



Service Bulletin

Bulletin No.: 23-NA-004
Date: January, 2024

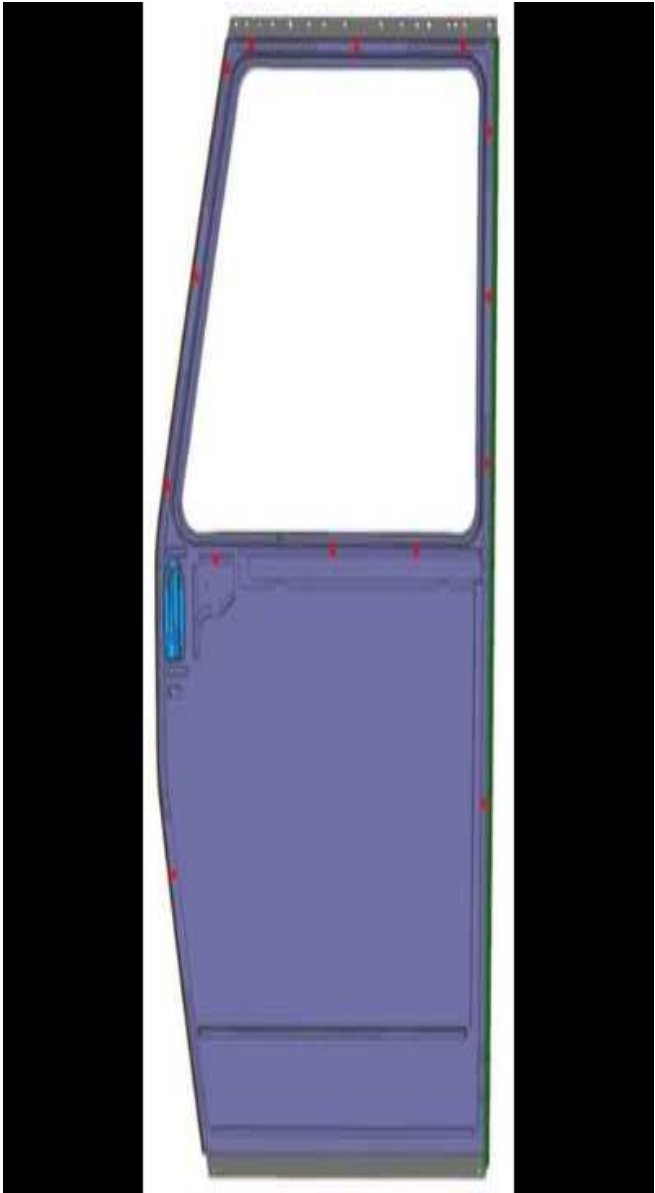
TECHNICAL

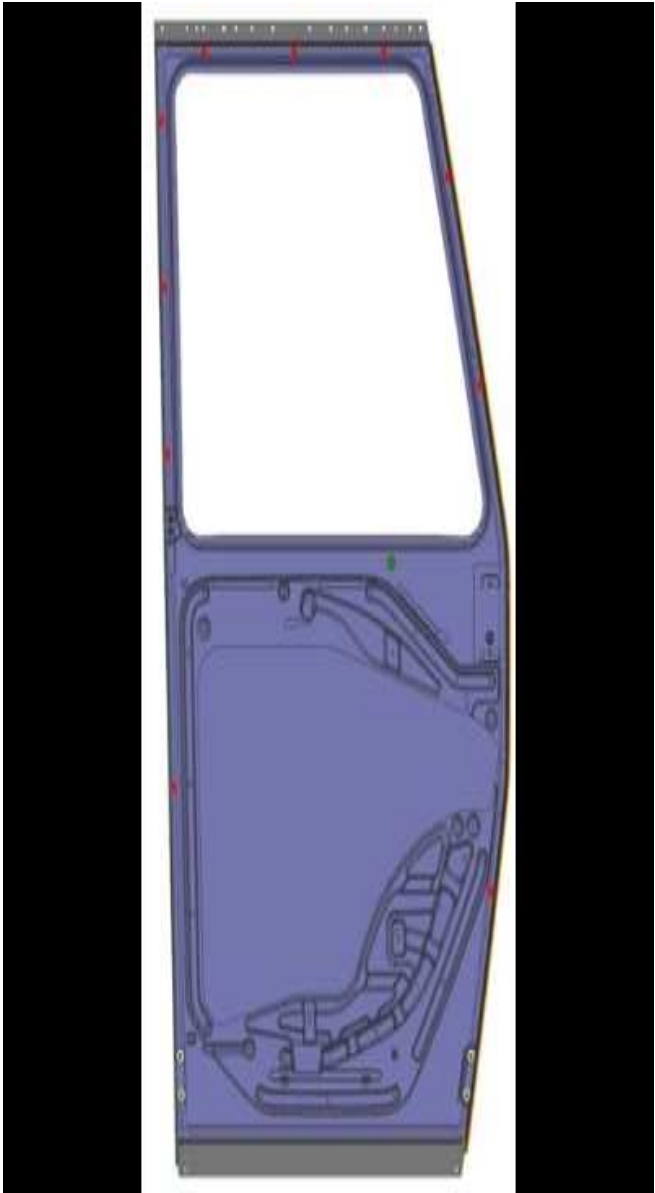
Subject: Front Door Panel Separating

Brand:	Model:	Model Year:		VIN:		Engine:	Transmission:
		from	to	from	to		
BrightDrop	EV600	2022	2022				
	Zevo 600	2023	2023				

Involved Region or Country	North America
Additional Options (RPOs)	
Condition	Some customers may comment that the front (inner or outer) side door panel is separating from the door frame.  6252115

	 6252116
Cause	The causes of the condition may be due to the loss of adhesion of the bonding tape that secures the outer panel to the door frame.
Correction	Upon verifying that the door can be repaired in a manner that will provide the proper appearance and function, Dealers are to resecure the inner and outer door panels using additional fasteners per the steps in the service procedure below. If the damage to the door is determined to be not repairable, the complete door assembly must be replaced per the PN's listed in the GM EPC.

	 Outboard Rivets 6252117
--	--

	 A technical drawing of a vehicle door frame, viewed from the interior. The frame is shown in a light blue/purple color. Red dots indicate the locations of inboard rivets along the top, bottom, and side rails. A green dot is visible on the lower side rail. The drawing is flanked by two vertical black bars.	6252118
	Inboard Rivets	

Service Procedure

Important: Service agents must comply with all International, Federal, State, Provincial, and/or Local laws applicable to the activities it performs under this bulletin, including but not limited to handling, deploying, preparing, classifying, packaging, marking, labeling, and shipping dangerous goods. In the event of a conflict between the procedures set forth in this bulletin and the laws that apply to your dealership, you must follow those applicable laws.

