

Subject: FRONT END OF REAR DOOR GLASS RUN-CHANNEL IS LOOSE	Bulletin No.: 09-044/23
	Last Issued : 12/07/2023

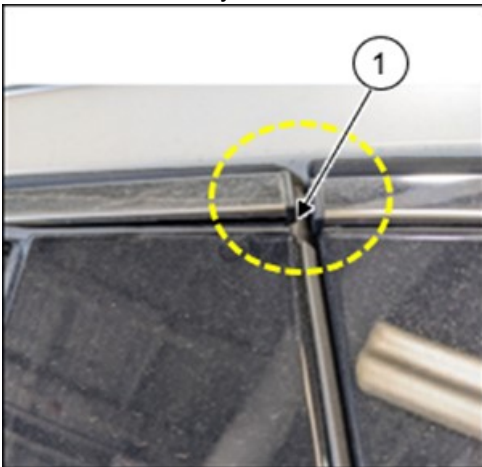
BULLETIN NOTES

APPLICABLE MODEL(S)/VINS

2024 CX-90 with VINS lower than JM3KK*****125140 (produced before July 27, 2023)

DESCRIPTION

Some vehicles may exhibit the front end of the rear door glass run-channel (1) coming off from the rear door.



This is caused by the adhesive process of the sash molding primer coating and the double-sided tape not being properly performed with sufficient adhesive strength, resulting in the peeling off the double-sided tape on the the rear door glass run-channel. To eliminate this concern, the adhesive process of the sash molding primer coating and the double-sided tape has been modified to improve the adhesive strength.

Customers having this concern should have their vehicle repaired using the following repair procedure.

REPAIR PROCEDURE

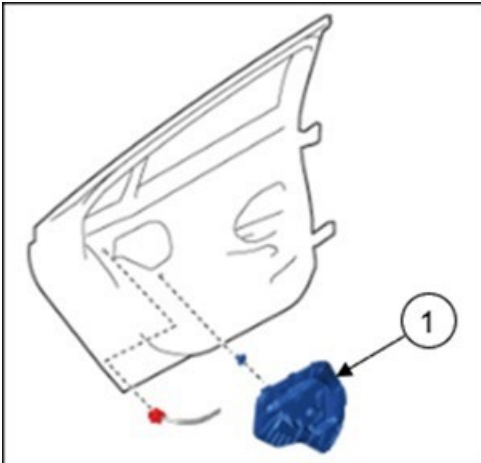
1. Verify the customer concern.
2. Replace both sides of the rear door glass run-channels with the modified ones according to the instructions in MGSS (REAR DOOR GLASS RUN-CHANNEL REMOVAL/INSTALLATION) and the following steps.
 - a. Perform repairs up to "Remove Driver's Side Glass" of the instructions in MGSS (REAR DOOR GLASS RUN-CHANNEL REMOVAL/INSTALLATION).

Rear door service hole cover No.1 Removal Note:

NOTE: The images show the left side (same as right side).

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b. Replace the service hole cover according to the following steps.

