



BENTLEY

Bentley Bulletin

Aftersales

21-037

June 16, 2021

To: Parts & Service

Subject: RECALL CAMPAIGN – Bentley 21MY Bentayga Rear Axle Trailing Arm Lock Nut (RE20/21)

RECALL CAMPAIGN – Bentley 21MY Bentayga Rear Axle Trailing Arm Lock Nut (RE20/21)

We are writing to advise you that Bentley Motors has determined a potential safety defect may exist on Bentley 21MY Bentayga vehicles, with the rear axle trailing arm lock nut, manufactured between October 2020 and December 2020.

This letter will provide you with all of the information to explain why this recall is being initiated, the actions you are required to take and provide you with the appropriate administrative details.

Due to stress corrosion on lock nuts of particular production batches, the nut of the eccentric bolt on the trailing arm of the rear axle may break which may cause alterations in the wheel alignment of the rear axle. This could be noticed by a steering wheel misalignment when driving straight ahead or by the vehicle pulling to one side when braking or accelerating. It cannot be ruled out that the rear axle could suddenly and uncontrollably move in the wrong direction at higher speeds. This can lead to a loss of vehicle control and a crash without warning.

Owners of affected cars will be notified in writing week beginning 14th June 2021

The Bentley Technical Product Information (TPI) document, has been posted to ElsaPro and details the procedure which must be followed exactly (copy attached at the end of this Bulletin).

It is not necessary to contact us for authorisation. We will take our records from your warranty claim which must be generated and submitted immediately upon completion of the work. You are reminded that claims for recalls cannot contain any other warranty repairs. The warranty code and repair time are quoted within the TPI.

It is to our mutual advantage that this recall campaign goes as smoothly as possible. Should you have any questions or queries concerning this recall, please contact your Area Aftersales Manager.

Sincerely,

Aftersales Team
Bentley Motors, Inc.

Field campaign

Topic	Rear axle lower lever (right and left) Inner and outer nut replacement (RE21/17)
Market area	Australia E04 Bentley rest Asia and Australia (6E04),China 796 VW Import Comp. Ltd (Vico), Beijing (6796),Germany E02 Bentley rest Europe (6E02),Japan E03 Bentley Japan (6E03),United Arab Emirates E06 Bentley Middle East and Africa (6E06),United Kingdom E01 Bentley UK (6E01),United States E05 Bentley USA and rest America (6E05)
Brand	Bentley
Transaction No.	2063114/1
Campaign number	RB98
Note	
Type	
US code	

Vehicle data

Bentayga

Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
4V1*	2021	E		*	*	*

Documents

Document name
master.xml
re2117vinlist.pdf

Notes

Repair instructions

Technical background

All vehicles require replacement of the original (WHT 007 610) left and right hand rear axle lower lever inner and outer nuts (x4)

A new specification part (WHT 010 234) is now available, the inspection of the original nuts (Figure 1) prior to removal is imperative as this will confirm if any other components require replacement.

Replacement of WHT 007 610 (x4) nuts is mandatory on all vehicles

NOTE: For photographic purposes Figure 1 shows one side only

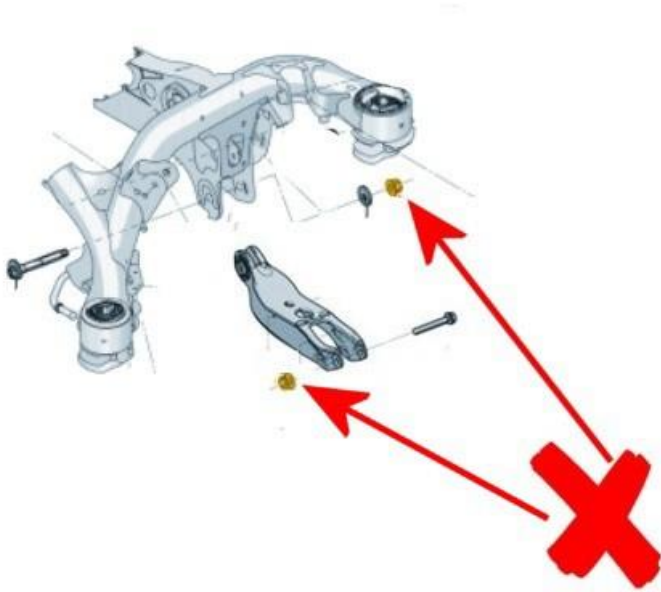


Figure 1

Remedy

Replacement of the left and right hand lower rear axle lever nuts (x4) is required due to a potential fracturing issue, the issue has been identified as a possible concern on a very low number of vehicles

Customer notification

Customers of affected vehicles will be notified in writing by their Bentley retailer to arrange an appointment.

