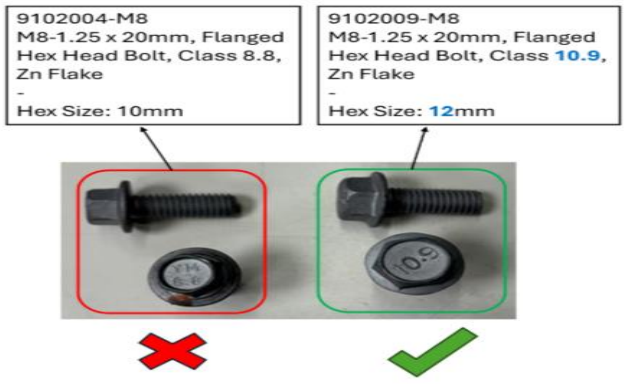
15B250004: Tilt Disc Split Pins Check/ Replacement and Disc Bolts Replacement.

INFORMATION

Campaign NO.	15B250004
Campaign Type	Service Measure Check
Info. Version	1.0
Created by	GAIUS RD team
Revised by	GAIUS RD team
Released by	GAIUS After-Sale team
Initial Date	14/Jul/2025
Revised Date	14/Jul/2025
Applicable Model	Rapide XL (RP3)
Affected Units	500
Campaign Description	**1. Vehicles supplied to Australia were found to have four loose bolts in the tilt brake disc area. The instructions are to replace these bolts with part number 9102009-M8: M8 x 1.25 x 20mm flanged hex head bolts, Class 10.9, with zinc flake coating. Please have all affected vehicles returned to service partners for this campaign.**  **2. The tilt brake disc bolts will become loose and resulting split pins come out. If any split pin is found (even only with one side) dislodged on vehicle, both sides of slip pins shall be replaced with new ones as per the instructions in the following pages.**

WORK DESCRIPTION

Required Tool:

1. Special torque wrench tool

2. Medium Strength Thread locker (Loctite 243 or equivalent)

3. Interchangeable Torque Wrench Head (Bi-Hexagonal Type)

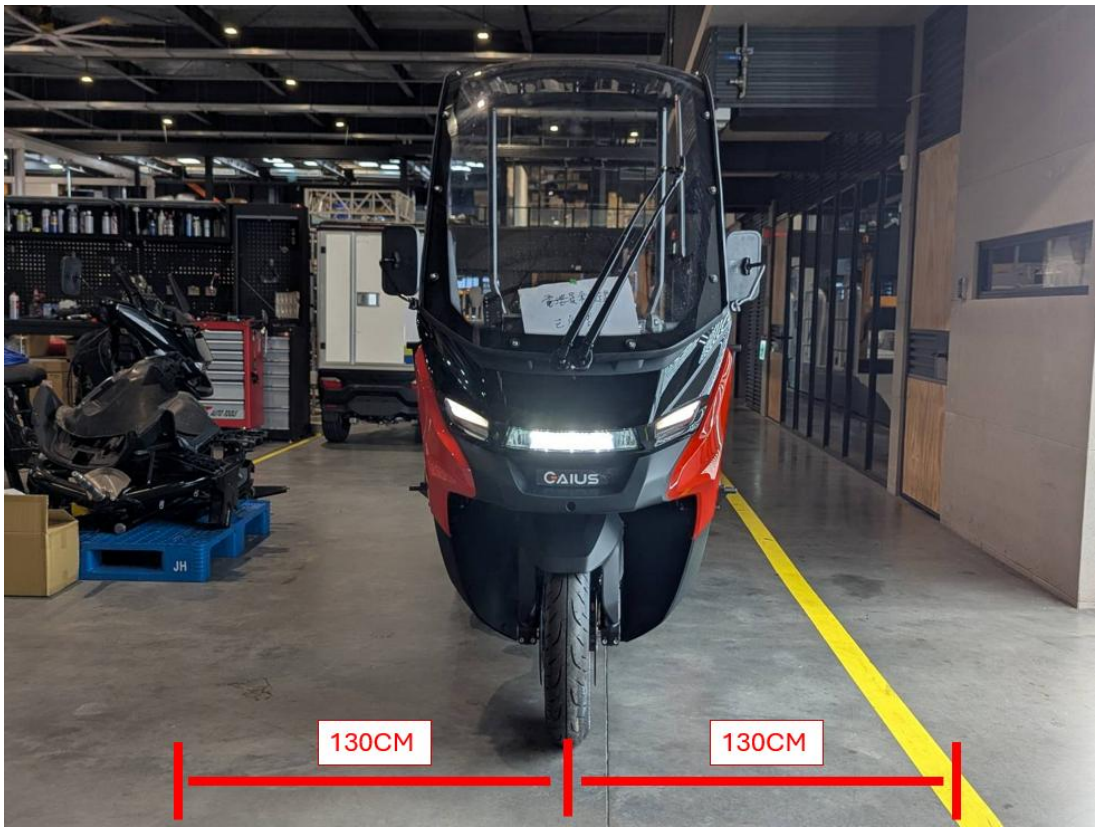
4. Scissors jack

5. Large pry bar

6. Green indelible paint pen

Campaign Procedure:

1. Park the vehicle in a level maintenance area, ensuring a clearance of at least 130 cm on both left and right sides to allow vehicle tilting.