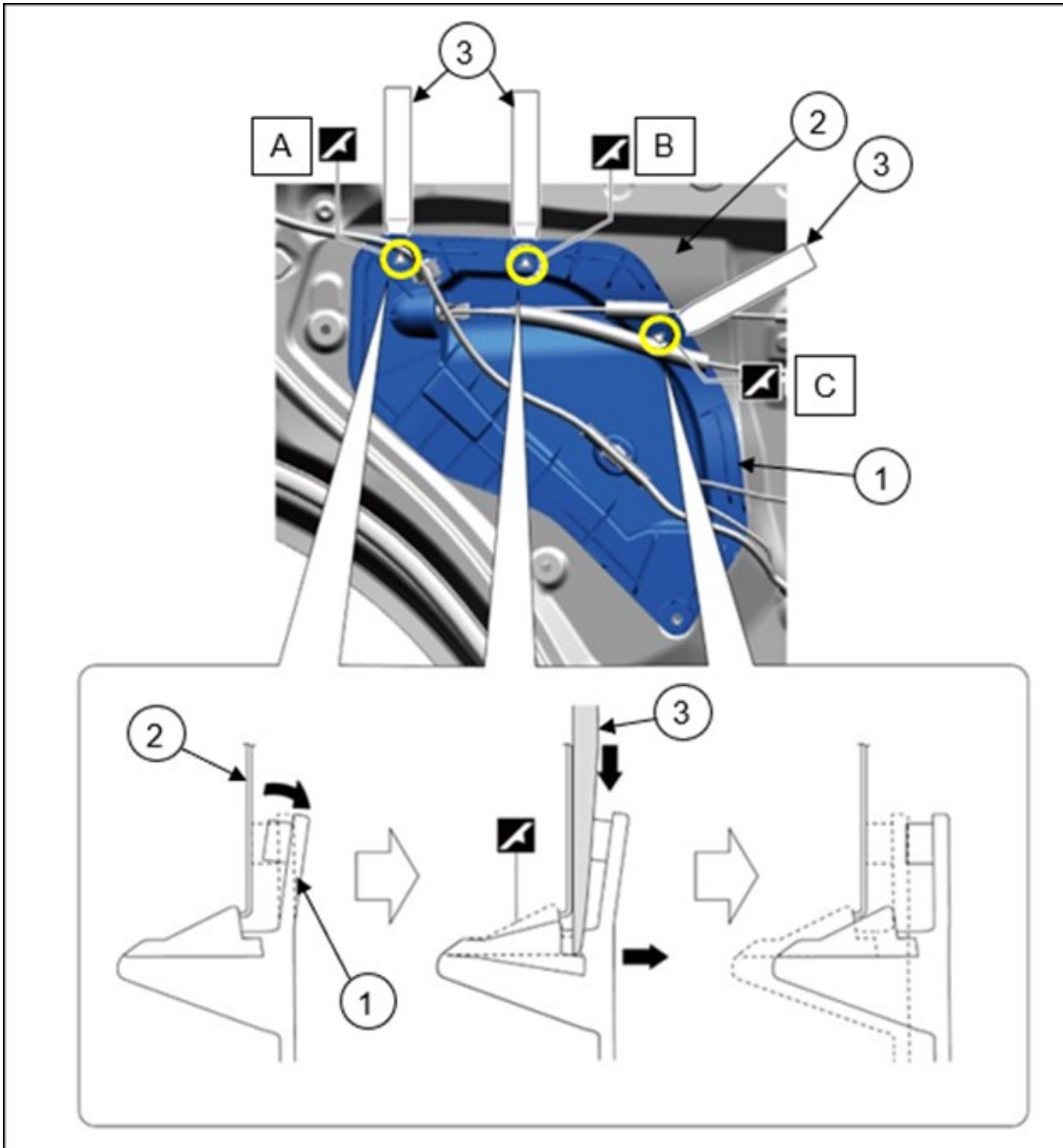


(1) Rear Door Service Hole Cover No. 1
(Service Hole Cover)

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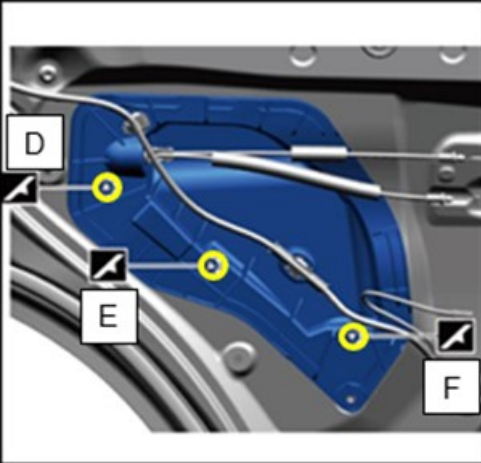
1) Pull the edge of the service hole cover (1) at the mark (A) (B) (C) to make a gap between the cover and the door panel (2) and insert the remover tool (3) into the gap and remove the tabs on the service hole cover in order of the mark (A) (B) (C) as per the following images.

ATTENTION: Insert the remover tool carefully so as NOT to damage the seal rubber on the service hole cover.

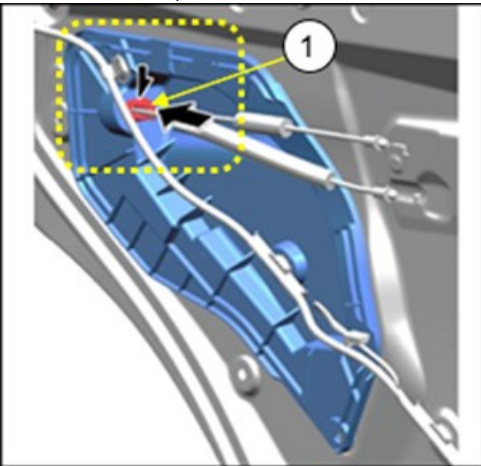


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2) Remove the tabs in order of the mark (D) (E) (F) in the same procedure as Step-1.



