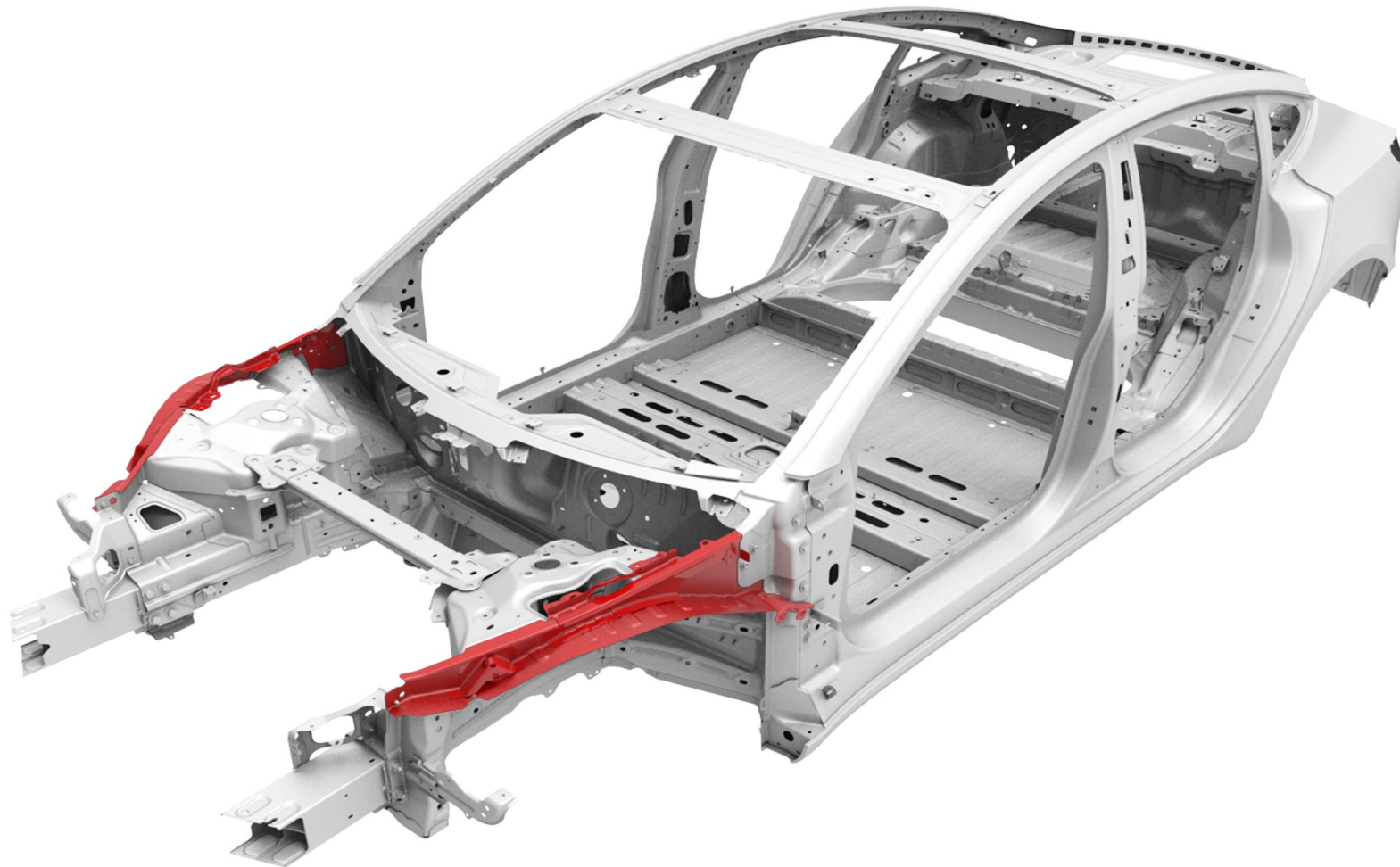








Shotgun Inner








Parts List

Quantity	Part Number	Description	Image / Notes
1	1080025-S0-B (LH) 1080026-S0-B (RH)	Shotgun Inner	
3 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.
3 rivets needed; order 10 rivets	1454538-00-A	 High Strength Structural 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 right-hand component; the procedure is identical for the left-hand component.</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> NOTE: Refer to BR-17-10-005, “Model 3 Body Structure Materials and Allowed Operations”, for information about the material each structural component is made from and the operations that are allowed on each type of material.</p>	<p>The special tool listed below is required to perform this procedure:</p> <ul style="list-style-type: none">Resistance Spot Welder <p>Use only an approved resistance spot welder. Refer to BR-16-92-007, “Approved Welders” for a list of current approved resistance spot welders.</p>



Prerequisites

1

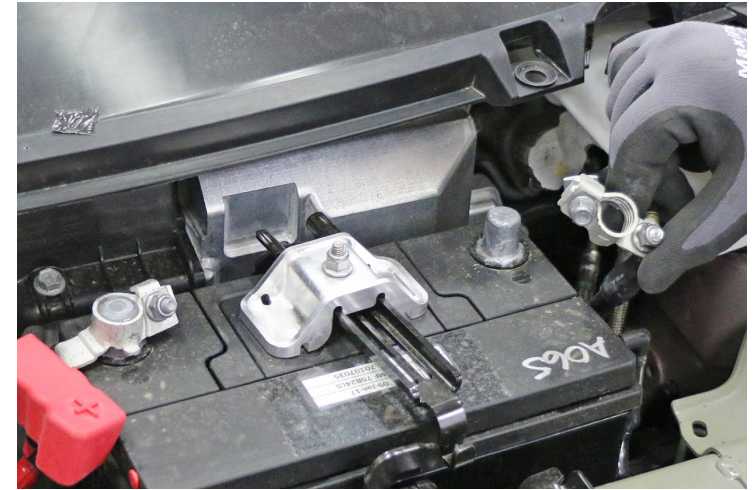
Disconnect 12V and high voltage power (refer to the appropriate section in [BR-17-17-004](#), "Disconnecting 12V and High Voltage Power on Model 3").



