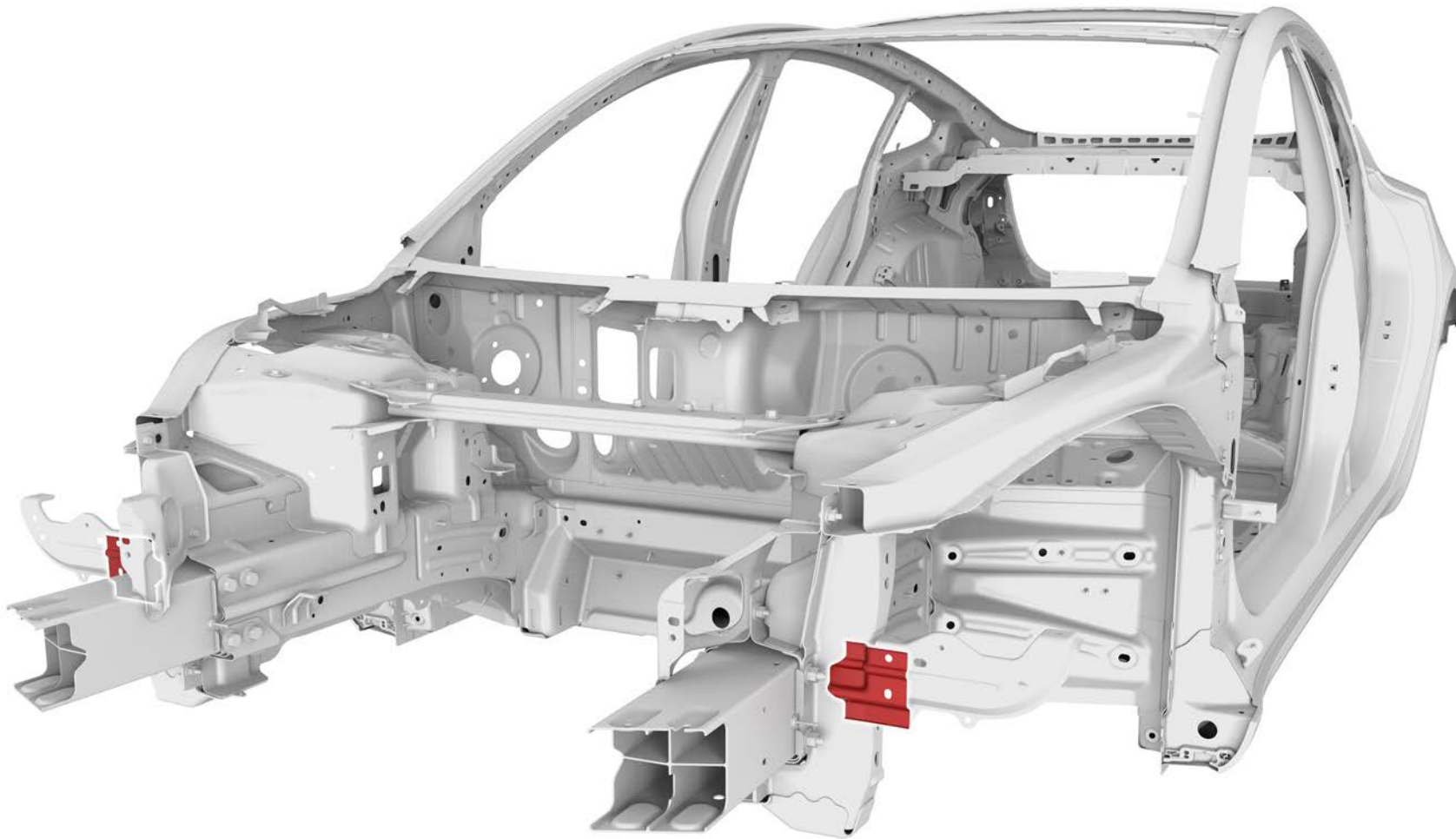


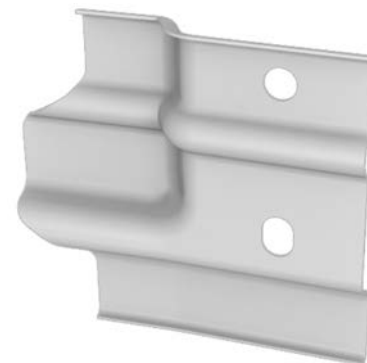




Fender Front Inner Bracket







Parts List

Quantity	Part Number	Description	Image / Notes
1	1089673-S0-A (LH) 1089674-S0-A (RH)	Fender Front Inner Bracket	
4 rivets needed; order 10 rivets	1063943-00-A	 Structural Bulb Rivet, 6.5 mm	All rivets come in packages of 10; order all rivets in multiples of 10.
1	—	Structural Adhesive	 WARNING: Use only Tesla-approved structural adhesive; refer to BR-15-92-008 , "Approved Structural Adhesive and Urethane Sealants" for a list of current approved structural adhesives. Refer to BR-17-92-002 , "Obtaining Adhesives, Coolant, and Other Chemicals" for information on how to obtain approved structural adhesive.

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the [Parts Manual](#).



Repair Information

Repair Information	Warnings and Cautions	Special Tools
<p>This procedure is for the left-hand component; the procedure is identical for the right-hand component.</p> <p>The original Fender and Lamp Support Bracket is removed as part of this procedure. Install the new Fender and Lamp Support Bracket after this procedure has been completed.</p>	<p> WARNING: Wear the appropriate personal protective equipment (PPE) when performing this procedure.</p> <p> CAUTION: This procedure involves only steel components. Use the appropriate tools to avoid cross-contamination.</p>	<p>No special tools are required to perform this procedure.</p>



