		Tesla, Inc. Service Bulletin		<i>Inspect Front Seat Belt Pre-Tensioners and Seat Belts for Correct Installation</i>	
SB-23-20-004 July 21, 2023					
Classification		Section/Group		Mobile Service	Configuration
Recall Bulletin		20 - Safety and Restraint		Can Perform (where permitted)	All
Model Year	Model	Country/Region		Build Location	
2021 - 2023	Model S, Model X	North America, EMEA		Fremont	
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.					

Recall Bulletin: Recall Bulletins are mandatory service procedures that, unless they can be completed via a software update that a customer installs through the normal course of ownership, must be carried out by Tesla-certified Service Centers. Recall work performed by uncertified technicians could lead to unsafe conditions or voided warranty provisions.

Condition

Some Model S and Model X vehicles require inspection to the 1st row seat belts to confirm proper connection to the pretensioners.

Correction

Inspect the 1st row seat belts for proper connection to the pretensioners. If necessary, resecure the pre-tensioners and/or replace the seat belt retractors as directed.

Correction Description	Correction	Time	
		Model S	Model X
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; No Additional Work Required	S012320004	0.06	0.06
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure One Pre-Tensioner	S022320004	0.06	0.06
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure Both Pre-Tensioners	S032320004	0.06	0.06
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Replace One Seat Belt Retractor	S042320004	0.48	0.36
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Replace Both Seat Belt Retractors	S052320004	0.96	0.72
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure One Pre-Tensioner And Replace One Seat Belt Retractor	S062320004	0.48	0.36
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure One Pre-Tensioner And Replace Both Seat Belt Retractors	S072320004	0.96	0.72
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure Both Pre-Tensioners And Replace One Seat Belt Retractor	S082320004	0.48	0.36
Inspect LH And RH 1st Row Pre-Tensioners And Seat Belts For Correct Installation; Resecure Both Pre-Tensioners And Replace Both Seat Belt Retractors	S092320004	0.96	0.72

	Part Number	Description	Quantity
Parts If Necessary		Model S	
	1556500-91-C	MS P2.0, 1R RTR, LH, NA, BLK	1
	1556501-91-C	MS P2.0, 1R RTR, RH, NA, BLK	1
		Model X	
	1615468-91-B	MX P2.0, 1R RTR, LH, NA, BLK	1
	1615469-91-B	MX P2.0, 1R RTR, RH, NA, BLK	1

These part numbers were current at the time of publication. Use the revisions listed or later, unless otherwise specified in the [Parts Catalog](#).

Procedure

 **NOTE:** This procedure must be performed on both the LH and RH 1st row seat belt pre-tensioners and seat belts.

1. Open the LH and RH front doors and lower the front windows.
2. Move the front seats forward and raise the seats to the highest position.

 **CAUTION:** Adjust the seat backs to avoid contact with the headliner, if necessary.

3. Verify the LH and RH 1st row seat belts are orientated correctly:

- The seat belt tongue must be on the same side as the seat belt linkage lock screw (Figure 1).
- The lock screw must face inboards (towards the occupant) (Figure 2).
- Make sure that there are no noticeable twists in the seat belt webbing from the upper B-pillar trim to the pre-tensioner connection (Figure 3).

