


RSB-56-23-002-1: R1S Upper Liftgate Body Fit and/or Water Leakage

Rivian is launching a technical service bulletin for some model year 2022 R1S vehicles that have a liftgate seal flange that is shorter than designed. These vehicles may have water ingress near the upper liftgate, or the upper liftgate may contact the rear roof applique when the liftgate is opened. These vehicles also require specific adjustments if the upper liftgate is replaced. Perform this procedure upon customer complaint, or if the upper liftgate is replaced.

Document Type	Technical Service Bulletin
Date	June 14, 2023
Affected Region(s)	USA
Affected Model(s)	R1S
Model Year(s)	2022
Approximate Build Dates	November 2021 - July 2022
 Refer to the TSB Guide Dashboard to determine if this document applies to a specific vehicle.	
Vehicle System	56 - Closures
Minimum Service Location	Service Center

Required Parts

Part Number	Quantity	Engineering Name	Service Name/Notes
PT00013750-K	1	SEAL_LIFTGATE	Seal, Liftgate

! **Attention:** The parts listed in this table are only for unique steps that are called out in this bulletin. Some sections of this bulletin might refer to Service Manual procedures which require additional parts. Always review the bulletin and all potentially related Service Manual procedures before ordering parts and beginning work.

Potentially Required Parts

Part Number	Quantity	Engineering Name	Service Name/Notes
SC00017821-A	5	BOLT - M8X1.25X26.6 HX WSHR FL PIL SHE CL10.9 R105B	Non-reusable. Replace if removed.
One of the following:			
SC00007621-A	3	BOLT - M6X1.0X13.45 HX WSHR MAT ADH R105B	Non-reusable. Replace if removed.
SC00018585-A	3	BOLT - M6X1.0X14.12 HX WSHR CON MAT SE CL8.8 R113	Non-reusable. Replace if removed.

! **Attention:** The parts listed in this table are only for unique steps that are called out in this bulletin. Some sections of this bulletin might refer to Service Manual procedures which require additional parts. Always review the bulletin and all potentially related Service Manual procedures before ordering parts and beginning work.

Required Special Tools:

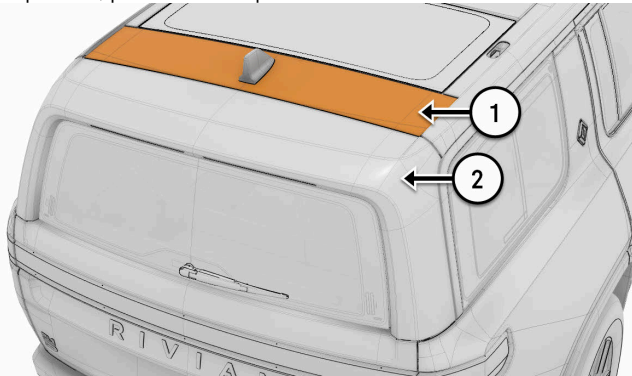
Tool Number	Tool name
TSN01020	Go/no-go gap gauge, R1S, liftgate-lower body
TSN01021	Go/no-go gap gauge, R1S, liftgate-roof header

! **Attention:** The special tools listed in this table are only for unique steps that are called out in this bulletin. Some sections of this bulletin might refer to Service Manual procedures which require additional special tools. Always review the bulletin and all potentially related Service Manual procedures before beginning work.

Introduction

Early-build R1S vehicles have a liftgate seal flange that is shorter than typical. If the TSB Guide Dashboard shows that this document applies to the vehicle:

- Perform this procedure when the upper liftgate is replaced.
- Upper liftgates were adjusted at the factory to prevent water leakage. This could result in sub-optimal body gaps around the liftgates.
 - If a customer complains of water leakage near the liftgate, perform this procedure.
 - If a customer complains that the upper liftgate contacts the rear roof applique when the liftgate is opened, perform this procedure.



1	Rear roof applique
2	Upper liftgate

- If the customer complains of sub-optimal body gaps around the liftgate, do not perform this procedure. It is likely that the body gaps are already appropriate and will not be improved by this procedure.

