



HYUNDAI

Technical Service Bulletin

GROUP	NUMBER
ENGINE MECHANICAL	25-EM-003H
DATE	MODEL(S)
APRIL 2025	ELANTRA (CN7)

SUBJECT: INTEGRATED THERMAL MANAGEMENT (ITM) MODULE
HEAT EXCHANGE PORT REPLACEMENT


This TSB supersedes 24-EM-011H to expand the range of production dates, update the warranty information, and add a notice for torque fastening on pages 1-2.

Description: Certain 2024MY Elantra (CN7) vehicles may produce a coolant leak from the Heat Exchange Port on the Integrated Thermal Management (ITM) Module assembly. Follow the procedure outlined in this TSB to replace the Heat Exchange Port at the ITM assembly.

Applicable Vehicles:

- 2024MY Elantra (CN7) vehicles equipped with 2.0L engine and produced from 08/07/2023 – 04/17/2024 (VINs starting with 'KMH')

Parts Information:

Part Name	Part Number	Figure	Remarks
ITM Service Kit (25690 - 2J299QQH)	25695-2J299		Heat Exchange Port Assembly QTY: 1
	25696-2J299		Teflon Gasket QTY: 1
	25623-2J200		ITM Housing Gasket QTY: 1
	25697-2J299		Funnel QTY: 1
	25698-2J299		Coolant Recovery Container QTY: 1
	25699-2J299		Insulation Cap QTY: 1
Pink Coolant	00232-19098		1 gallon can treat up to 14 vehicles. (Used due to minimal loss of coolant during ITM removal)

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

SUBJECT:INTEGRATED THERMAL MANAGEMENT (ITM) MODULE HEAT
EXCHANGE PORT REPLACEMENT**Warranty Information:**

Model	Op. Code	Operation	Op. Time	Causal Part	Nature Code	Cause Code
Elantra (CN7)	40D015R3	ITM Module Heat Exchange Port Replacement	1.5 M/H	25600-2J300	L31	ZZ4

NOTE 1: Submit claim on Claim Entry Screen as “Campaign” type.

NOTE 2: Take a picture of the warrantable defect. Op times include VIN, Mileage, and Repair justification photo(s) as outlined in the Digital Documentation Policy.

NOTE 3: The incident parts are subject to callback through the normal Warranty Technical Center (WTC) parts return process. **Claim is subject to debit if the part is not returned.**

NOTE 4: If a part is found in need of replacement while performing this TSB 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 5: Use of coolant in the amount of \$3.00 will be reimbursed as sublet under the above OP code.

Service Procedure:**DIGITAL DOCUMENTATION**

This TSB includes repair justification photos. Refer to the latest Warranty Digital Documentation Policy for requirements.

NOTICE

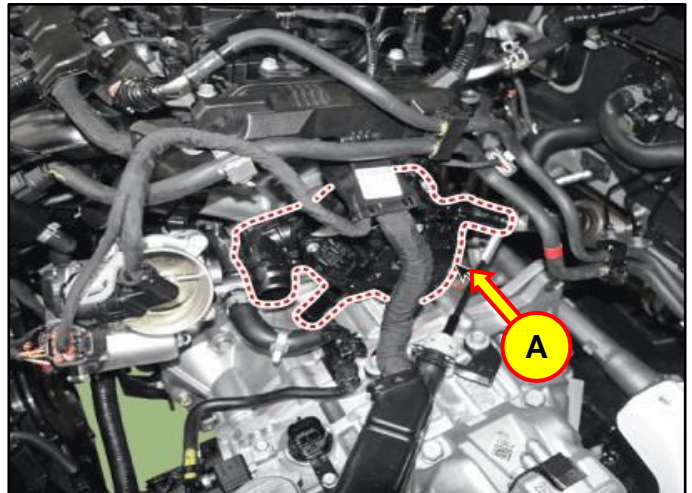
Applying the recommended torque to all fasteners is essential to reduce potential issues from occurring after the service procedure.

