 Tesla, Inc. Service Bulletin		<h2>Retrofit A/C Compressor Pipes With Support Bracket, North America</h2>	
SB-23-18-004 April 6, 2023			
Classification		Section/Group	Mobile Service
Repair Bulletin		18 - Thermal Management	Can Perform (where permitted)
Model Year	Model	Country/Region	Build Location
2021 - 2023	Model S, Model X	North America	Fremont
<small>The model(s) and model year(s) listed are a general approximation of the affected VIN list. Refer to the VIN/Bulletin Tracker or Customer/Vehicle profile to determine applicability of this bulletin for a particular vehicle.</small>			

Repair Bulletin: This repair bulletin provides instructions on addressing a possible customer concern regarding the operation of Tesla vehicles. These instructions should only be performed by trained professionals.

Condition

Certain Model S and Model X vehicles may require a support bracket retrofit to the A/C compressor pipes.


Correction

If a service operation has removed the underhood storage unit, use the opportunity to inspect the A/C compressor discharge and suction pipes for a support bracket securing the pipes together. If no bracket is present, retrofit the support bracket between the pipes to reduce the stress on the discharge pipe.

Correction Description	Correction	Time
SB-23-18-004 Not Applicable	S012318004	0.00
Inspect Vehicle For Support Bracket, Retrofit Not Necessary	S022318004	0.05
Inspect And Retrofit A/C Compressor Pipes With Support Bracket (Without Foam Sleeve)	S032318004	0.05
Inspect And Retrofit A/C Compressor Pipes With Support Bracket (With Foam Sleeve)	S042318004	0.05

Part Number	Description	Quantity
Parts Required 1780132-00-A	SUCTION/DISCHARGE LINE SUPPORT BRACKET	1
<small>This part number was current at the time of publication. Use the revisions listed or later, unless otherwise specified in the Parts Catalog.</small>		
Shop Supplies 1061317-00-A	Electrical Tape, Yellow	

Procedure

 **NOTE:** This procedure is to be performed when the underhood storage unit is removed for another service operation.

1. Inspect the A/C compressor pipes for a support bracket (Figure 1 and 2):
 - If a support bracket is installed, go to step 5 to complete this procedure. Use correction code S022318004.
 - If a support bracket is not installed, continue to the next step.



Figure 1 – Support bracket on pipes without foam sleeve



Figure 2 – Support bracket (under tape) on pipes with foam sleeve

2. Press the smaller clip of the support bracket onto the A/C compressor discharge pipe (Figures 3 and 4).



Figure 3 – Suction pipe without foam sleeve

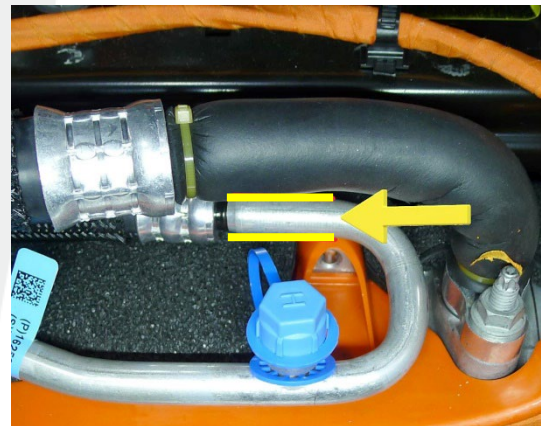


Figure 4 – Suction pipe with foam sleeve

3. If the suction pipe is without the foam sleeve, perform these steps.
 - a. Rotate the support bracket up to the suction pipe (Figure 5).

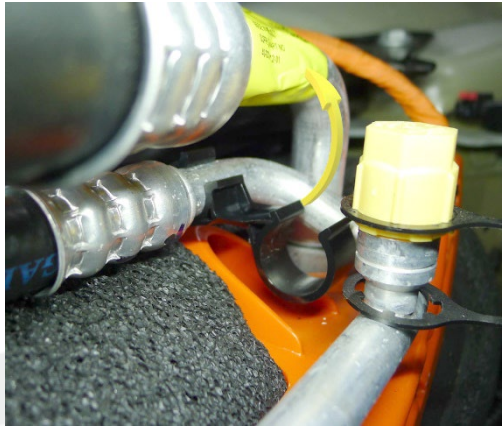



Figure 5

- b. Press the larger clip of the support bracket onto the suction pipe.

 **NOTE:** If there is a label on the suction pipe, roll the label against the pipe, and then press the support bracket on.

- c. Verify that the support bracket fits both pipes securely (Figure 6).



Figure 6

- d. Go to step 5 to complete this procedure. Use correction code S032318004.

4. If the suction pipe has a foam sleeve, perform these steps:

- a. Rotate the support bracket up to the suction pipe (Figure 7).