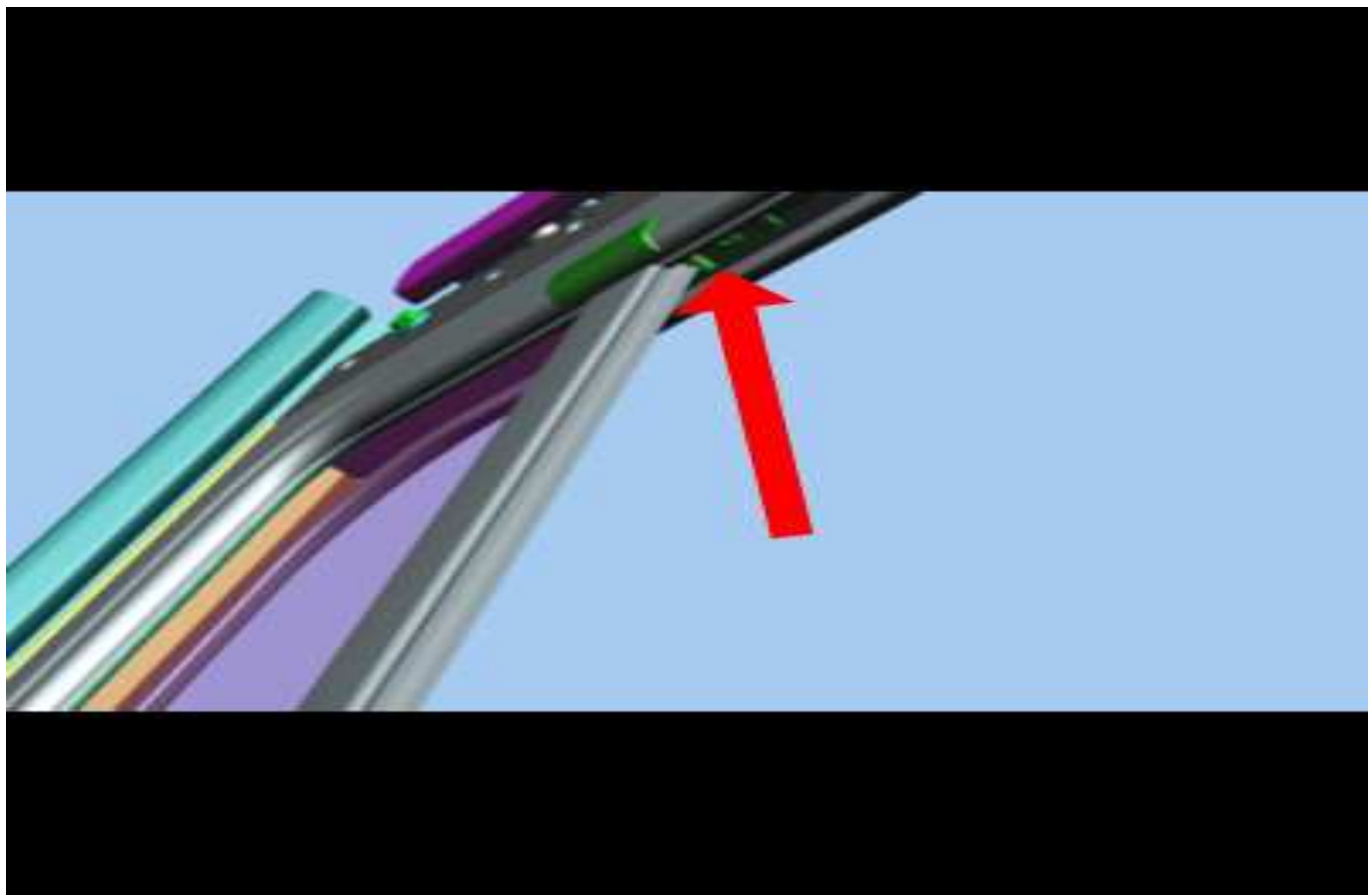
Important: This technical service bulletin (TSB) can only be completed by BrightDrop dealers or BrightDrop certified repair facilities who have met all BrightDrop specific training, tool and equipment requirements. Repairs must be performed by a technician who has successfully completed the required training.

Note: Prior to performing the door repairs, inspect the front side door stationary window for signs of breakage and/or damage. This is most apparent if the door glass has shifted within the frame causing a gap condition. If the front stationary door does not look like it has shifted, it is still necessary to inspect the bracket itself per the procedure below.



6252120

1. Disengage the inner and outer upper weatherstrips at the front side door stationary window and inspect the upper bracket for signs of breakage or damage.



6252121

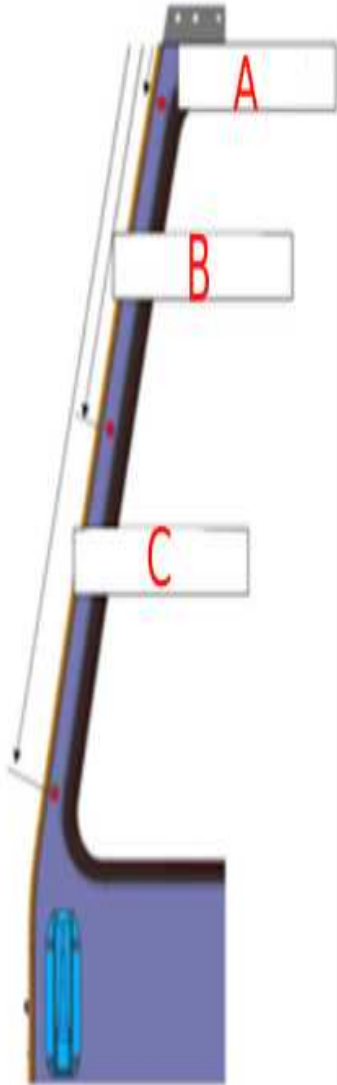


6252122

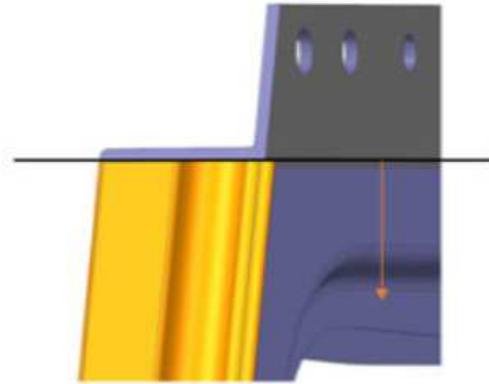
- If the bracket shows any signs of breakage or damage, replace the front side door stationary window. Refer to *Front Side Door Stationary Window Replacement in the Service Manual*.

