



**TECHNICAL SERVICE BULLETIN**  
**Buzz/Vibration/Rattle From Center Left Of Instrument Panel (IP) During Tip-In**

**23-2079**  
 13 March 2023

**Model:**

<b>Ford</b> 2022-2023 Explorer
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**Issue:** Some 2022-2023 Explorer vehicles may exhibit a buzz/vibration/rattle from the center left of the IP during tip-in when the vehicle is at operating temperature. This may be due to heater tube movement against the tube bracket. To correct the condition, follow the Service Procedure to apply flock tape to the heater tube bracket

**Action:** Follow the Service Procedure to correct the condition on vehicles that meet the following criteria:

- 2022-2023 Explorer
- Buzz/vibration/rattle from the center left of the IP during tip-in
- Concern isolated to heater tube bracket

**Parts**

Service Part Number	Quantity	Description
164-R4903	As Needed	Flock Tape Strips (Rotunda Part Number, Included In The Rotunda Squeak and Rattle Kit)

**Parts**

**Parts To Use Only If No Individual Flock Tape Is Available**

Service Part Number	Quantity	Description
164-R4900	If Needed	Rotunda Squeak and Rattle Kit (Complete Kit)

As Needed indicates the amount of the part may vary and/or is not a whole number. Parts can be billed out as non-whole numbers, including less than 1.

If Needed indicates the part is not mandatory.

**Warranty Status:** Eligible under provisions of New Vehicle Limited Warranty (NVLW)/Service Part Warranty (SPW)/Special Service Part (SSP)/Extended Service Plan (ESP) coverage. Limits/policies/prior approvals are not altered by a TSB. NVLW/SPW/SSP/ESP coverage limits are determined by the identified causal part and verified using the OASIS part coverage tool.

**Labor Times**

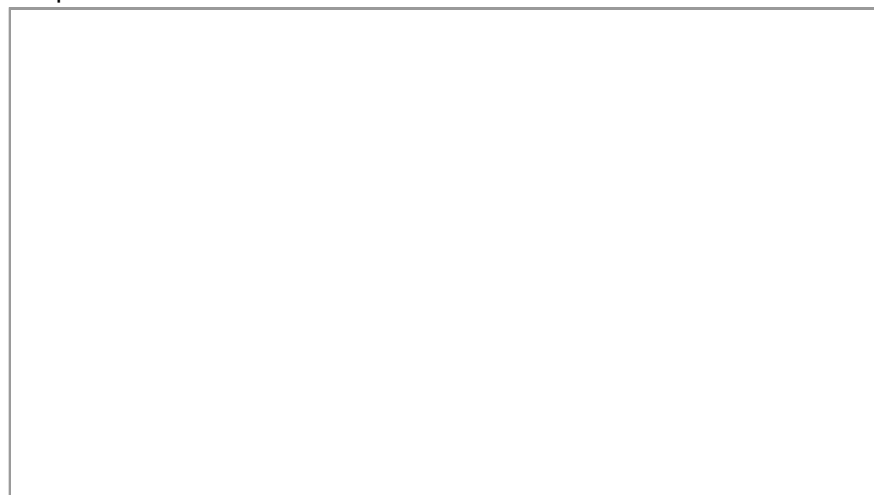
Description	Operation No.	Time
2022-2023 Explorer: Install Flock Tape Following The Service Procedure (Do Not Use With Any Other Labor Operations)	232079A	0.5 Hrs.