Please ensure that all affected vehicles are checked and repaired at the nearest opportunity, make a note of the required action on the workshop order before it is signed by the customer.

If it is omitted to perform the work required during a workshop visit, the customer should be notified immediately.

You should also pass on this information to your new and used car sales departments so that affected vehicles are checked and repaired immediately

Warranty accounting instructions

Replacement of the rear axle lower lever nuts (x4) - All vehicles

Warranty type 710 or 790

Damage service number RB98

Damage code 0099

Criteria 01

Labour

Labour Operation Code 42 11 42 00

Time 50 TU

NOTE: The time of 50 TU also includes the replacement of (x4) rear axle lower lever inner and outer bolts including washers (left and right hand

side if required)

Alignment of applicable driver assist systems (Depending on vehicle specification)

- Vehicle front + rear measured wheel alignment checked - 44 95 03 00 - 110 TU
- Rear wheel camber adjust - 44 94 15 50 - 30 TU
- Rear wheel track adjust - 44 93 15 50 - 30 TU
- Front wheel camber adjust - 44 89 15 50 - 40 TU
- Front wheel track adjust - 44 88 15 50 - 20 TU
- (ACC) - Radar sensor checked + adjusted - 91 63 05 51 - 30 TU
- Overhead view camera adjusted - 90 83 15 00 - 40 TU
- Driver assist camera adjusted - 96 38 15 50 - 120 TU
- Control unit for (Lane change assist) adjusted - 96 35 15 00 - 50 TU
- Night vision system calibration - 90 80 15 50 - 40 TU
- Headlamps to adjust - 94 15 16 00 20 TU

Genuine parts

All vehicles require the original (*WHT 007 610*) left and right hand rear axle lower lever nuts (x4) replacing as below:

New Part number	Description	Quantity
WHT 010 234	Nut	4

*The following parts may not require replacing on all vehicles, please refer to the Work section for further details, should the parts require replacement, the left and right hand lower bolts and applicable washers **MUST** be replaced as below:*

Part number	Description	Quantity
WHT 007 043A	Washer	2
WHT 007 092A	Inner Bolt	2
N91 236 301	Outer Bolt	2

Parts supply

The required replacement parts **MUST** be ordered from Bentley Motors Limited Crewe or through your regional Bentley parts distribution centre

Parts despatch control

Not applicable

Questions and answers

1) What is the specific issue with the affected vehicles?

During manufacturing at the supplier, an error was made which resulted in individual batches of nuts being manufactured to the incorrect specification. The affected nuts are susceptible to hydrogen-induced stress corrosion cracking.

2) What repercussions does the fault have?

Should the nut crack, the rear axle tracking may change. This could be noticed by a steering wheel misalignment when driving straight ahead or by the vehicle pulling to one side when braking or accelerating. It cannot be ruled out that the rear axle could suddenly and uncontrollably move in the wrong direction at higher speeds. This can lead to a loss of vehicle control and a crash without warning.

3) Are any other Bentley models affected?

No, this issue only affects 444 specific Bentley vehicles. The affected vehicles have been identified using supplier and manufacturing records. Other vehicles are not affected by this issue.

4) Have you seen any reports on Bentley vehicles?

We are not aware of any reported occurrences on Bentley vehicles.

5) What is the fix?

Bentley authorised retailers will remove the out of specification nuts and replace them with correctly specified nuts. Following replacement, vehicle geometry and driver assistance systems will be checked and recalibrated as necessary. This will take approximately five hours dependant on specification of vehicle.

6) Can customers continue to drive the cars?

Yes, however, we encourage customers to arrange an appointment with their retailer as soon as possible. If while driving, steering wheel misalignment or pulling to one side during braking or accelerating is noticed, we recommend that customers proceed with caution and contact their retailer immediately.

7) Do I have to make an appointment?

Yes, that's important. Customers need to contact their retailer immediately.

