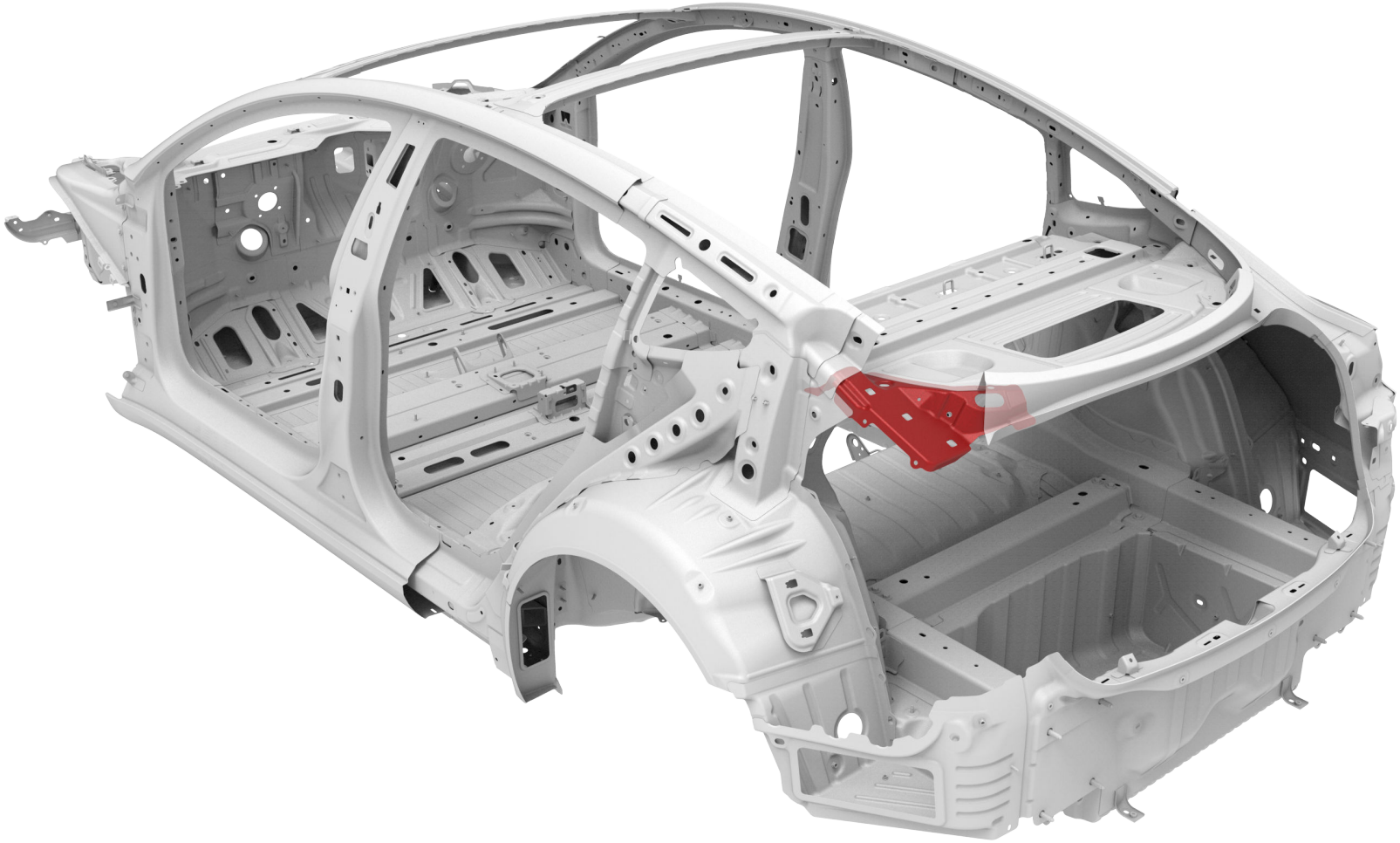
Parcel Shelf Rear Extension



Parts List

Quantity	Part Number	Description	Image / Notes
1	1094693-S0-A (LH) 1094694-S0-A (RH)	M3 EXTN, PARCEL SHELF RR	
9 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 rivets needed; order 10 rivets	1069308-00-A	Countersunk Rivet, 4.8 mm Short	All rivets come in packages of 10; order all rivets in multiples of 10.
1 rivets needed; order 10 rivets	1069329-00-A	Flow Form Rivet S18	All rivets come in packages of 10; order all rivets in multiples of 10.
4	1008842-00-A	BOLT PANHEAD FLANGE M6-1.00x12 ZINC ALUMINUM	
4	1016227-00-A	NUT, HEX, FLANGE,M6-1.0x14	
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.