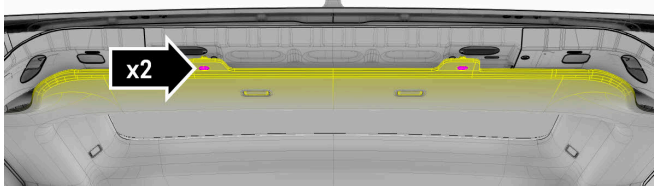
! **Important:** This procedure is only for the vehicles that are affected by this service bulletin, as shown in the TSB Guide Dashboard. Use the standard procedure to adjust the liftgates on other vehicles.

Preparation

1. Remove and discard: Seal, Liftgate (refer to service manual procedure 568040010).
2. Remove: Panel, Sill Flap (refer to service manual procedure 648243010).

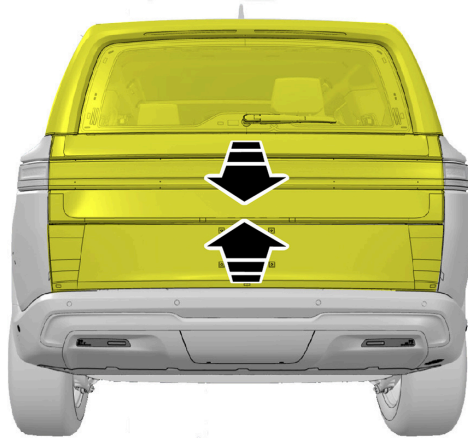
3. Remove: Trim Panel, Roof, Rear (refer to service manual procedure 648276010).

4.



Inspection

1.

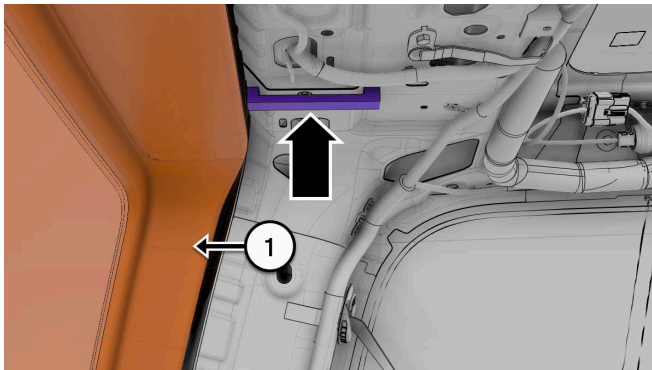


2. Working in the cargo area: On both sides: Position the tool as shown.

a. Insert the narrow side of the tool in the gap.

b. Insert the wide side of the tool in the gap.

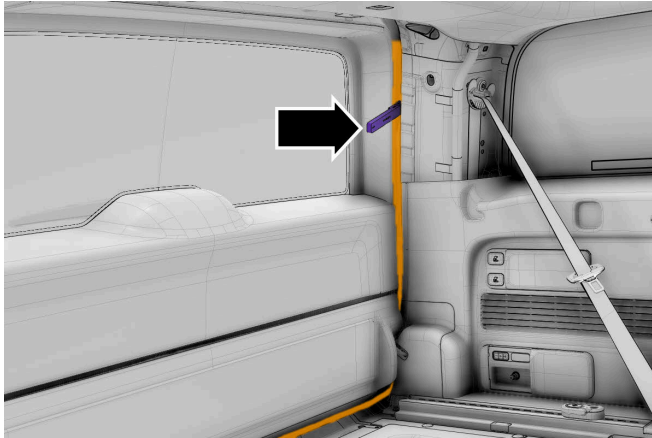
c. The upper liftgate is aligned within specification if the narrow side slides freely in the gap and the wide side does not fit in the gap.



Note: Shown with components removed for clarity.

1	Upper liftgate
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3. On both sides: Use the tool to check the gaps in the highlighted areas.
 - a. Insert the narrow side of the tool in the gap.
 - b. Insert the wide side of the tool in the gap.
 - c. The liftgates are aligned within specification if the narrow side slides freely in the gap and the wide side does not fit in the gap.



 **Note:** Shown with components removed for clarity.

Adjustment

If adjustment is necessary: Adjust the components in the following order.

