

SERVICE BULLETIN

Reference number:	SB-01-1001V2	Issued: 10 January, 2018
Subject:	Front Division Bar and Quarter Glass assembly - add hole to door	
Model(s):	Vanquish (13MY Onwards) Coupe and Volante	
VIN Range:	J00001 to J02109	
Applicable to:	All Dealers	
Distribute to:	After Sales Manager Executive Manager Service Manager Sales Manager	Warranty Technician(s) Parts

Reason for Version 2 of this Service Bulletin:

This release gives more accurate VIN range data. Please destroy all copies of SB-01-1001 that you have, and replace them with SB-01-1001V2.

Reason for this Service Bulletin

The design of the division bar and quarter glass assembly on the Vanquish has changed. It is now attached at three points to the door. New division bar and quarter glass assemblies are now only available to attach to the door at three points. If you need to replace the front division bar and quarter glass assembly on an earlier vehicle, you must do the Workshop Procedure that follows to add a hole to the door.

Workshop Procedure

This workshop procedure has the parts that follow:

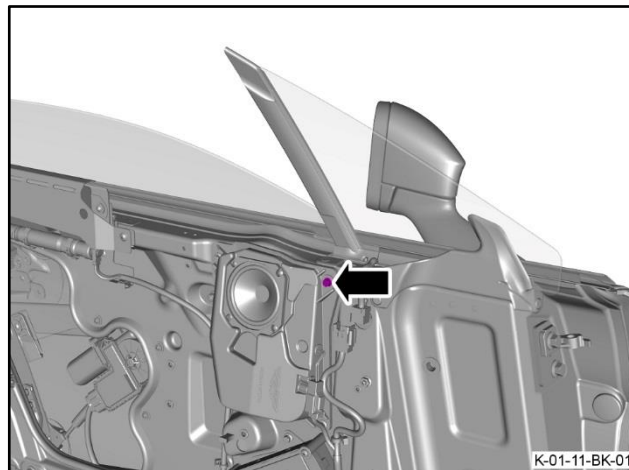
- Part A – Remove the division bar and quarter glass assembly attached at two points
- Part B – Remove the door glass
- Part C – Change the door to have three holes to attach the new division bar and quarter glass assembly
- Part D – Assemble the door
- Part E – Adjust the division bar and quarter glass assembly

WARNING: PUT ON PROTECTIVE GLOVES AND EYE PROTECTION WHEN YOU HOLD THE DOOR GLASS. THE DOOR GLASS CAN BREAK EASILY AND CAUSE INJURY.

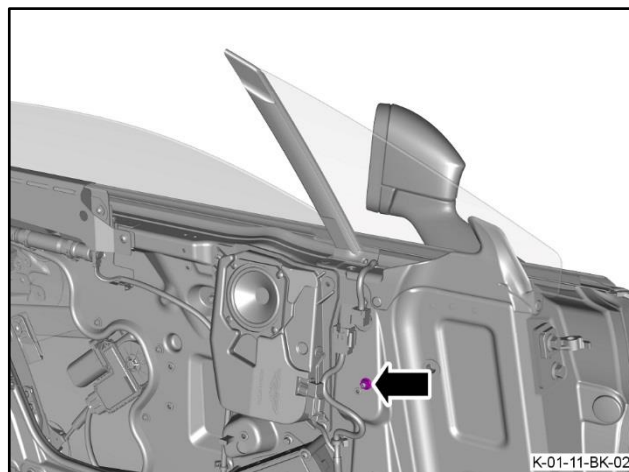
Note: *The images in the procedures that follow show a left door assembly. The procedure is the same for a right door assembly.*

Part A – Remove the division bar and quarter glass assembly attached at two points