Integrated Thermal Management (ITM) Module Removal

1. Remove the Integrated Thermal Management (ITM) Module (A).

Refer to shop manual:

- **Engine Mechanical System > Cooling System > Integrated Thermal Management Module (ITM) > Repair Procedures**


i Information

Use the supplied funnel and coolant recovery container when draining the coolant to avoid contamination. The coolant will be reused.

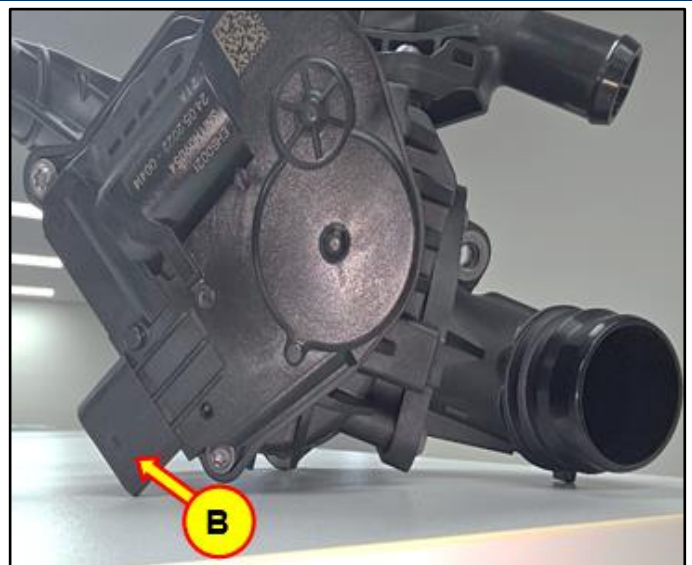
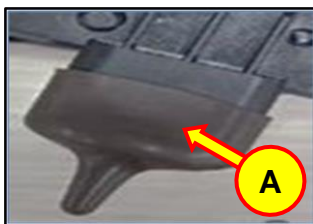


Heat Exchange Port Replacement

1. Install the supplied insulation cap (A) to the ITM actuator connector (B).

i Information

Remove the cap after replacement of the heat exchange port.

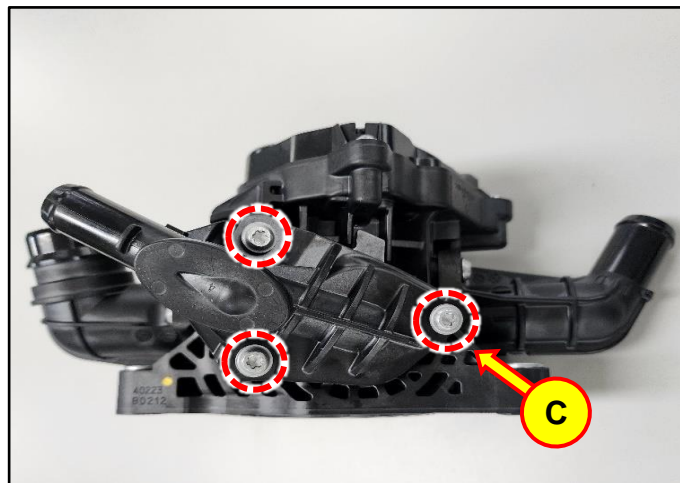


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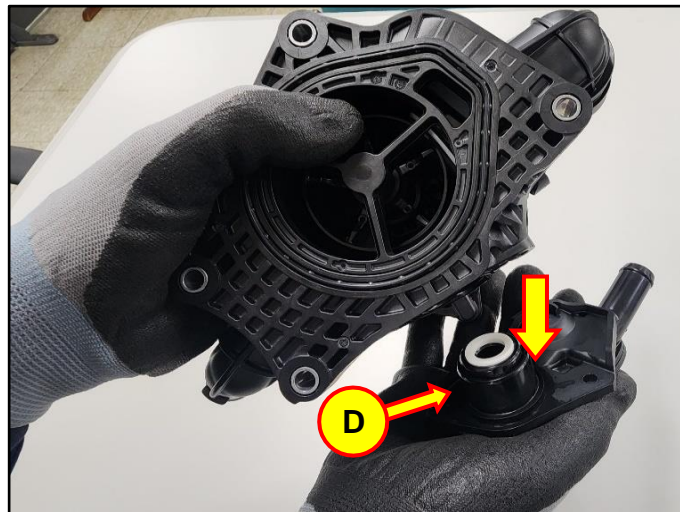
2. Loosen and remove the fixing screw bolts from the heat exchange port (C).