WARNING: Before disconnecting the 12V power supply, make sure that all windows are at least slightly open. Attempting to open a door with a fully-closed window when the 12V power supply is disconnected could result in door glass shatter.



NOTE: Before disconnecting the 12V power supply, make sure that the driver's door window is fully open. Failure to lower the driver's door window before disconnecting the 12V power supply could result in vehicle lockout.





Prerequisites

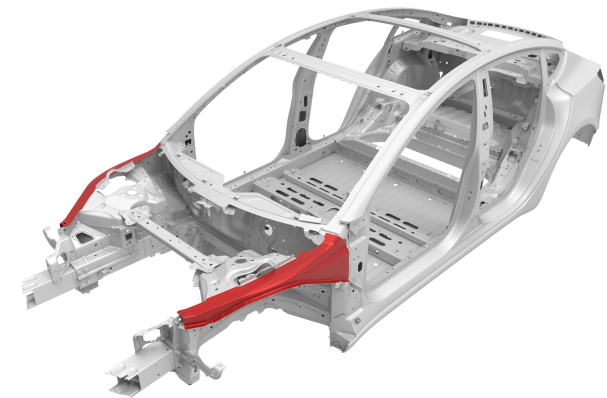
2

Remove the items listed below. Refer to the applicable Service Manual procedure.

- Windshield (Service Manual procedure 10200102)
- Front Door (Service Manual procedure 10106001)
- Wiper Motor (Service Manual procedure 17502502)
- Front Suspension

3

Remove the [Shotgun Outer](#).





Removal

1 Remove the original component.

A Use a drill with a 6.7 mm (17/64 in) bit to drill completely through the spot welds shown.

▲ Factory Spot Weld (x4)



NOTE: A structural rivet and structural bulb rivets will be installed in these locations in a [later step](#).



