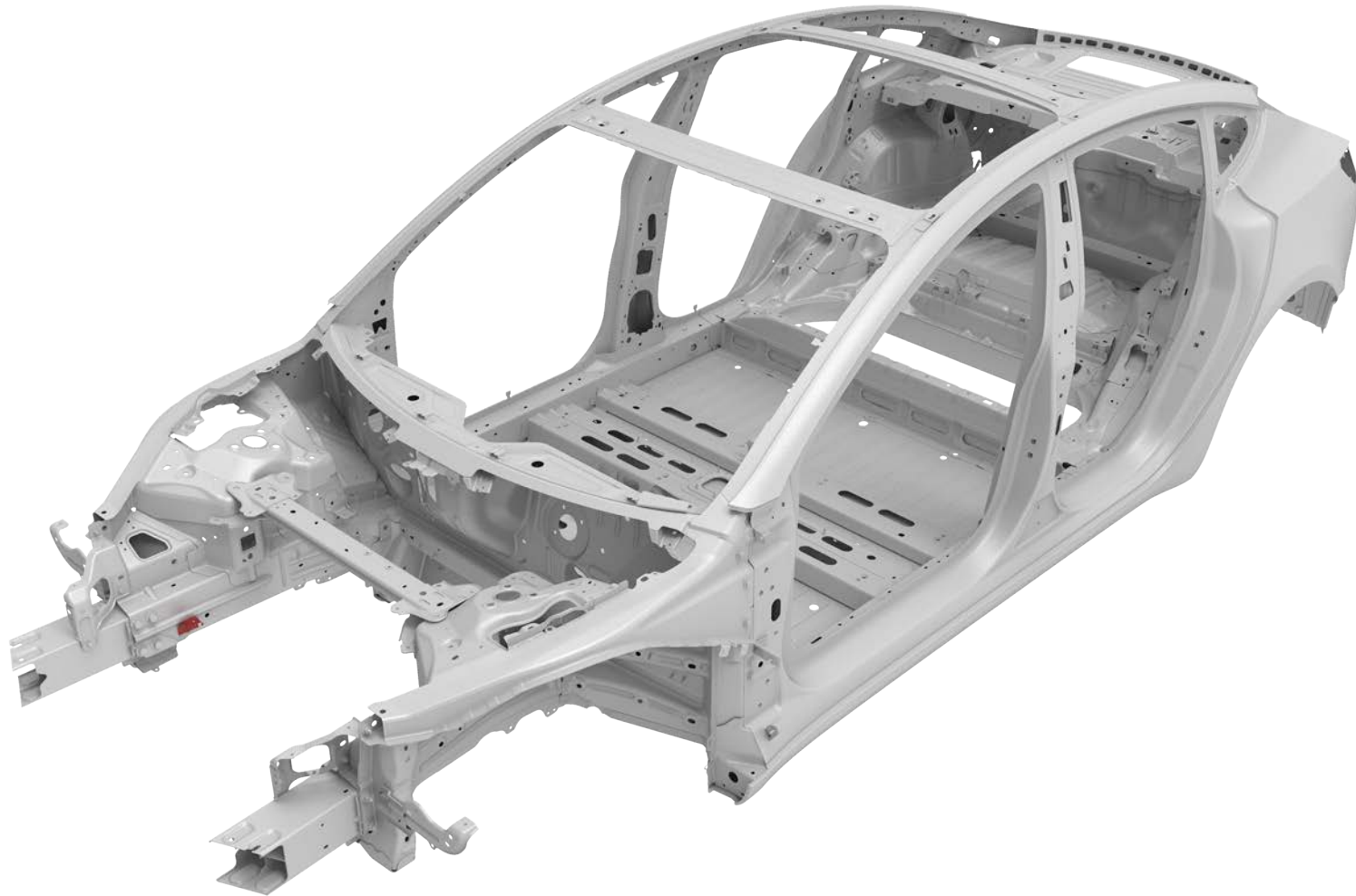





## Frunk Bracket







# Parts List

Quantity	Part Number	Description	Image / Notes
1	1105305-S0-A	Frunk Bracket	
2 rivets needed; order 10 rivets	1028719-00-A	● Structural Rivet, 4.8 mm	All rivets come in packages of 10; order all rivets in multiples of 10.
1	—	Structural Adhesive	<p><b>⚠ WARNING:</b> Use only Tesla-approved structural adhesive; refer to <a href="#">BR-15-92-008</a>, "Approved Structural Adhesive and Urethane Sealants" for a list of current approved structural adhesives.</p> <p>Refer to <a href="#">BR-17-92-002</a>, "Obtaining Adhesives, Coolant, and Other Chemicals" for information on how to obtain approved structural adhesive.</p>
1	—	Corrosion-Resistant Primer	Source locally; not available from Tesla.

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> <b>WARNING:</b> Wear the appropriate personal protective equipment (PPE) when performing this procedure.</p> <p> <b>CAUTION:</b> 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 belt sander to sand down the factory spot welds, or use a drill with a spot weld bit to drill them out.