Outboard Side Repair Procedure

- Remove the affected front side door and place the door on a suitable surface with a protective covering as to not damage/scratch the door panel. Refer to *Front Side Door Replacement in the Service Manual*.

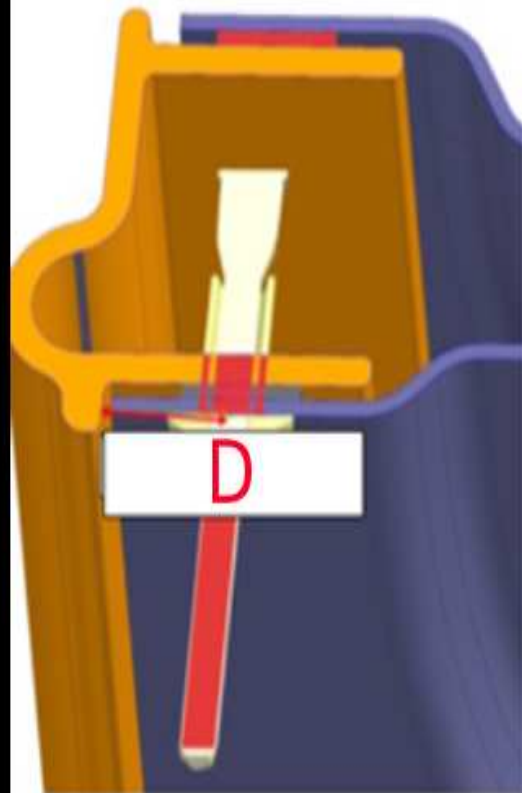


6252123



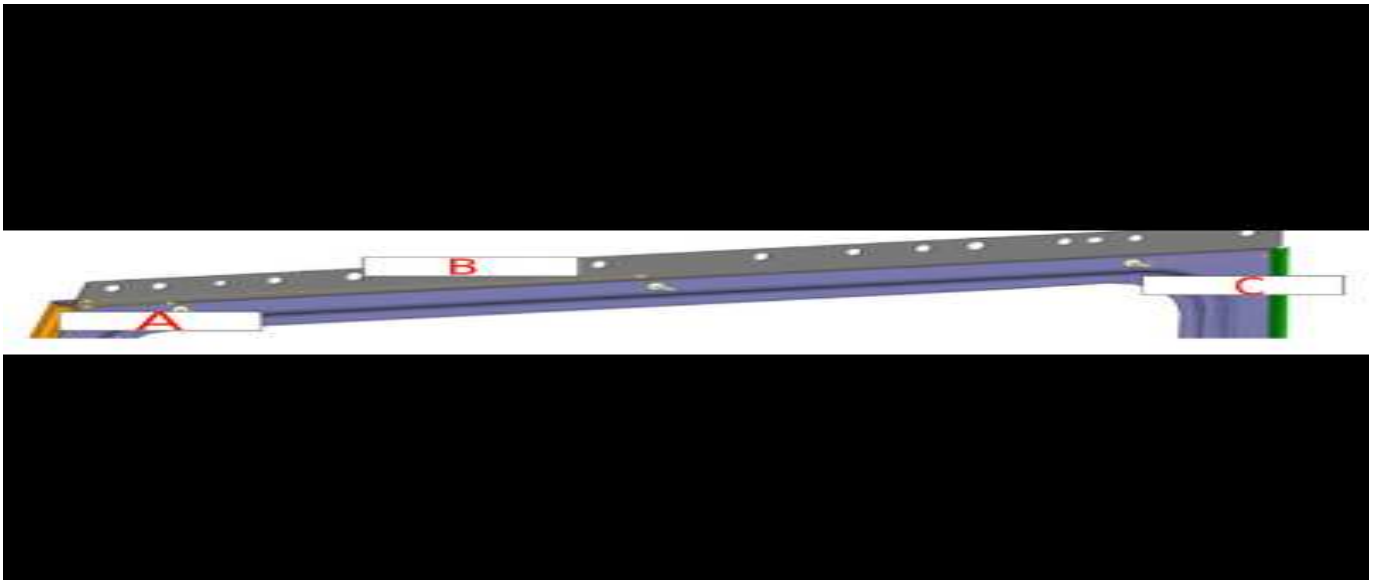
6252124

- Mark the vertical (A, B, C) locations along the left side of the window, A at 54mm (2.12 in), B at 442 mm (17.4 in) the midpoint between the top and bottom, and C at 827 mm (32.56 in).

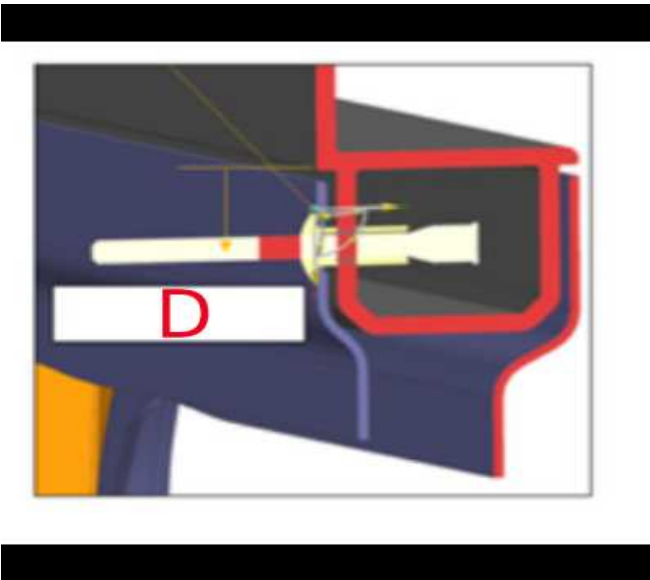


6252125

The locations (D) where the rivets will be installed at 13 mm (0.51 in) from the top.