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

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

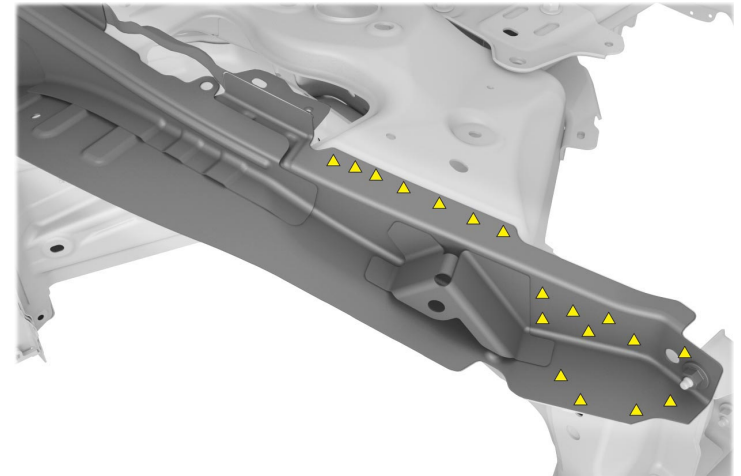
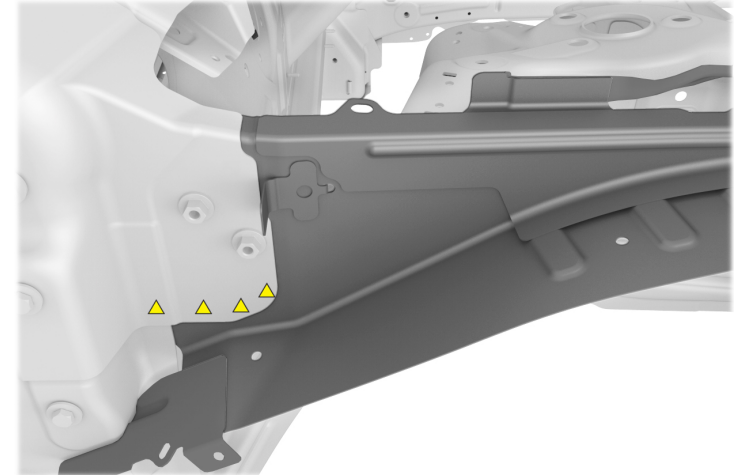
▲ Factory Spot Weld



NOTE: Unless specifically instructed otherwise, spot welds should be drilled out or ground down on the component being removed to avoid damaging surrounding components.



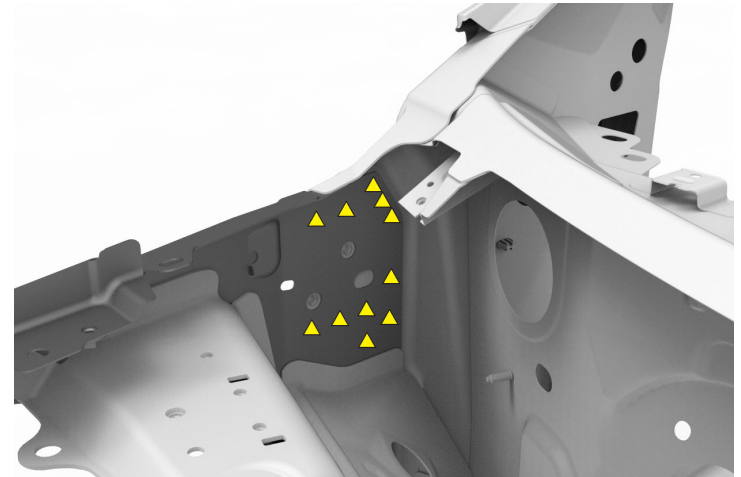
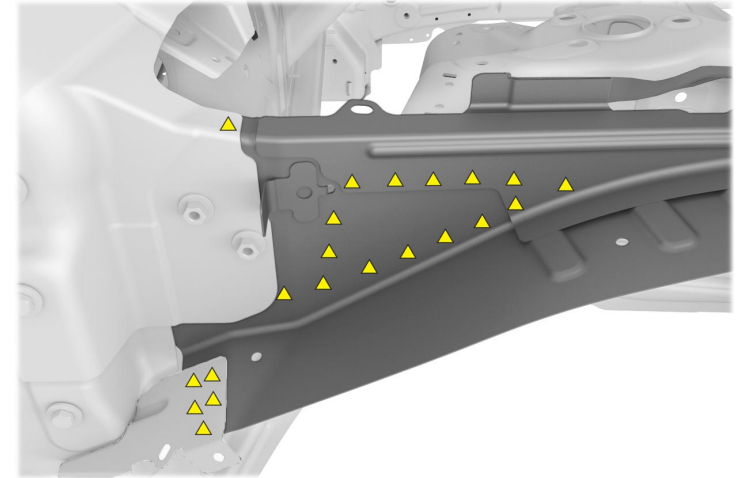
NOTE: Factory spot weld locations shown are approximate. Exact spot weld locations and number vary from vehicle to vehicle.