Parts List

Quantity	Part Number	Description	Image / Notes
1	_	Seam Sealer	Source locally; not available from Tesla.

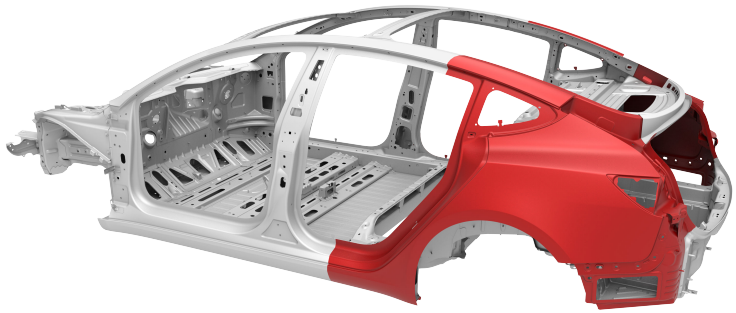
These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Manual.

Repair Information

Repair Information	Warnings and Cautions	Special Tools
This procedure is for the left-hand component; the procedure is identical for the right-hand component.	**WARNING:** Wear the appropriate personal protective equipment (PPE) when performing this procedure. **CAUTION:** This procedure involves both steel and aluminum components. Use the appropriate tools at each step to avoid cross-contamination. Refer to BR-17-10-005, “Model 3 Body Structure Materials and Allowed Operations,” for more information.	The special tools listed below are required to perform this procedure: • Flow Form Rivet Installation Tool • Microstop Countersink kit Use only approved fastener installation tools for structural repairs. Refer to BR-16-92-001, "Approved Fasteners and Fastener Installation Tools for Structural Repairs" for a list of current approved fastener installation tools.

Prerequisites

Remove the Quarter Outer Complete.

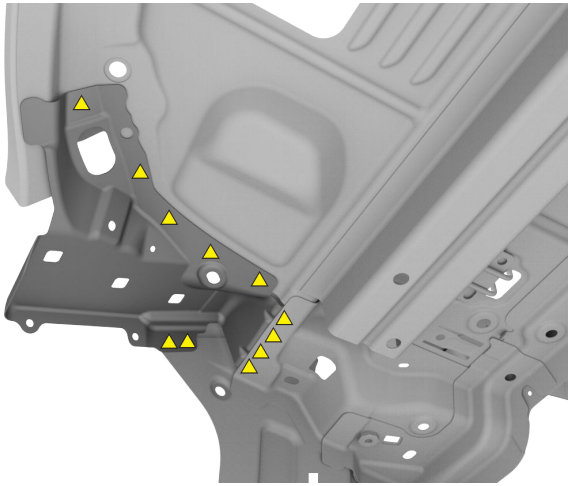


Removal

A

Use a drill with a spot weld bit to drill out the factory spot weld. Use a belt sander to sand down any factory spot welds that cannot be reached with a drill.

△ Factory Spot Weld (x11)

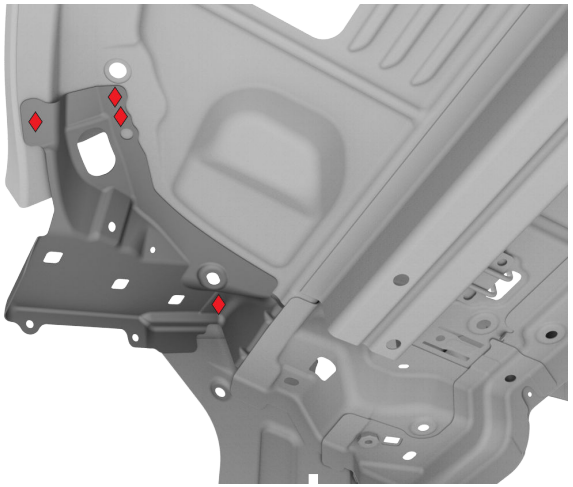


NOTE: Factory spot weld locations shown are approximate. Exact spot weld locations and number vary from vehicle to vehicle.

