

JLRTB02037NAS1

**TECHNICAL BULLETIN**

03 NOV 2020



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NOTE: The information in Technical Bulletins is intended for use by trained, professional Technicians with the knowledge, tools, and equipment required to do the job properly and safely. It informs these Technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The procedures should not be performed by 'do-it-yourselfers'. If you are not a Retailer, do not assume that a condition described affects your vehicle. Contact an authorized Land Rover service facility to determine whether this bulletin applies to a specific vehicle.

**INFORMATION****SECTION:**

501-03

**SUBJECT/CONCERN:**

Dust Entering The Passenger Compartment

**AFFECTED VEHICLE RANGE:**

| <b>MODEL:</b> | <b>MODEL YEAR:</b> | <b>VIN:</b>    | <b>ASSEMBLY PLANT:</b> |
|---------------|--------------------|----------------|------------------------|
| I-PACE (X590) | 2019-2020          | F60145-F81898  | Graz (Austria)         |
| I-PACE (X590) | 2020 Onwards       | 600001 Onwards | Graz (Austria)         |

**MARKETS:**

NORTH AMERICA

**CONDITION SUMMARY:****SITUATION:**

Dust can be found entering the passenger compartment when the doors are opened. The dust can be found on the second row seats, tread plates and lower C-pillar molding.

**CAUSE:**

Dust collects on the door shut surfaces and is drawn into the passenger compartment by the inward airflow when a door is opened.

**ACTION:**

Follow the instructions below.

**PARTS:****NOTES:**

- An allowance equivalent to \$12.00 US has been allocated to locally source 4 sachets of 3M™ Adhesion Promoter 06396 (or equivalent) and 2 sachets of 3M™ surface cleaner (or equivalent), per vehicle.
- 1 sachet of 3M™ Adhesion Promoter 06396 (or equivalent) is required for each door.
- 1 sachet of 3M™ surface cleaner (or equivalent) will clean the surface of 2 doors.

| PART NUMBER | DESCRIPTION  | QUANTITY |
|-------------|--|----------|
| T4K15466    | Front door - Lower seal kit  | 1        |
| T4K15467    | Rear door - Lower seal kit   | 1        |
| ZZZ001      | 4 sachets of 3M™ Adhesion Promoter 06396 and 2 sachets of 3M™ surface cleaner (or equivalents) | \$12.00  |

**WARRANTY:**

**NOTES:**

- Repair procedures are under constant review, and therefore times are subject to change; those quoted here must be taken as guidance only. Use TOPIx to obtain the latest repair time.
- The JLR claims submission system requires the use of causal part numbers. Labor only claims must show the causal part number with a quantity of zero.

| DESCRIPTION  | SRO      | TIME (HOURS) | CONDITION CODE | CAUSAL PART |
|--|----------|--------------|----------------|-------------|
| JLRTB02037 - Lower door seal - Install - Vehicle set | 99.01.11 | 0.5          | 49             | T4K1398     |

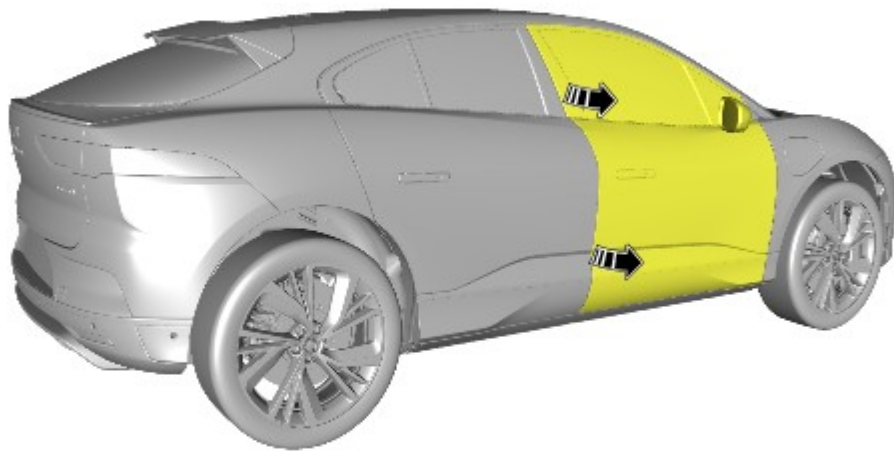
**NOTE:**

Normal Warranty procedures apply.

