RCA-30-25-001-1: Apply Sealant to HV Battery Connectors, R1T and R1S

Rivian is initiating a customer satisfaction campaign for some model year 2022-2024 R1T and R1S vehicles. These vehicles may have HV battery connectors that are susceptible to corrosion in some climates. If corrosion occurs, the vehicle may enter into a reduced performance safe-state mode and a fault indicator light will illuminate on the driver display alerting the driver to have service performed on their vehicle. Rivian will apply sealant to prevent corrosion. Rivian is launching this campaign for customer satisfaction and to ensure the quality of Rivian vehicles.

Document Type	Customer Satisfaction Campaign Bulletin
Date	November 20, 2025
Affected Region(s)	USA, Canada
Affected Model(s)	R1T, R1S
Model Year(s)	2022-2024
Approximate Build Dates Refer to **Open Containments** in ServiceOS to determine if this document applies to a specific vehicle.	August 2021-December 2023
Vehicle System	30 - HV Battery

Required Parts

Part Number	Quantity	Engineering Name	Service Name/Notes
N/A	1	McMaster-Carr 6710A42	Dispensing needle
N/A	1	McMaster-Carr 51525K124	Lock tube coupling
N/A	1	McMaster-Carr 3902N292	Plastic tubing
N/A	1	McMaster-Carr 7467A73	Mixer nozzle
N/A	1	McMaster-Carr 7467A23	3M Scotch-Weld Epoxy Adhesive DP110
SC00015866-A (or equivalent)	2	CABLE TIE - 1.5-110 BNDL	Cable tie

Attention: The parts listed in this table are only for unique steps that are called out in this bulletin. Some sections of this bulletin might refer to Service Manual procedures which require additional parts. Always review the bulletin and all potentially related Service Manual procedures before ordering parts and beginning work.

Required Tools:

Tool Number	Tool Name	Quantity
McMaster-Carr 7467A41	Dispensing gun	1

Attention: The tools listed in this table are only for unique steps that are called out in this bulletin. Some sections of this bulletin might refer to Service Manual procedures which require additional tools. Always review the bulletin and all potentially related Service Manual procedures before beginning work.

DANGER: ASTM class 0 electrical-protection gloves with leather protectors must be worn when working near any exposed high voltage conductor.

DANGER: Before beginning work for the day, test electrical-protection gloves for air leakage and visually inspect them for damage. Repeat the air test and inspection immediately following any incident that can reasonably be suspected of causing damage.

Warning: Wear appropriate eye protection during this procedure.

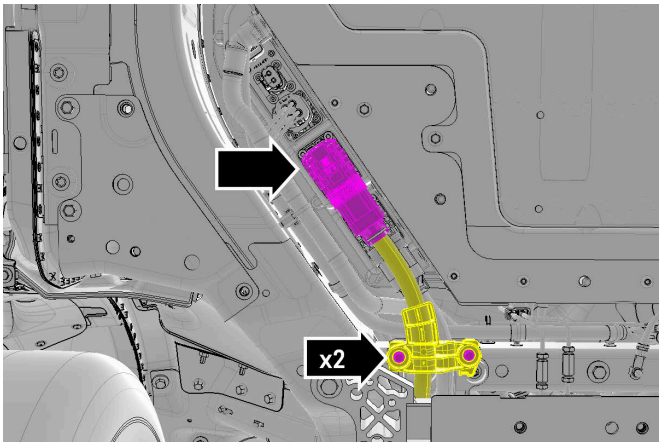
Warning: Use electrical-insulating tools when working on high voltage components to protect against accidental contact with live circuits.

DANGER: Wear a balaclava and arc-flash protection face shield or an arc-flash protection hood.

DANGER: Wear appropriate clothing with an arc rating of 8 cal/cm^2 or more.