2. Remove the seat by loosening the seat mounting bolts.

3. Lift the front end of the seat upward.

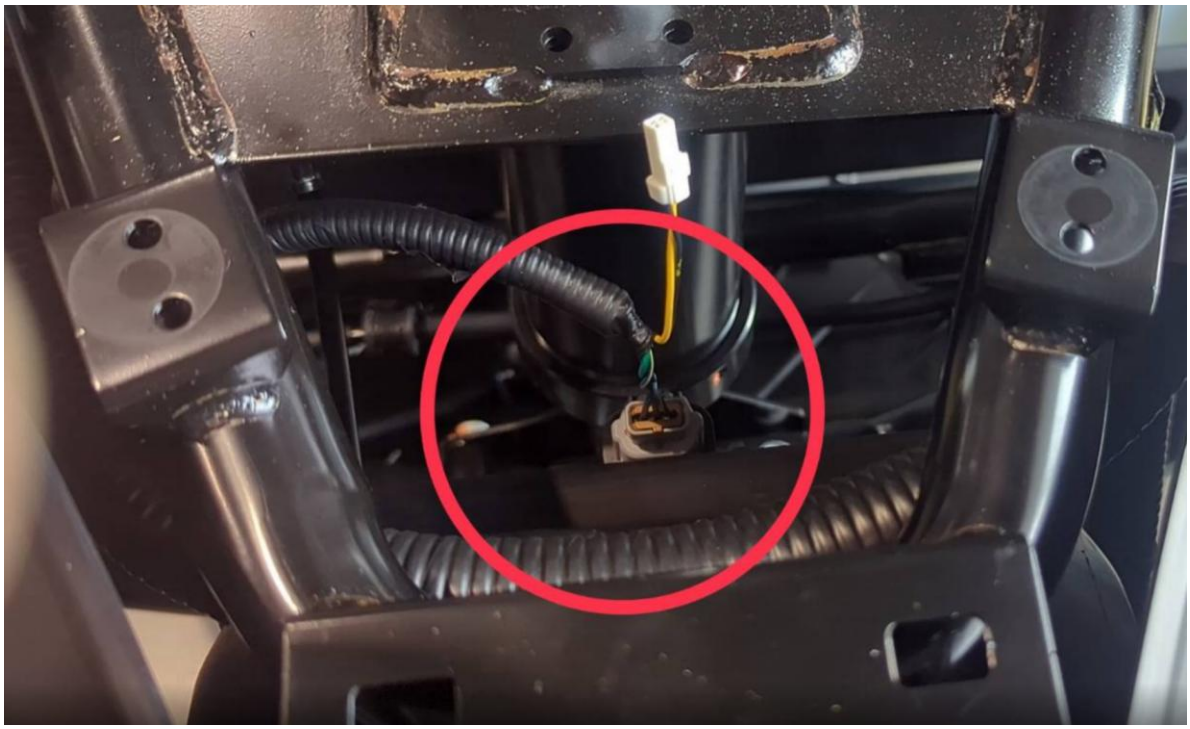
4. Disconnect the seat sensor connector.

5. Remove the seat apron.

NOTE: The information 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. If any concerns, please contact GAIUS technical support mailbox. The information was current at the time of printing.