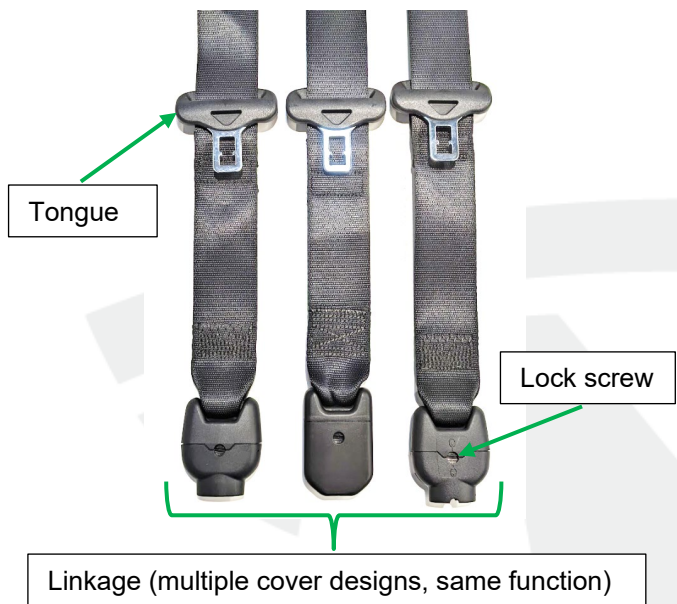


Figure 1

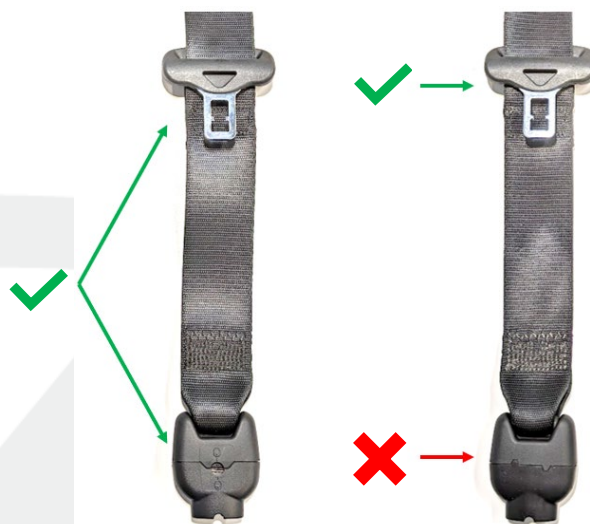



Figure 2 (Occupant view of the seat belt)



Figure 3

- If both seat belts are orientated correctly, continue to the next step.
- If one or both seat belts are orientated incorrectly:
 - Take clear pictures of the defective seat belt(s).
 - Note the seat belt serial number(s) (Figure 4).
 - Add detailed notes and the images to the repair order.

 **NOTE:** Corrective action(s) will be determined later in this procedure, continue to the next step after the repair order is updated.

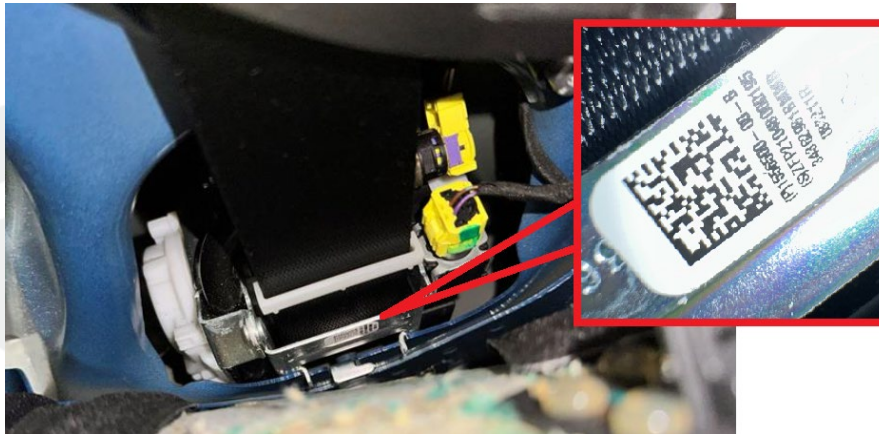




Figure 4 (Seat belt serial number location, lower B-pillar trim shown removed for clarity)

4. Verify the LH and RH 1st row seat belt pre-tensioners are connected correctly.
 - a. Using both hands, perform a firm pull test on the seat belt with at least 15 pounds of force (Figure 5).

 **WARNING:** To reduce the risk of falling and personal injury, use a staggered stance (one foot slightly behind the other) while performing this operation.

 **CAUTION:** Make sure not to damage components and trim.


 **NOTE:** A pre-tensioner that is connected incorrectly will detach from the seat belt linkage with a few strong pulls (Figure 6).



Figure 5 (Pre-tensioner installed correctly, successful pull test)



Figure 6 (Pre-tensioner installed incorrectly, unsuccessful pull test)

- If the pull test does not cause the pre-tensioner to detach from the seat belt linkage, continue to step 4b.
 - If the pull test causes the pre-tensioner to detach from the seat belt linkage, the seat belt pre-tensioner is connected incorrectly. Take clear pictures of the defective connection, add detailed notes and the images to the repair order, and then continue to step 5.
- b. If the seat belt pre-tensioner pull test does not cause the pre-tensioner to detach from the seat belt linkage, as a secondary confirmation, verify the lock screw is in the locked (vertical) position (Figure 7).

