



Technical Service Bulletin

GROUP CAMPAIGN	NUMBER 24-01-029H
DATE MAY 2024	MODEL(S) SANTA FE (MX5A)

SUBJECT: REAR FIXED SUNROOF GLASS REPLACEMENT
(SERVICE CAMPAIGN TBS)

*** IMPORTANT**

Dealers must perform this service campaign on all affected vehicles prior to customer retail delivery and whenever an affected vehicle is in the shop for any maintenance or repair.

Access the "Vehicle Information" screen via WebDCS to identify open campaigns.


Description: This bulletin describes the procedure to replace the rear fixed sunroof glass on certain 2024MY Santa Fe (MX5A) vehicles equipped with the dual-pane sunroof, due to an incorrect primer applied on the glass.



Applicable Vehicles (Certain):

- 2024MY Santa Fe (MX5A) vehicles equipped with the dual-pane sunroof produced from 01/04/2024 – 02/02/2024

Parts Information:

Model	Part Name	Part Number	Figure	Qty
Santa Fe (MX5a)	Rear Sunroof Glass	81640-P6100QQH		1

Circulate To: General Manager, Service Manager, Parts Manager, Warranty Manager, Service Advisors, Technicians, Body Shop Manager, Fleet Repair

Recommended Equipment/Supplies:

Name	Equipment/Supply #	Figure	Remarks
Advanced Cure Auto Glass Urethane Adhesive	BETASEAL Express		Brand: DOW
All-in-One Primer	BETAPRIME 5504G		

NOTE: These equipment/supplies will be provided by the glass sublet company (or their own equivalent).

Warranty Information:

Model	Op. Code	Operation	Op. Time	Casual Part	Nature Code	Cause Code
Santa Fe (MX5A)	40DA01R0	Removal & Re-installation of Rear Sunroof Mechanism & Admin Time	2.6 M/H	81640-P6100	B1B	ZZ7

NOTE 1: Submit 2 or 3 claims as needed:

1. Submit one claim as Campaign from the op code table listed above. The Campaign claim will include reimbursement of the following:
 - Removal & re-installation of rear sunroof mechanism
 - Administrative time
 - New rear sunroof glass (QTY: 1)
2. Submit the 2nd claim as Warranty using the same repair order as the Campaign claim. Include all sublet items under op code 81640AZZ with the following information:

Repair Order	OP Code	Sublet Code	Nature Code	Cause Code	Causal Part
Same as Campaign claim	81640AZZ	G1	B1B	ZZ7	81640-P6100

- Labor for rear sunroof glass removal/replacement
 - Labor for rear sunroof glass preparation
 - Any miscellaneous materials for repair (sealant, primer shop supplies, etc.)
3. If a rental is needed, use the same repair order as the Campaign claim and submit as a separate claim.

NOTE 2: If a part is found in need of replacement while performing this campaign and the affected part is still under warranty, submit a separate claim using the same repair order. If the affected part is out of warranty, submit a Prior Approval request for goodwill consideration prior to performing the work.

NOTE 3: Dealer will need to attach sublet invoice of glass replacement upon submission of Campaign claim.

NOTE 4: Damage that occurs to the sunroof glass due to improper repair procedures is **not** covered under normal warranty.

NOTICE

Replacement procedure of the rear fixed sunroof glass is to be performed by a third party vendor, such as a reputable automotive glass company. Dealer is not to perform glass replacement.

Service Procedure:

Remove head lining and rear sunroof mechanism assembly



Sublet rear sunroof glass replacement



Reassemble in reverse order

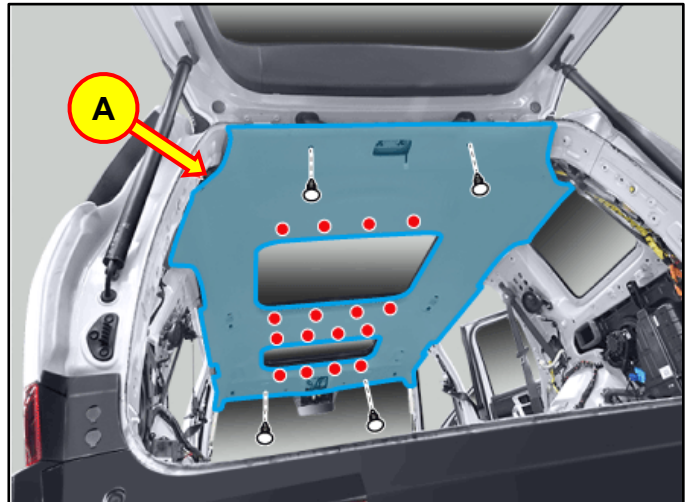
1. Remove the head lining (A).