6. There are two mounting clips on the top, and one clip on each lower left and right side.

7. Disconnect the rollover sensor connector.



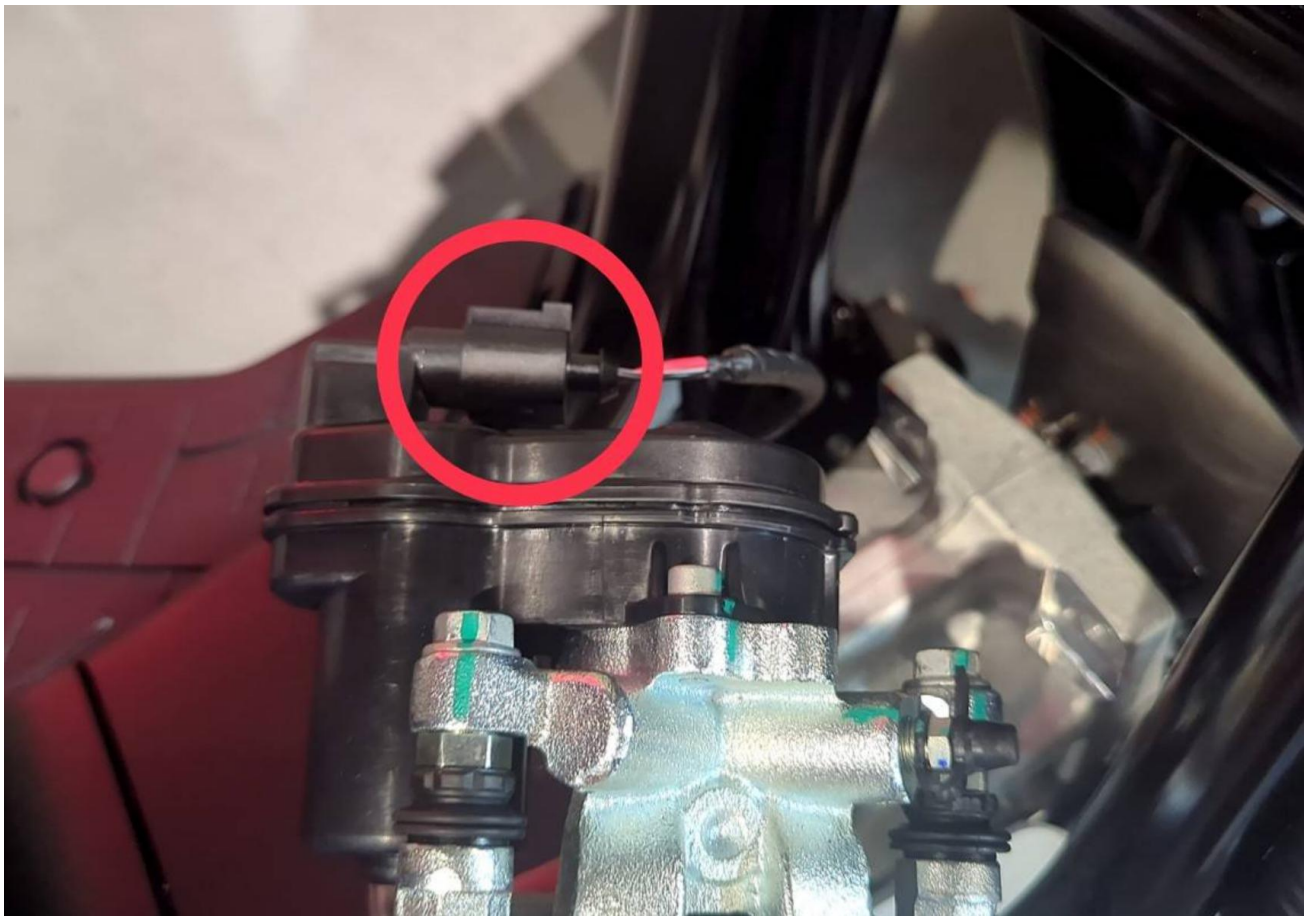
8. Pull the seat apron upwards.

9. Place the jack under footrest to support the vehicle. This step is critical because the next step requires unlocking the tilt lock. **If not properly supported, the front of the vehicle will immediately tip over.**

10. Set the vehicle's ETL (Electronic Tilt Lock) to Maintenance Mode.
11. Release ETL (Electronic Tilt Lock) so that lock icons on both DASH and IDU disappear.
12. Press and hold the ETL button for 10 seconds. ETL icon on the DASH will begin to flash. Once it starts flashing, press the button again to enter Maintenance Mode.