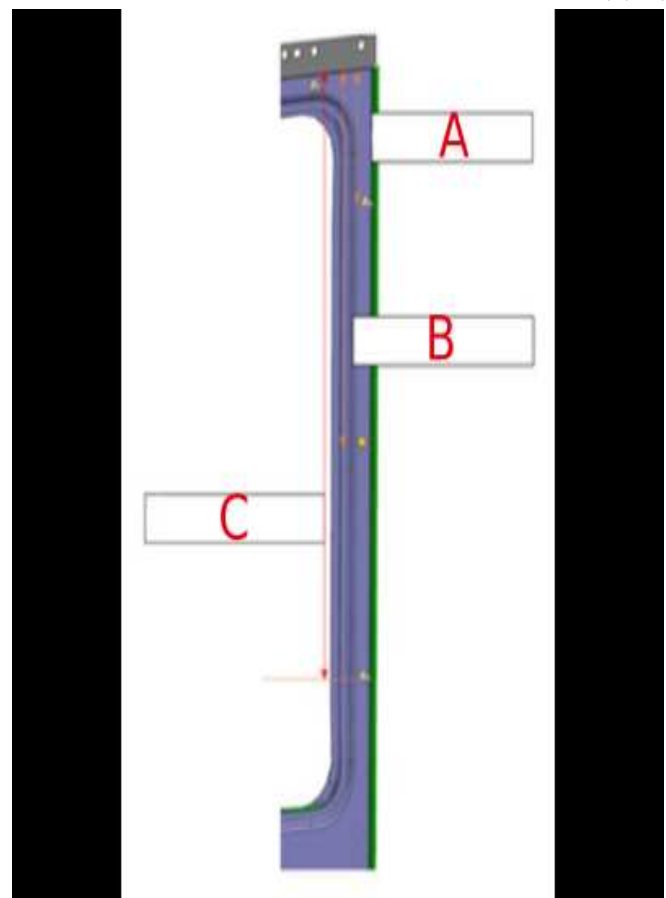


Mark the rivet locations along the top of the door frame A at 80mm (3.2 in) from the left side, B at 434mm (17.09 in) from the left side, and C at 106mm (4.17 in) from the right side.



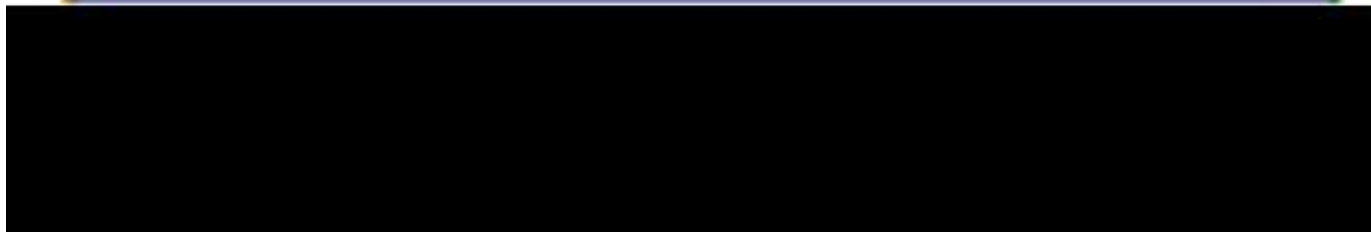
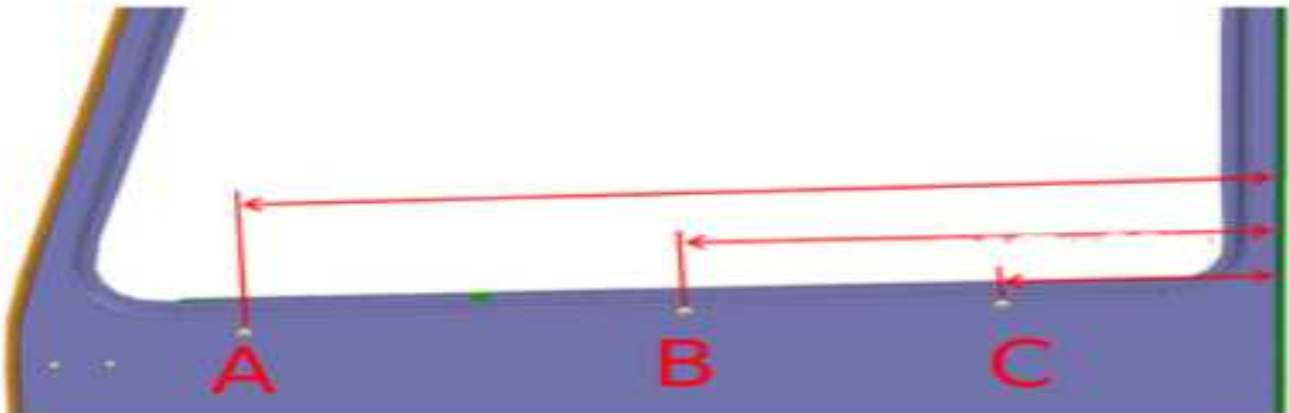
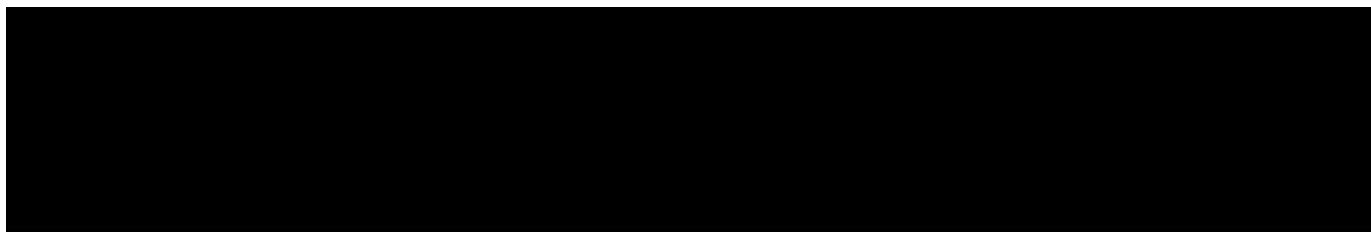
6252128

The rivet locations D should be measured at 13mm (0.51 in) from the top.