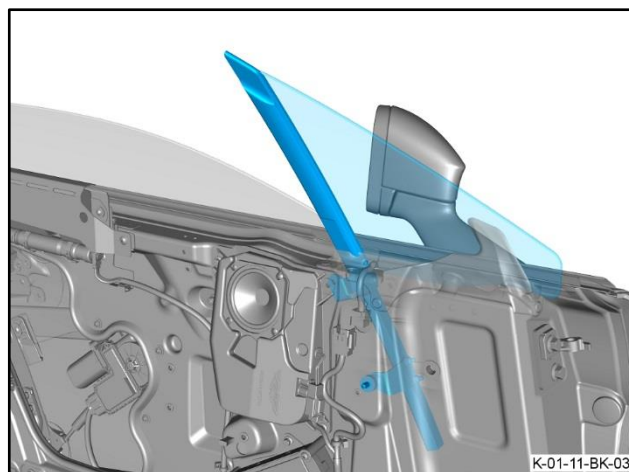
1. Remove the trim panel for the applicable door (refer to Workshop Manual procedure 01.05.GB or 01.05.GQ).
2. Remove the inner waist weather strip for the applicable door (refer to Workshop Manual procedure 01.07.AF or 01.07.AG).
3. Operate the door glass down until it disengages from the division bar and quarter glass assembly.
4. Remove the bolt that attaches the division bar and quarter glass assembly to the door (refer to Figure 1).

**Figure 1**

5. Remove the nut that attaches the division bar and quarter glass assembly to the door (refer to Figure 2).

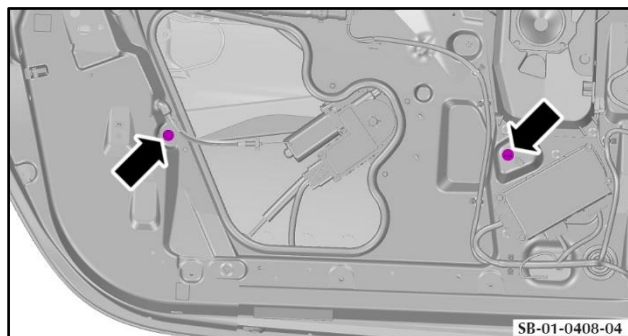
**Figure 2**

6. Remove the division bar and quarter glass assembly (refer to Figure 3).

**Figure 3**

Part B – Remove the door glass

1. Remove the two plugs to get access to the clamp screws for the door glass (refer to Figure 4).

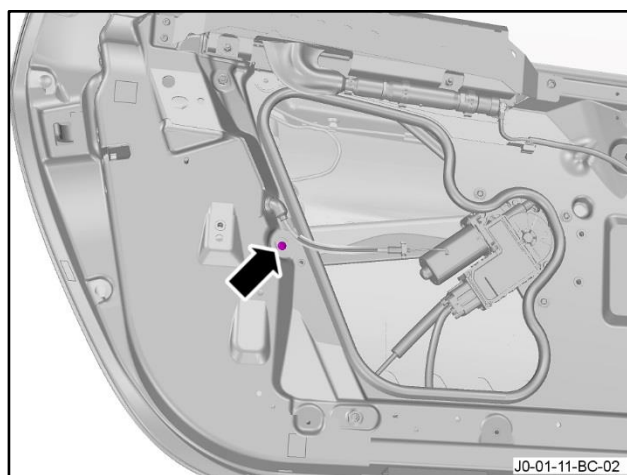
**Figure 4**

2. Temporarily connect the door window switch.
3. Operate the door glass to get access to all of the clamp screws that hold the door glass.

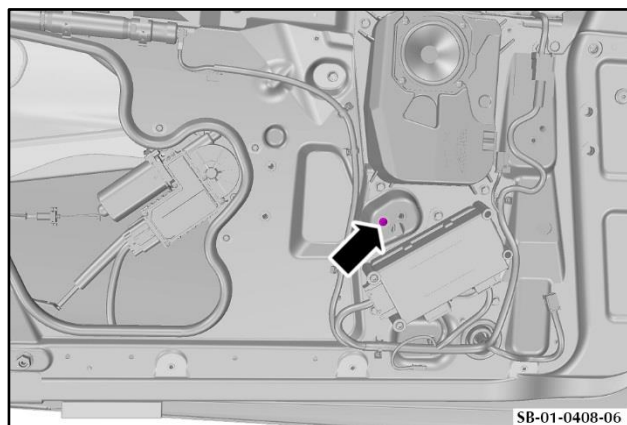
WARNING: PUT ON PROTECTIVE GLOVES AND EYE PROTECTION WHEN YOU HOLD THE DOOR GLASS. THE DOOR GLASS CAN BREAK EASILY AND CAUSE INJURY.