-  **Tip:** The next steps are easier with an assistant.
-  **Note:** Adjust in small increments. Repeat the [Inspection](#) section after each adjustment to make sure that the liftgates are still aligned within specification.
-  **Note:** The target gap and flushness measurements shown here apply to vehicles affected by this technical service bulletin. They may not be valid for other vehicles.

1.

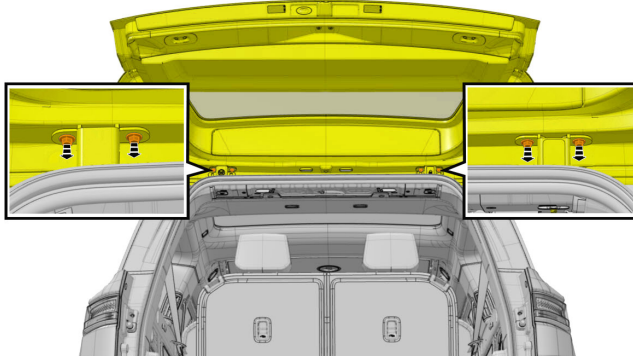
a. Check the gaps shown.



Target gap:

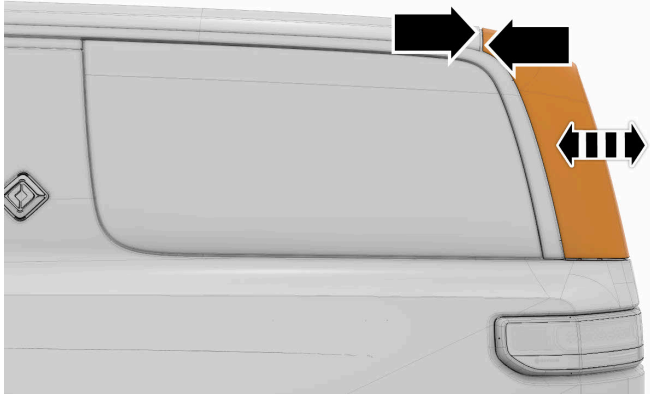
- 2-6 mm with upper liftgate assist struts installed
- 3.5-7.5 mm with upper liftgate assist struts removed

b. If adjustment is necessary: Loosen the highlighted fasteners to adjust the component.



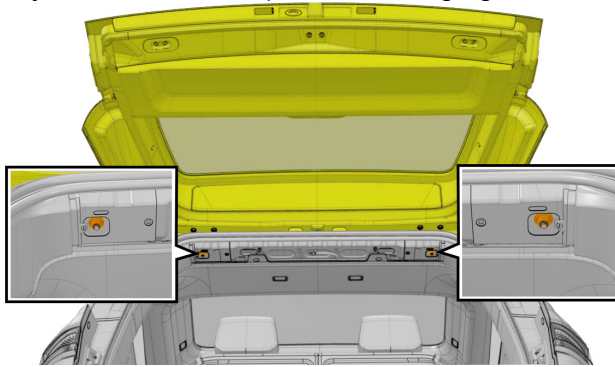
2.

a. On both sides: Check the gaps shown.



Target gap: Defined by the special tools in the [Inspection](#) section.

b. If adjustment is necessary: Loosen the highlighted fasteners to adjust the component.



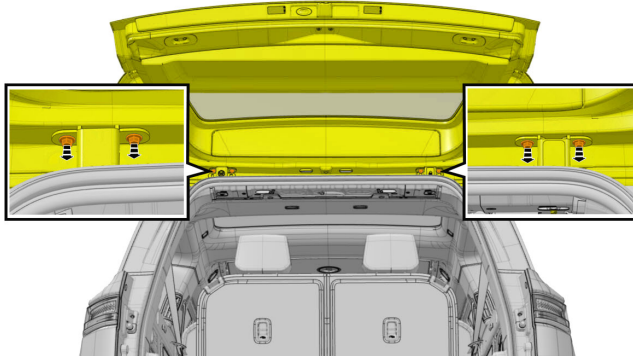
3.

a. Check the gaps shown.



