

Field campaign

Topic	Transmission Replacement Continental GT/GTC/Flying Spur 25MY (SC25/47)
Market area	Germany E02 Bentley rest Europe (6E02),United Kingdom E01 Bentley UK (6E01),United States E05 Bentley USA and rest America (6E05)
Brand	Bentley
Transaction No.	2080111/1
Campaign number	ED75
Note	
Type	
US code	

Vehicle data

25MY Continental GT/GTC & Flying Spur

Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
Z23*	2025	E		*	*	*
Z24*	2025	E		*	*	*
Z32*	2025	E		*	*	*

Documents

Document name
master.xml
sc2547vinlist.pdf

Notes



Technical background

Affected vehicles have been identified for a containment action with regards to the automatic transmission. Due to a supplier process error, the rotor carrier of the electric motor may not be correctly welded to the rotor shaft. As a result, the transmission of torque for the lifetime of the unit cannot be guaranteed.

Remedy

Replacement of the automatic transmission is required. Please refer to the Work section and conduct all instructions to completion

Customer notification

Customers of affected vehicles will be notified in writing by their Bentley retailer to arrange an appointment.

Please ensure that all affected vehicles are checked and repaired at the nearest opportunity, make a note of the required action on the workshop order before it is signed by the customer.

If it is omitted to perform the work required during a workshop visit, the customer should be notified immediately.

You should also pass on this information to your new and used car sales department so that affected vehicles are checked and repaired immediately.

Warranty

Claim Type: 790 or 710

Service Number: ED75

Damage Code: 00 66

Criteria ID: 01

Labour

Automatic Gearbox Remove and Install

Labour Operation Code – 37 35 19 26 (*Live on 29.01.2026, use 37 35 19 99 prior to this date*)

Time – 2090 TU

Automatic Gearbox Replace

Labour Operation Code – 37 35 55 50

Time – 80 TU (Continental GT/GTC)

Time – 90 TU (Flying Spur)

Vehicle Front and Rear Geometry Check

Labour Operation Code – 44 95 03 00

Time – 90 TU

Time for GFF/Guided Functions

Labour Operation Code – 01 50 00 00

Time – 50 TU

Road Test

Labour Operation Code – 01 21 00 01

Time – 30 TU



If the vehicle geometry requires adjustment, please refer to the applicable adjustment Labour Operation codes to be claimed as required per ElsaPro.

Parts

Part Name	Part Number	Quantity Required
Parts set for engine and gear lowering	3SA 198 115 H	1
Fixing Kit for Engine & Transmission Assy Refit	3SA 198 115 J	1
8-speed dual clutch gearbox	ODS 300 028 L	1

Parts supply

Refer to ETKA parts catalogue.

Parts despatch control

Not applicable

Repair instructions



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Check

If the vehicle is not already listed as repaired in the 'Repair history' section of ElsaPro, check the 'Identification' section of this document. In the event that the campaign has not been applied, please carry out the required work in accordance with these instructions.

Parts

Part Name	Part Number	Quantity Required
Parts set for engine and gear lowering	3SA 198 115 H	1
Fixing Kit for Engine & Transmission Assy Refit	3SA 198 115 J	1
8-speed dual clutch gearbox	ODS 300 028 L	1

Tools

Refer to ElsaPro and the required associated operations for all required tools.

Work

DANGER

High voltage can cause fatal injury. Danger of severe or fatal injuries from high-voltage components or high-voltage wiring if they are severely damaged. The high-voltage system must be de-energised by a suitably qualified person. Take all necessary precautions when working on high voltage components. Refer to "Safety precautions when working on high-voltage system" .→ Rep. Gr. 00

DANGER

Fuel is highly flammable and extreme care must be exercised whenever the system is opened (i.e. pipes or unions disconnected, fuel cap removed) or when the fuel system is drained. The following basic rules should apply: – Always ensure adequate ventilation. – Disconnect the 12V battery. – Ensure that adequate firefighting equipment is available in the vicinity of the vehicle. Fuel system - Safety precautions. → Rep. Gr. 20 Fuel system - Rules for cleanliness. Rep. Gr. 20 Before commencing work on and around the engine, ensure that it has cooled sufficiently, failure to do so may cause injury to personnel. Avoid prolonged and repeated contact with oils and fluids etc. Always protect the skin with impervious gloves. Always wear suitable eye protection.

WARNING

Always follow all general safety warnings and repair instructions outlined in ElsaPro before commencing any work on the vehicle. This includes but it is not limited to: Safe handling of pressurised systems, suspension components under load, and electrical isolation procedures. Failure to observe these precautions may result in vehicle damage or personal injury.

NOTICE

Within this procedure there are single use items which must be replaced and not reused. Ensure that new replacements are available prior to starting this procedure. Also ensure all fasteners are torqued to specification.

NOTICE

Follow all additional steps, associated operations and warnings within ElsaPro for automatic transmission removal, replacement and installation.

Removal

The engine is removed from the vehicle with the automatic transmission assembly and front subframe still attached. Only then can the engine and the automatic transmission assembly be separated on the hydraulic lifting table.

- Fit vehicle protection.
- Place the vehicle on a ramp and set to "Jack" mode.

Refer to ElsaPro Booklet 404 "Raising and supporting the car"

- Remove the engine, front sub frame and automatic transmission assembly from the vehicle.

Refer to ElsaPro Repair Group 10 'Engine and automatic transmission - To remove and fit'

- Separate the automatic transmission from engine.

Refer to ElsaPro Repair Group 37 "'Automatic transmission (V8) - To remove and fit"

NOTICE

Follow all additional steps within ElsaPro for automatic transmission replacement.

