TECHNICAL BULLETIN

No: LA-501-016
Issue: 1
Date: 14 Mar 2006

CIRCULATE: TO	Service Mgr	Warranty	Workshop	Body Shop	Parts
	X	X	X	X	X

SECTION: 501-03

Tailgate Support Mounting

AFFECTED VEHICLE RANGE:

Land Rover LR3 (LA) **VIN: 5A000360 onwards**

CONDITION SUMMARY:

TAILGATE SUPPORT RATTLE

A customer may report a rattle from the upper tailgate area.

Cause: Torque relaxation of the upper strut support ball fitting, which could develop into damage to the mounting, may be the cause.

Action: Should a customer express concern regarding the above, refer to the Repair Procedure detailed in this bulletin.

PARTS:

STC50552.....Thread lock (10ml) **Qty 1**
BKF780010.....Ball fitting **Qty 1**
ALR780770.....Tailgate reinforcement plate **Qty 1**
AZP500060.....Self-adhesive aluminum patch **Qty 1**

WARRANTY:

△ **NOTE: Repair procedures are under constant review and times are subject to change; those quoted here are to be taken as guidance. Always refer to DDW to obtain the latest repair time.**

△ **NOTE: Repair times quoted in this Bulletin include an allowance for materials associated with welding/painting. Parts listed in the parts listing above are not part of the quoted times.**

DDW 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*
Remove and inspect ball fitting/reinforcement plate nut; Loctite and reinstall ball fitting	**76.40.89/42**	**0.1**	33	BKF780010
Replace left-hand liftgate strut ball fitting reinforcement plate	**76.40.89/40**	**2.7**	33	BKF780010
Replace right-hand liftgate strut ball fitting reinforcement plate	**76.40.89/41**	**2.7**	33	BKF780010

Normal warranty policy and procedures apply.

REPAIR PROCEDURE

INSPECT TAILGATE SUPPORT MOUNTING

WARNING: The tailgate must be supported with a brace before removing the tailgate support strut.

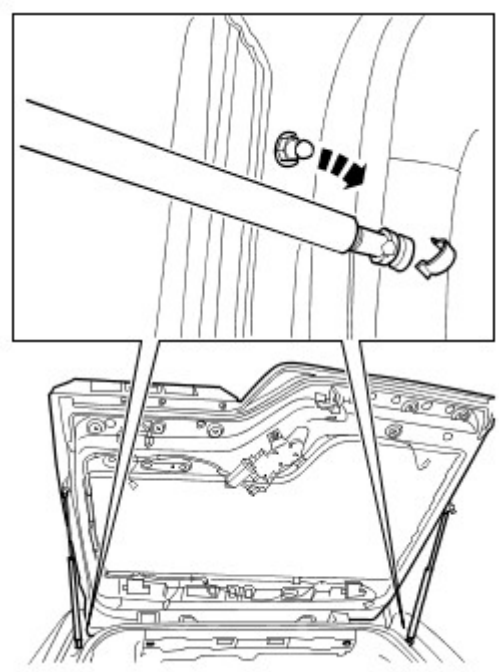
1. Remove the upper tailgate support strut from the D-pillar ball fitting. (Figure 1)

2. Disassemble the ball fitting, checking for damage to both the ball fitting and the securing nut thread.

3. If no damage is detected, complete repairs as follows:
   - Apply liquid thread lock (STC50552) to the thread of the ball fitting.
   - Install the ball fitting.
   - Tighten to **23 Nm (17 lbf-ft)**.
   - Install the upper tailgate support strut.
   - Verify proper operation of the tailgate and no rattle is present while driving.

4. If securing nut thread is damaged, or the nut has been displaced into the D-pillar, perform tailgate support repair.

Figure 1



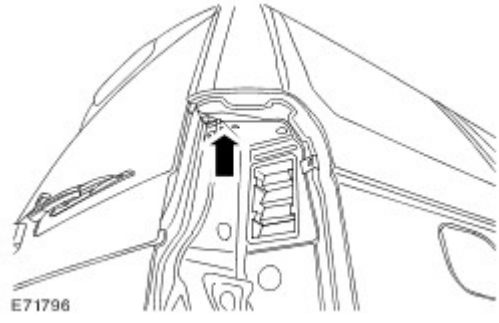
REPAIR TAILGATE SUPPORT MOUNTING

CAUTION: Care should be taken not to damage the tailgate seal, which should be partially removed if necessary.