Tightening Torque:

lb-ft	4.4
lb-in	53
N.m	5.9



3. Position the heat exchange port (D) downward and carefully detach it from the housing.

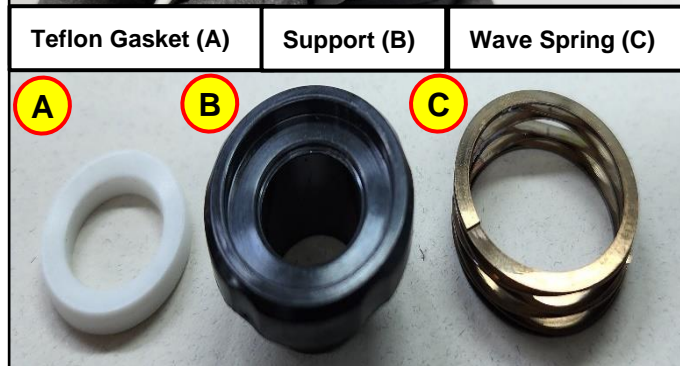
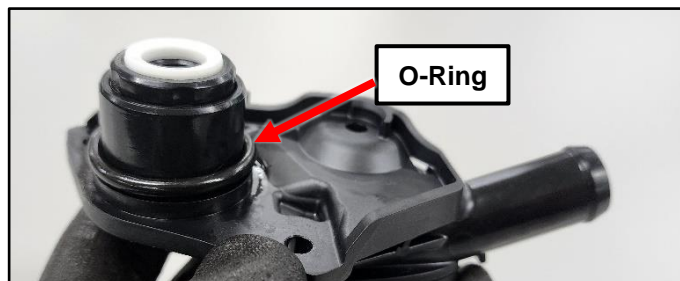


4. Remove parts in this order:
A. Teflon gasket
B. Support
C. Wave Spring

**Information**

Reused parts: Support & Wave Spring
Replaced parts: Teflon Gasket & Heat Exchange Port (O-ring Included)

***Ensure the marking on the Teflon gasket is facing downward when reinstalling.**

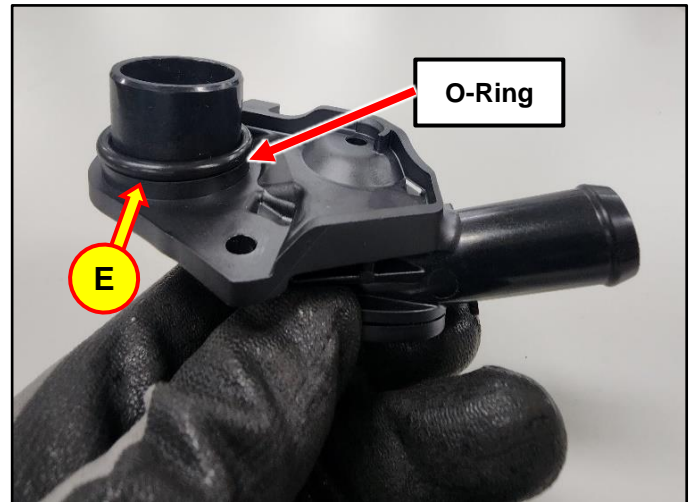


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5. Reinstall parts in this order:
- C. Wave Spring
 - B. Support
 - A. Teflon Gasket

NOTICE

When installing the O-ring (E) onto the ITM housing, coat the entire O-ring with coolant.