Refer to Shop Manual:

- **Body (Interior / Exterior / Electrical) > Roof Trim > Roof Trim Assembly > Removal and Installation**

NOTICE

Replace any damaged clips and add new foam tape underneath all clips to reduce the possibility of noise after reinstallation.



2. Remove the rear sunroof mechanism (B).

Refer to Shop Manual:

- **Body (Interior / Exterior / Electrical) > Sunroof > Sunroof Mechanism Assembly > Removal > Rear**

i Information

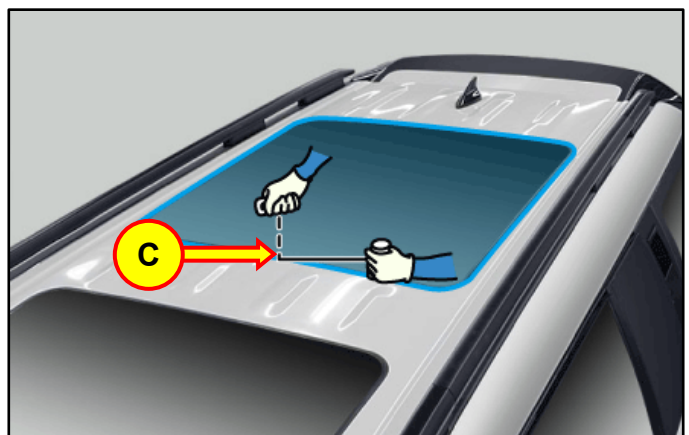
Dealer will perform steps 1-2 and 15-16. Sublet company will perform steps 3-14.



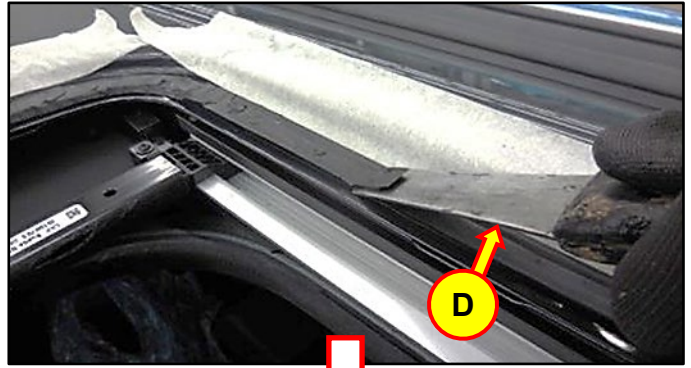
3. Sublet the vehicle to an automotive glass company to remove the rear fixed sunroof glass following appropriate glass work procedures (C).

Refer to Shop Manual:

- **Body (Interior / Exterior / Electrical) > Sunroof > Sunroof Glass > Removal > Sunroof Glass (Rear)**



4. Remove any remaining urethane (sealant) from the roof body panel using a urethane scraper tool (D).



5. Remove any debris/contamination from the roof body panel and wipe it clean.
6. Apply primer to the roof body panel on top of where the urethane was previously applied (E).

NOTICE

Allow time for the primer to dry per the manufacturer's instructions.

Be careful not to contaminate the primer application area while it is drying.



7. Use a glass cleaner and lint-free cloth to clean the new rear sunroof glass surface.

8. Apply primer to the new rear sunroof glass surface (F).

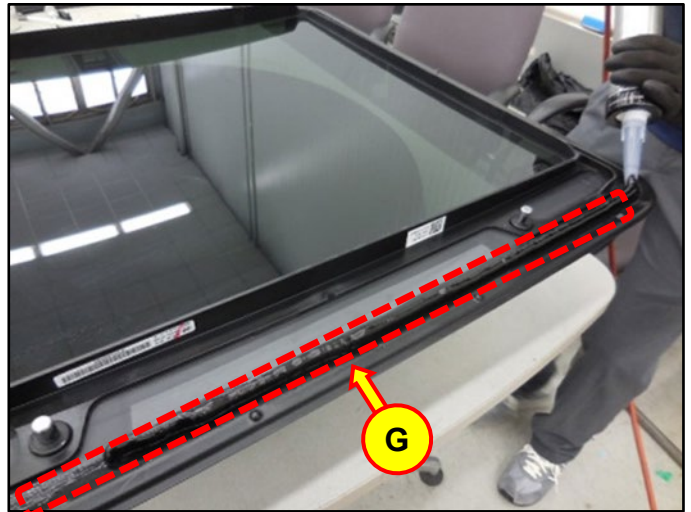
NOTICE

Allow time for the primer to dry per the manufacturer's instructions.