SERVICE INSTRUCTION - FRONT DOOR

1. Raise and support the vehicle (see TOPIx Workshop Manual section 100-02: Jacking and Lifting - Description and Operation - Jacking and Lifting).

2.



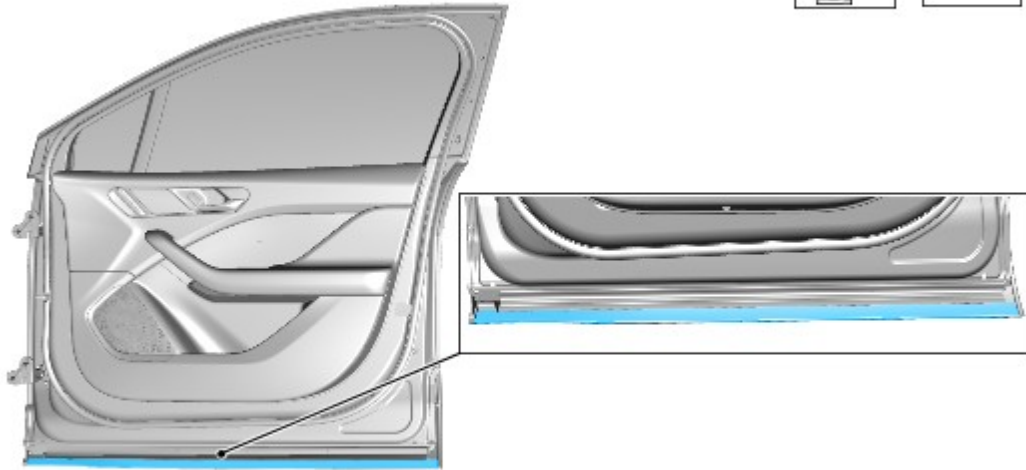
E264123

Open the front right door.

3.

**NOTE:**

Allow a minimum of 60 seconds for the 3M™ surface cleaner (or equivalent) to dry before continuing to step 4.



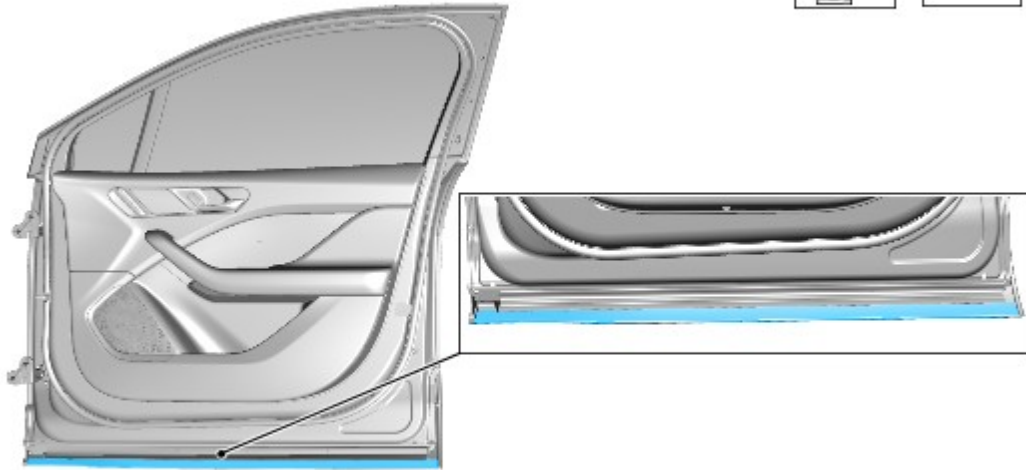
E264125

Using 3M™ surface cleaner (or equivalent), clean the inside edge of the front right door lower molding, as shown highlighted in the illustration.