WARNING: DO NOT LET THE DOOR GLASS FALL DURING THE STEPS THAT FOLLOW. THE DOOR GLASS CAN BREAK EASILY AND CAUSE INJURY.

4. Loosen the clamp screw that attaches the door glass to the rear regulator slider (refer to Figure 5).

**Figure 5**

5. Loosen the clamp screw that attaches the door glass to the front regulator slider (refer to Figure 6).

**Figure 6**

6. Release the door glass from the regulator sliders (refer to Figure 7).

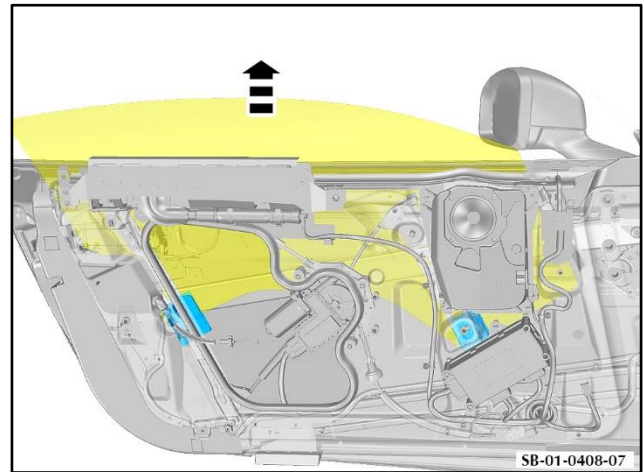


Figure 7

7. Remove the door glass (refer to Figure 8).

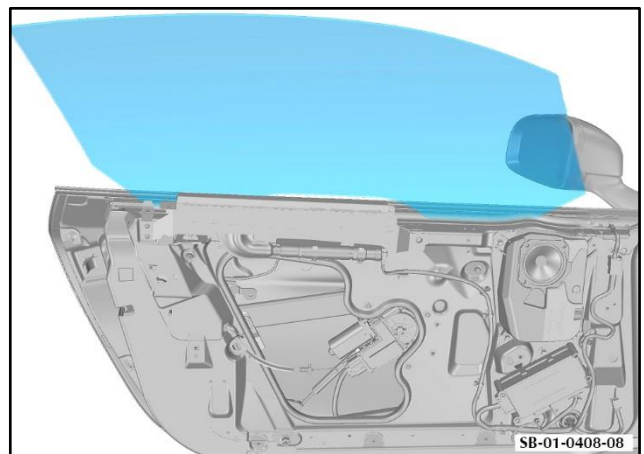


Figure 8

8. Release the three clips that attach the door inner moulding to the door (refer to Figure 9).

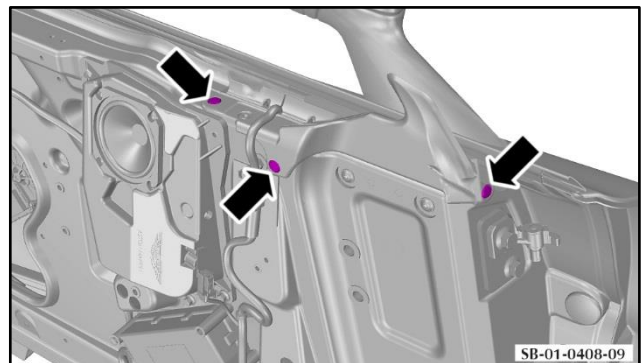


Figure 9

9. Release the strip of adhesive tape and the sealant that attach the door inner moulding to the door (refer to Figure 10).