B

Use an SPR removal tool or a drill with a high-strength steel bit to remove the factory self-piercing rivets. Use a belt sander for any factory self-piercing rivets that cannot be removed with an SPR removal tool or a drill.

◆ Factory SPR (x4)



Removal

(continued).

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

WARNING: Do not heat the adhesive joints above 100°C (212°F). Heating the adhesive joints above 100°C (212°F) can weaken the aluminum and compromise vehicle crash integrity.

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.

D Use a disc sander with a medium-abrasive surface conditioning disc to remove any remaining materials from the mating surfaces. 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.

WARNING: Use only sanding wheels and belts that are 80 grit or finer on aluminum components. Using sanding wheels or belts that are coarser than 80 grit can cause fractures in the aluminum.

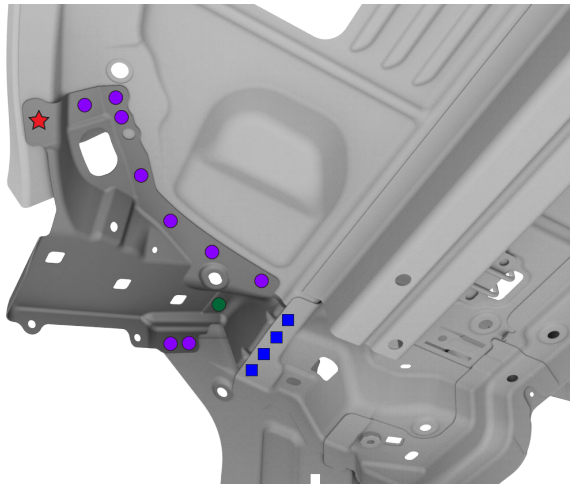
Replacement

1 Prepare for installation.

A Put the new component into position and secure it in place.

B Mark the fastener locations on the new component.

- Structural Bulb Rivet, 6.5 mm (x9)
- Countersunk Rivet, 4.8 mm Short (x1)
- Flow Form Rivet S18 (x1)
- Bolt, Torx-head (x4)

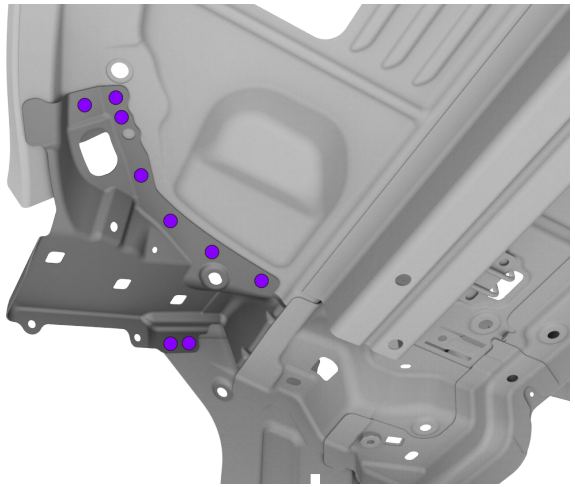


Replacement

1 Prepare for installation (continued).

C Use a drill with a 6.7 mm bit to drill holes for structural bulb rivets.

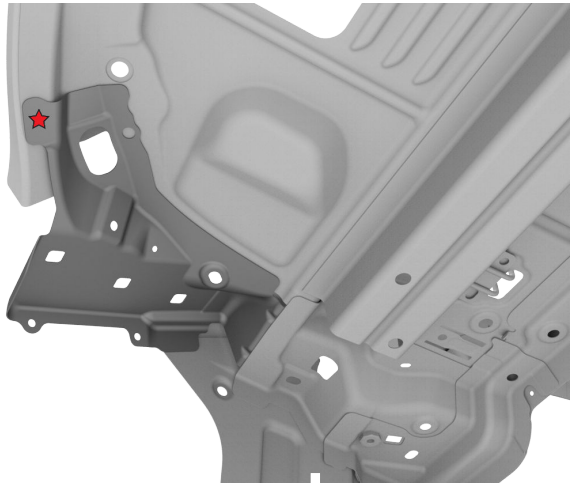
- Structural Bulb Rivet, 6.5 mm (x9)



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

D Create an 8 mm hole for the Flow Form rivet.