4.

**NOTE:**

Allow a minimum of 90 seconds for the 3M™ adhesion promoter (or equivalent) to dry before continuing to step 5.



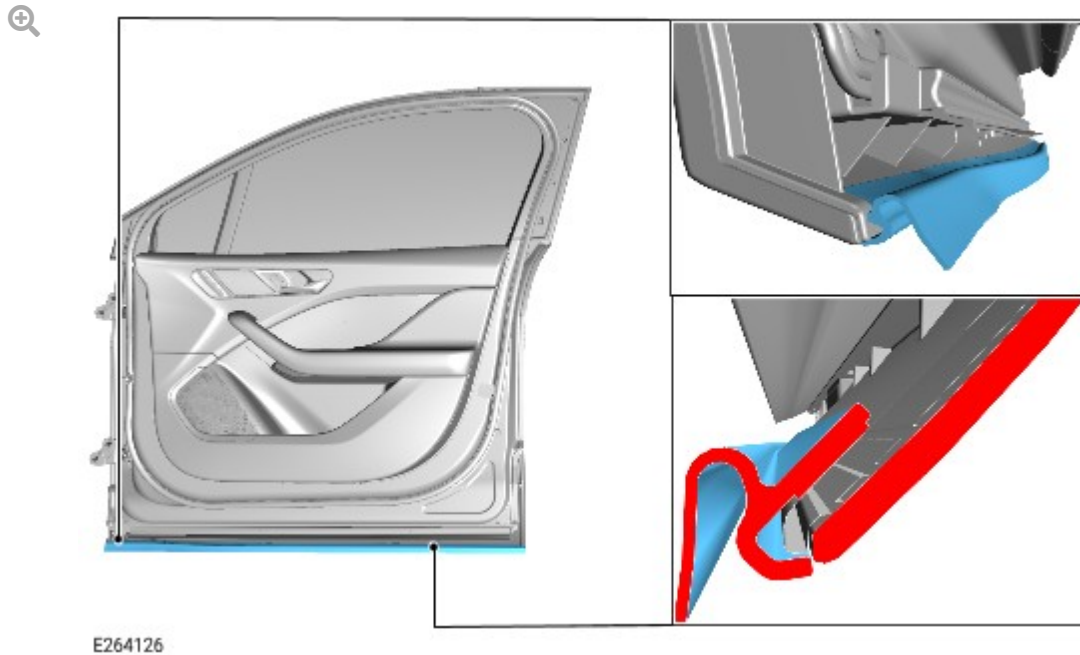
E264125

Following the manufactures specifications, apply the 3M™ adhesion promoter (or equivalent) to the inside edge of the front right door lower molding, as shown highlighted in the illustration.

5.

**NOTES:**

- Make sure the new front right door lower seal is installed following the contour of the front right door lower molding.
- Do not completely remove the adhesive backing before installing the new front right door lower seal.



Gradually remove the adhesive backing and install the new front right door lower seal in small sections at a time. Apply firm pressure along the entire length of the lower seal to make sure the adhesive is bonded to the front right door lower molding.

6.

**NOTE:**

Do not expose the new front right door lower seal to water for a minimum of 24 hours.