Removal

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





Removal

1 Remove the original component (continued).

C Use a heat gun to heat the adhesive joints, and then use a hammer and chisel to remove the original component.



WARNING: Do not heat any adhesive joints of components that are not being removed. Heating adhesive joints weakens the adhesive bond and could compromise vehicle crash integrity.

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.




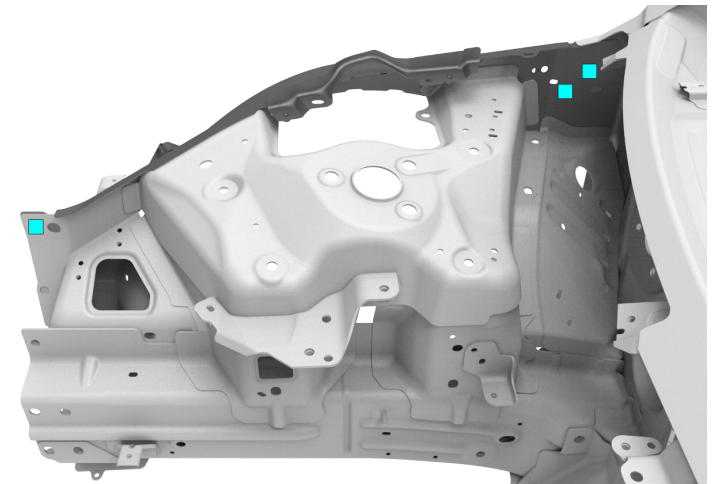
Replacement

1 Prepare for installation.

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

B Temporarily install the 3 M8 bolts shown to secure the component in place, but do not torque them at this time.

 Bolt, hex-head (x3)



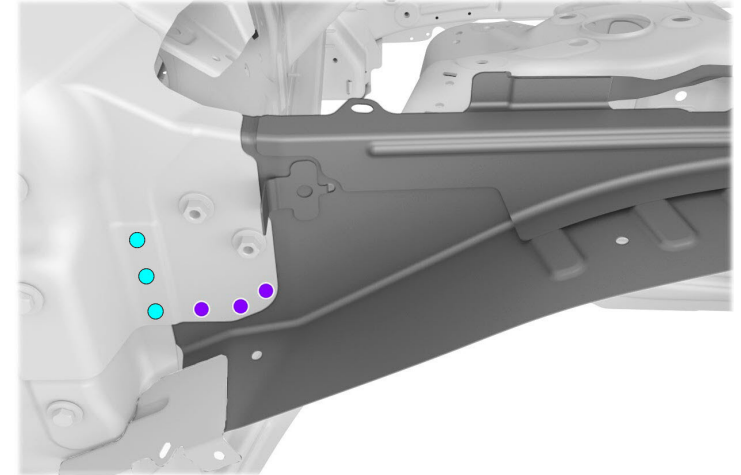


Replacement

1 Prepare for installation (continued).

C Mark the fastener locations on the new component.

- Structural Bulb Rivet, 6.5 mm (x3)
- High Strength Structural Rivet, 6.5 mm (x3)



D Use a drill with a 6.7 mm (17/64 in) bit to drill holes for structural bulb rivets and structural rivets.