- Flow Form Rivet S18 (x1)



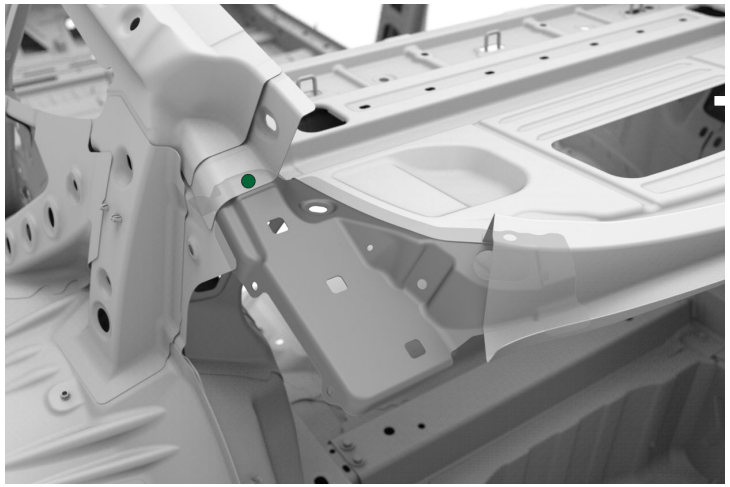
Replacement

1 Prepare for installation (continued).

E Drill a 4.8 mm hole for a countersunk rivet.

- Countersunk Rivet, 4.8 mm Short (x1)

NOTE: Drill through the original factory SPR hole on the vehicle.



F Use a drill with the Microstop countersink cage assembly and the appropriate-sized countersink bit to countersink the holes for countersunk rivets (Microstop Countersink Kit, Tesla p/n 1133101-00-A).

NOTE: If the depth adjustment for the Microstop countersink cage assembly has not already been set, do the procedure in the Microstop Countersink Kit tool instructions to adjust the tool.

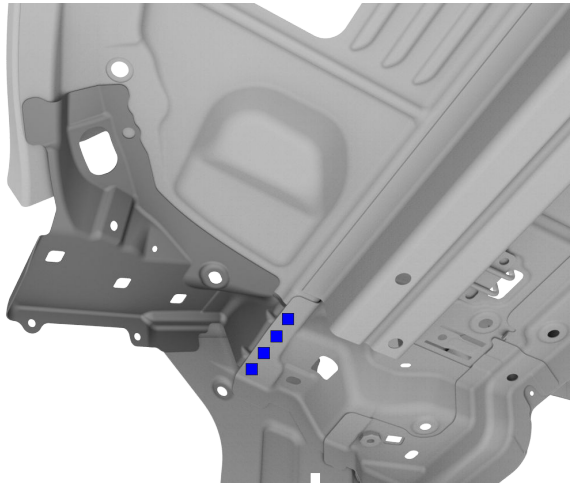
Replacement

1 Prepare for installation (continued).

G Use a drill with a 6 mm (1/4 in) bit to drill holes for the M6 Torx head bolts.

- Bolt, Torx-head (x4)

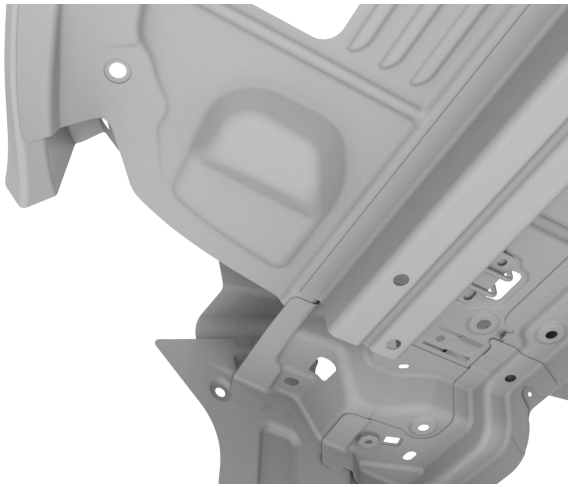
H Mark boundary lines along all mating surfaces between the new component and the vehicle for surface preparation.