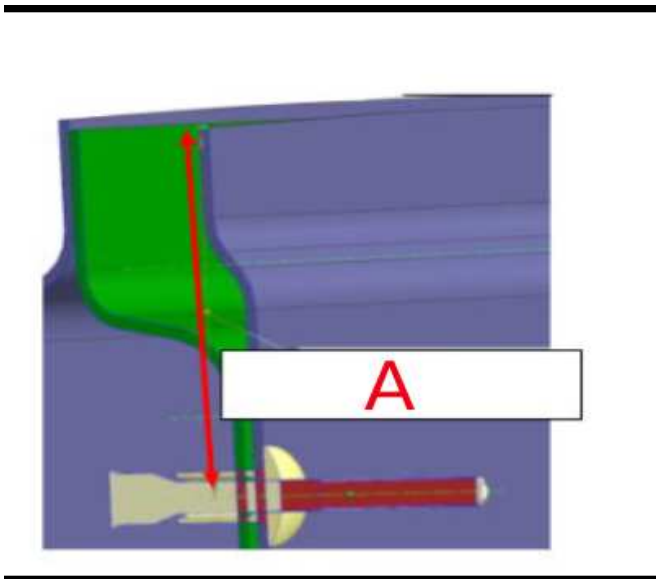


6252129

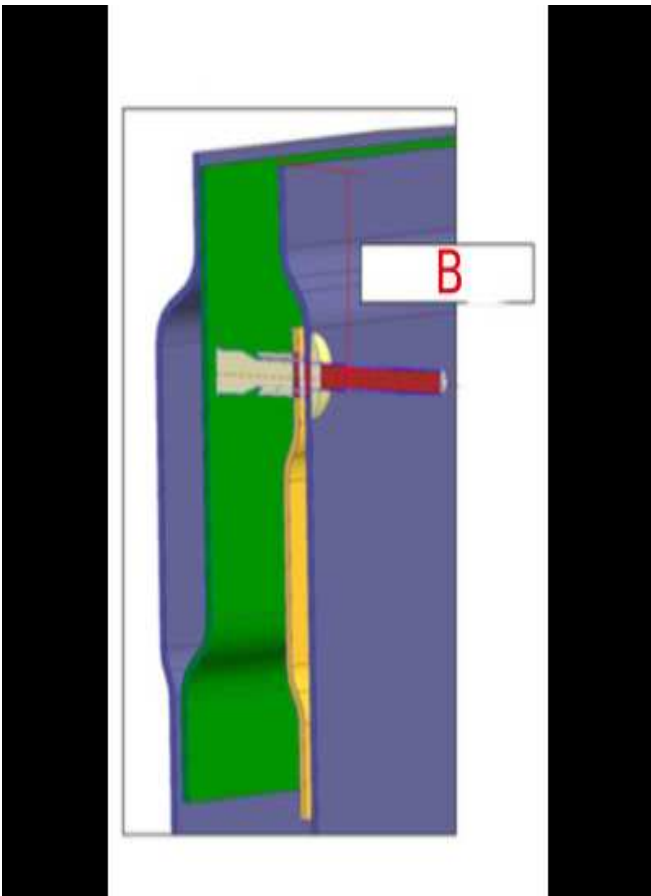
The three rivets on the right side of the window A at 160mm (6.3 in), B at 458mm (18.03 in), and C at 756mm (29.76 in) from the top and 13 mm (0.51 in) from the right side.



6252130

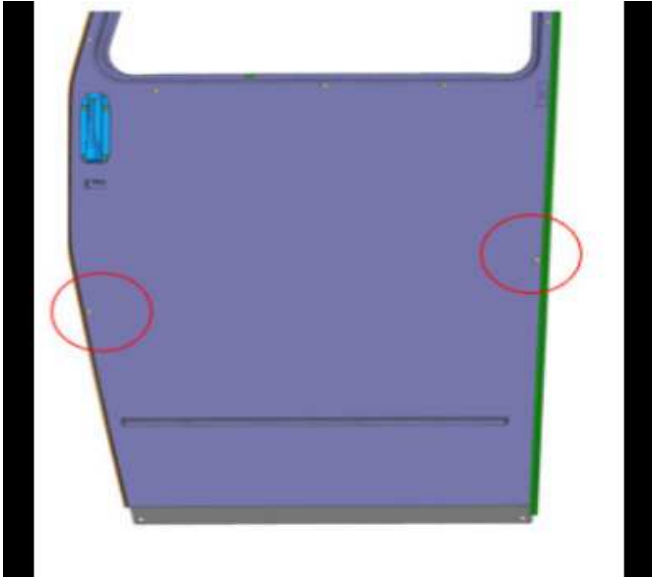


6252131



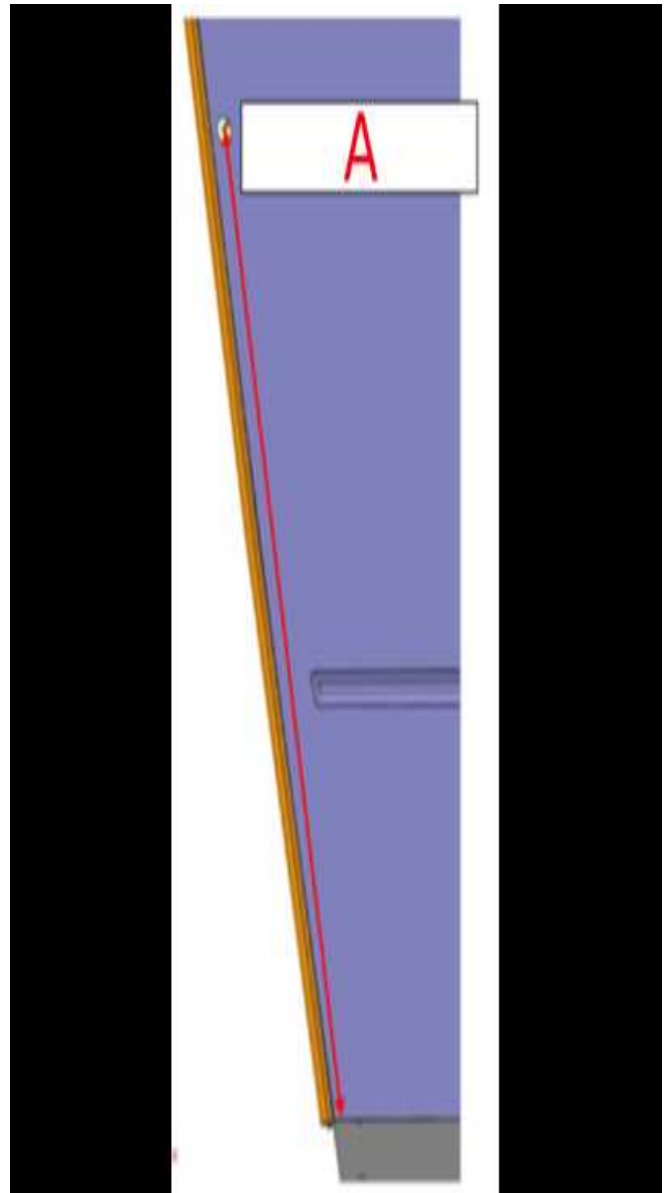
6252132

The three rivets at the bottom of the window frame A at 916mm (36.06 in) and 46mm (1.81 in) from the bottom of the window frame, B at 526mm (20.71 in), and C at 247mm (9.72 in) from the right side and 31mm (1.22 in) from the bottom of the window frame.