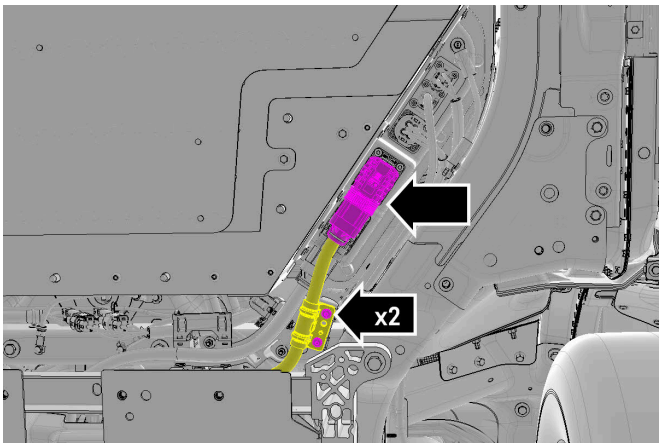
Access

1. Disable High Voltage (refer to service manual procedure 340010017).
2. Remove: Reinforcement, Frame, Front, Lower (refer to service manual procedure 522212010).
3. Remove:
   - **R1T:** Panel, Underbody, HV Battery, Rear (refer to service manual procedure 606513010).
   - **R1S:** Panel, Underbody, Rear Subframe (refer to service manual procedure 606516010).
4. LH front:

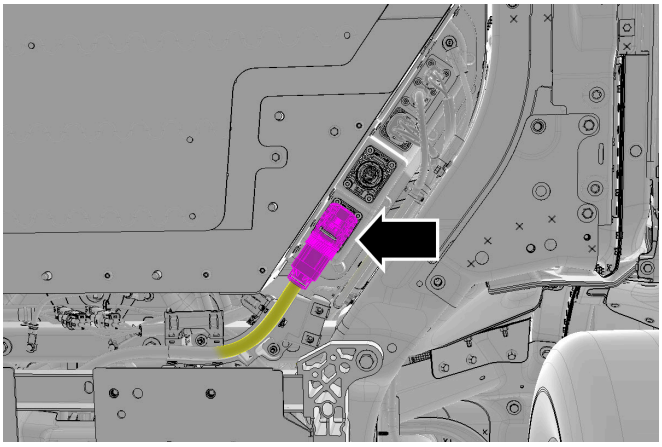


5. LH front:

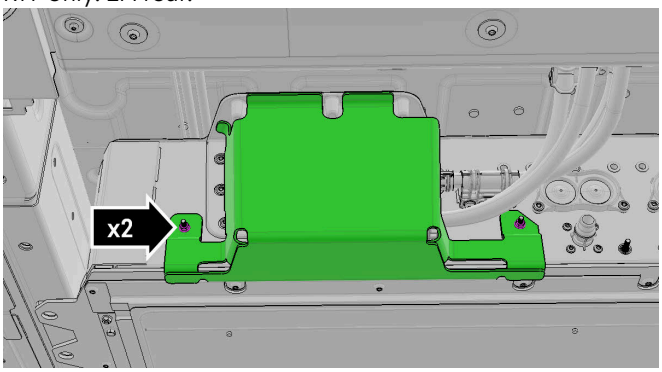
6. RH front:



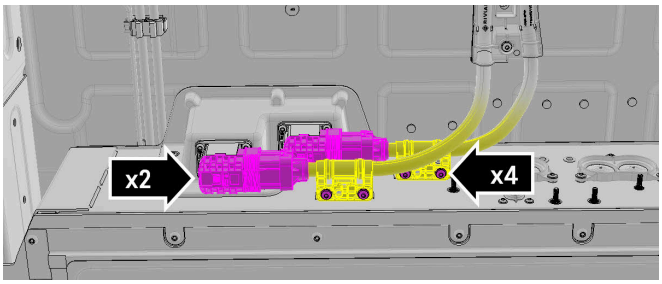
7. RH front:



8. R1T only: LH rear:



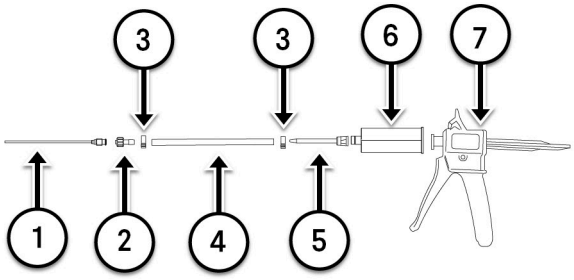
9. LH rear:



Torque specifications in this section

Step Number	Torque (Nm)
4	9
6	9
8	12
9	9

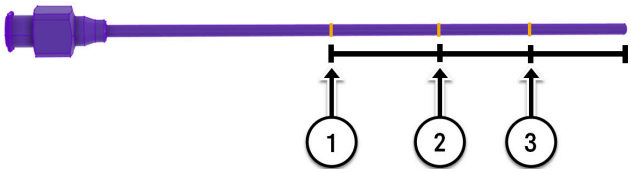
Assemble Tool



1. Assemble:

1	McMaster-Carr 6710A42
2	McMaster-Carr 51525K124
3	Cable tie (SC00015866-A or equivalent)
4	McMaster-Carr 3902N292
5	McMaster-Carr 7467A73
6	McMaster-Carr 7467A23
7	McMaster-Carr 7467A41

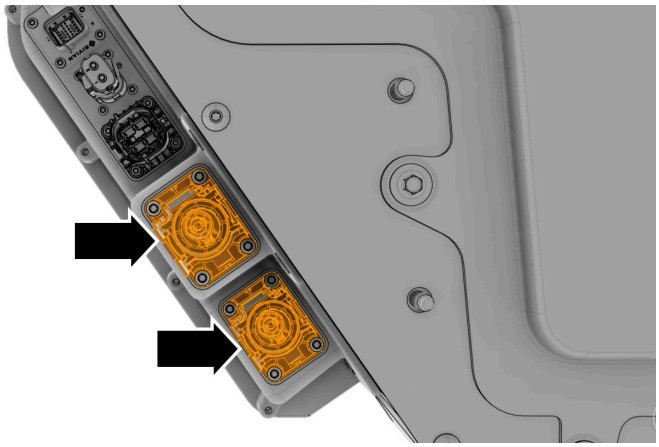
2. Measuring from the tip of the dispensing needle: Mark the locations shown.



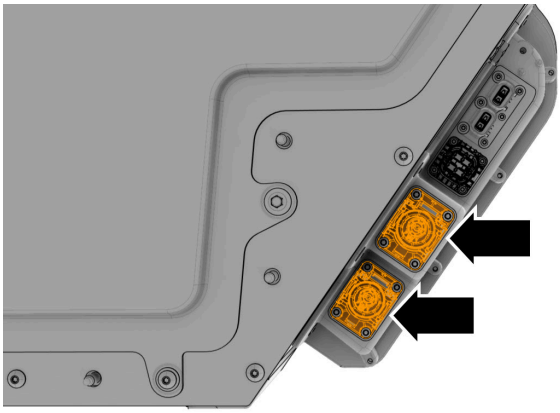
1	50 mm
2	35 mm
3	15 mm

Lower Connectors

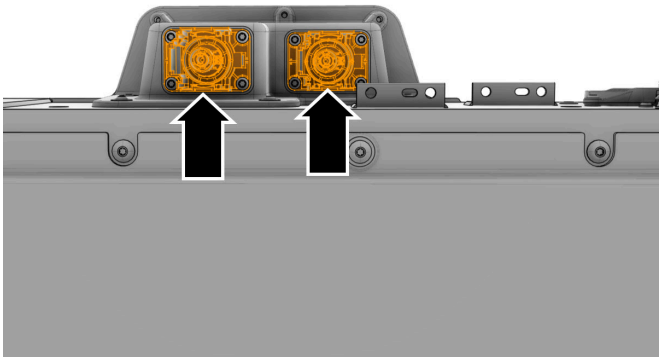
1. Identify the 6 connectors that require rework.
   - **LH Front:**