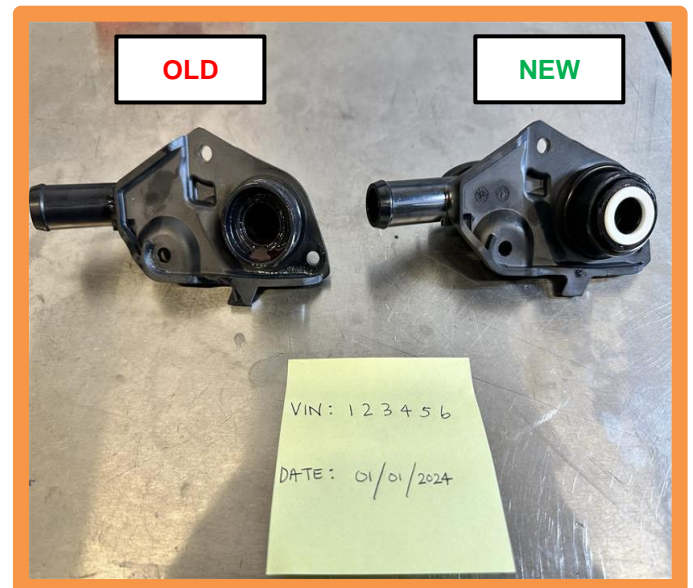


6.

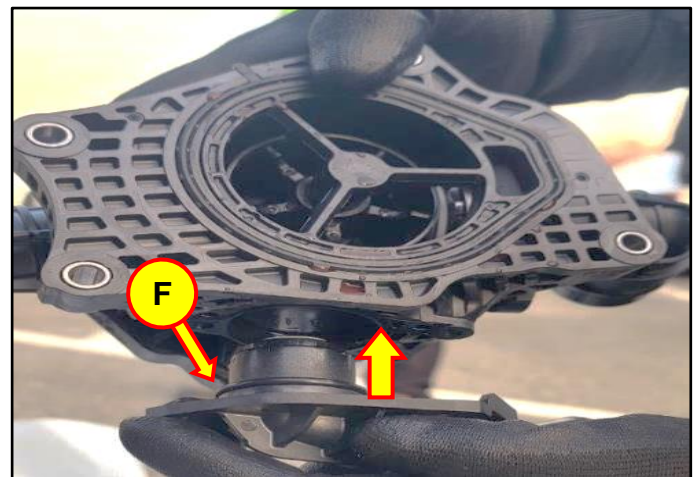
DIGITAL DOCUMENTATION

Using STUI, take a photo of the New and Old Heat Exchange Ports (side-by-side) with the last 6 digits of the VIN and the date of repair on a piece of paper.

Upload the photo to STUI.