Prerequisites

No welded, riveted, or bonded panels need to be removed prior to performing this procedure.



Removal

1 Remove the original component.

A Trace the outline of the original component to aid in installation in a [later step](#).

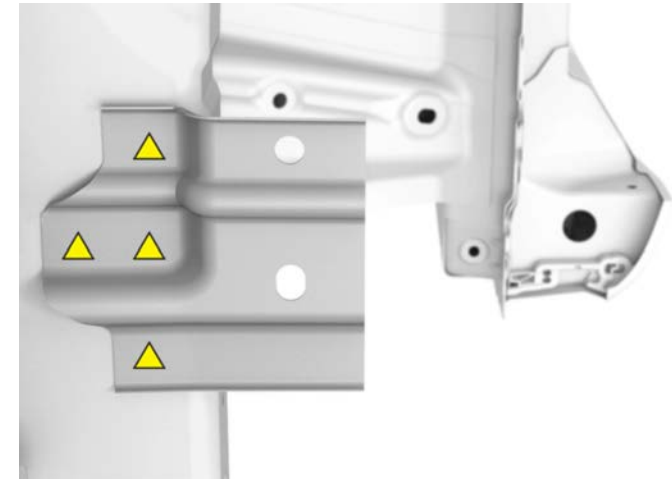


B Use a drill with a spot weld bit to drill out the factory spot welds.

▲ Factory Spot Weld (x4)



NOTE: Factory spot weld locations shown are approximate. Exact spot weld locations and number vary from vehicle to vehicle.





Removal

- 1 Remove the original component (continued).
- B Use a drill with a spot weld bit to drill out the factory spot welds (continued).



- C Use a hammer and chisel to remove the original component.





Removal

- 1 Remove the original component (continued).
- C Use a hammer and chisel to remove the original component (continued).





Removal

2

Use a disc sander with a medium-abrasive surface conditioning disc to remove any remaining materials from the bond paths. Use a belt sander with a medium-abrasive belt for any areas that cannot be reached with a disc sander. Vacuum any adhesive dust.



WARNING: Remove the epoxy adhesive in a well-ventilated area. Wear suitable personal protective equipment.