   - **RH Front:**



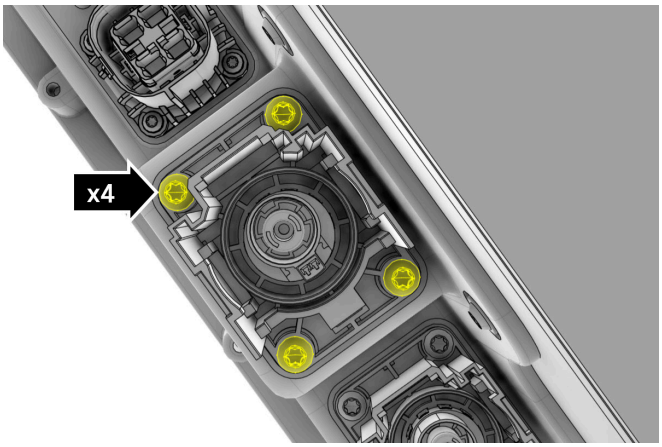
   - **Rear:**



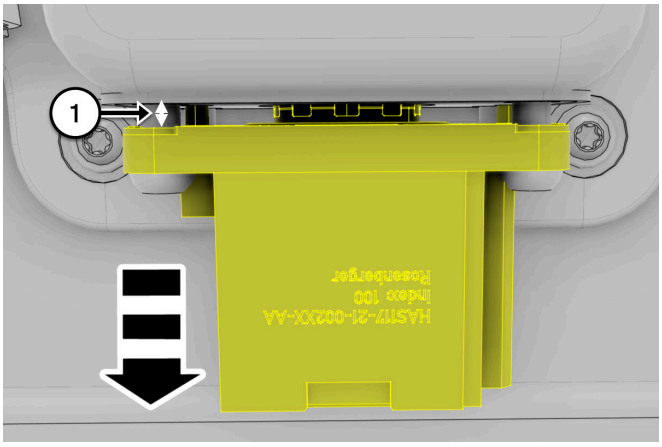
2. On each connector:

Note: LH front shown; all connectors similar.

a. Loosen:



b.

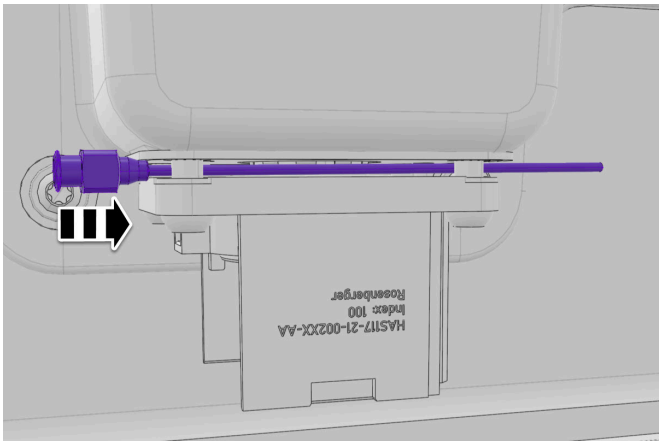


1	4-5 mm

Note: Do not fully remove the component.

Tip: If necessary: Temporarily re-attach the cable to provide additional leverage.

c. Test-fit the dispensing needle. Make sure that the dispensing needle can completely pass between the connector and HV battery housing.



Apply Sealant

1. Gather the required supplies/tools:
    - Flashlight
    - Paper towels and swabs
    - Torque wrench set at 7.5 Nm

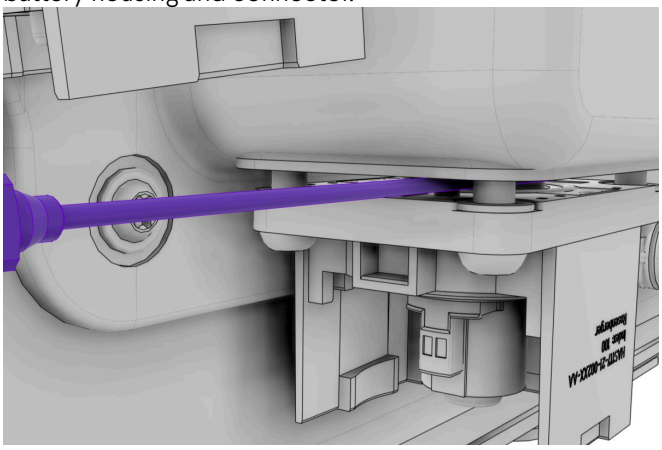
Important: Review the rest of the steps in this section before continuing.

Important: The next steps must be performed within less than 8 minutes. Perform all of the steps on all of the connectors without stopping.