7. Reinstall the heat exchange port to the ITM housing (F).

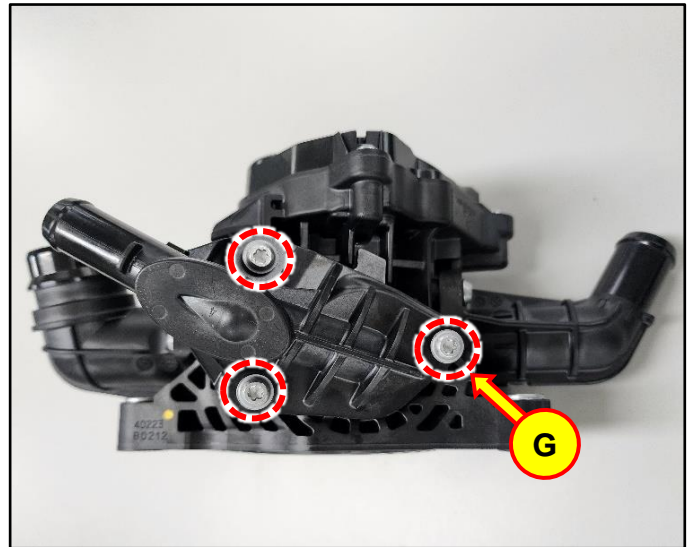


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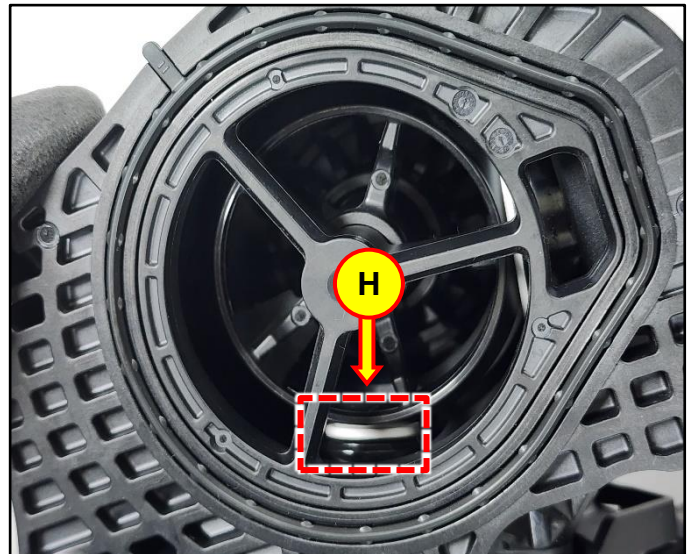
8. Reinstall the fixing screw bolts (G) into the heat exchange port.

Tightening Torque:

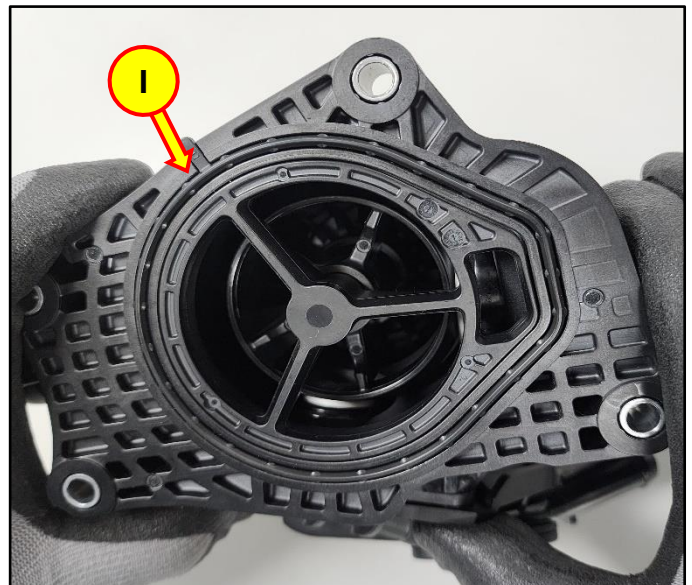
lb-ft	4.4
lb-in	53
N.m	5.9



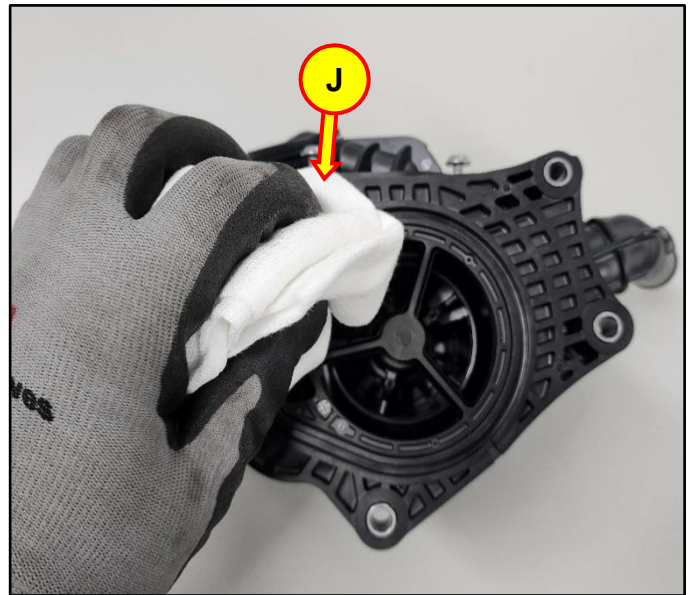
9. Verify the Teflon gasket (H) is properly fitted.