Installation

Where applicable, ensure any other brackets, heat shields etc., are removed from the OLD automatic transmission and installed onto the NEW automatic transmission.

- Install the NEW transmission onto the engine, installation is the reverse of removal procedure.

Refer to ElsaPro Repair Group 37 "Automatic transmission (V8) - To remove and fit"

- Install the engine, front sub frame and NEW automatic transmission assembly into the vehicle.

Refer to ElsaPro Repair Group 10 'Engine and automatic transmission - To remove and fit'

- Rebuild the vehicle ensuring all fasteners are torqued to specification. Installation of removed parts is the reverse of removal procedure.

Final Checks

- Perform the ElsaPro Diagnostics procedure for a new automatic transmission assembly.



- Check and fill the transmission fluid level as required.

Refer to ElsaPro Repair Group 38 "Automatic transmission fluid - To check, drain and replenish"

- Reset the vehicle geometry.

Refer to ElsaPro Repair Group 10 'Wheel geometry – Wheel alignment and ride height'



CAUTION

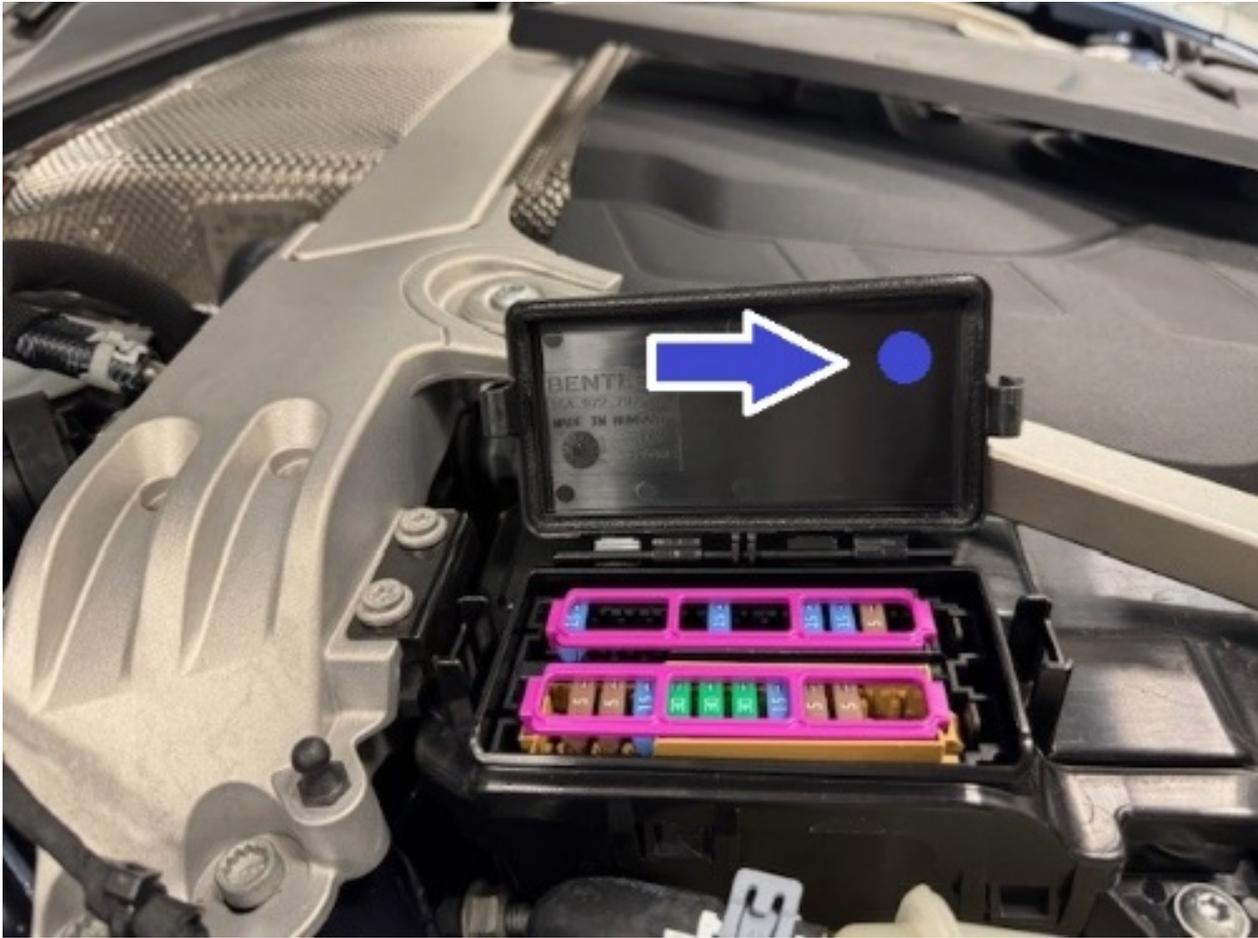
Once the wheel alignment has been carried out, the following "Bentley Safeguard" systems (where fitted), **MUST** be recalibrated: – Automatic cruise control – Night vision – Front camera for driver assist systems – Rear radar – Top view / rear view camera (specification dependant) – Matrix headlights (specification dependant) Failure to carry out these adjustments will lead to erratic operation of the driver assist symptoms.

- Road test the vehicle: check for leaks, re-check all fluid levels, and top up as necessary.
- Refer to the Identification section.

Identification

Once the applicable action has been conducted, the operative must submit a warranty claim as this will show the service campaign action as complete within Elsa Pro "Repair history".

You must also add a blue paint mark to the Fusebox as per the image below.



▲ Repair instructions ▲ Notes

SCBBF53S0SC019721

SCBBP6ZG3SC023252

SCBCF13SXSC020887

SCBCL13S4SC023342