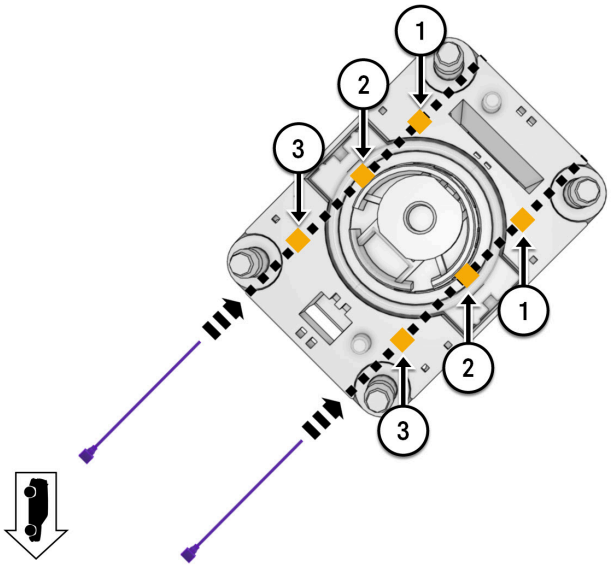
Important: Have an assistant ready with paper towels, swabs, and flashlight.

2. Dispense a small amount of adhesive onto a paper towel to remove air from the tool.
3. Apply sealant to the 2 LH front connectors:

    a. Starting from the forward edge of the component: Insert the dispensing needle between the HV battery housing and connector.



    b. In 6 locations: Apply continuous pressure on the plunger for 3 seconds to dispense adhesive.



Note: Shown from the top of the component.

Note: Position the dispensing needle as close to the fasteners as possible.

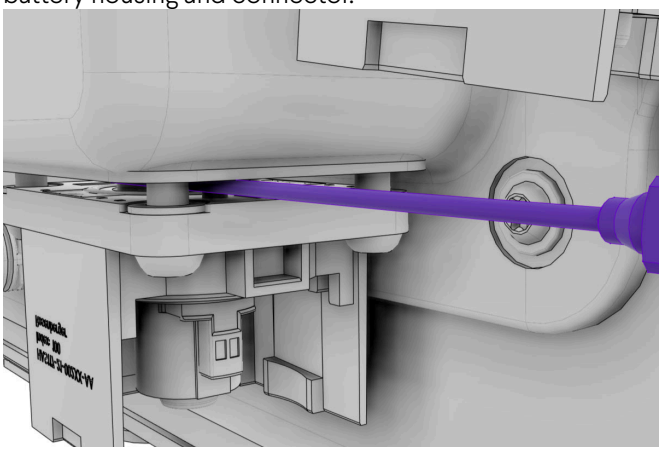
Note: Use the marks on the needle to determine the appropriate insertion depth.

1	50 mm deep
2	35 mm deep
3	15 mm deep

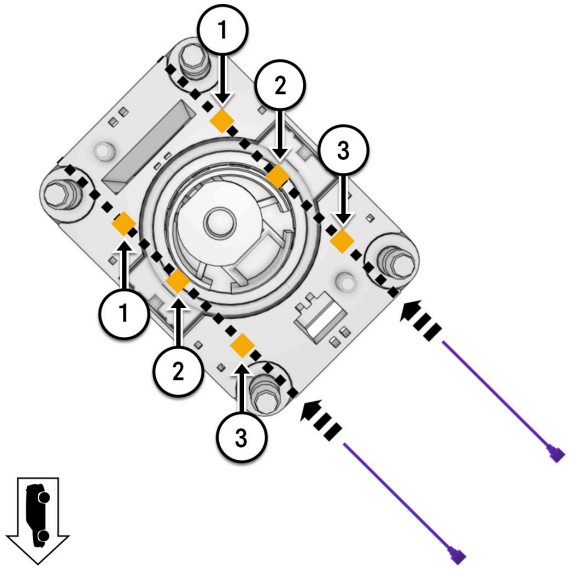
c. While continuing to the next step: Have an assistant use a flashlight to check for excess adhesive inside the connector. The assistant should use paper towels and swabs to remove any adhesive.

4. Apply sealant to the 2 RH front connectors:

a. Starting from the forward edge of the component: Insert the dispensing needle between the HV battery housing and connector.



b. In 6 locations: Apply continuous pressure on the plunger for 3 seconds to dispense adhesive.



Note: Shown from the top of the component.

Note: Position the dispensing needle as close to the fasteners as possible.