10. Remove the ITM housing gasket (I).



11. Wipe off the excess coolant from the ITM housing with a shop rag or towel (J).



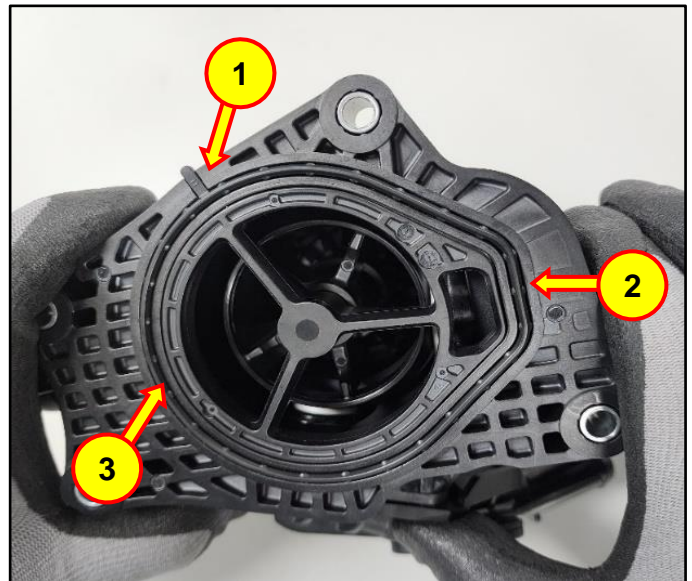
12. Reinstall the supplied ITM housing gasket from the service kit in the order as shown in the picture.



Information

Always use a new ITM rubber gasket.

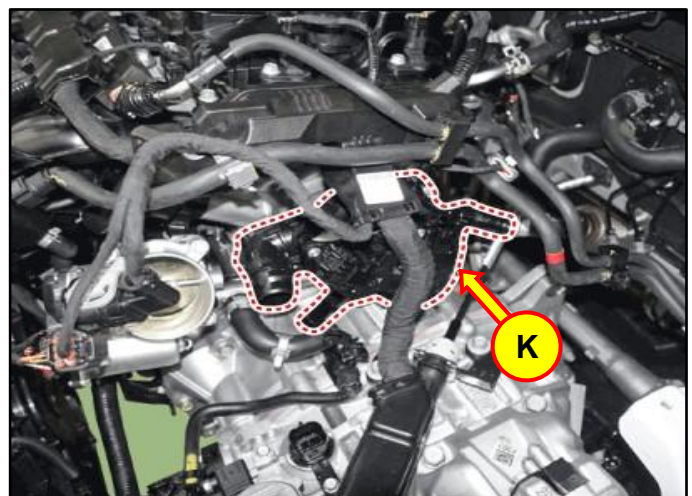
Ensure that the ITM housing gasket is properly installed and pushed into the grooves of the ITM housing.



13. Reinstall the ITM (K).

Tightening Torque:

lb-ft	5.1
lb-in	61
N.m	6.9



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14. Install remaining components in reverse order of removal.
15. Fill the engine coolant with the previously drained coolant, adding new coolant as necessary.

Refer to shop manual:

- **Engine Mechanical System > Cooling System > Coolant > Repair procedures**

16. Start the engine and check for coolant leakage.
17. Adjust coolant level as necessary up to the **FULL** line.

NOTICE

Be sure to follow the ITM Coolant Filling Mode procedure. Failure to do so may result in air pockets and overheating of the engine.

* [Integrated flow control valve (ITM) coolant filling]	
This function opens up the coolant flow path in the engine with ITM and helps fill coolant.	
*[CONDITION]	
1. IG ON	
2. Transmission position P / Parking brake ON	
3. Vehicle speed 0km/h (0 mile/h)	
4. Coolant temperature is 90°C or under	
[OK] Button : Current coolant temperature check	
[Cancel] Button : Optional function completed	

18. The service procedure is now complete.