Repair instructions

■ Notes

Technical background

All vehicles require replacement of the original (*WHT 007 610*) left and right hand rear axle lower lever inner and outer nuts (x4)

A new specification part (*WHT 010 234*) is now available, the inspection of the original nuts (Figure 1) prior to removal is imperative as this will confirm if any other components require replacement.

■
Replacement of *WHT 007 610* (x4) nuts is mandatory on all vehicles

NOTE: For photographic purposes Figure 1 shows one side only

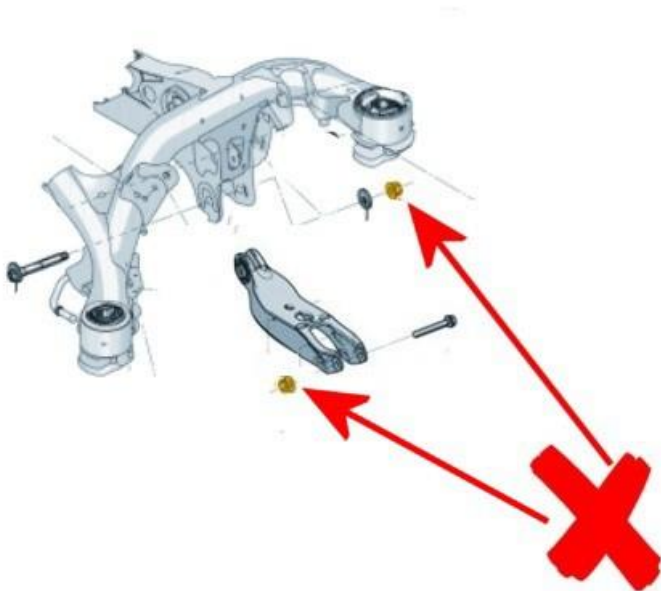


Figure 1

Check

If the vehicle is not already listed as repaired in the "Repair history" (in Elsa Pro) refer to the Identification section to check the presence of the red paint completion mark

Should neither be evident ("Repair history" or applicable paint mark) carry out the required work in accordance with these instructions

Genuine parts

■
All vehicles require the original (*WHT 007 610*) left and right hand rear axle lower lever nuts (x4) replacing as below:

New Part number	Description	Quantity
WHT 010 234	Nut	4

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*The following parts may not require replacing on all vehicles, please refer to the Work section for further details, should the parts require replacement, the left and right hand lower bolts and applicable washers **MUST** be replaced as below:*

Part number	Description	Quantity
WHT 007 043A	Washer	2

WHT 007 092A	Inner Bolt	2
N91 236 301	Outer Bolt	2

Work

- Set the vehicle in "Jack" mode and position the vehicle on a wheel free ramp
- Discharge the air from the left and right air spring dampers - Refer to "Air suspension system - To discharge and charge".
- Carry out a visual inspection of the left and right hand rear lower lever inner and outer nuts (x4) as Figure 1 IMPORTANT: Check for fracturing or signs of reduced torque, see the example shown in Figure 2 of a fractured nut



Figure 2

In the event the left and or right hand side nuts (x4) are found NOT fractured with NO signs of reduced torque - Conduct Section 1

Or

In the event that any of the left and/or right hand side nuts are found to be fractured - Conduct Section 2

Section 1 Nuts not fractured - No signs of reduced torque

1) Remove the left and right hand rear lower lever covers Rep.Gr 42

- Remove the left hand lower lever inner and outer nuts and discard as per all local environmental guidelines
- Fit the replacement left hand lower lever inner and outer nuts *IMPORTANT: Do not torque tighten the fixing at this stage*

2) Repeat step 1 on the right hand lower lever inner and outer nuts

3) Refer to Rep.Gr 42 - Rear lower suspension lever - rear - To remove and fit - Torque tighten the newly replaced nuts (x4) ensuring the following is strictly adhered to:

VERY IMPORTANT: The operative MUST ensure the procedure within Rep.Gr 42 is strictly followed in particular the following:

The suspension must be set to a specific angle prior to torque tightening the fixings as per Rep.Gr 42 guidelines

There is a requirement that any suspension component with bonded rubber bushes, all levers and the bearing housing MUST be set at standard ride height before tightening the fixings.

Bonded rubber bushes can only be turned to a limited extent. The suspension mountings must therefore only be tightened when the suspension is in the unladen position or normal level.