3) Unfasten the service hole cover and the grommet (1) while pushing the grommet.

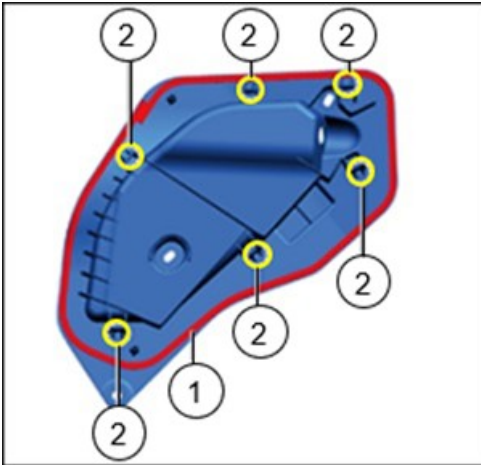


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Rear door service hole cover No.1 Installation Note:

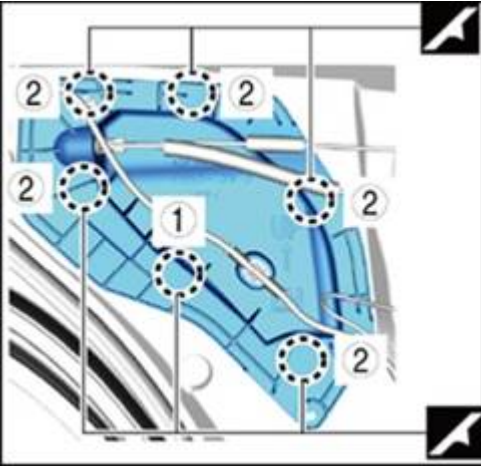
NOTE: The images show the left side (same as right side).

ATTENTION: If the seal rubber (1) and /or the tabs (2) on the door service hole cover are damaged, replace them with a new one(s).



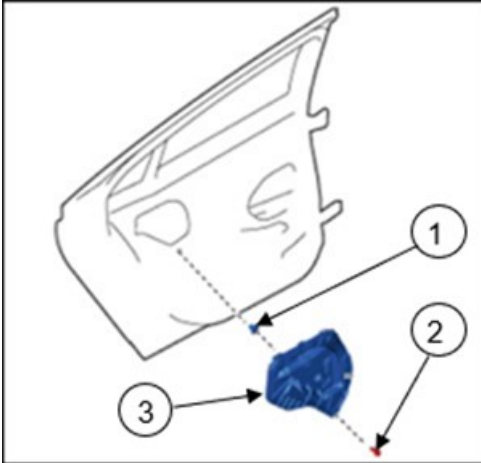
(1) Seal Rubber
(2) Tab

1) Install the service hole cover in order of the number in the following image.



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- 2) If the required screw (2) tightening torque cannot be achieved, replace the grommet (1).
Tightening torque: 17 in·lbf (2 N·m, 20 kgf·cm)

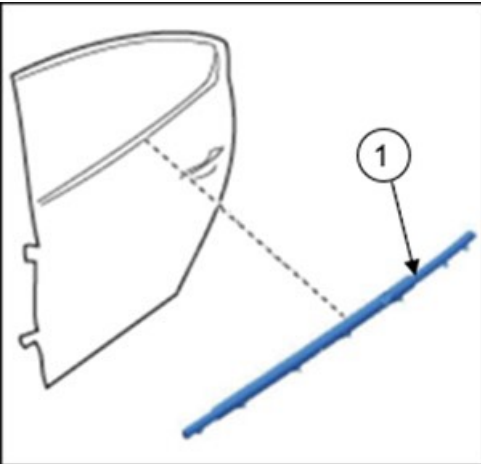


- (1) Grommet
 (2) Screw
 (3) Rear Service Hole Cover No. 1

NOTE: It is unnecessary to remove and replace both sides of the rear beltline moldings (1), although it is a replacement part according to the instructions in MGSS.