CAUTION: Do not damage the Shock Tower.



NOTE: Drill through the existing holes that were created in an [earlier substep](#).



Replacement

1

Prepare for installation (continued).

E

Mark the surface preparation boundary lines on the new component and on the vehicle.

F


Remove the new component.



Replacement

1 Prepare for installation (continued).

G Mark the bond path areas on the new component and the vehicle. These areas will be prepared for bonding in the next step.

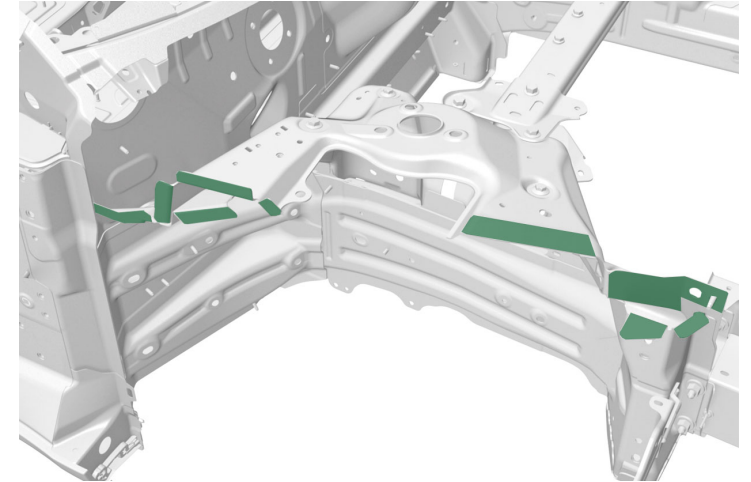
 Steel-to-Steel Bond Path



NOTE: The bond path areas on the inside of the A-Pillar Outer Reinforcement are not shown.



NOTE: Mark the bond path areas on the new component that correspond to the bond path areas on the vehicle.



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.

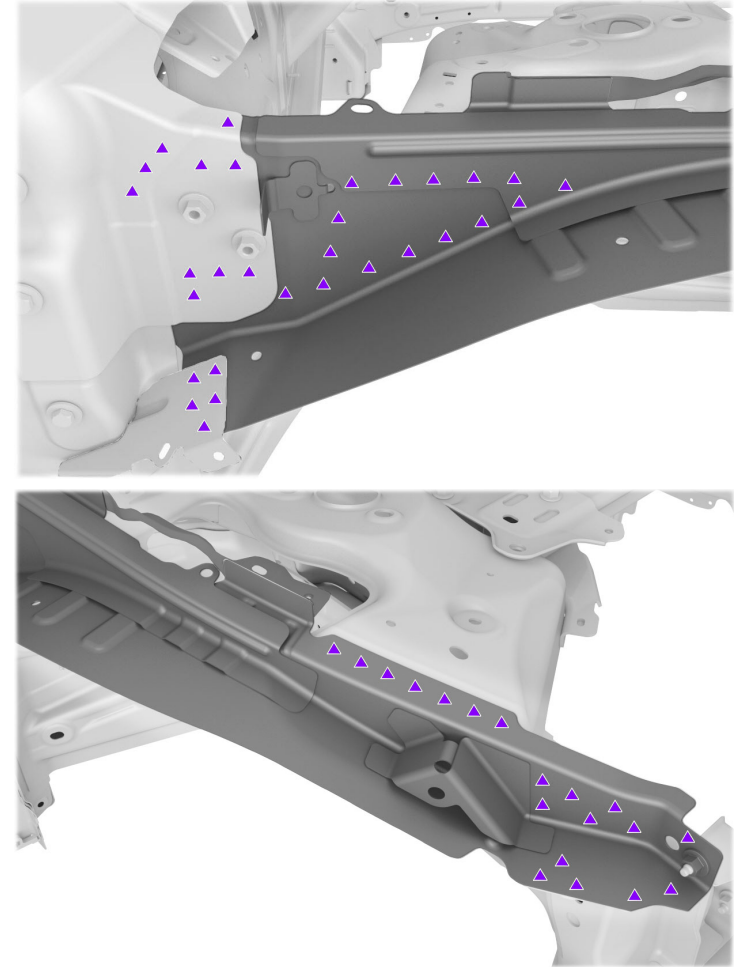


Replacement

2 Prepare the surfaces (continued).

B Mark the weld areas on the new component or components and the vehicle.

