



# TECHNICAL SERVICE BULLETIN

## Whistle/Humming Noise At Highway Speeds From Right Side Of The Instrument Panel - Climate Control System In Recirculation Mode

**25-2485**

16 October  
2025

### Model:

<b>Ford</b> 2025 Expedition	Built on or before 28-Jul-2025
<b>Lincoln</b> 2025 Navigator	Built on or before 28-Jul-2025

**Markets:** North American markets only

**Issue:** Some of the vehicles listed in the Model statement above may exhibit a whistle/humming noise from the right side of the instrument panel when the climate control system is in recirculation mode and driving at highway speeds. This may be due to an air leak through the air inlet housing.

**Action:** For vehicles that meet all of the criteria in the Issue and Model statements, follow the Service Procedure to seal the air inlet housing.

### Parts

Service Part Number	Claim Quantity	Package Order Quantity	Number in Package	Description	Note
164-R9343	1	1	1	Rotunda Felt Tape	Rotunda Part Number

### Parts - Parts To Inspect And Replace Only If Necessary

Service Part Number	Claim Quantity	Package Order Quantity	Number in Package	Description
SL1Z-19A618-A	Only If Necessary (Up to 1)	Only If Necessary (Up to 1)	1	Air Inlet Housing
SL1Z-18D654-A	Only If Necessary (Up to 1 Kit)	Only If Necessary (Up to 1 Kit)	1	Air Inlet Housing Case Screw (M4)
HL3Z-19B596-A	Only If Necessary (Up to 1)	Only If Necessary (Up to 1)	1	O-Ring Kit
W714409-S439	Only If Necessary (Up to 1)	Only If Necessary (Up to 1)	4	Screws (M8X32MM)
VC-13-G	Only If Necessary	Only If Necessary		Motorcraft® Yellow Concentrated Antifreeze/Coolant (All Markets Except Canada)
CVC-13-G	Only If Necessary	Only If Necessary		Motorcraft® Yellow Concentrated Antifreeze/Coolant (Canada Only)

Service part numbers and "number in package" quantity may change after publication, thus also affecting the "package order quantity". Refer to the parts catalog for the latest information.

**Claim Quantity** refers to the total number of individual pieces required to repair the vehicle.

**Package Order Quantity** refers to the amount of the service part number package(s) required to repair the vehicle.

**Number In Package** refers to the number of individual pieces included in a service part number package, also known as unit of issue (UOI).

**Only If Necessary** indicates the part is not mandatory. Refer to the Service Procedure to determine the inspection/inclusion criteria.

**Warranty Status:** Eligible under provisions of New Vehicle Limited Warranty (NVLW)/Service Part Warranty (SPW)/Service Part New Vehicle (SPNV)/Extended Service Plan (ESP) coverage. Limits/policies/prior approvals are not altered by a TSB. NVLW/SPW/SPNV/ESP coverage limits are determined by the identified causal part and verified using the OASIS part coverage tool.

### Labor Times

Description	Operation No.	Time
2025 Expedition/Navigator: Install Tape Road Test To Verify Repair (Pass)	252485A	0.7 Hrs.
2025 Expedition: Install Tape Road Test To Verify Repair (Fail) Replace The Air Inlet Housing	252485B	4.4 Hrs.
2025 Navigator: Install Tape Road Test To Verify Repair (Fail) Replace The Air Inlet Housing	252485C	4.8 Hrs.

### Repair/Claim Coding

Causal Part:	19A618
Condition Code:	02

### Service Procedure

1. Connect a battery charger such as Rotunda GRX-3590 or DCA-8000 to the 12-volt battery.

**NOTE: To prevent the battery saver mode from activating on the vehicle, make sure the negative cable of the charger is installed on a chassis or engine ground, and not the 12-volt battery negative terminal. Make sure only the 12-volt battery charger is installed.**