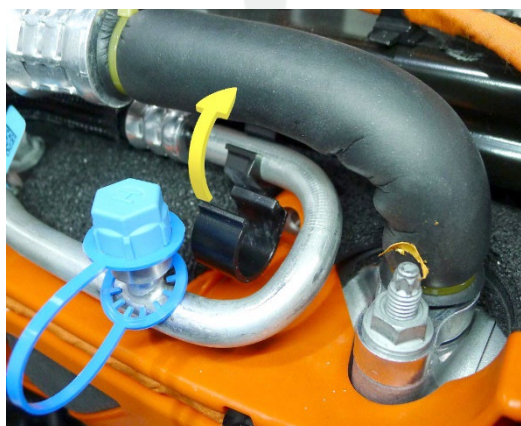


Figure 7

- b. Hold the support bracket against the foam sleeve, and mark the edges of the bracket where it touches the foam (Figure 8).

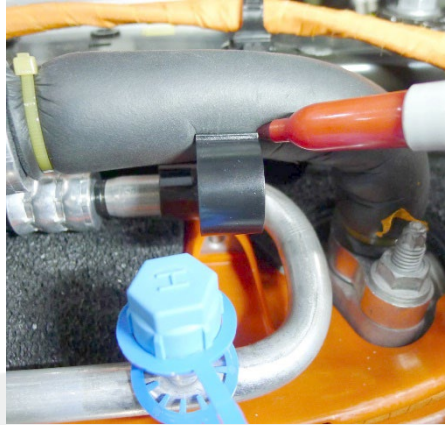


Figure 8

- c. Use a utility knife to cut a flap in the foam sleeve at the markings (Figure 9).

⚠ WARNING: Wear cut resistant gloves and other PPE as appropriate.

⚠ CAUTION: Do not damage the suction pipe underneath the foam.



Figure 9

- d. Lift the flap cut into the foam sleeve, and press the larger clip of the support bracket onto the suction pipe (Figure 10).



Figure 10

- e. Prepare a piece of the electrical tape 130 mm long, and split the ends for 35 mm (Figure 11).

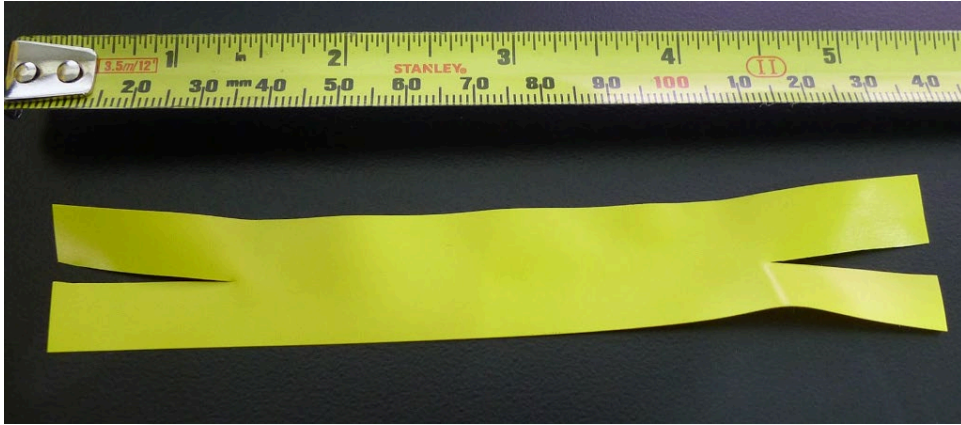


Figure 11

- f. Wrap the tape around the foam sleeve to close the flap and secure the bracket support to the suction pipe (Figure 12), and overlap the tape ends in a criss-cross pattern.

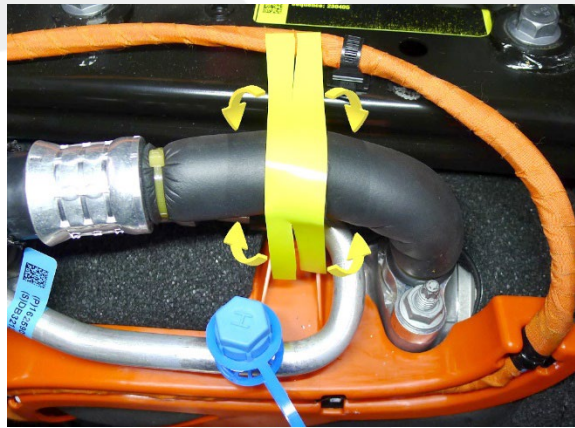


Figure 12

- g. Go to step 5 to complete the procedure. Use correction code S042318004.
5. Return to the service procedure in progress before this bulletin was performed.