**Repair/Claim Coding**

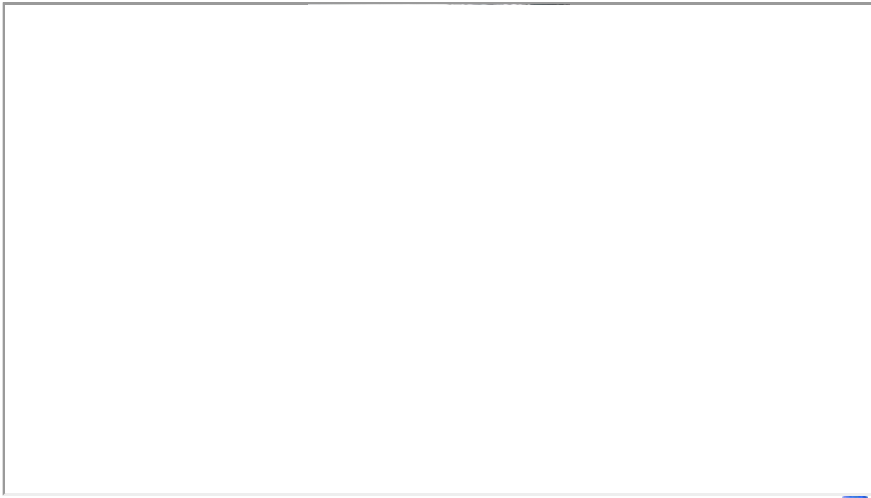
Causal Part:	18476
Condition Code:	07

**Service Procedure**

**Example of constant buzz**



**Example of intermittent buzz**



1. Remove the left side insulation panel. Refer to Workshop Manual (WSM), Section 211-04.

2. Remove the lower steering column trim panel. Refer to WSM, Section 211-04. (Figure 1)

Figure 1

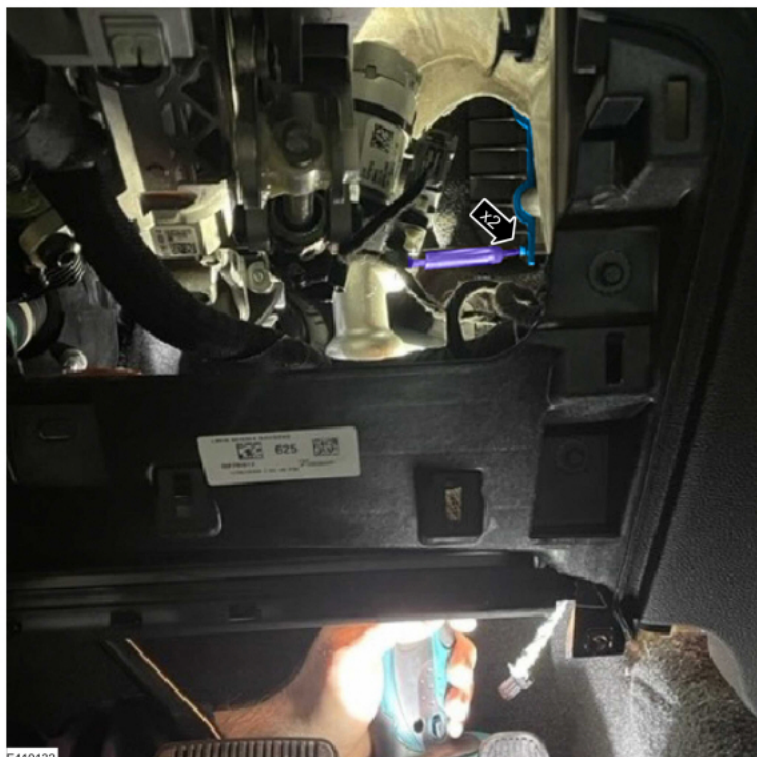


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3. Apply flock tape to the heater tube bracket.

(1). Remove the left half of the heater tube bracket. (Figure 2)

Figure 2



(2). Clean the heater tubes and bracket with isopropyl alcohol or equivalent.

(3). Apply flock tape from the Rotunda Squeak And Rattle Kit to the left heater tube bracket in the saddle area that clamps the heater tubes. (Figure 3)

Figure 3



(4). Reassemble the heater tube bracket.

(5). Tighten the 2 heater tube bracket screws to 11.5 lb-in (1.3 Nm).

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NOTE: The information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment 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". Do not assume that a condition described affects your car or truck. Contact a Ford or Lincoln dealership to determine whether the Bulletin applies to your vehicle. Warranty Policy and Extended Service Plan documentation determine Warranty and/or Extended Service Plan coverage unless stated otherwise in the TSB article. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ford Motor Company reserves the right to supersede this information with updates. The most recent information is available through Ford Motor Company's on-line technical resources.