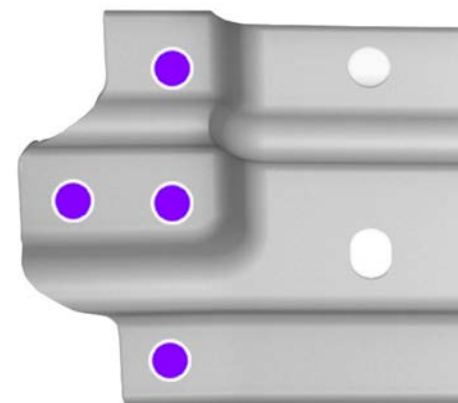


Replacement

1 Prepare for installation.

A Mark the locations for structural bulb rivets on the new component.

● Structural Bulb Rivet, 6.5 mm (x4)





Replacement

1 Prepare for installation (continued).

B Use a drill with a 6.7 mm (17/64 in) bit to drill holes for structural bulb rivets on the new component.



C Put the new component into position and mark the structural bulb rivet locations on the vehicle.

● Structural Bulb Rivet, 6.5 mm (x4)



NOTE: Use the outline traced in an [earlier step](#) to aid in installation.





Replacement

- 1 Prepare for installation (continued).
 - C Put the new component into position and mark the structural bulb rivet locations on the vehicle (continued).
 - D Mark the bond path areas on the new component and the vehicle. These areas will be prepared for bonding in the next step.





Replacement

1 Prepare for installation (continued).

E Remove the new component.

F Use a drill with a 6.7 mm (17/64 in) bit to drill a hole for a structural bulb rivet on the vehicle.





Replacement

1 Prepare for installation (continued).

G Put the new component into position and install a grip screw to hold the new component in place.



H Use a drill with a 6.7 mm (17/64 in) bit to drill the remaining holes for structural bulb rivets on the vehicle.



NOTE: Install a grip screw after drilling each hole to keep the panel aligned while drilling the remaining holes.



Replacement

- 1 Prepare for installation (continued).
 - 1 Remove the new component.



- 2 Prepare the surfaces.
 - A Use a red Scotch-Brite pad or equivalent to scuff the e-coat on the new component and on the vehicle in the bond path areas.



NOTE: Remove any oxidation that might have formed on any bare metal in the bond path areas on the vehicle.



Replacement

2 Prepare the surfaces (continued).

B Clean all the bond paths on the new component or components and on the vehicle with isopropyl alcohol (IPA).



WARNING: Wipe off the remaining isopropyl alcohol with a clean, dry towel immediately after application. Do not let the remaining isopropyl alcohol air dry. Allowing the remaining isopropyl alcohol to air dry can compromise the adhesive bond.

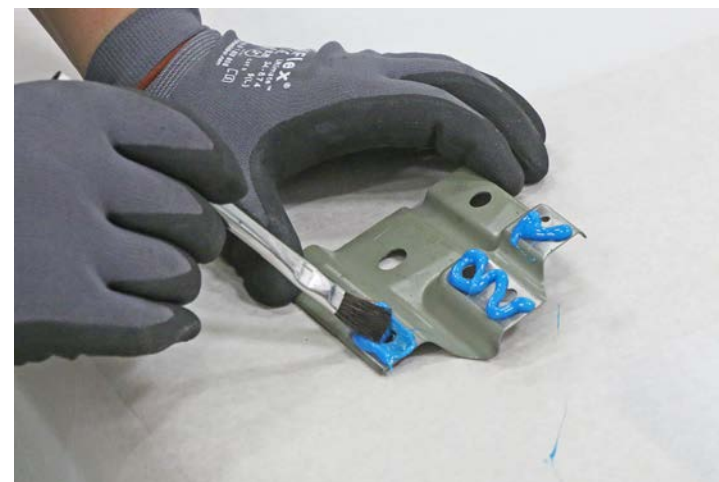


3 Apply structural adhesive.

A Spread a thin coating of structural adhesive as a primer layer on the bond paths on the vehicle and the new component.



NOTE: Assembly must be performed while the primer layer is still wet. The drying time of the adhesive varies depending on temperature and humidity.