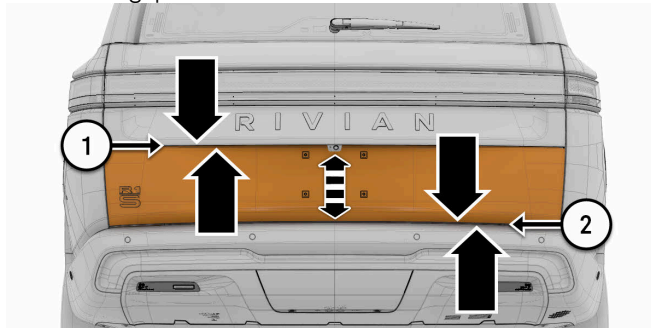
Target gap: Equal values (the component should be centered).

b. If adjustment is necessary: Loosen the highlighted fasteners to adjust the component.



4.

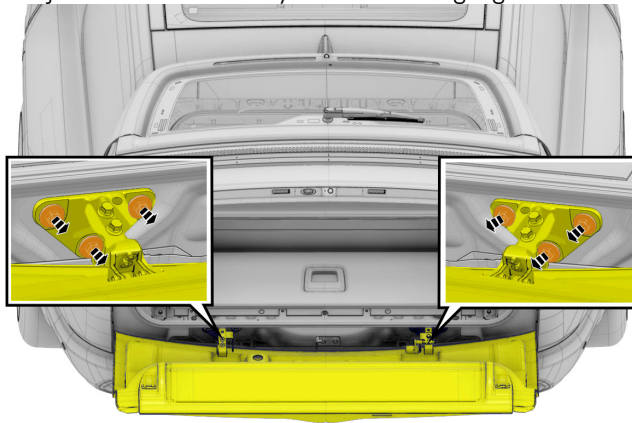
a. Check the gaps shown.





Target gap

1	2.3-5.7 mm
2	3.1-8.9 mm

b. If adjustment is necessary: Loosen the highlighted fasteners to adjust the component.

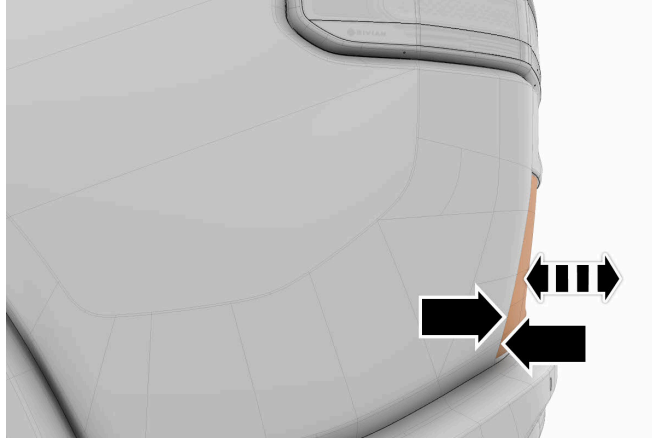


 **CAUTION:** Non-reusable component(s).

 **Note:** Adjust the panel before replacing any fasteners. Once the panel is properly adjusted, tighten all but 1 fastener. Replace the loose fastener and tighten it fully. Continue to replace the other fasteners, 1 at a time, keeping the remaining fasteners fully tightened. This prevents the panel from moving as each fastener is replaced.

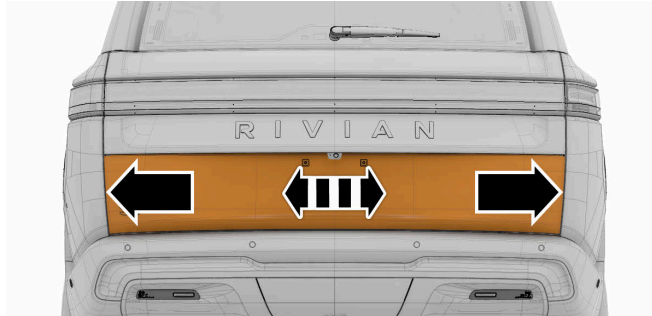
5.

- a. On both sides: Check the flushness between the components.