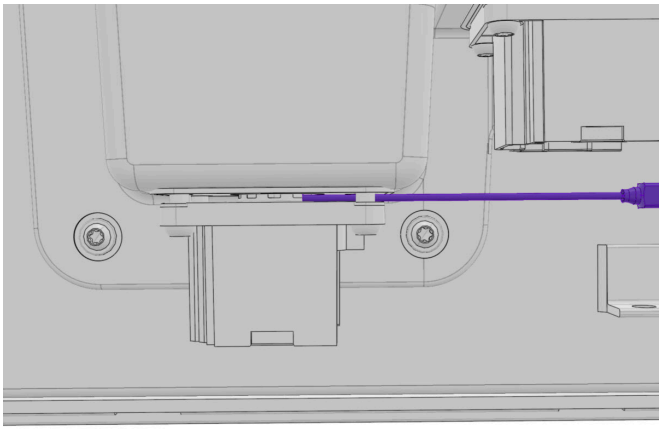
Note: Use the marks on the needle to determine the appropriate insertion depth.

1	50 mm deep
2	35 mm deep
3	15 mm deep

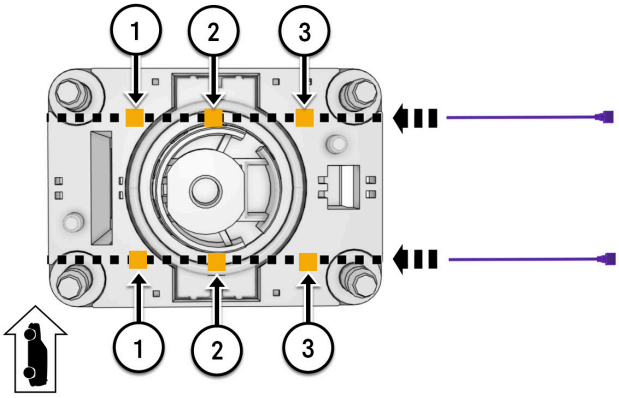
c. While continuing to the next step: Have an assistant use a flashlight to check for excess adhesive inside the connector. The assistant should use paper towels and swabs to remove any adhesive.

5. Apply sealant to the 2 rear connectors:

a. At the RH side of the component: Insert the dispensing needle between the HV battery housing and connector.



b. In 6 locations: Apply continuous pressure on the plunger for 3 seconds to dispense adhesive.



Note: Shown from the top of the component.

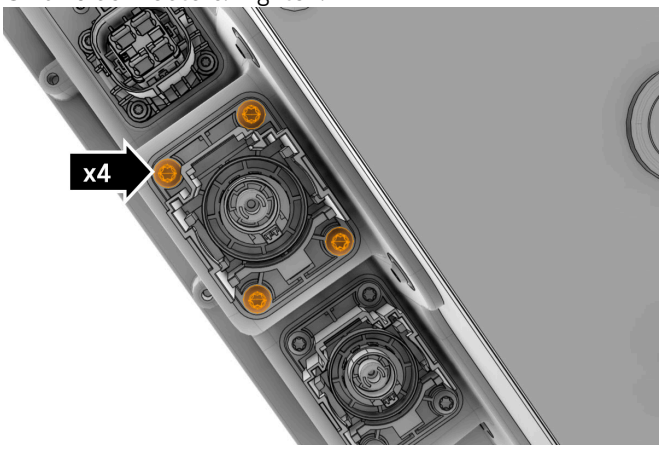
Note: Position the dispensing needle as close to the fasteners as possible.

Note: Use the marks on the needle to determine the appropriate insertion depth.

1	50 mm deep
2	35 mm deep
3	15 mm deep

c. While continuing to the next step: Have an assistant use a flashlight to check for excess adhesive inside the connector. The assistant should use paper towels and swabs to remove any adhesive.

6. On all 6 connectors: Tighten:



Torque specifications in this section

Step Number	Torque (Nm)
6	7.5

Final Steps

1. Allow the adhesive to cure.

   CAUTION: Check the product packaging for the necessary cure time.

2. Perform: HV Battery Housing Leak Test (refer to service manual procedure 302180032).
3. Reinstall all components that were removed for access and replace all non-reusable components. Refer to the service manual procedures referenced in this document for additional component reusability information and torque specifications.

Labor Codes

Labor Code	Description
RCA302500100	RCA-30-25-001 not applicable
RCA302500101	Apply sealant to HV battery connectors