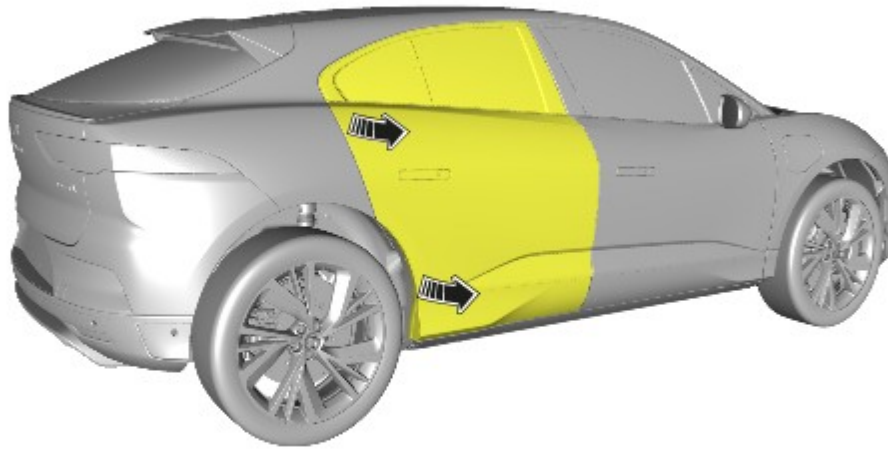
Close the front right door and allow a minimum time of 20 minutes, at 21°C (70°F), for the adhesive to bond.

7. Repeat the steps 2 to 6 for the front left door and then continue to 'Service Instruction - Rear Door'.

SERVICE INSTRUCTION - REAR DOOR

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1.



E264124

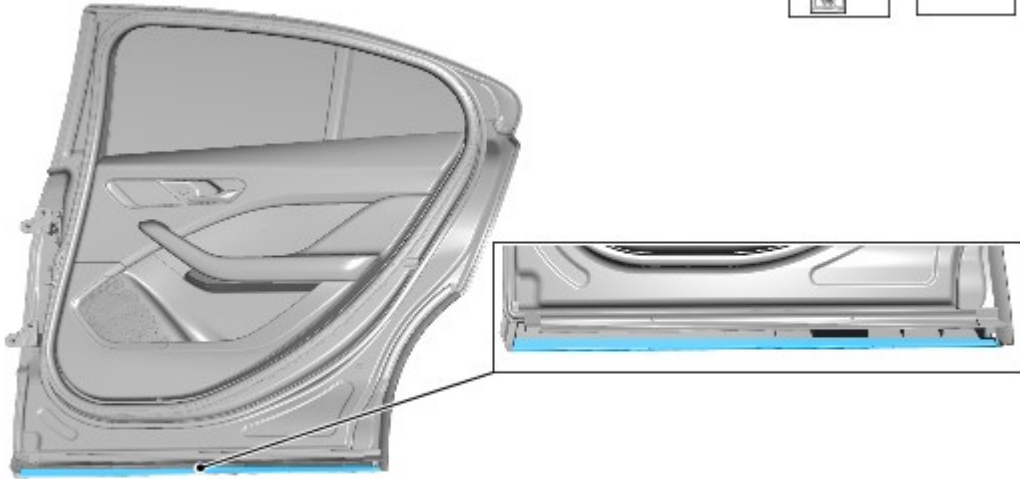
Open the rear right door.

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2.

**NOTE:**

Allow a minimum of 60 seconds for the 3M™ surface cleaner (or equivalent) to dry before continuing to step 3.



E264128

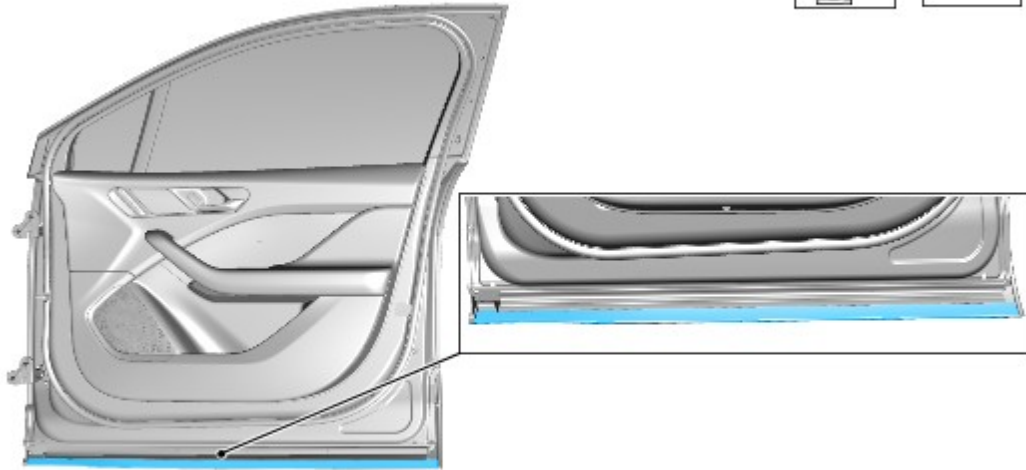
Using 3M™ surface cleaner (or equivalent), clean the inside edge of the rear right door lower molding, as shown highlighted in the illustration.