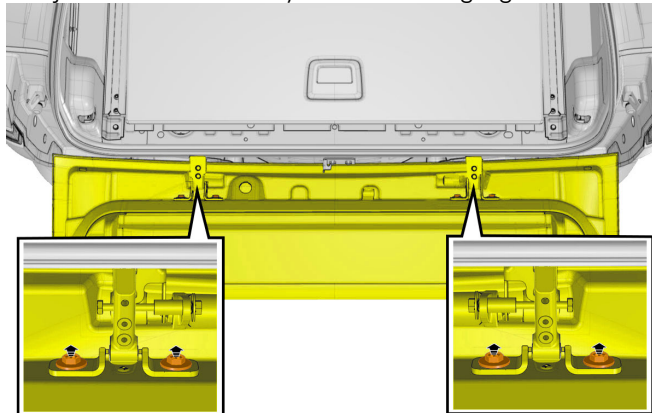
Target flushness: Lower liftgate 0.5-3.5 mm underflush to the bodyside.


- b. Check the gaps shown.




Target gap: Equal values (the component should be centered).

- c. If adjustment is necessary: Loosen the highlighted fasteners to adjust the component.

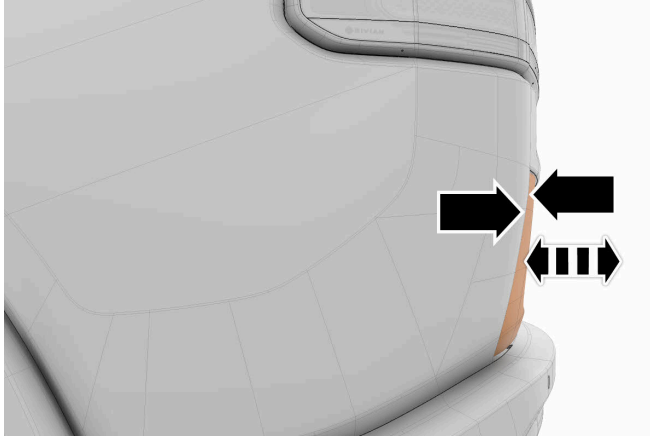


 **CAUTION:** Non-reusable component(s).

 **Note:** Adjust the panel before replacing any fasteners. Once the panel is properly adjusted, tighten all but 1 fastener. Replace the loose fastener and tighten it fully. Continue to replace the other fasteners, 1 at a time, keeping the remaining fasteners fully tightened. This prevents the panel from moving as each fastener is replaced.

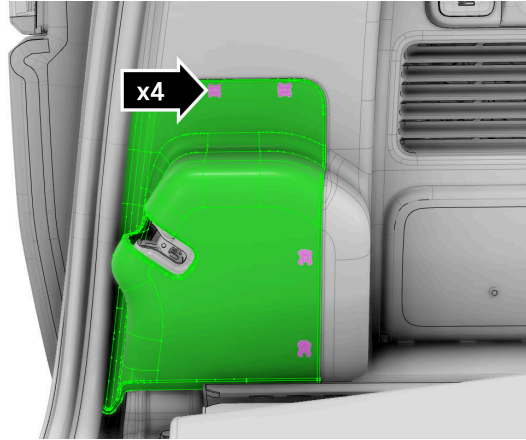
6.

- a. On both sides: Check the flushness between the components.

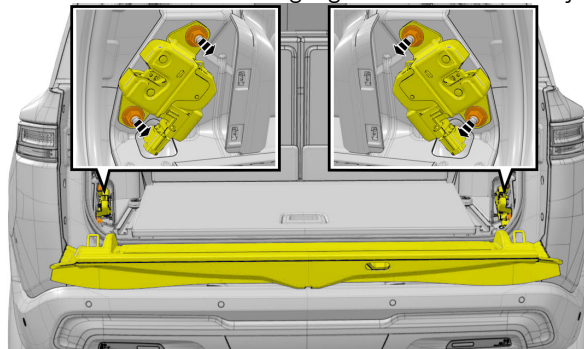


Target flushness: Lower liftgate 0.5-3.5 mm underflush to the body side.

- b. If adjustment is necessary: On both sides: Use a trim tool to pry near the highlighted clip(s).