NOTE: GTR lookup sequence is as follows: GTR Home > NAS > Service Information/LA LR3/2005 > Workshop Manuals > LR3 Workshop Manual > Bookmark "Electrical/Lighting/ 417-01: Exterior Lighting" > Link "Rear Lamp Assy (86.40.70)"

5. Remove the rear lamp assembly to gain access to the base of the D-pillar. (Figure 2)

Figure 2



NOTE: GTR lookup sequence is as follows: GTR Home > NAS > Service Information/LA LR3/2005 > Workshop Manuals > LR3 Workshop Manual > Bookmark "Body & Paint/501-25A Body Repairs/General Information/Description and Operation" > Link "Body Repairs".

6. Using suitable hole saw, make a **maximum** 40 mm (1-1/2 in) diameter hole in the base of the D-pillar to gain access to the inside of the upper D-pillar ball fitting retaining plate. (Figures 3 and 4)
7. Pass a length of MIG welding wire through the ball fitting attachment hole – down through the D-pillar cavity, and out the 40 mm (1-1/2 in) diameter hole and temporarily secure at both ends. (Figure 5)

CAUTION: Drilling anywhere other than through the spot welds may cause damage.

NOTE: When released, the plate will fall down guided by the wire and can then be removed from the D-pillar cavity. (Figure 6)

8. Using an 8 mm (5/16 in) diameter drill bit, drill through the two spotwelds which secure the reinforcement plate to the D-pillar. (Figure 5)
9. Remove the reinforcement plate and the guide wire. (Figure 6)

Figure 3

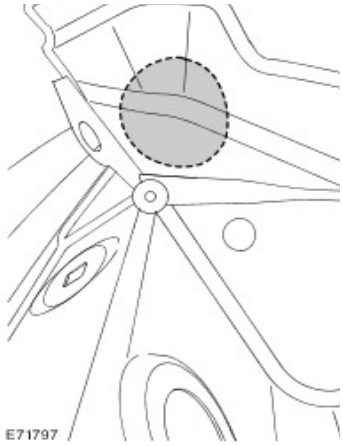


Figure 4

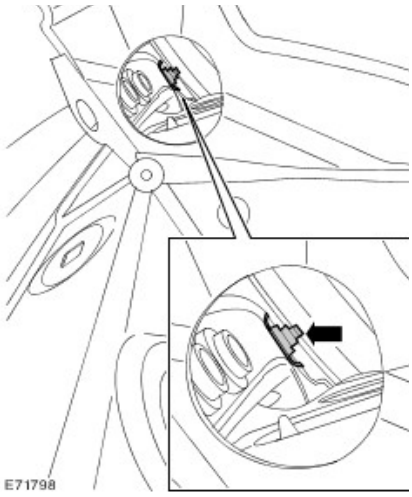


Figure 5

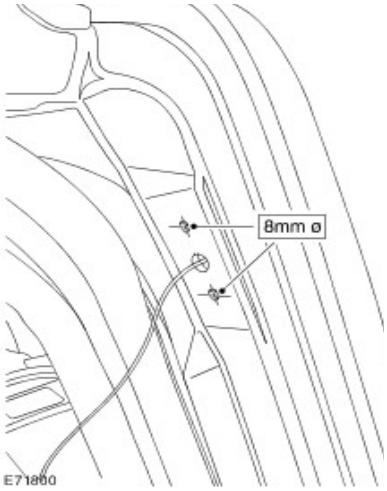
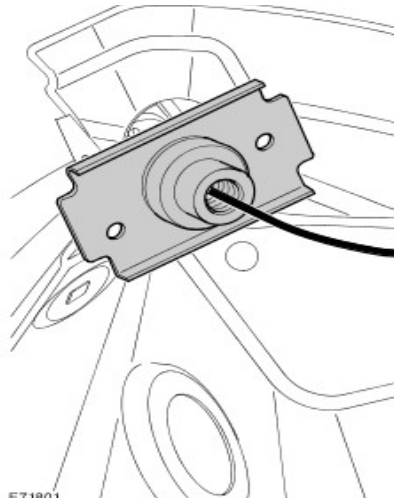


Figure 6



10. Inspect the plate and compare with the new part (ALR780770) to detect if any pieces may have been left in the D-pillar cavity.

11. Remove any loose parts or pieces in the D-pillar cavity to prevent future rattles.

CAUTION: Welding repair operation precautions must be followed to prevent damage to battery, Engine Control Module (ECM), Restraints Control Module (RCM) or any other electronic control module. Refer to GTR section 501-25A Body Repairs General Information > link "Safety Measures" for proper precautions and safety measures.

12. Pass a length of MIG welding wire through the upper drilled spotweld hole, down through the D-pillar section and out of the 40 mm (1-1/2 in) diameter hole. (Figure 7)

13. Temporarily secure the top end of the wire.

CAUTION: Care must be taken to prevent damage to any plastic/rubber trim items and to minimize the heat affected area.