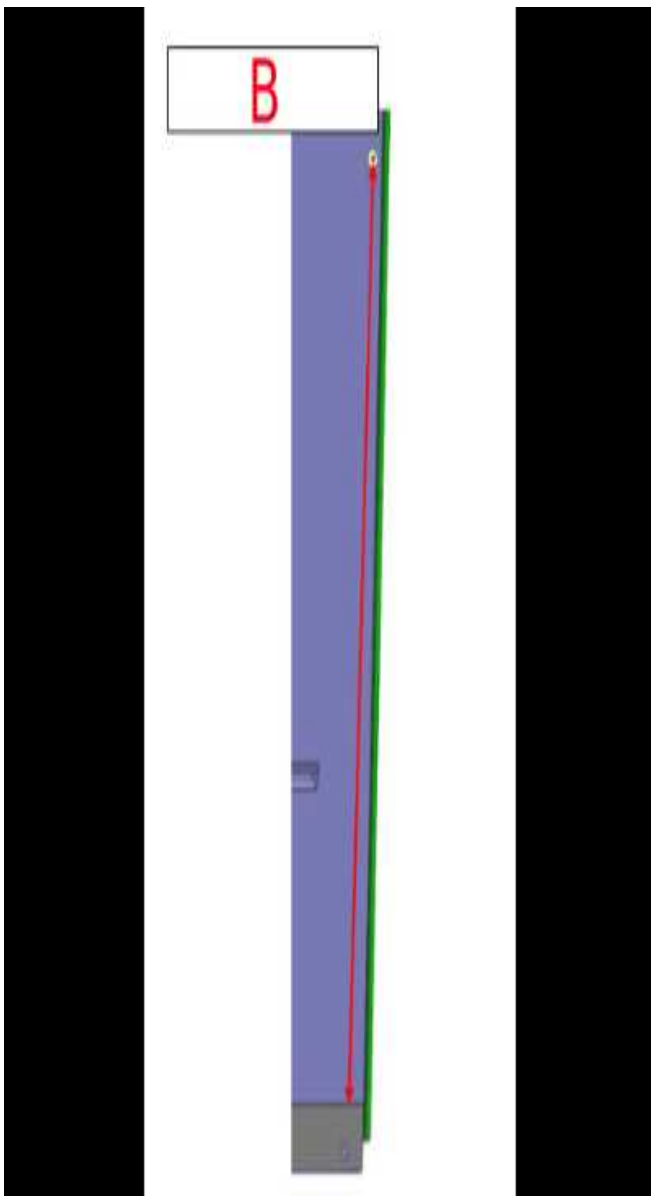
6252133

The two rivet locations in the middle of the door frame.



6252134

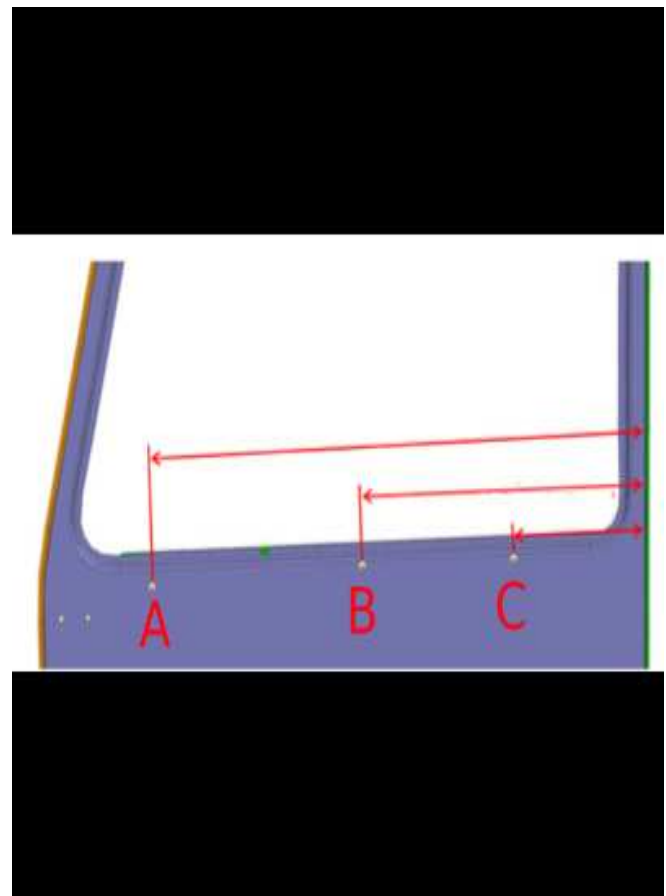
Rivet A is at 507mm (19.96 in) from the bottom and 13mm (0.51 in) from the left side.



6252135

Rivet B at 627mm (24.68 in) from the bottom and 13mm (0.51 in) from the right side.

5. Protect the surface of each location to prevent paint damage during the drilling process.
6. Using a 6.8mm (17/64 in) drill bit set to a depth of 10mm (using a drill stop), drill through the OUTER panel and door frame at each of the fourteen locations.



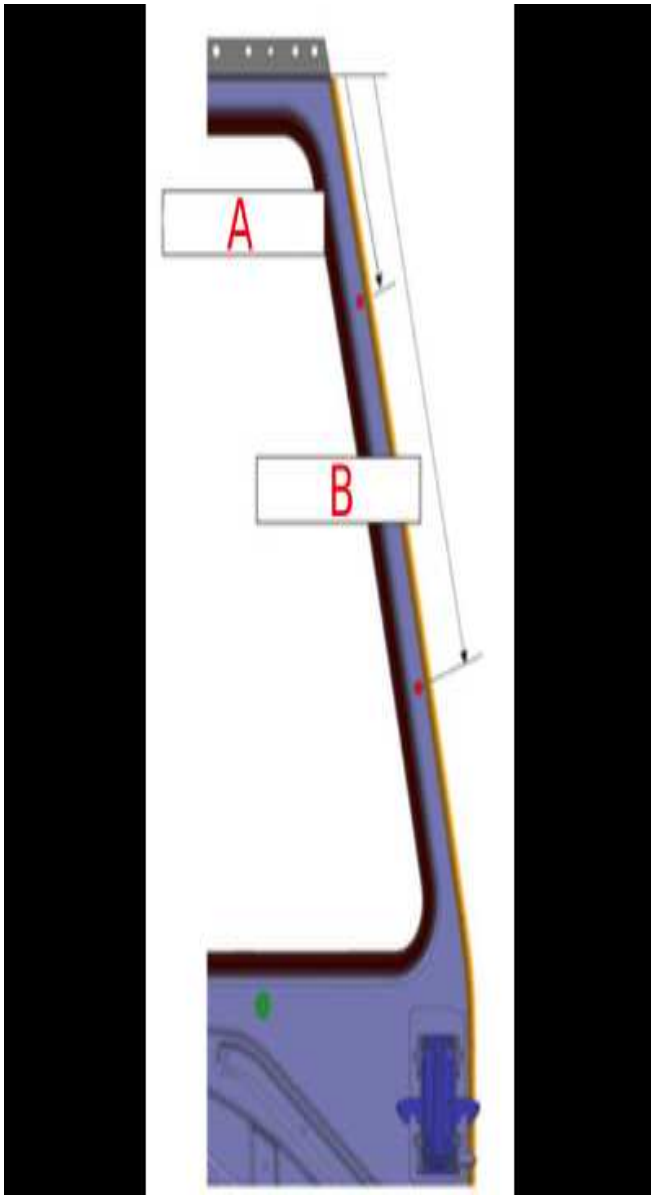
6252255

Note: when attempting to install the rivets at positions 2 and 3, pull outboard on the panel at these rivet locations for additional clearance from the main door glass.