Replacement

3 Apply structural adhesive (continued).

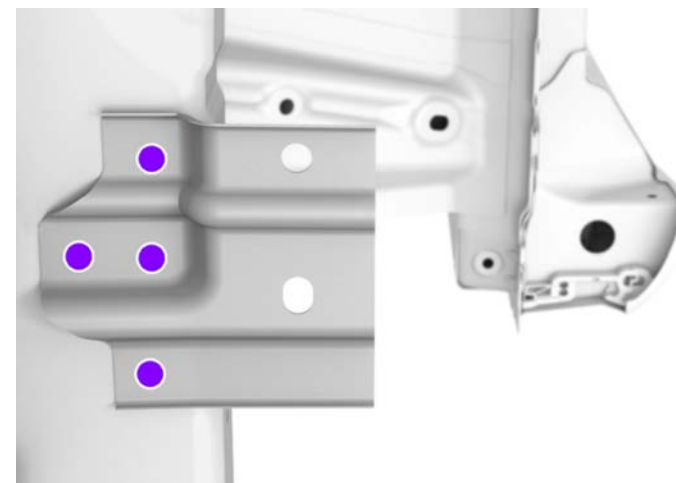
B While the primer layer is still wet, apply a bead of structural adhesive on top of the primer layer on the new component.



4 Install the new component.

A Put the new component into position and insert the structural bulb rivets to hold it in place.

● Structural Bulb Rivet, 6.5 mm (x4)





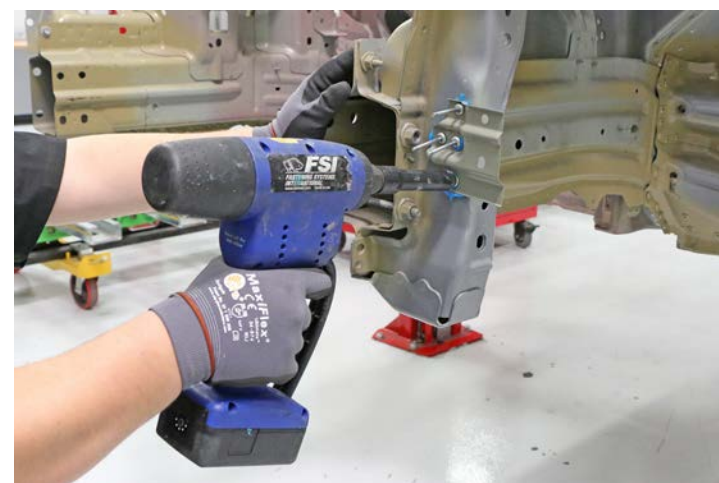
Replacement

4 Install the new component (continued).

A Put the new component into position and insert the structural bulb rivets to hold it in place (continued).



B Install the structural bulb rivets.





Replacement

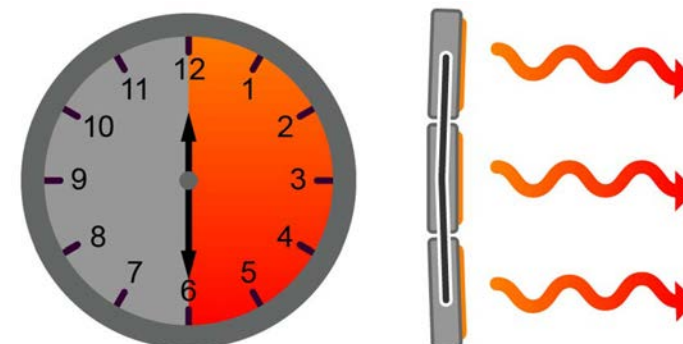
4 Install the new component (continued).

C Wipe off any excess adhesive.

D Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



WARNING: Do not allow the High Voltage Battery to reach a temperature above 74°C (165°F). Heating the High Voltage Battery above 74°C (165°F) for an extended period could result in injury to personnel and/or damage to the battery.



00:30:00+

60°C–80°C



Replacement

5

Install the new [Fender and Lamp Support Bracket](#).