13. Remove tilt brake caliper mounting bolts.

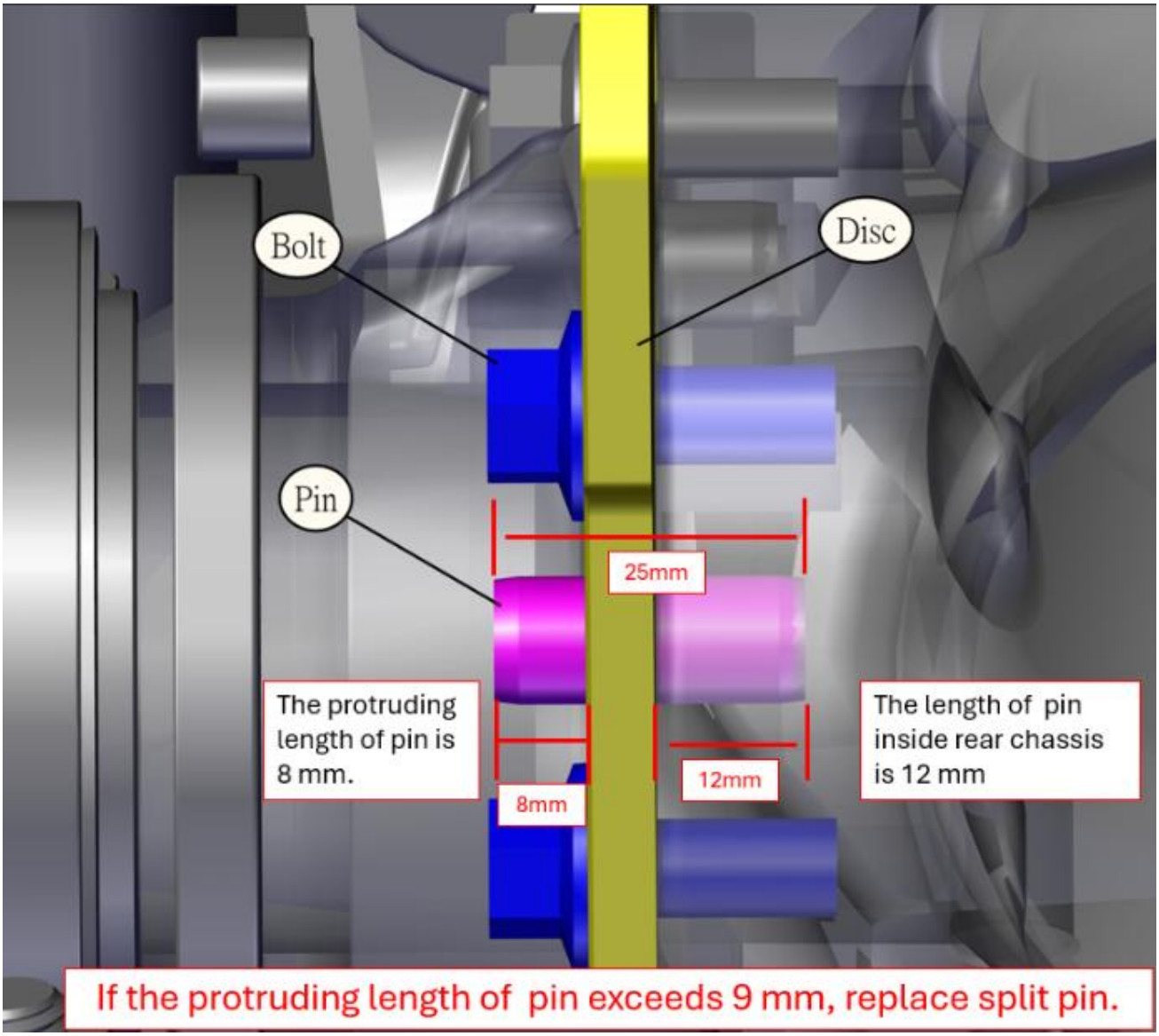
14. Disconnect tilt brake caliper motor connector.



15. Check the length of split pins.

If it is within specification as below, reinstall the tilt brake caliper (refer to Step 25~26) and proceed with the Tilt Disc Bolts replacement. (Refer to Step 27~53)

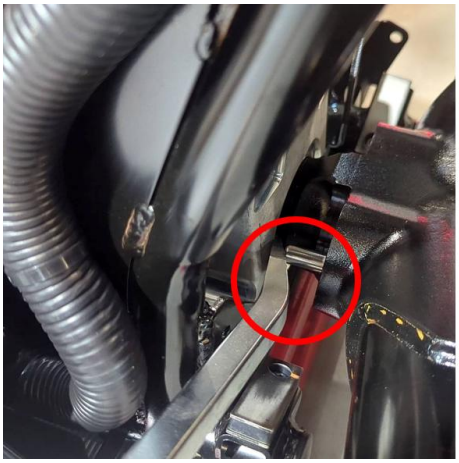
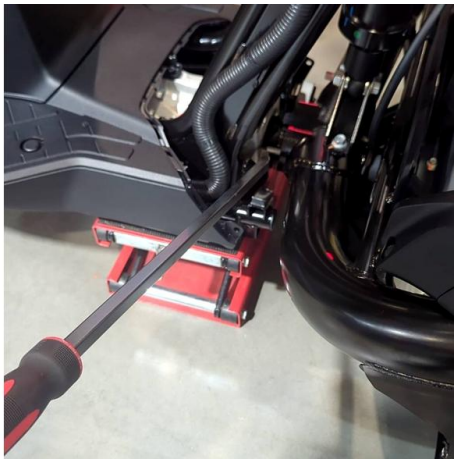
If the protruding length of split pin exceeds 9 mm, replace the split pins. (Refer to Step 16~26, and continue step 49~53)