7. Clean the OUTER surface with an alcohol wipe to remove any debris caused by the drilling process.
8. Insert and install a rivet in each of the fourteen OUTER locations.

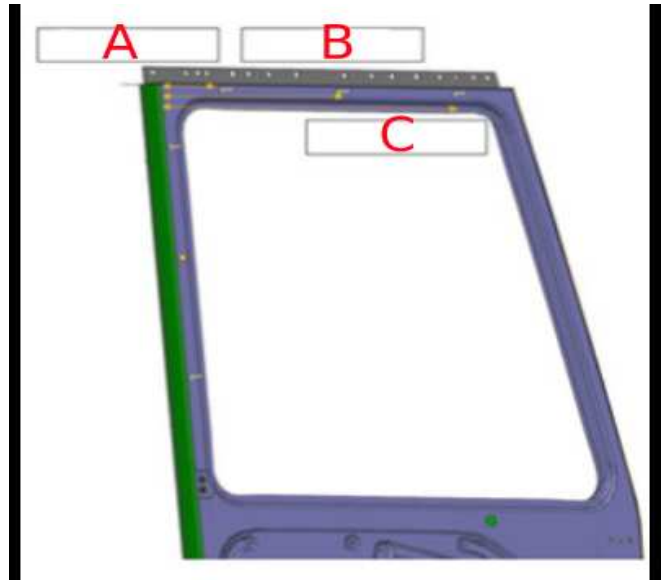
Inboard Side Repair Procedure

9. Turn the door over to access the inboard side of the door.



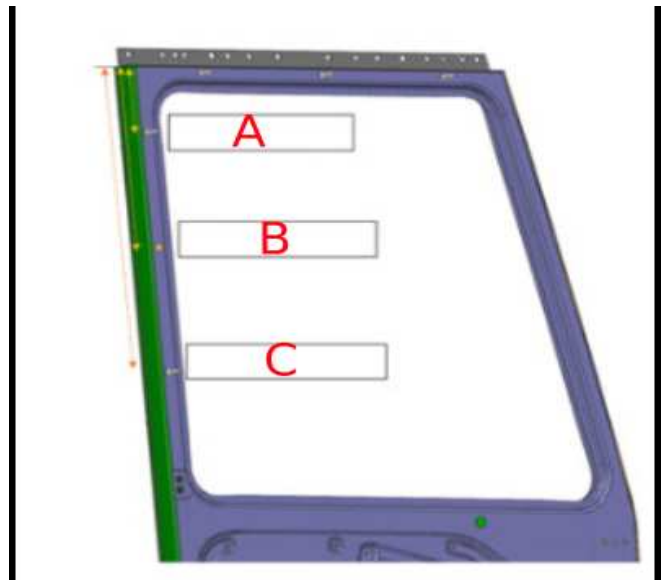
6252256

10. Mark the two locations from the top A at 250mm (9.84 in) and B at 640mm (25.2 in) and 13mm (0.51 in) from the outside.

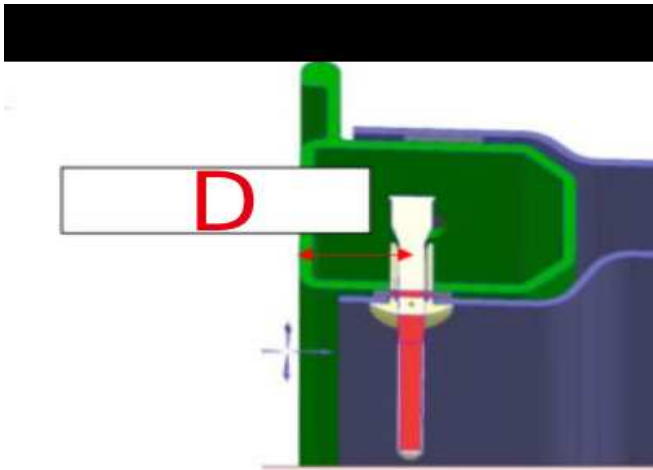


6252257

Measuring along the top from the left side mark A at 138mm (5.43 in), B at 437mm (17.2 in), and C at 737mm (29.02 in) from the left side and 17mm (0.70 in) from the top.