▲ Installation Spot Weld





Replacement

2 Prepare the surfaces (continued).

C 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 weld 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.

D Clean all the bond paths and weld areas 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.



Replacement

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.



CAUTION: If any bare metal bond paths have been exposed for two hours or longer, abrade the bond paths again to remove oxidation, then clean the bond paths with isopropyl alcohol (IPA).



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.



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

B

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




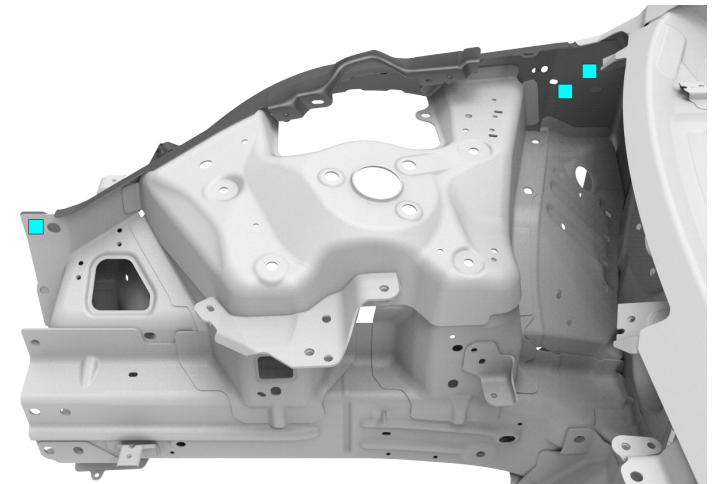
Replacement

4 Install the new component.

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

B Temporarily install the 3 M8 bolts shown to secure the component in place, but do not torque them at this time.

 Bolt, hex-head (x3)





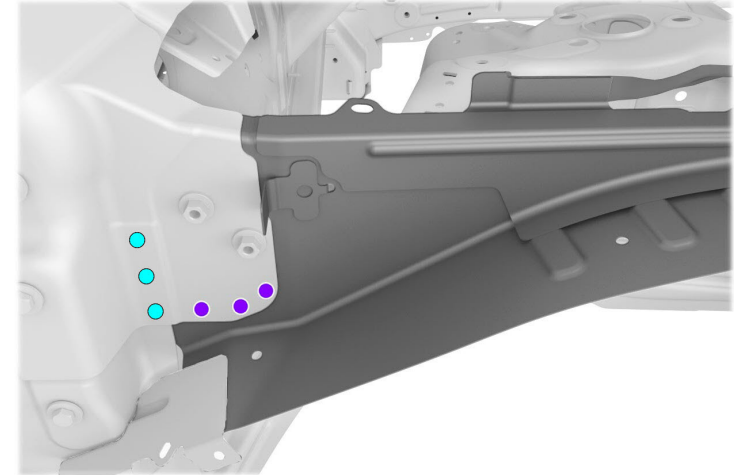
Replacement

4 Install the new component (continued).

C Insert the structural bulb rivets and structural rivets.

● Structural Bulb Rivet, 6.5 mm (x3)

● High Strength Structural Rivet, 6.5 mm (x3)



D Install the structural bulb rivets and structural rivets.



Shotgun Inner

Replacement

4 Install the new component (continued).

E

Tighten the 3 M8 bolts that secure the new Shotgun Inner in place.



NOTE: These bolts will be removed after the adhesive cures.

F

Wipe off any excess adhesive.