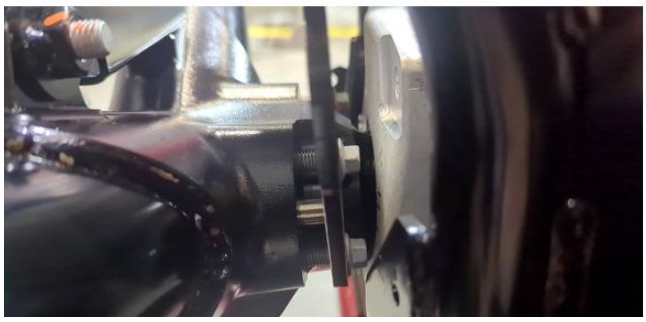
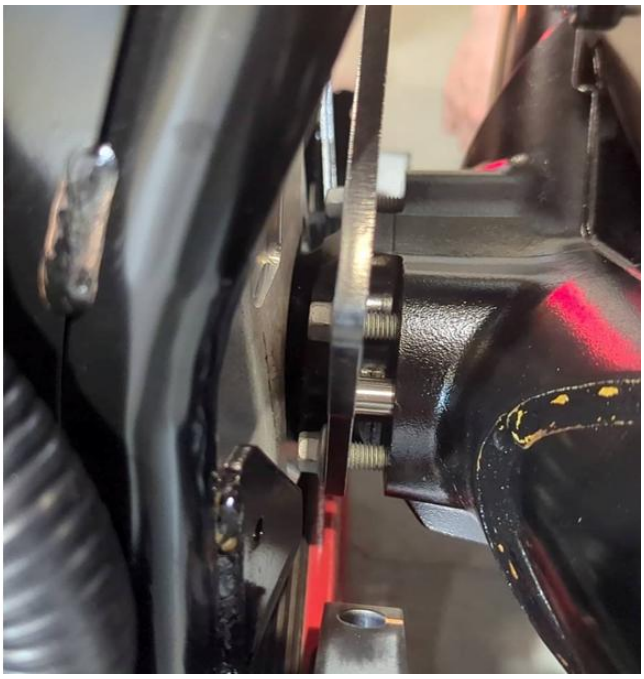
16. Remove tilt disc mounting bolts x4 and remove disc.


17. Clean and degrease surfaces between tilt disc and rear chassis.
18. Insert/set new split pins into rear chassis. Pins should be installed with the open groove down to minimize water accumulation.

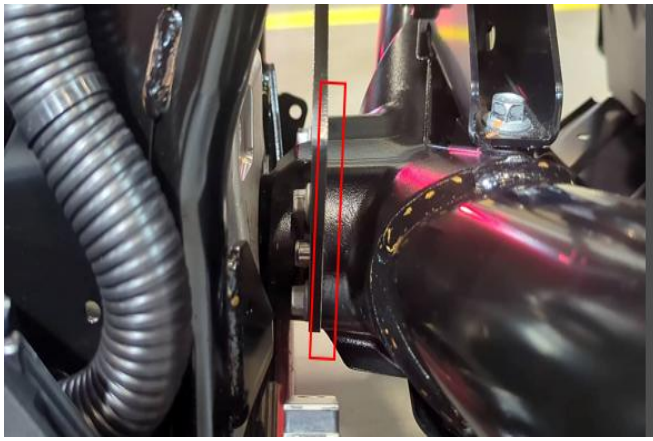
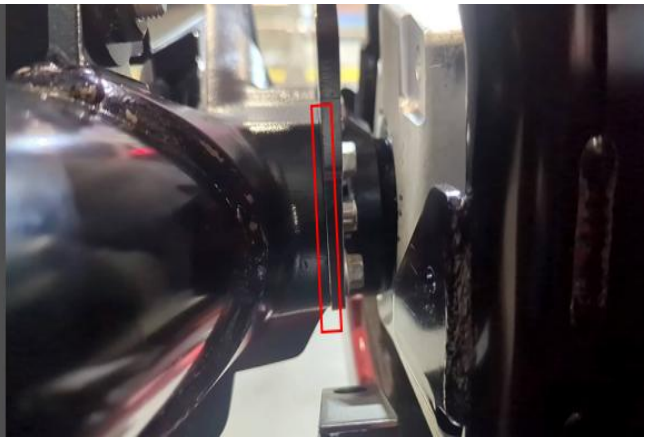
19. Use a large pry bar to press the retaining pin in by applying leverage.

20. First, place the old screws onto the disc, then install the disc onto the rear chassis. Evenly tighten screws to secure disc, and push disc into split pins.