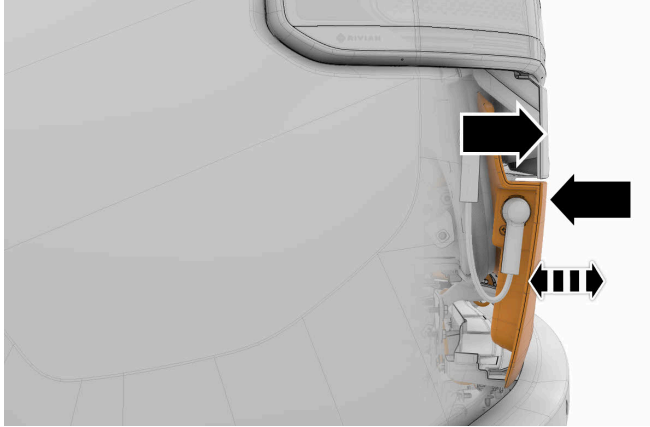


- c. On both sides: Loosen the highlighted fasteners to adjust the component.



7.

- a. On both sides: Check the flushness between the components.

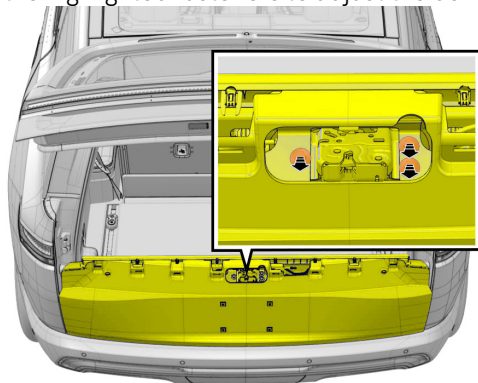


Note: Shown with components removed for clarity.

Target flushness: Lower liftgate 1 mm underflush-1 mm overflush to the upper liftgate.

- b. If adjustment is necessary: Remove: Trim Panel, Lower Liftgate, Upper (refer to service manual procedure 641956010).

- c. Loosen the highlighted fasteners to adjust the component.



CAUTION: Non-reusable component(s).



Note: Adjust the panel before replacing any fasteners. Once the panel is properly adjusted, tighten all but 1 fastener. Replace the loose fastener and tighten it fully. Continue to replace the other fasteners, 1 at a time, keeping the remaining fasteners fully tightened. This prevents the panel from moving as each fastener is replaced.

8. Continue to the next section.

Torque specifications in this section

Step Number	Torque (Nm)
1.b	30
2.b	65
3.b	30
4.b	38.5
5.c	38.5
6.c	25
7.c	10

Final Tasks

1. Install, using new component(s): Seal, Liftgate (refer to service manual procedure 568040010).
2. Working in the cargo area: Check for water leakage while an assistant uses a hose to spray water over the rear of the roof and around the upper and lower liftgates.
3. Reinstall all components that were removed for access and replace all non-reusable components. Refer to the service manual procedures referenced in this document for additional component reusability information and torque specifications.

Labor Codes

Labor Code	Description
RSB562300200	RSB-56-23-002 not applicable
RSB562300201	Customer concern of liftgate fit only; no work performed
RSB562300202	Check liftgate fit, replace liftgate seal, no adjustments necessary
RSB562300203	Check liftgate fit, perform 1 adjustment, replace liftgate seal, test for water leakage
RSB562300204	Check liftgate fit, perform 2 adjustments, replace liftgate seal, test for water leakage
RSB562300205	Check liftgate fit, perform 3 adjustments, replace liftgate seal, test for water leakage
RSB562300206	Check liftgate fit, perform 4 adjustments, replace liftgate seal, test for water leakage
RSB562300207	Check liftgate fit, perform 5 adjustments, replace liftgate seal, test for water leakage
RSB562300208	Check liftgate fit, perform 6 adjustments, replace liftgate seal, test for water leakage
RSB562300209	Check liftgate fit, perform 7 adjustments, replace liftgate seal, test for water leakage
RSB562300210	Check liftgate fit, perform 8 adjustments, replace liftgate seal, test for water leakage
Contact ServiceDocumentFeedback@rivian.com regarding labor codes and document content.	