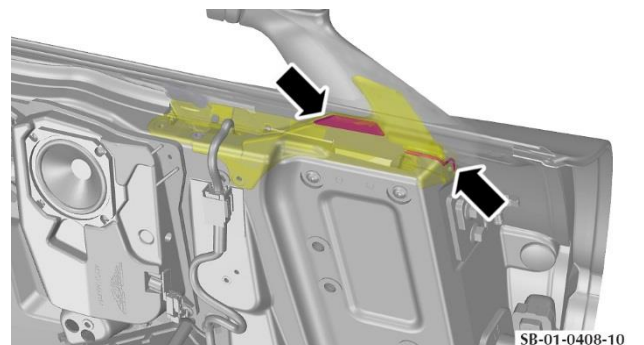
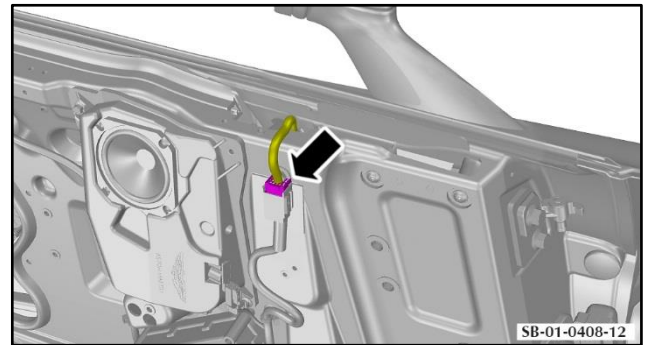
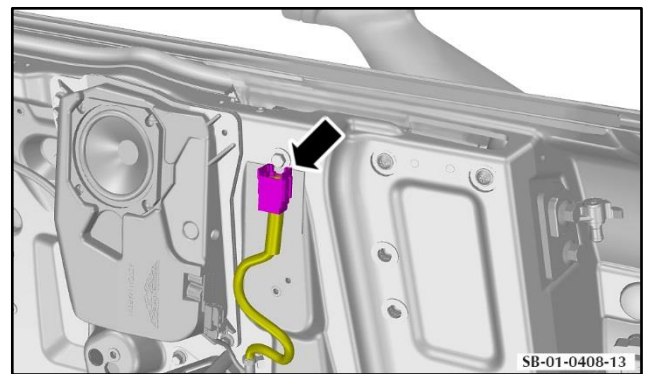


Figure 10

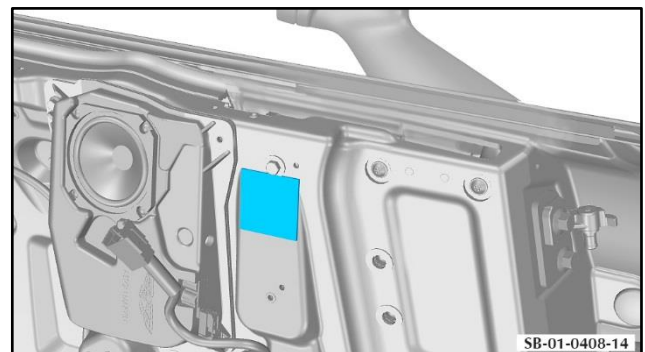
10. Remove and discard the moulding.
11. Clean all remaining adhesive tape from the door.
12. Disconnect the electrical connector for the exterior mirror (refer to Figure 11).