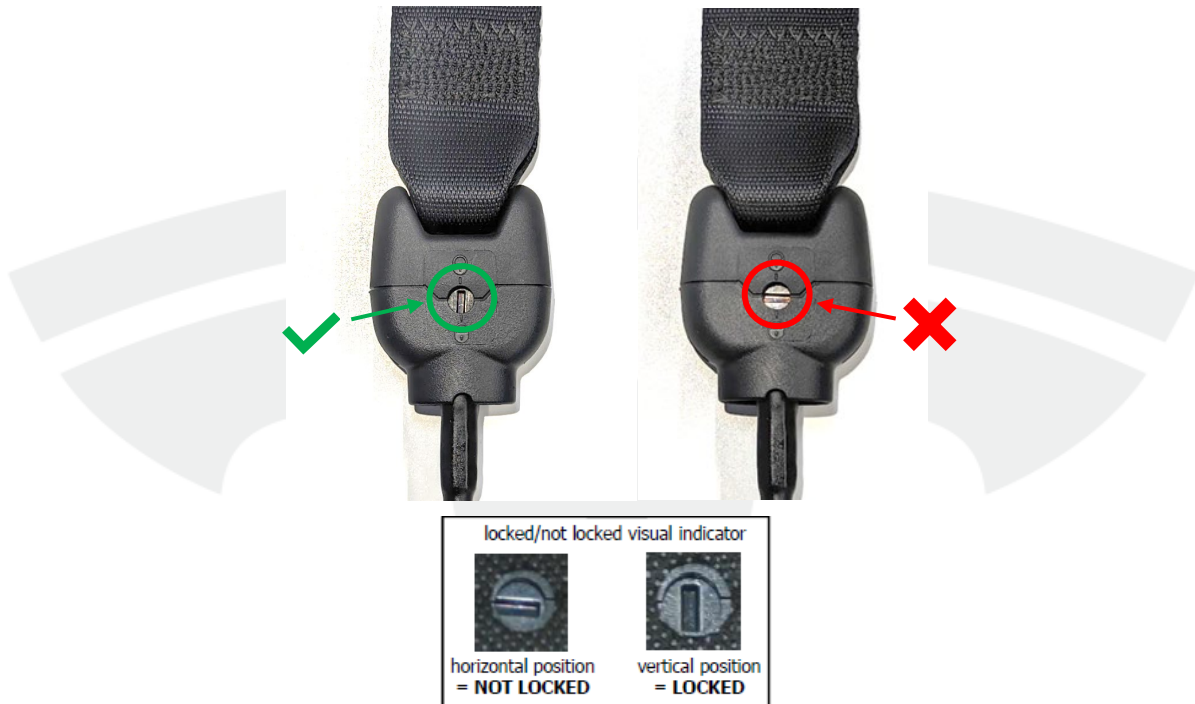



Figure 7 (Pre-tensioner lock screw positions)


- If the lock screw is in the locked (vertical) position, the seat belt pre-tensioner is installed correctly. Continue to step 5.
 - If the lock screw is in the unlocked (horizontal) position, the seat belt pre-tensioner is installed incorrectly. Continue to step 5.
5. Determine corrective action(s) based on the condition(s) observed in this procedure.
- Replace any incorrectly oriented 1st row seat belt retractors (refer to Service Manual procedure 20054102; [Model S](#), [Model X](#)).
 - Resecure any incorrectly connected 1st row seat belt pre-tensioners.
 - a. If necessary, turn the lock screw counterclockwise to unlock the seat belt linkage. **DO NOT** rotate the lock screw clockwise.
-  **NOTE:** An audible click will be heard, and the lock screw will remain horizontal.
- b. If not already disconnected, disconnect the pre-tensioner from the seat belt linkage.

- c. Verify that the error proofing notch on the pre-tensioner cable is on the RH side of the linkage (Figure 8). The pre-tensioner latch will not engage if the notch is positioned incorrectly.



Figure 8

- d. Press the seat belt linkage down onto the pre-tensioner cable.

 **NOTE:** An audible click will be heard, and the lock screw will remain vertical.

- e. Repeat the seat belt pull test performed in step 4a.

6. Move the front seats back to original position.
7. Raise the front windows and close the LH and RH front doors.
8. Close out this document using the appropriate correction code based on the repair(s) performed.