14. Align the removed plate with the new one and mark the spot weld locations on the new plate. (Figure 8)

15. Tack-weld the lower end of the wire to the new reinforcement plate in the area of the original upper mark. (Figure. 9)

16. Draw the wire, with the new reinforcement plate attached, through the 40 mm (1.5 in) diameter hole and up into the D-pillar section. (Figure 9)

17. Manipulate the reinforcement plate into position using the wire and secure into place by temporarily installing the old ball fitting (to avoid any heat damage to the new ball fitting during welding).

Figure 7

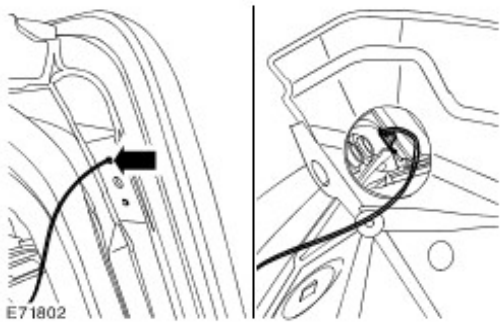


Figure 8

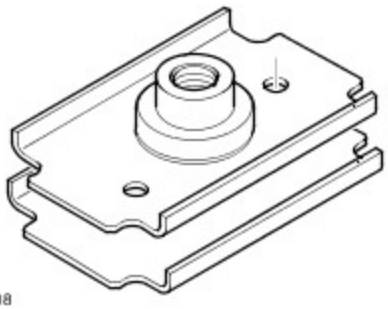
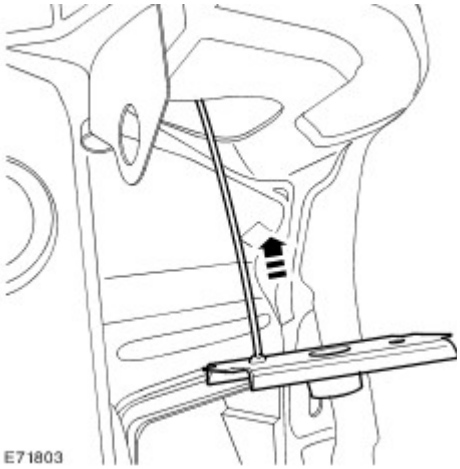
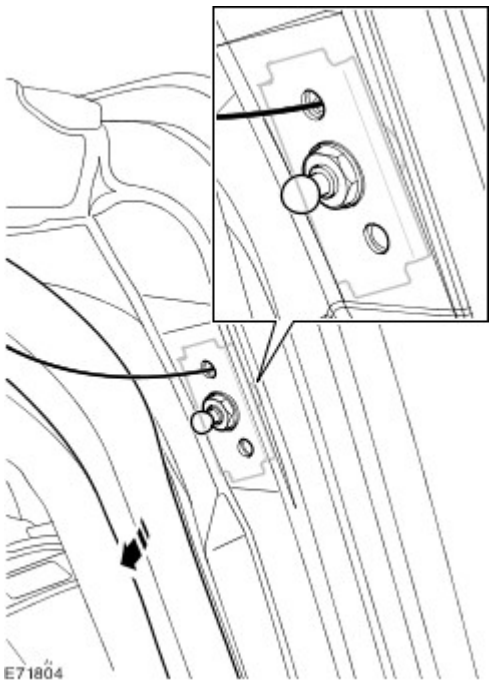


Figure 9



18. Verify that the ball fitting and reinforcement plate are centralized with the body hole. (Figure 10)

Figure 10



19. Puddle-weld the reinforcement plate to the D-pillar through the lower drilled hole.
20. Release the guide wire and puddle-weld the reinforcement plate to the D-pillar through the upper drilled hole.
21. Remove the old ball fitting.
22. Ensure the mounting surface is flat and prepare the welded area as necessary for paint repair.
23. Paint the welded repair area.

△ **NOTE: If the ball fitting hole in the D-pillar is greater than 10 mm (3/8 in) diameter, install an additional flat washer behind the new ball fitting assembly.**

The area around the access hole must be clean and dry.

24. Apply liquid thread-lock to the ball fitting.
25. Install the ball fitting with additional flat washer, if required, and tighten to **23 Nm (17 lbf-ft)**.
26. If an additional washer is required, install a similar washer behind the opposite side ball fitting to match appearance.
27. Visually check the upper tailgate support for damage and secure the upper tailgate support strut to the ball fitting.
28. Remove burrs around the 40 mm diameter D-pillar access hole and ensure the area is clean and dry.
29. Apply an air-drying paint to the cut surface, and allow to dry.
30. Cover the 40 mm diameter hole with the 50 mm (2 in) diameter self-adhesive aluminum patch (AZP500060).
31. Refer to GTR section 86.40.70 and install the rear lamp assembly.
32. Verify proper operation of the tailgate and no rattle is present while driving.