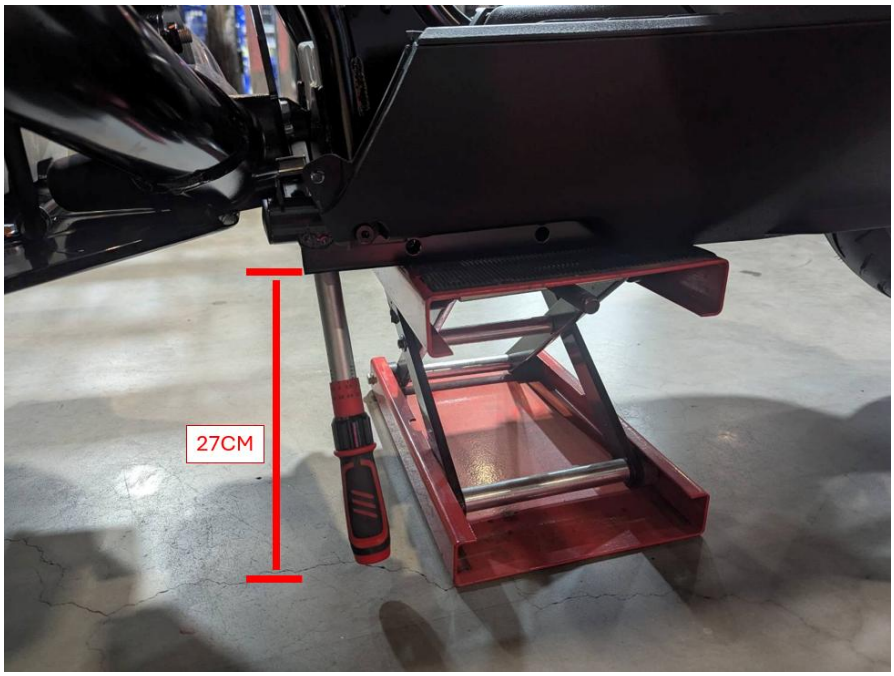




21. After confirming disc is fully seated, remove old screws and replace them with new ones. Apply thread locker to the threads of the new screws before installation.

22. Replace with the correct screws. Apply thread locker (Loctite 243 or equivalent) to the threads of the new screw, leaving the first two threads uncoated. Begin applying the thread locker from the 5th or 6th thread onward.

23. Raise the jack to the height of 27 cm from the floor that permits proper operation of torque wrench. Hand-tighten screws until seated, then use special tool to torque it to 30 N-m.

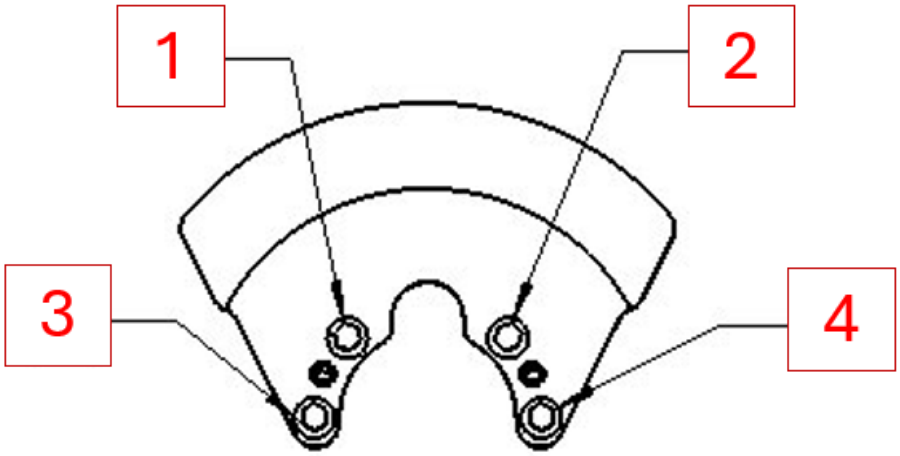


24. After tightening screws, mark it with a green paint marker.

25. Install tilt brake caliper and torque mounting bolts to 65 N-m. Reconnect tilt brake motor connector.

26. Please pull up the ETL and make sure that the EPB and ETL are fully locked. The lock icon will be displayed on the instrument panel and IDU. After confirming that the lock is locked, turn off the vehicle power and remove the scissor jack.

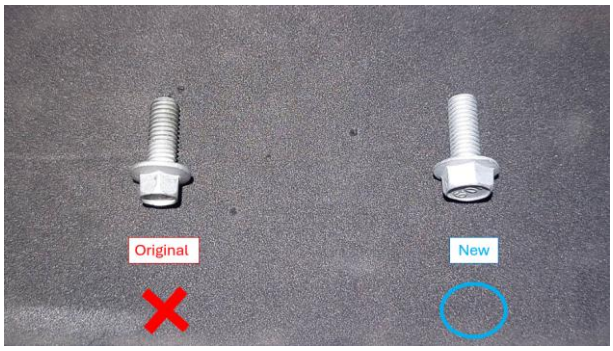
27. Replace disc screws in the order shown in the image



This image is viewed from the front of the vehicle looking toward the rear

28. Use a plum open-end wrench to loosen fixing the screw on upper right side of disc.

29. Replace with correct screw.



30. Apply thread locker (Loctite 243 or equivalent) to threads of the new screw. Leave the first two threads uncoated and apply thread locker starting from 5th to 6th thread onward.