**Figure 11**

13. Release the clip that attaches the electrical connector for the exterior mirror to the door (refer to Figure 12).

**Figure 12**

14. Remove the sealing pad (refer to Figure 13).

**Figure 13**

15. Remove the bolt, spacer and washers (refer to Figure 14).

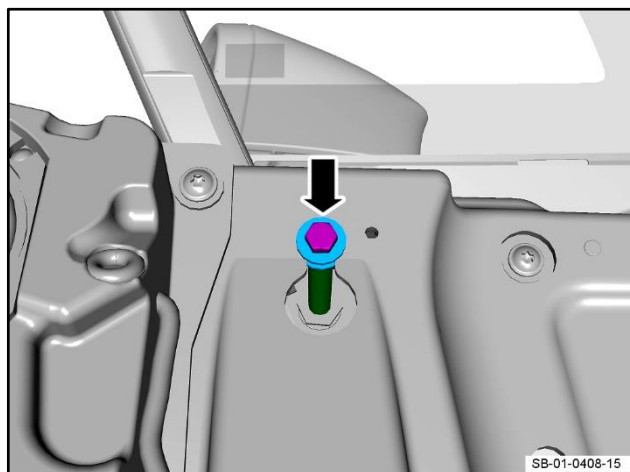


Figure 14

16. Release the front section of the inner waist weather strip and move it away (refer to Figure 15).

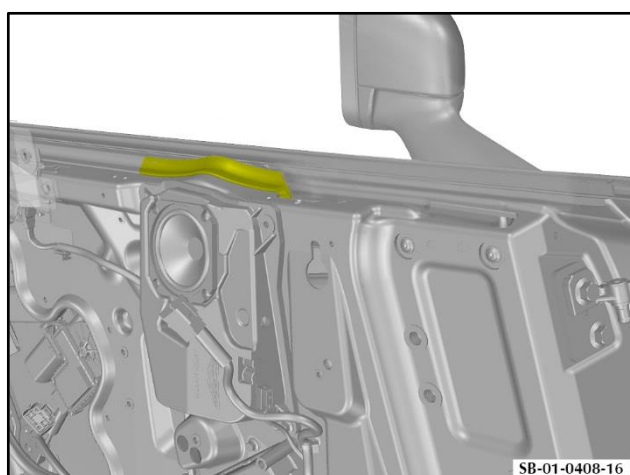


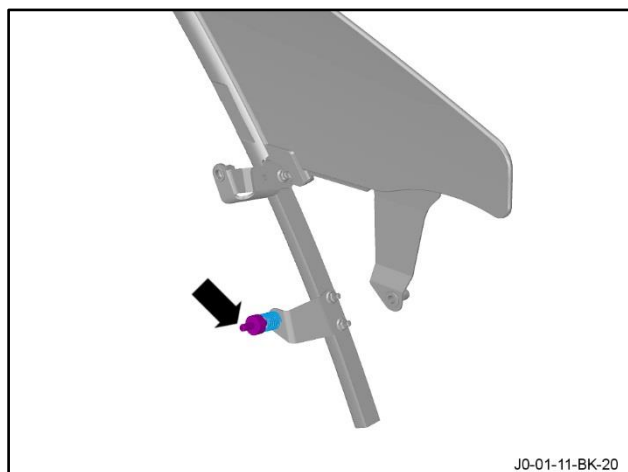
Figure 15

Part C – Change the door to have three holes to attach the new division bar and quarter glass assembly

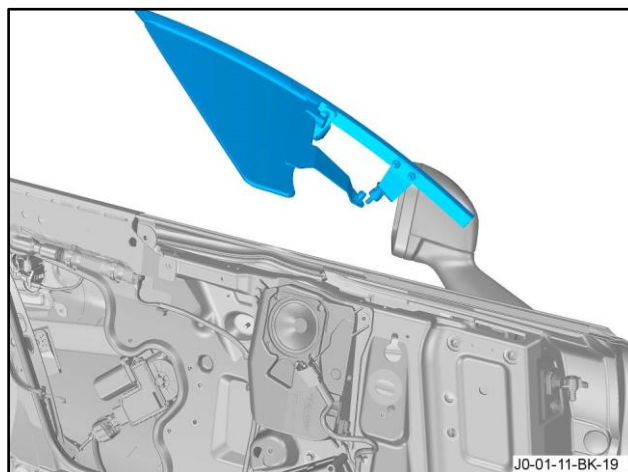
1. Print the template from Appendix A of this document.
2. Make sure that the template is the correct scale. Use the “MEASURING SCALE” printed on the template.
3. Cut out the applicable right or left template (refer to Figure 16 – the left side is shown).
4. Use adhesive tape to temporarily attach the template to the door in the position shown in Figure 16.
5. Make a 13 mm hole through the door, at the marked position on the template.
6. Remove and discard the template.
7. Remove any rough edges from the hole.
8. Apply an applicable protective paint to all bare metal around the hole to prevent corrosion.

**Figure 16****Part D – Assemble the door**

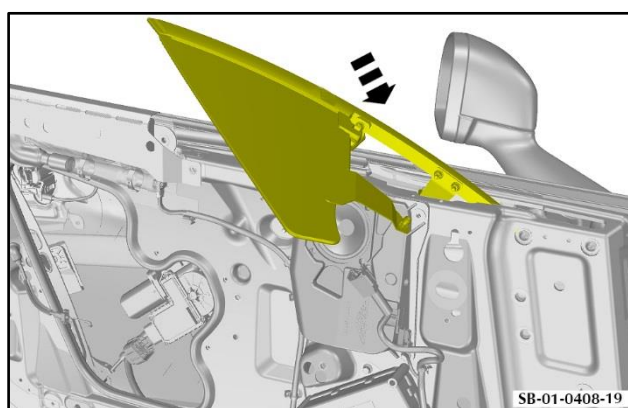
1. Turn the adjustment screw on the division bar and quarter glass assembly 21 turns clockwise to compress the spring (refer to Figure 17).