3.

**NOTE:**

Allow a minimum of 90 seconds for the 3M™ adhesion promoter (or equivalent) to dry before continuing to step 4.



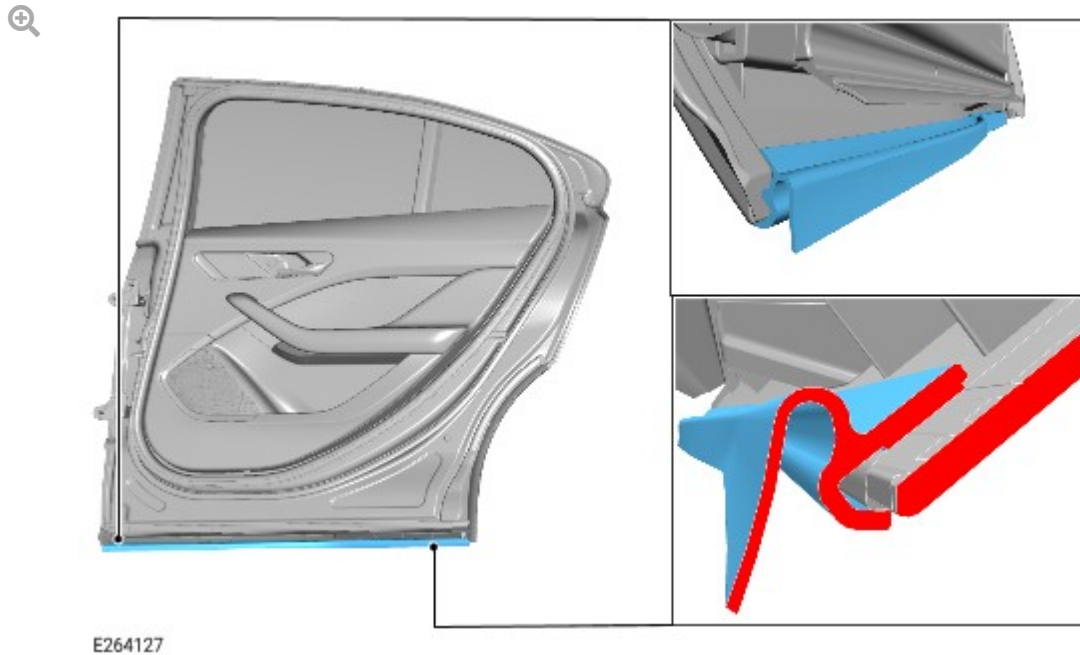
E264125

Following the manufactures specifications, apply the 3M™ adhesion promoter (or equivalent) to the inside edge of the rear right door lower molding, as shown highlighted in the illustration.

4.

**NOTES:**

- Make sure the new rear right door lower seal is installed following the contour of the rear right door lower molding.
- Do not completely remove the adhesive backing before installing the new rear right door lower seal.



Gradually remove the adhesive backing and install the new rear right door lower seal in small sections at a time. Apply firm pressure along the entire length of the lower seal to make sure the adhesive is bonded to the rear right door lower molding.

5.

**NOTE:**

Do not expose the new rear right door lower seal to water for a minimum of 24 hours.

Close the rear right door and allow a minimum time of 20 minutes at 21°C (70°F) for the adhesive on the bond.

6. Repeat the steps 1 to 5 for the rear left door.

7. Lower the vehicle.