Replacement

1 Prepare for installation (continued).

I Remove the new component.



2 Prepare the surfaces.

A Use a red Scotch-Brite pad or equivalent to scuff the e-coat on the mating surfaces of the new component and the vehicle.

Replacement

2 Prepare the surfaces (continued).

B Clean all the mating surfaces and weld areas of the new component or components and 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 mating surfaces of 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 vehicle.

4 Install the new component.

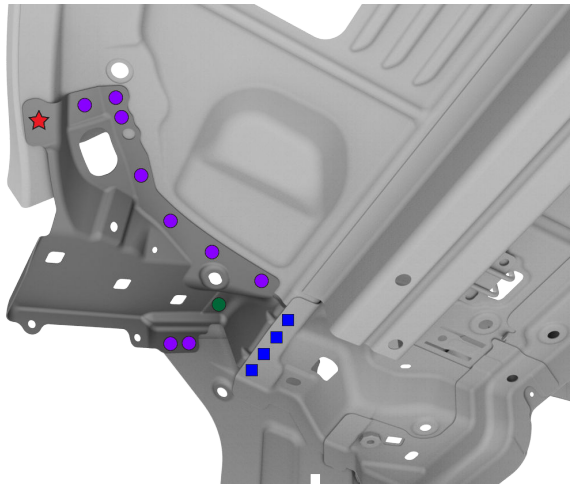
A Put the new component into position and secure it in place.

Replacement

4 Install the new component (continued).

B Insert all structural rivets, countersunk rivets, flow form rivets, and Torx head bolts and nuts.

- Structural Bulb Rivet, 6.5 mm (x9)
- Countersunk Rivet, 4.8 mm Short (x1)
- Flow Form Rivet S18 (x1)
- Bolt, Torx-head (x4)



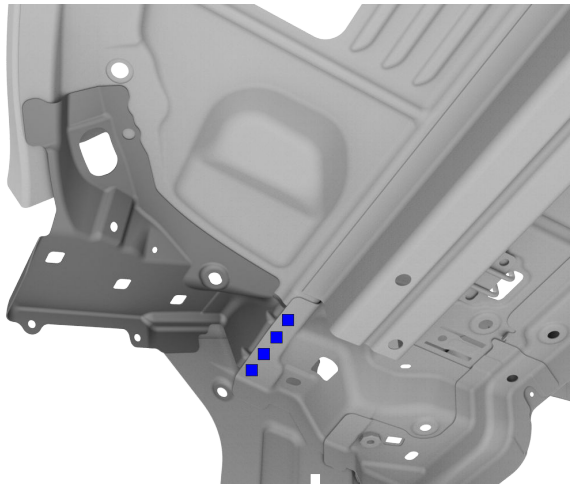
C Install all structural, countersunk, and Flow Form rivets.

Replacement

4 Install the new component (continued).

D Torque the M6 Torx head fasteners to 16 Nm (12 ft lbs).

■ Bolt, Torx-head (x4)



E Clamp all bonded areas that are not secured with a fastener.

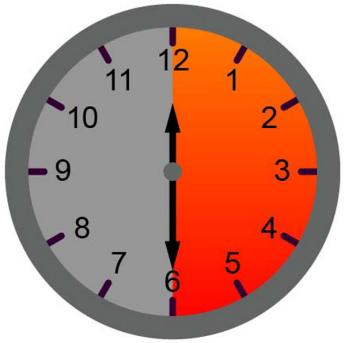
Replacement

4 Install the new component (continued).

F Wipe off any excess adhesive.

G 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.



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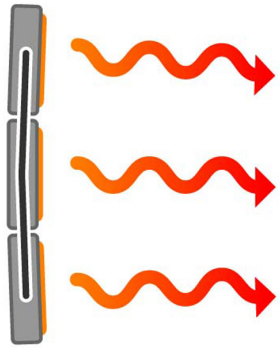

60°C–80°C

Replacement

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

6 Install the Quarter Outer Complete.