- If the rear beltline moldings were accidentally removed, replace them with new ones.

NOTE: The image shows the left side (same as right side).

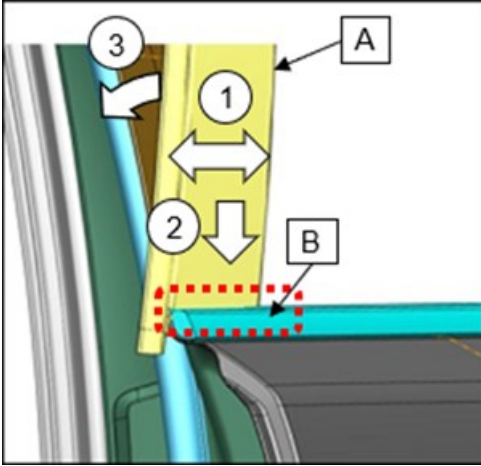


- c. Proceed repairs from "Remove Passenger Side Rear Door Garnish (Front)" to the end of the instructions in MGSS (REAR DOOR GLASS RUN-CHANNEL REMOVAL/INSTALLATION).

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Rear door garnish (front) Installation Note: When installing the rear door garnish (front), refer to the following procedures.

- 1) Remove the double-sided adhesive tape on the door panel using a utility knife.
- 2) Clean and degrease the area where the double-sided adhesive tape was applied.
- 3) Install the modified rear door garnish (front) according to the procedure shown in the image.

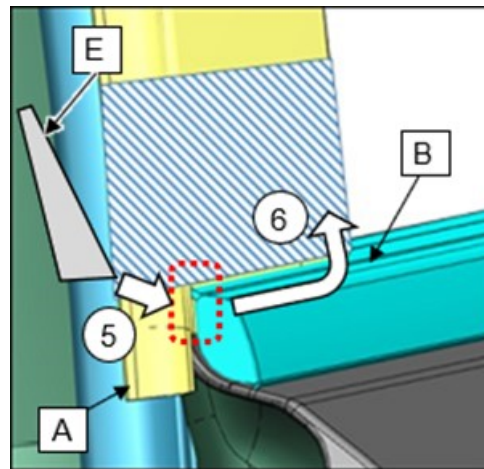
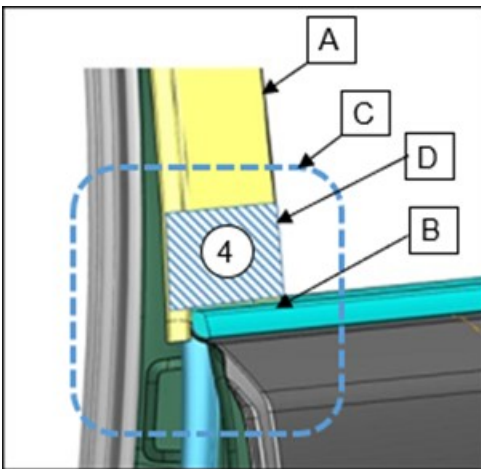


- a) Move the rear door garnish (A) from side to side so that the beltline molding lip (B) in the red frame is not entrapped.
- b) Insert the garnish between the beltline molding and the door panel while moving the garnish from side to side.

NOTE: Be careful not to entrap the lip.

c) Install the garnish to the door panel.

NOTE: Be careful not to entrap the lip.



Detail of C

d) If the beltline molding lip (B) is entrapped, apply a masking tape (D) for procedures of step e and f below.

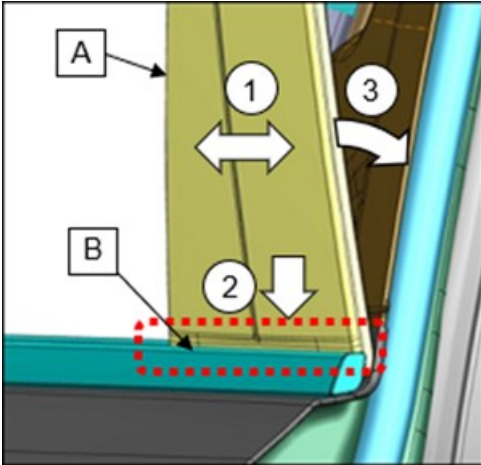
e) Insert a thin plastic spatula (E) into the gap between the lip (B) and the garnish (A).