2. Remove the cabin air filter. Refer to WSM, Section 412-00.

**NOTE: Prevent dust, debris, or dropped items into exposed areas during the procedure.**

3. Turn the ignition KOEO.

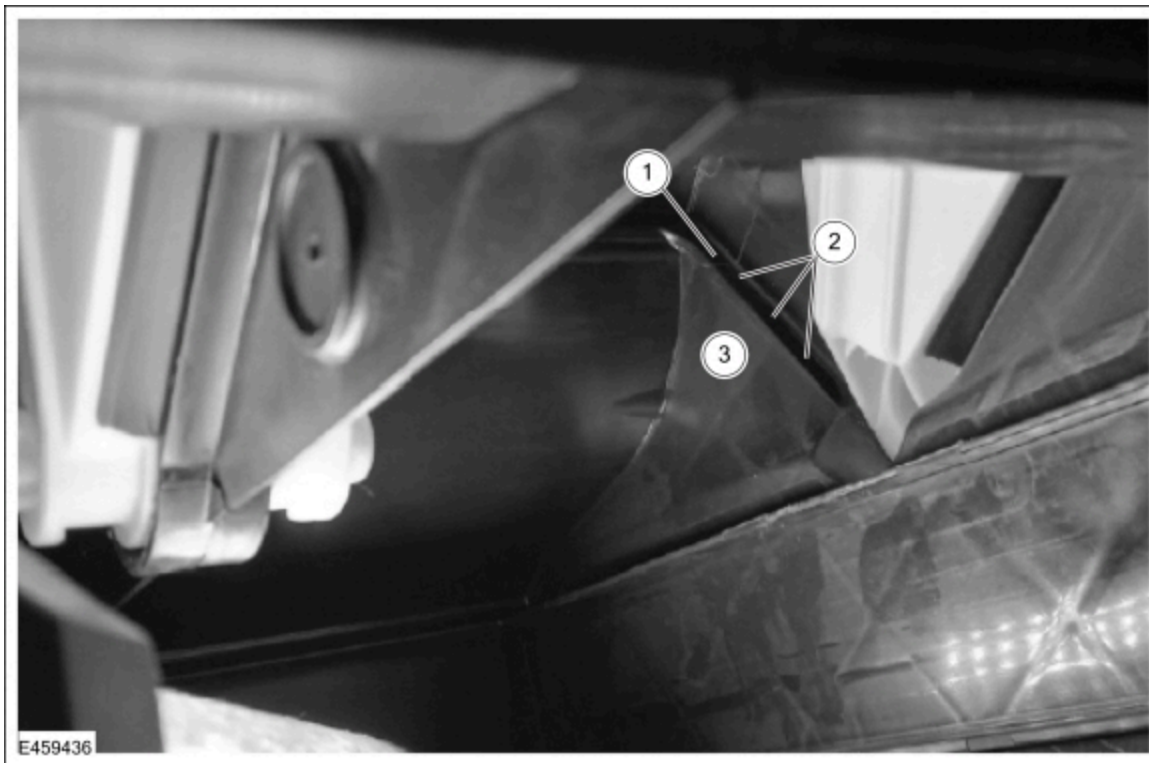
4. Use the latest software version of the FDRS to place the HVAC module PID (RECIRC\_DPOS = -HVAC) to the 0% value.

 **CAUTION: Failure to apply the 3M™ tape correctly (as shown in Figure 3) may result in an insufficient repair.**

5. Apply 3M™ tape onto the air inlet housing.

(1). Clean the 3M™ tape application area on the air inlet housing using a small lint free cloth (Figure 1)

Figure 3



(2). Cut one, 34 mm (1.3 inch) length of 3M™ tape.

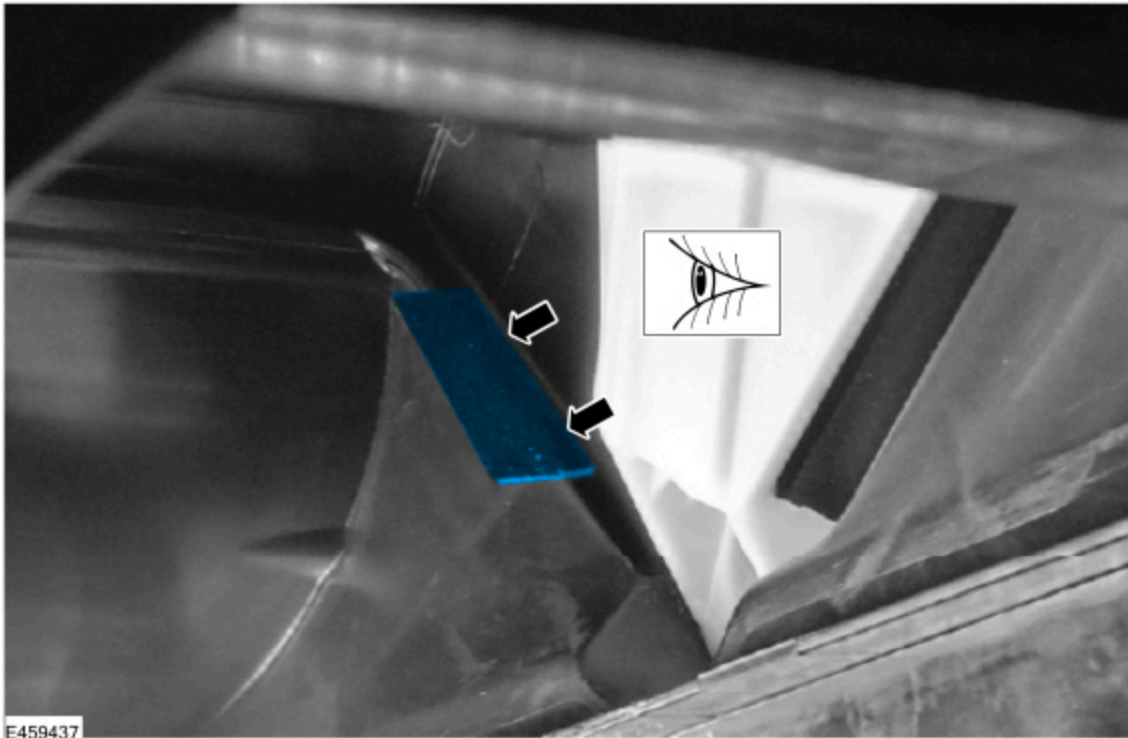
(3). Place a small flashlight into the left section of the air inlet housing to brightly illuminate the right side of the housing. (Figure 1, call out 3)

(4). Insert a hand into the air inlet housing and locate the upper plastic ridge on the housing (Figure 1, Callout 1). This ridge will be the starting point for the tape application during the next step.