Failure to comply will result in the lever bushes undertaking excessive torsional twist, resulting in rupture and complete failure of the rubber inserts

4) Carry out wheel alignment and ensure the driver assist system calibrations are performed (Depending on vehicle specification) as follows

- Vehicle front + rear measured wheel alignment checked
- Rear wheel camber adjust
- Rear wheel track adjust
- Front wheel camber adjust
- Front wheel track adjust
- (ACC) - Radar sensor checked + adjusted
- Overhead view camera adjusted
- Driver assist camera adjusted
- Control unit for (Lane change assist) adjusted
- Night vision system calibration
- Headlamps to adjust
- 5) Refit the left and right hand rear lower lever covers Rep. Gr 42

6) Raise a non-technical DISS query attaching the following:

- Before and after screen shot of the wheel alignment results
- Screen shots confirming the applicable drive assist systems have been successfully adjusted/calibrated

Without the submission of the requested wheel alignment and calibration results via a non-technical DISS query warranty payments will be cancelled

6) Place a red paint completion mark on the 12 volt battery retaining strap

Section 2 – Nuts fractured or signs of reduced torque

The following MUST be conducted and all fixings replaced (Bolts, Nuts and Washers) in the event that any of the nuts are found to be fractured or have signs of reduced torque

1) Referring to Rep. Gr 42 – Rear lower suspension lever - To remove and fit - Conduct the following:

- Remove the left and right hand rear lower lever covers Rep. Gr 42
- Remove the left and right hand lower lever inner Bolts - Washer and Nut - Discard as per all local environmental guidelines
- Check the rear lower lever for any damage/wear
- Fit the replacement left and right hand inner bolts – washers and new replacement nuts *IMPORTANT: Do not torque tighten the fixing at this stage*

2) Remove the left and right hand lower lever outer bolts – Discard as per all local environmental guidelines

- Check the rear lower lever for any damage/wear
- Fit the replacement left and right hand outer bolts and new replacement nuts *IMPORTANT: Do not torque tighten the fixing at this stage*

3) Refer to Rep. Gr 42 - Rear lower suspension lever - rear - To remove and fit - Torque tighten the newly replaced fixings (left and right hand side) ensuring the following is strictly adhered to:

VERY IMPORTANT: The operative MUST ensure the procedure within Rep. Gr 42 is strictly followed in particular the following:

The suspension must be set to a specific angle prior to torque tightening the fixings as per Rep. Gr 42 guidelines

There is a requirement that any suspension component with bonded rubber bushes, all levers and the bearing housing MUST be set at standard ride height before tightening the fixings.

Bonded rubber bushes can only be turned to a limited extent. The suspension mountings must therefore only be tightened when the suspension is in the unladen position or normal level.

Failure to comply will result in the lever bushes undertaking excessive torsional twist, resulting in rupture and complete failure of the rubber inserts

4) Carry out wheel alignment and ensure the driver assist system calibrations are performed (Depending on vehicle specification) as follows:

- Vehicle front+ rear measured wheel alignment checked
 - Rear wheel camber adjust
 - Rear wheel track adjust
 - Front wheel camber adjust
 - Front wheel track adjust
 - (ACC) - Radar sensor checked + adjusted
 - Overhead view camera adjusted
 - Driver assist camera adjusted
 - Control unit for (Lane change assist) adjusted
 - Night vision system calibration
 - Headlamps to adjust
 - 5) Refit the left and right hand rear lower lever covers Rep. Gr 42
- 6) Raise a non-technical DISS query attaching the following
- Before and after screen shot of the wheel alignment results
 - Screen shots confirming the applicable drive assist systems have been successfully adjusted/calibrated

Without the submission of the requested wheel alignment and calibration results via DISS warranty payments will be cancelled