▲ Factory Spot Weld (x2)



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



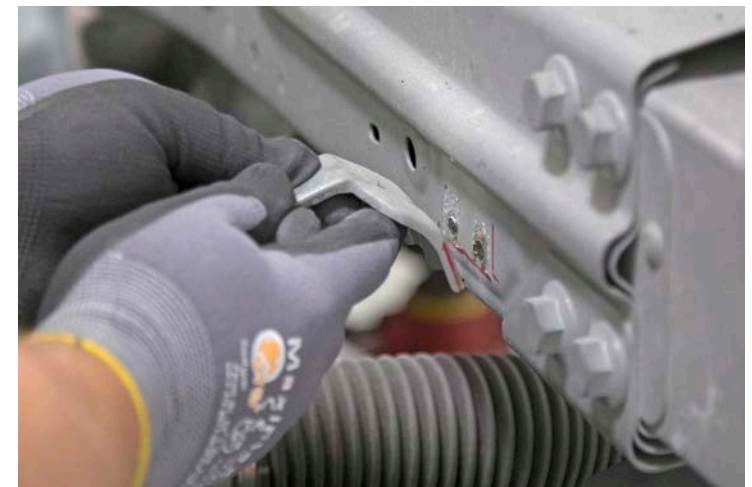
## Removal

1 Remove the original component (continued).

B Use a belt sander to sand down the factory spot welds, or use a drill with a spot weld bit to drill them out (continued).



C Remove the original component.





## 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.





## Replacement

1 Prepare for installation.

A

Put the new component into position and clamp it into place.



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

B

Use a drill with a 4.8 mm (3/16 in) bit to drill holes for structural rivets.

- Structural Rivet, 4.8 mm (x2)







## Replacement

- 1 Prepare for installation (continued).
  - B Use a drill with a 4.8 mm (3/16 in) bit to drill holes for structural rivets (continued).



- C Remove the new component.





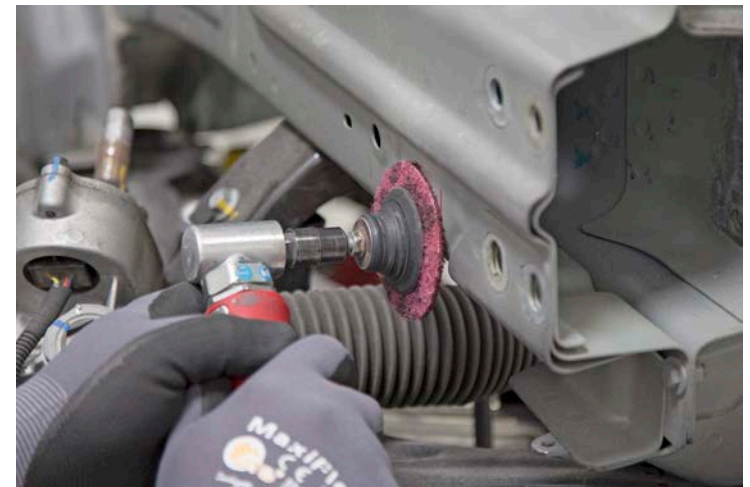
## Replacement

2 Prepare the surfaces.

A Use a disc sander with a medium-abrasive surface conditioning disc to remove the e-coat on the new component and on the vehicle in the bond path areas. Use a belt sander with a medium-abrasive belt for any areas that cannot be reached with a disc sander.



**WARNING:** Remove the e-coat in a well-ventilated area. Wear suitable personal protective equipment.





## 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).



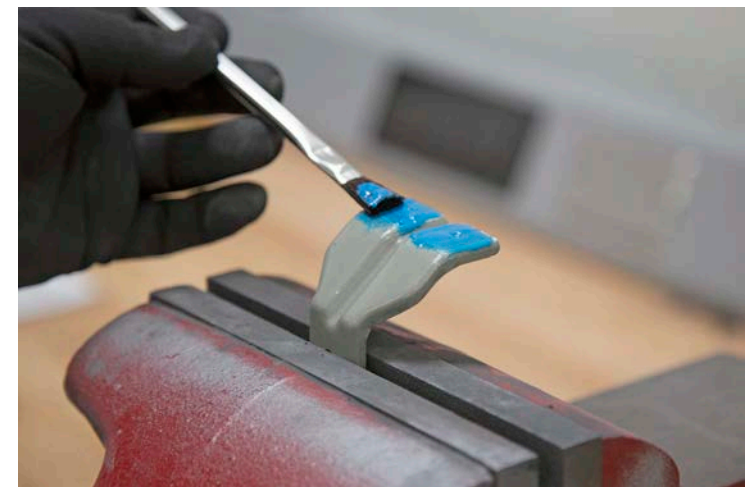
**WARNING:** Wipe off the remaining isopropyl alcohol with a clean, dry towel immediately after application. Do not let the remaining isopropyl alcohol air dry. Allowing the remaining isopropyl alcohol to air dry can compromise the adhesive bond.

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 rivets to align the new component.

● Structural Rivet, 4.8 mm (x2)







## Replacement

4 Install the new component (continued).

A Put the new component into position and insert the structural rivets to align the new component (continued).



B Install the structural rivets.





## Replacement

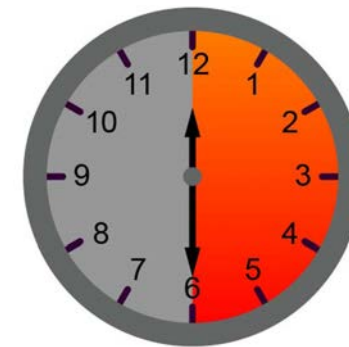
4 Install the new component (continued).

C Wipe off any excess adhesive.

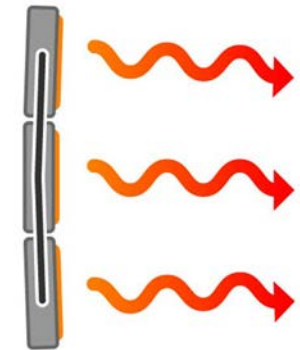
D Bake the structural adhesive so that the bonded panels reach a temperature of 60°C–80°C (140°F–176°F) for at least 30 minutes to achieve full strength.



**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

Prime any bare metal with a suitable corrosion-resistant primer.