Be careful not to contaminate the primer application area while it is drying.



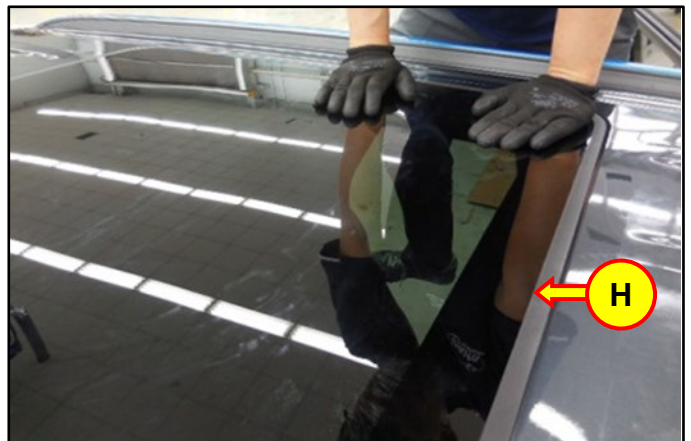
9. Use a power caulk gun to apply a continuous and uniform urethane bead (G) on the new rear sunroof glass where the primer was applied.



10. Install the new rear sunroof glass (H).

Refer to Shop Manual:

- **Body (Interior / Exterior / Electrical) > Sunroof > Sunroof Glass > Installation > Sunroof Glass (Rear)**



11. Inspect for any gaps between the rear sunroof glass and roof body panel.

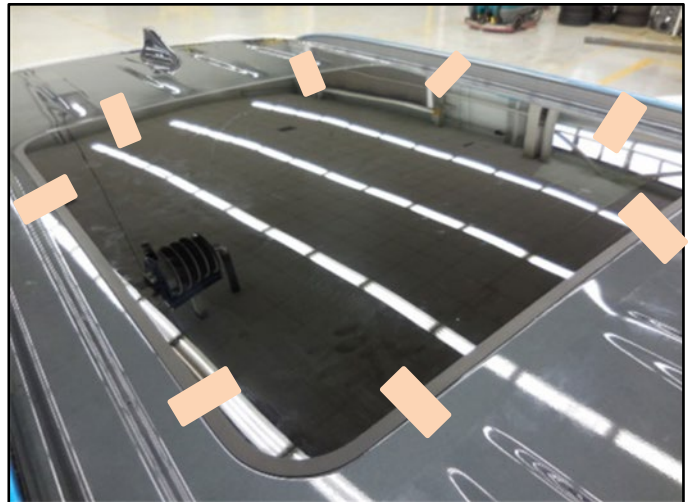
If any gaps are found, adjust the glass to close the gap(s).

12. Inspect the rear sunroof glass guide (G) for any damage.

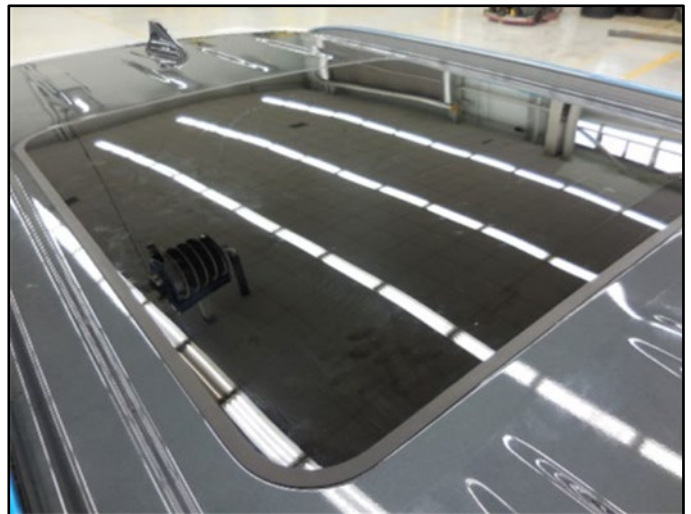


13. Attach masking tape to the rear sunroof glass as shown to secure it in place while the urethane cures.

Wait for the urethane to cure for an hour per the manufacturer's specifications before moving the vehicle.



14. Remove the tape and clean the surrounding roof body panel area.



15. Reinstall all parts in the reverse order of removal.
16. The service procedure is now complete.