7) Place a red paint completion mark on the 12 volt battery retaining strap

Identification

Red paint completion mark on the 12 volt battery retaining strap



SJAAM2ZV0MC033766	SJAAM2ZVXMC033841	SJAAM2ZV5MC033908	SJAAM2ZV3MC033972
SJAAM2ZV2MC033767	SJAAM2ZV1MC033842	SJAAM2ZV7MC033909	SJAAM2ZV7MC033974
SJAAL1ZVXMC033769	SJAAM2ZV3MC033843	SJAAM2ZV3MC033910	SJAAL1ZVXMC033982
SJAAM2ZV2MC033770	SJAAL14VXMC033844	SJAAM2ZV5MC033911	SJAAD14V5MC033988
SJAAM2ZV4MC033771	SJAAM2ZV7MC033845	SJAAL1ZV0MC033912	SJAAM2ZV9MC033989
SJAAM2ZV6MC033772	SJAAM2ZV9MC033846	SJAAM2ZV9MC033913	SJAAM2ZV9MC033992
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SJAAM2ZVXMC033774	SJAAM2ZV2MC033848	SJAAM2ZV2MC033915	SJAAM2ZV4MC033995
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SJAAM2ZV3MC033776	SJAAM2ZV0MC033850	SJAAM2ZV6MC033917	SJAAD14V8MC033998
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SJAAM2ZV7MC033781	SJAAM2ZVXMC033855	SJAAM2ZVXMC033922	SJAAM2ZV8MC034003
SJAAM2ZV1MC033789	SJAAM2ZV1MC033856	SJAAM2ZV1MC033923	SJAAM2ZVXMC034004
SJAAM2ZV8MC033790	SJAAM2ZV3MC033857	SJAAM4ZV9MC033924	SJAAM2ZV1MC034005
SJAAM2ZVXMC033791	SJAAM4ZV0MC033858	SJAAL1ZV9MC033925	SJAAD14V1MC034006
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SJAAM2ZV3MC033793	SJAAM2ZV3MC033860	SJAAD14V7MC033927	SJAAM2ZV7MC034008
SJAAM2ZV5MC033794	SJAAM2ZV5MC033861	SJAAD14V9MC033928	SJAAM2ZV9MC034009
SJAAM2ZV7MC033795	SJAAD14V5MC033862	SJAAM2ZV2MC033929	SJAA514V9MC034011
SJAAM2ZV9MC033796	SJAAM2ZV9MC033863	SJAAM2ZV9MC033930	SJAAM2ZV9MC034012
SJAAM2ZV0MC033797	SJAAM2ZVXMC033872	SJAA514V2MC033931	SJAAK14V1MC034013
SJAAM2ZV2MC033798	SJAAM2ZV1MC033873	SJAAM2ZV2MC033932	SJAAM2ZV4MC034015
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SJAA514V4MC034241	SJAA514V4MC034305	SJAAD14VXMC034392	SJAA514V8MC034470
SJAAD14V2MC034242	SJAAD14V2MC034306	SJAAD14V1MC034393	SJAAD14V6MC034471
SJAAD14V4MC034243	SJAAL1ZVXMC034307	SJAAD14V3MC034394	SJAAL14V4MC034472
SJAAD14V6MC034244	SJAAD14V6MC034308	SJAA514V0MC034396	SJAA514V3MC034473
SJAAM2ZVXMC034245	SJAAD14V8MC034309	SJAA514V6MC034399	SJAA534V6MC034477
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SJAAD14V3MC034251	SJAAD14V6MC034311	SJAA514V0MC034401	SJAA514V2MC034495
SJAAD14V5MC034252	SJAAD14V8MC034312	SJAA514V2MC034402	SJAA514V4MC034496
SJAAD14V7MC034253	SJAAD14VXMC034313	SJAAN1ZV3MC034403	SJAAD14V4MC034498
SJAA514V2MC034254	SJAAD14V1MC034314	SJAAD14V2MC034404	SJAAN1ZV3MC034501
SJAAK14V3MC034255	SJAAD14V3MC034315	SJAAD14V4MC034405	SJAA514V1MC034505
SJAAD14V2MC034256	SJAA514V9MC034316	SJAA514VXMC034406	SJAAD14V2MC034516
SJAAD14V4MC034257	SJAAD14V7MC034317	SJAAL1ZV5MC034408	SJAA514V0MC034527
SJAAL1ZV1MC034258	SJAAD14V9MC034318	SJAAD14V1MC034409	SJAA514V7MC034542
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SJAA514V8MC034260	SJAAD14V7MC034320	SJAAD14VXMC034411	SJAA514V6MC034581
SJAAD14V6MC034261	SJAAD14V4MC034324	SJAAL14V8MC034412	SJAAD14V0MC034661
SJAAD14V8MC034262	SJAA514VXMC034325	SJAAD14V3MC034413	SJAAD14V1MC034863