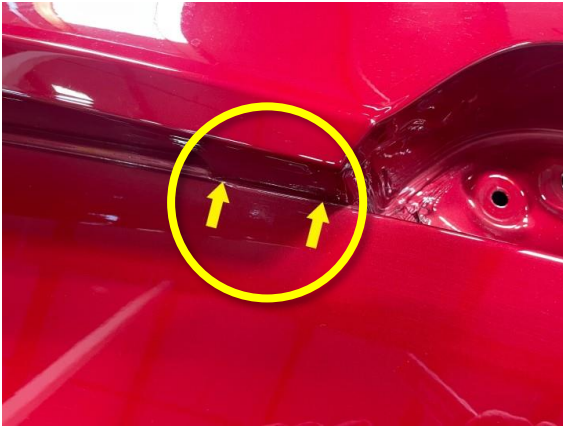


Figure 43



Figure 44



Figure 45

14. Remove excess sealant from the upper and lower panel mating surfaces with a clean, dry microfiber cloth (Figure 46). Allow 1 hour for the sealant to fully cure.

⚠ CAUTION: Do not use chemicals to remove excess sealant.

📋 NOTE: The sealant must be allowed to cure for 1 hour because touch-up paint will be applied onto it later in this procedure.



Figure 46

15. Apply touch-up paint onto newly sealed areas (Figure 47–50).

 **NOTE:** Make sure sealant is dry to the touch before touch-up paint is applied.



Figure 47



Figure 48



Figure 49

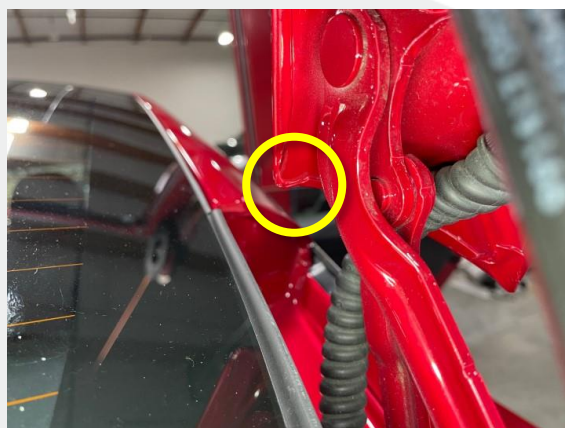


Figure 50

16. Inspect the overall condition of the trunk seal. If the trunk seal is compromised (Figure 51), replace the seal (refer to Service Manual procedure [11702002](#)).



 Figure 51

17. Close the trunk.
18. Verify that the trunk seal fully contacts the trunk lid and that there are no visible gaps (Figures 52 and 53).

 **NOTE:** With assistance, shine a flashlight from the exterior and make sure no light is visible on the inside. If light is visible, then replace the trunk seal and repeat this step. If light is still visible after the replacement of the trunk seal, then perform trunk seal adjustment, as needed.



Figure 52



Figure 53

19. Open the trunk.
20. Put the RH rear fog/reverse light upside down on a padded surface (Figure 54).



Figure 54

21. Remove and discard the gaskets for the RH light connector (Figure 55) and mounting stud (Figure 56), and then replace them with new ones (Figures 57 and 58).



Figure 55



Figure 56

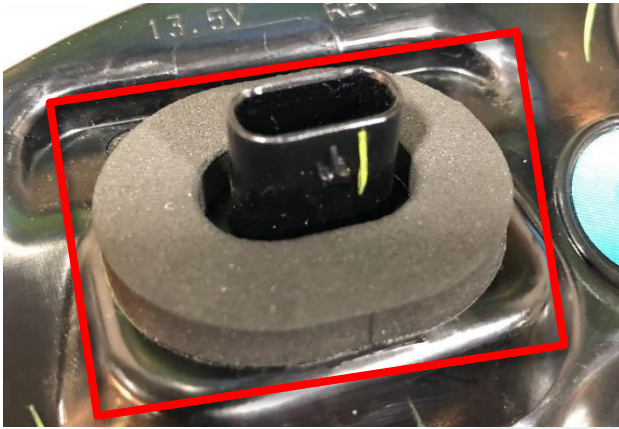


Figure 57



Figure 58

22. Repeat steps 20 and 21 for the LH rear fog/reverse light.
23. Install the LH and RH rear fog/reverse lights (refer to Service Manual procedure [17402702](#)).
24. Install the trunk lid trim (refer to Service Manual procedure [15111902](#))