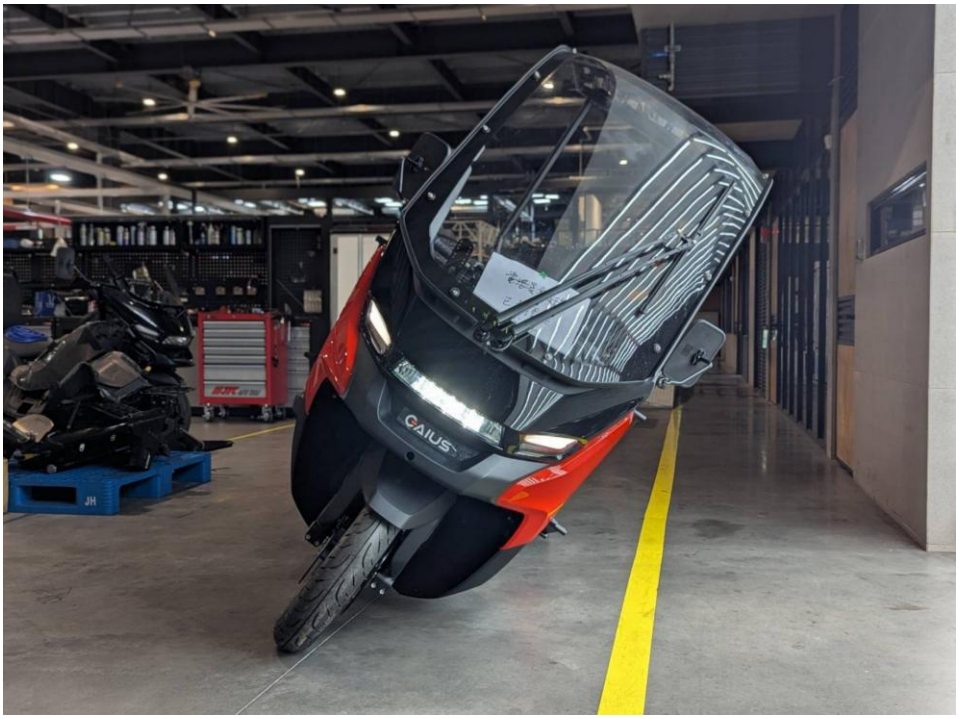
31. Hand-tighten screw until seated, then use special tool to torque it to 30 N-m.

32. After tightening screw, mark it with a green paint marker.

33. Use a plum open-end wrench to loosen fixing screw on the upper left side of disc.

34. Replace with the correct screw. Apply thread locker (Loctite 243 or equivalent) to threads of the new screw, leaving first two threads uncoated. Begin applying thread locker from 5th or 6th thread onward. (Refer to the image in Step 30.)
35. Hand-tighten screw until seated, then use special tool to torque it to 30 N-m.

36. After tightening screw, mark it with a green paint marker. (Refer to the image in Step 32)
37. Tilt vehicle fully to the left.



38. Please ensure that EPB and ETL are fully locked after tilting. Lock icons will be displayed on both Dash and IDU. Power off vehicle only after confirming locks are engaged before proceeding with any work.

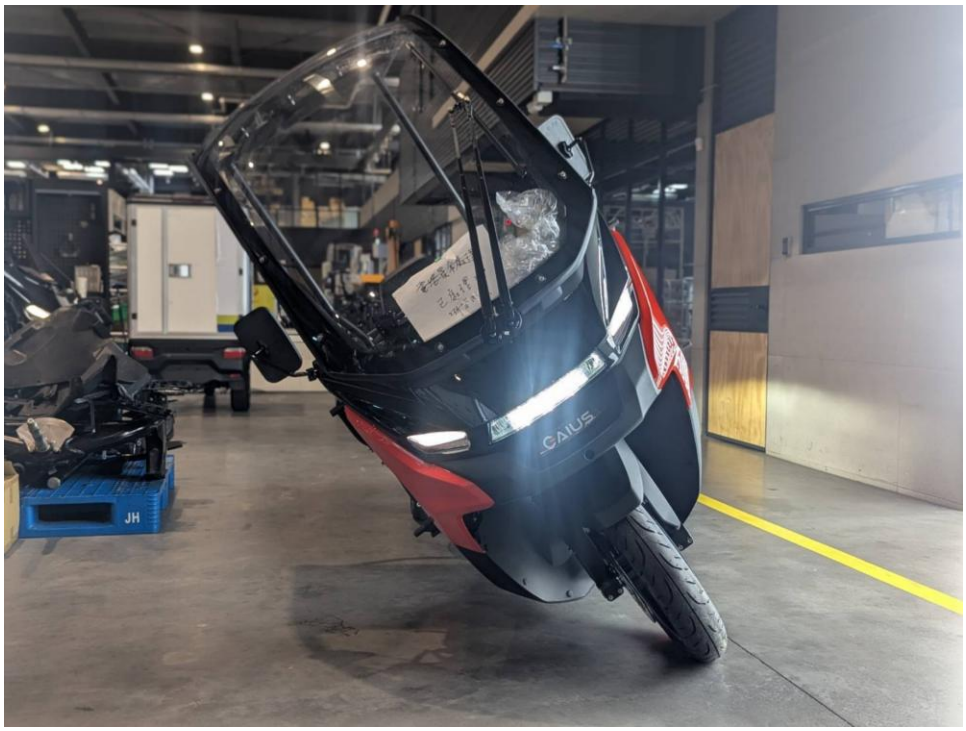
39. Use a plum open-end wrench to loosen fixing screw on the down right side of disc.