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f) Slide the spatula (E) sideways slowly to release the entrapped lip.

Rear door garnish (rear) Installation Note: When installing the rear door garnish (rear), refer to the following procedures.

- 1) Remove the double-sided adhesive tape on the door panel using a utility knife.
- 2) Clean and degrease the area where the double-sided adhesive tape was applied.
- 3) Install the rear door garnish (rear) according to the procedure shown in the image.



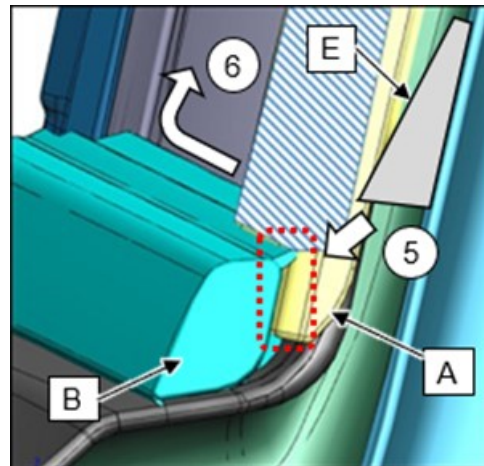
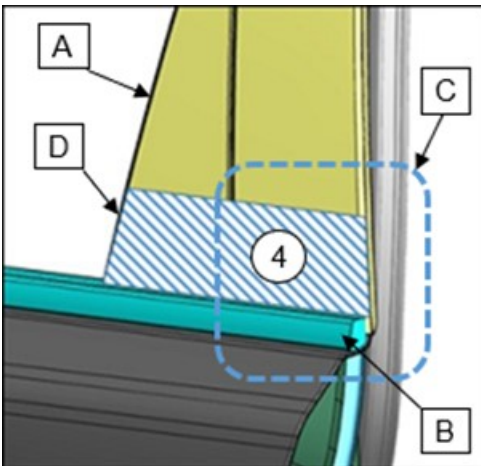
a) Move the rear door garnish (A) from side to side so that the beltline molding lip (B) in the red frame is not entrapped.

b) Insert the garnish (A) between the beltline molding (B) and the door panel while moving the garnish from side to side.

NOTE: Be careful not to entrap the lip.

c) Install the garnish to the door panel.

NOTE: Be careful not to entrap the lip.



Detail of C

d) If the beltline molding lip (B) is entrapped, apply a masking tape (D) for procedures of step e and f

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below.

e) Insert a thin plastic spatula (E) into the gap between the lip (B) and the garnish (A).

f) Slide the spatula sideways slowly to release the entrapped lip.

3. Verify the repair.

PARTS INFORMATION

Parts Number	Description	Qty.	Notes
KMV6-72-60XB	RUN CHANNEL(R),GLASS	1	BRIGHT
KMV6-73-60XB	RUN CHANNEL(L),GLASS	1	BRIGHT
KMV6-50-M30	GARNISH(R),REAR DOOR	1	[R] Black
KMV7-50-M30	GARNISH(R),REAR DOOR	1	[R] Piano Black
KMV6-50-M40	GARNISH(L),REAR DOOR	1	[R] Black
KMV7-50-M40	GARNISH(L),REAR DOOR	1	[R] Piano Black
KMV6-50-M50	GARNISH(R),REAR DOOR	1	[R] Black
KMV7-50-M50	GARNISH(R),REAR DOOR	1	[R] Piano Black
KMV6-50-M60	GARNISH(L),REAR DOOR	1	[R] Black
KMV7-50-M60	GARNISH(L),REAR DOOR	1	[R] Piano Black

[R]: Replacement parts

WARRANTY INFORMATION

NOTE:

- This warranty information applies only to verified customer complaints on vehicles eligible for warranty repair.
- This repair will be covered under Mazda's GHG Emissions Regulation Remote Power Window Operation Defect Warranty.
- Additional diagnostic time cannot be claimed for this repair.

Warranty Type	A
Symptom Code	73
Damage Code	94
Part Number Main Cause	KMV6-72-60XB or KMV6-73-60XB
Quantity	1
Operation Number / Labor Hours:	XXWJAXRX / 1.3 Hrs.

NOTE: Claim other side of glass run-channel and the rear door garnishes (front/rear) as related parts.

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