

L405 Side step Tapping .pdf

Reference SSM61977

Models Range Rover (All New) / L405

Title L405 Side Step Fitment Issues

Category Accessories

Last modified 20-Dec-2012 00:00:00

Symptom General Accessories

Please use the format structure below when creating any new SSM.

Issue:

On all L405 vehicles built to date the thread forming bolts will not fit into the 8 off bosses (4 per side) in the body structure.

Part numbers affected are:-

VPLGP0123 - Deployable side step

VPLGP0114 - Fixed side step

VPLGP0100 - Side tubes

Cause:

Content The current hole sizes in the body structure are undersized, preventing the bolts from fitting. This situation will be rectified and a clear VIN will be issued on a follow up SSM once introduced.

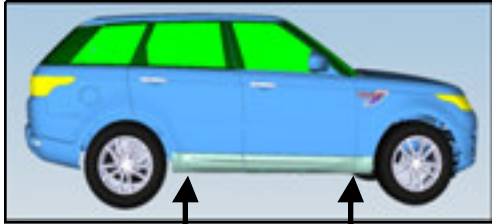
Action:

The 8 off bosses in the body structure need to be drilled out with a 9.3mm cobalt drill and then tapped out with an M10 tap. Please use a suitable lubricant whilst tapping out the bosses.

Please see attached JLR Repair Standard.

NOTE THIS IS A RE-RUN OF SSM 60317 AS THE SYSTEM DID NOT PUBLISH THE PREVIOUS VERSION.

Describe the Repair Method:

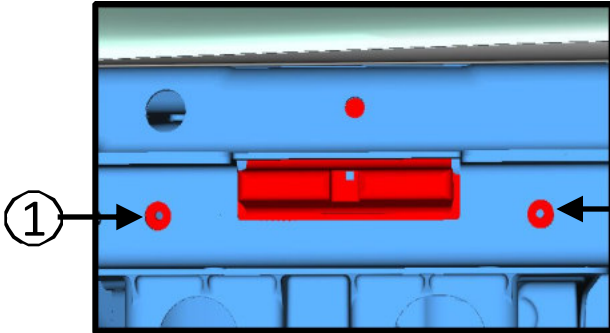


A

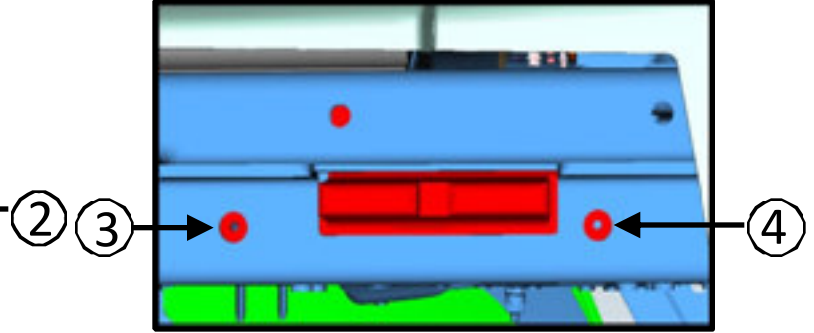
B

**THIS PROCESS TO BE CARRIED OUT BETWEEN STEPS 31 & 32 IN THE FOLLOWING FITTING INSTRUCTION:
Deployable Side Steps - CK5M-16B586-D FIT**

1. INCREASE EXISTING HOLES (1-4) TO $\varnothing 9.3\text{mm}$.
2. TAP HOLES USING M10 PLUG TAP.



VIEW ON ARROW A



VIEW ON ARROW B