40. Replace with correct screw. Apply thread locker (Loctite 243 or equivalent) to threads of the new screw, leaving first two threads uncoated. Begin applying thread locker from 5th or 6th thread onward. (Refer to the image in Step 30.)

41. Hand-tighten screw until seated, then use special tool to torque it to 30 N-m.

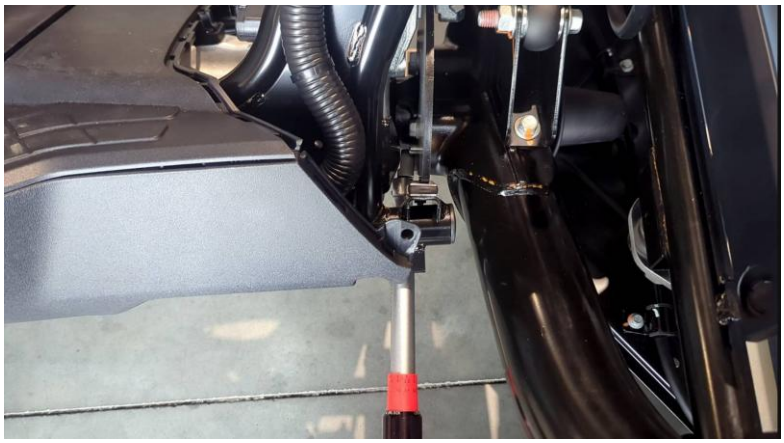
42. After tightening screw, mark it with a green paint marker. (Refer to the image in Step 32)

43. Tilt vehicle fully to the right.

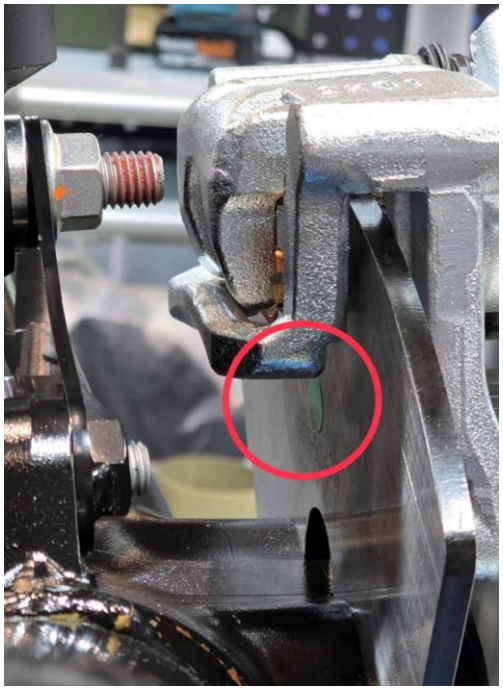


44. Please ensure that EPB and ETL are fully locked after tilting. Lock icons will be displayed on both Dash and IDU. Power off vehicle only after confirming locks are engaged before proceeding with any work. (Refer to the image in Step 38)
45. Use a plum open-end wrench to loosen fixing screw on the down left side of Disc.

46. Replace with the correct screw. Apply thread locker (Loctite 243 or equivalent) to threads of the new screw, leaving first two threads uncoated. Begin applying thread locker from 5th or 6th thread onward. (Refer to the image in Step 30.)
47. Hand-tighten screw until seated, then use special tool to torque it to 30 N-m.



48. After tightening screw, mark it with a green paint marker. (Refer to the image in Step 32)
49. After replacing all four screws, apply a green mark on the back of disc to indicate that screws have been properly replaced on this vehicle.



50. Reinstall seat apron and connect rollover sensor connector.

51. Before reinstalling the seat, ensure seat sensor connector is properly connected.

52. Tighten seat mounting bolts.

53. Fill in Gaius Tilt Quality Recording Form as attached and Email to Gaius technical support team.

LABOR HOUR & PARTS:

Parts		
P/N	Part Description	QTY.
9102009-M8	M8-1.25 x 20mm, Flanged Hex Head Bolt, Class **10.9**, Zn Flake	4
9503001-10	split pins	2
Labor Hour		
Labor Code	Labor Description	HR
15003	Tilt Disc Bolt Replace (choose 1)	0.5
15007	Tilt Disc Split Pins Replace (choose 1)	1.0