Replacement

4 Install the new component (continued).

G Perform resistance spot welding.
▲ Installation Spot Weld



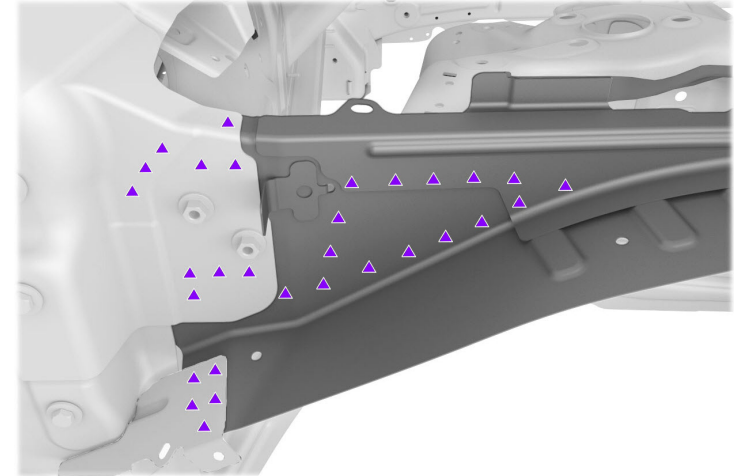
WARNING: Failure to follow all welding safety precautions, including the use of personal protective equipment, could result in serious injury or property damage. Only technicians who have successfully met Tesla’s requirements for welding training are authorized to weld structural components on Tesla vehicles.



CAUTION: Do not weld on a Tesla vehicle with an energized high voltage or 12V system. Welding on a Tesla vehicle with an energized high voltage or 12V system might damage vehicle components.



CAUTION: Use only insulated clamps within 200 mm (8 in) of resistance spot weld locations. Do not perform resistance spot welding when there is an uninsulated clamp within 200 mm (8 in) of the spot weld location.

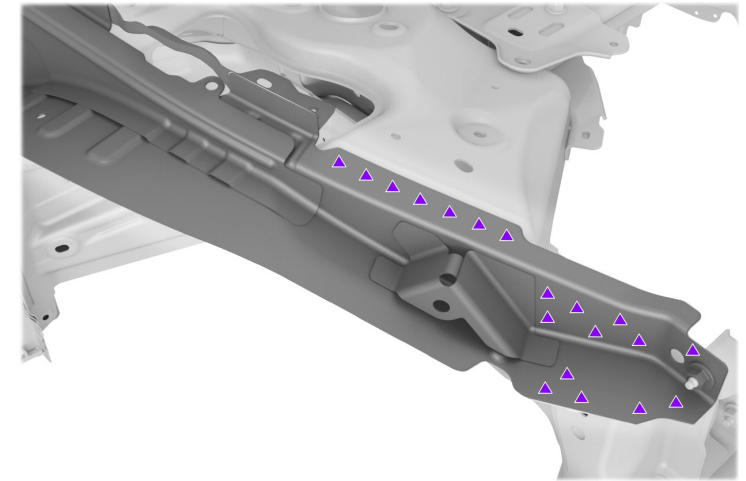




Replacement

4 Install the new component (continued).

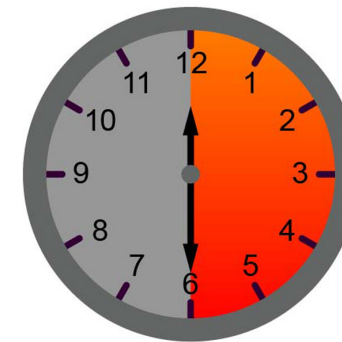
G Perform resistance spot welding (continued).



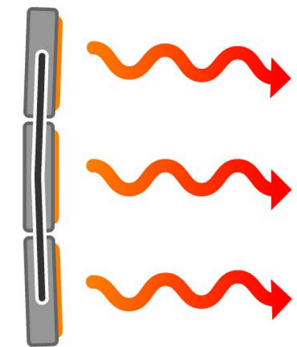
H Bake the structural adhesive so that the bonded panels reach a temperature of 60°C-80°C (140°F-176°F) for at least 30 minutes to achieve full strength.



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

Seal the seams in the factory locations, and as necessary.

6

Install the new [Shotgun Outer](#).