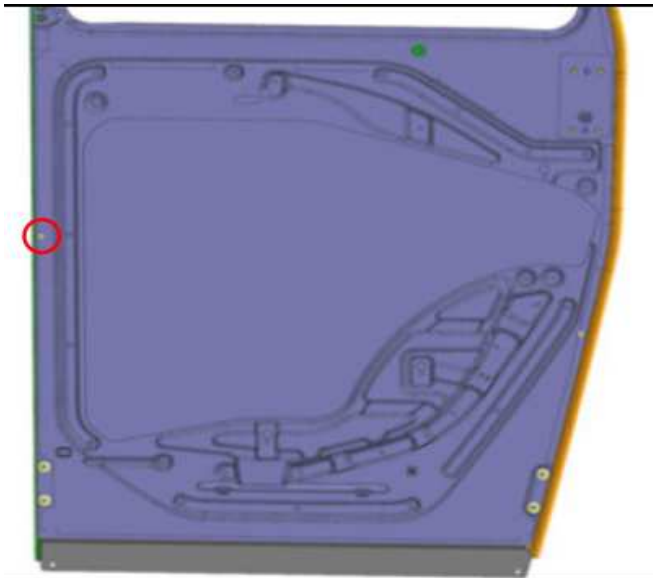


6252258

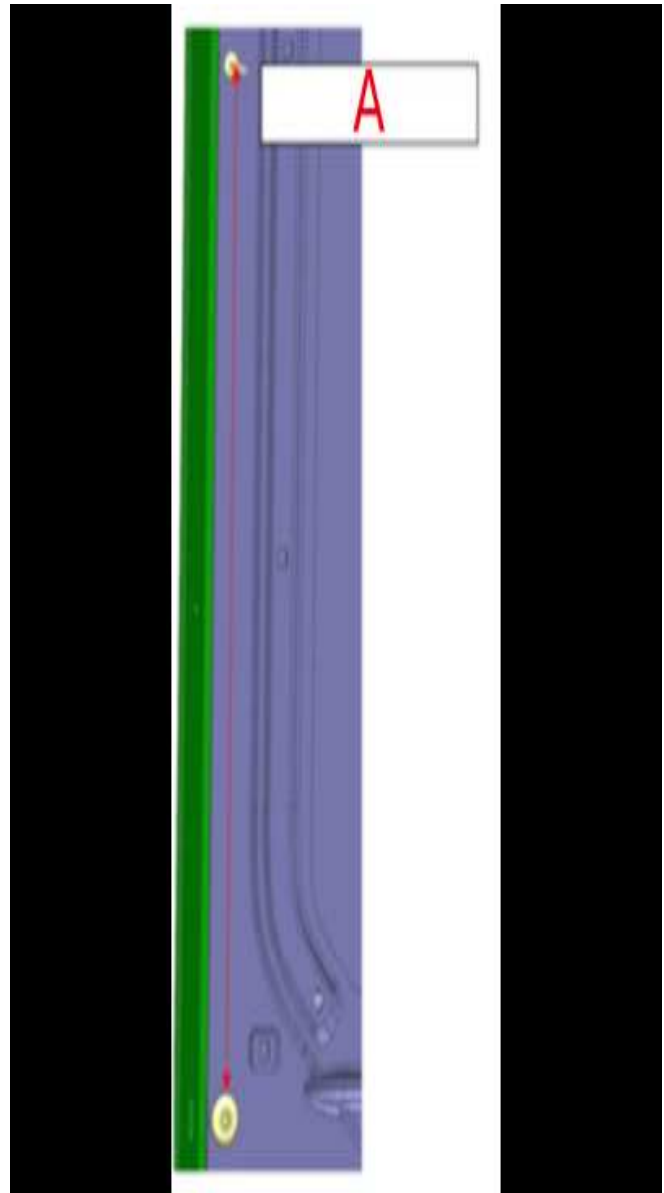


6252259

Mark the vertical locations on the left side starting from the top A at 138mm (5.43 in), B at 437mm (17.20 in), and C at 737mm (29.02 in) from the top at D 17mm (0.70 in) from the outside.

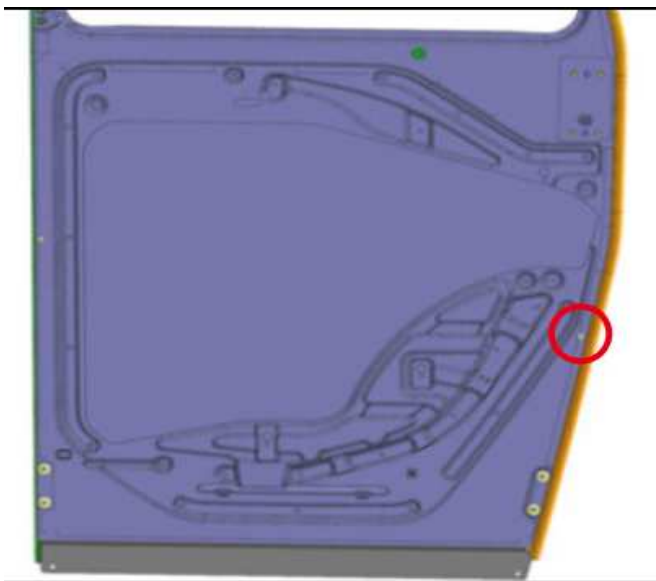


6252260

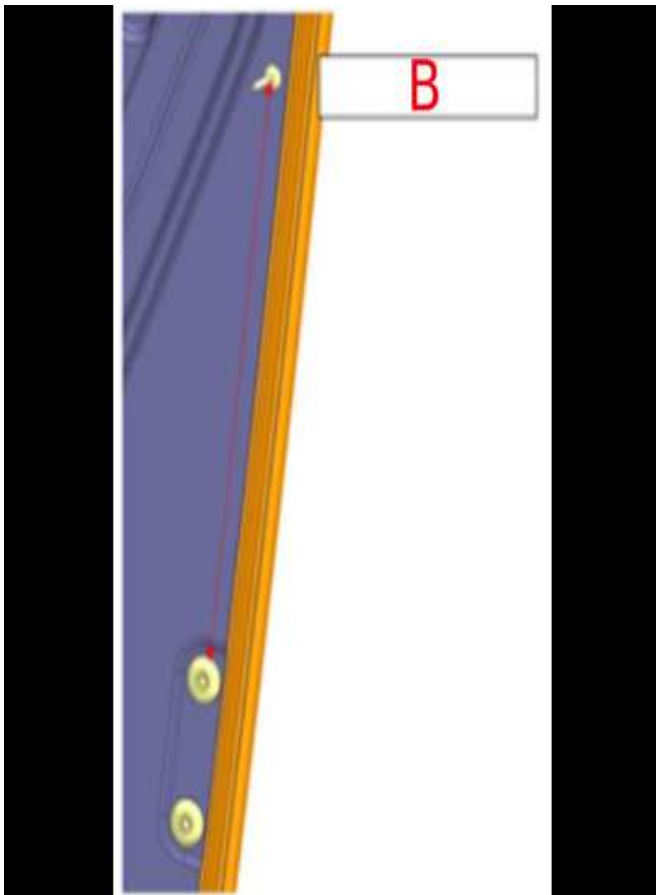


6252261

Mark the lower rivet location on the left side, measuring from the lower bolt at the bottom of the door A at 472mm (18.58 in) 17mm (0.7 in) from the outside.



6252262



6252263

- Mark the lower rivet location along the right side, measuring from the lower bolt mark B at 290mm (11.42 in) and 13mm (0.51 in) from the outside.
- 11. Protect the surface of each location to prevent paint damage during the drilling process.
 - 12. Using a 6.8mm (17/64 in) drill bit set to a depth of 10mm (using a drill stop), drill through INNER panel and door frame at each of the ten locations.
 - 13. Clean the surface with an alcohol wipe to remove any debris caused by the drilling process.
 - 14. Insert and install a rivet in each of the ten INNER locations.
 - 15. Install the affected side door. Refer to *Front Side Door Replacement in the Service Manual*.

Parts Information

Causal Part	Description	Part Number	Qty
X	RIVET,DOME, 0.25 SHANK DIA, 0.548 LENGTH, 0.5 OD, AA 5058, PL	09442978	24
X	WINDOW-FRT S/ D STA (RH)	85637662	1
X	WINDOW-FRT S/ D STA (LH)	85637661	1

Warranty Information

For vehicles repaired under the Bumper-to-Bumper coverage (Canada Base Warranty coverage), use the following Labor Operation. Reference the Applicable Warranties section of Investigate Vehicle History (IVH) for coverage information:

Labor Operation	Description	Labor Time
*2086608	Front Door Panel Repair	2.0 hr
Add	Replace Front Stationary Window	0.3 hr
*This is a unique Labor Operation for Bulletin use only.		

Version	3
Modified	Released April 14, 2023 Revised May 18, 2023 – Updating Part Numbers under the Parts Information Section. Revised January 09, 2024 - Added the 2023 BrightDrop Zevo 600.