(5). Remove the plastic backing from the 3M™ tape and apply it starting at the upper plastic ridge (Figure 1, Callout 1), all the way down the full length of the tape (Figure 1, Callout 2). Do not let the 3M™ tape ride up the vertical surface located to the right of this area.

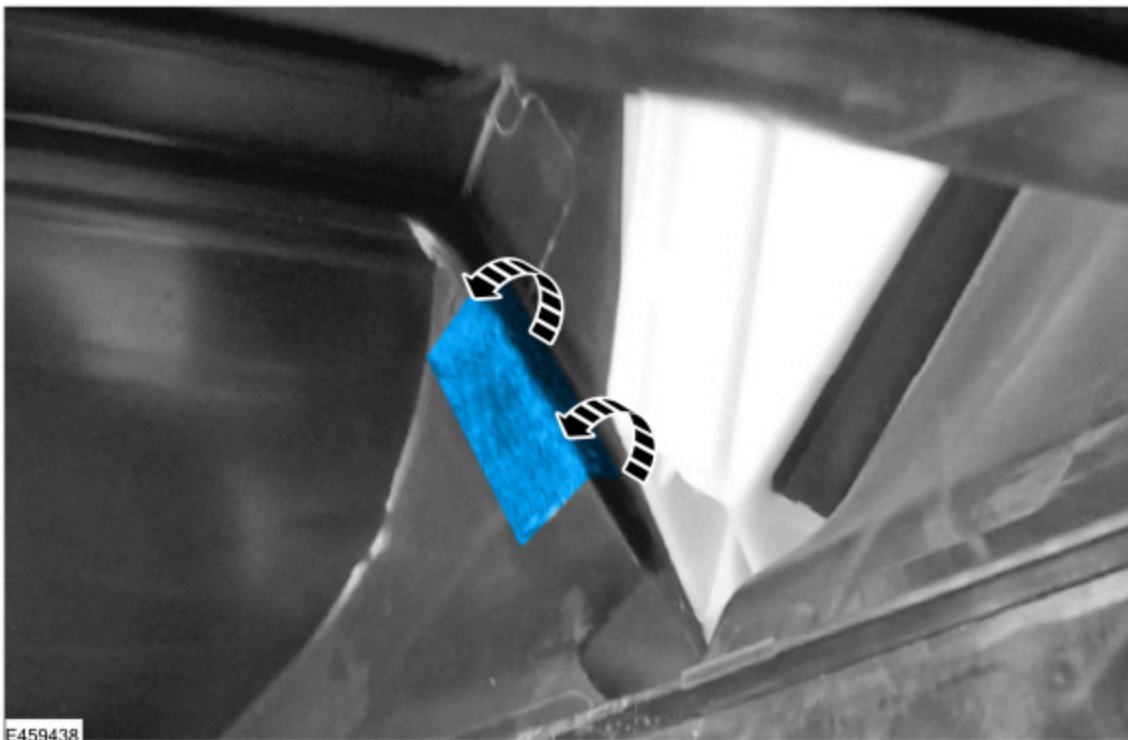
(6). Apply even, firm pressure along the entire section of 3M™ tape that was just installed. Remove air bubbles and ensure proper 3M™ tape orientation (Refer to Figure 2).

Figure 2



(7). Carefully wrap the 3M™ tape over the edge so that all portions of the 3M™ tape are fully adhered to the plastic inside the air inlet housing leaving no air bubbles. Refer to Figure 3 for an example of a properly installed piece of 3M™ tape.

Figure 3



(8). Remove all tools, flashlights, scrap 3M™ tape etc. from inside the air inlet housing.

6. Turn off the vehicle.

7. Install the cabin air filter. Refer to WSM, Section 412-00.

(1). Make sure the airflow direction arrows on the cabin air filter are correctly oriented.

(2). If the outer plastic clips on the cabin air filter cover break during removal and installation, M4 screws can be installed into either of the two pre-drilled holes located on the inside of each clip.

8. Turn on the climate control system to verify proper airflow and operation.
9. Road test the vehicle and turn on the climate control system in recirculation mode to confirm that the noise is no longer present. Are there any further whistle/humming noises coming from the air inlet door?
  - (1). Yes - replace the air inlet housing. Refer to WSM, Section 412-00.
  - (2). No - repair is complete.

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NOTE: The information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by "do-it-yourselfers". Do not assume that a condition described affects your car or truck. Contact a Ford or Lincoln dealership to determine whether the Bulletin applies to your vehicle. Warranty Policy and Extended Service Plan documentation determine Warranty and/or Extended Service Plan coverage unless stated otherwise in the TSB article. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ford Motor Company reserves the right to supersede this information with updates. The most recent information is available through Ford Motor Company's on-line technical resources.