**Figure 17**

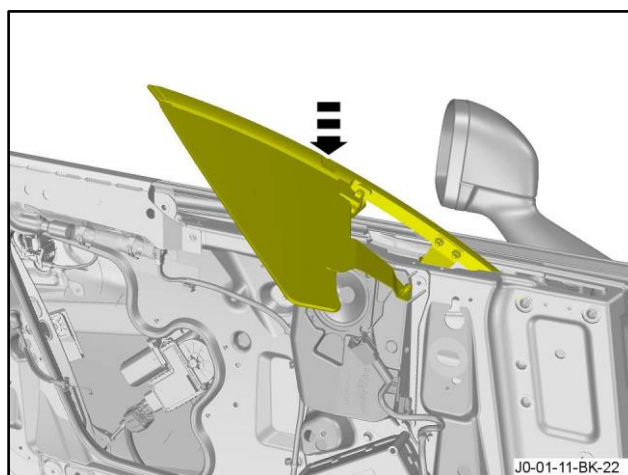
2. Put the division bar and quarter glass assembly in position. (refer to Figure 18).

**Figure 18**

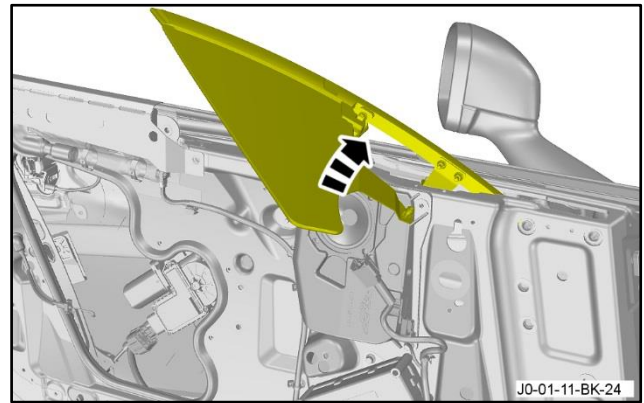
3. Install the division bar and quarter glass assembly into the door opening as shown (refer to Figure 19).

**Figure 19**

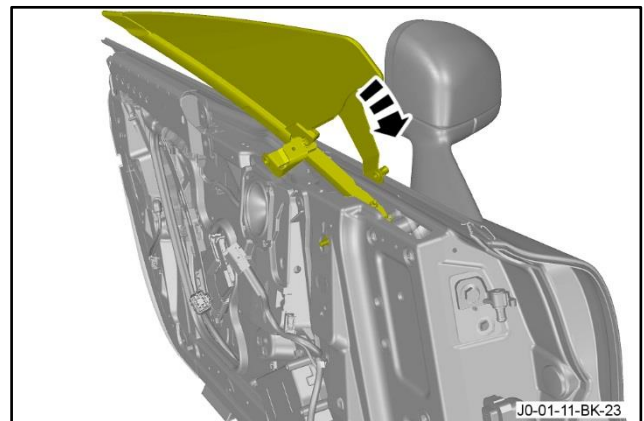
4. Lower the division bar and quarter glass assembly into the door.

**Figure 20**

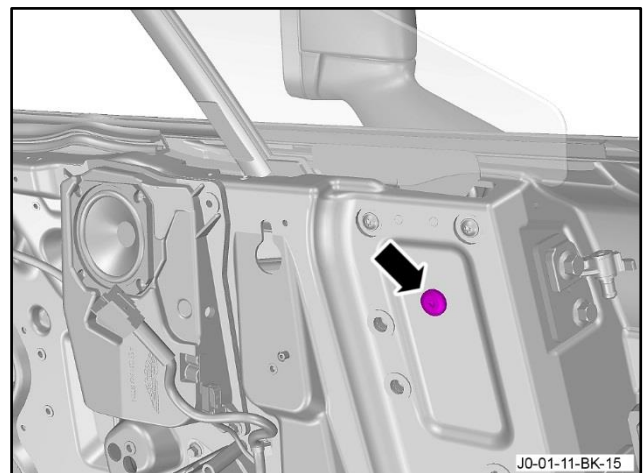
5. Turn the division bar and quarter glass assembly 90 degrees up in the direction of the outer door face (refer to Figure 21).

**Figure 21**

6. Tilt and lower the division bar and quarter glass assembly forward to engage the third fastener bracket into position. Align the hole in the bracket with the new hole in the door (refer to Figure 22).

**Figure 22**

7. Loosely install the bolt that attaches the third bracket of the division bar and quarter glass assembly to the door (refer to Figure 23).

**Figure 23**

8. Engage the adjuster assembly into the hole in the door (refer to Figure 24).

9. Turn the adjustment screw counter-clockwise 21 turns to release the spring.

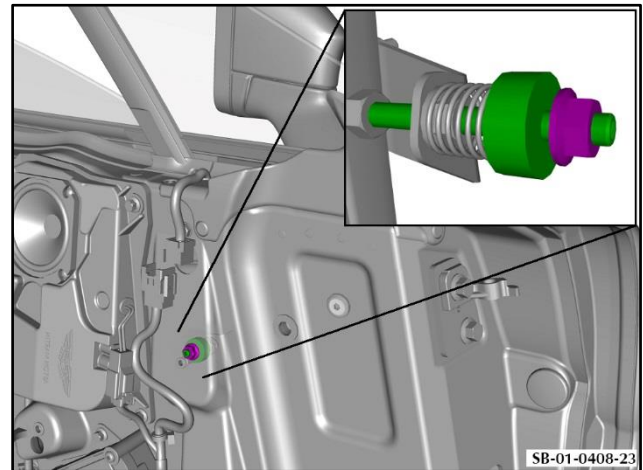


Figure 24

10. Put the inner waist weather strip back into position (refer to Figure 25).

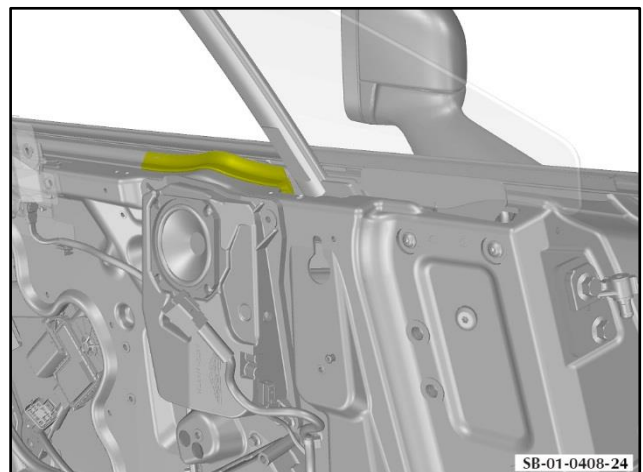


Figure 25

11. Loosely install the nut that attaches the division bar and quarter glass assembly to the door (refer to Figure 26).

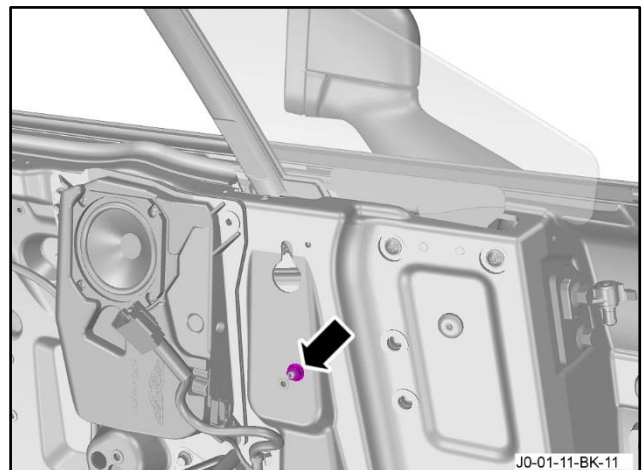


Figure 26

12. Install but do not torque the bolt that attaches the division bar and quarter glass assembly to the door (refer to Figure 27).

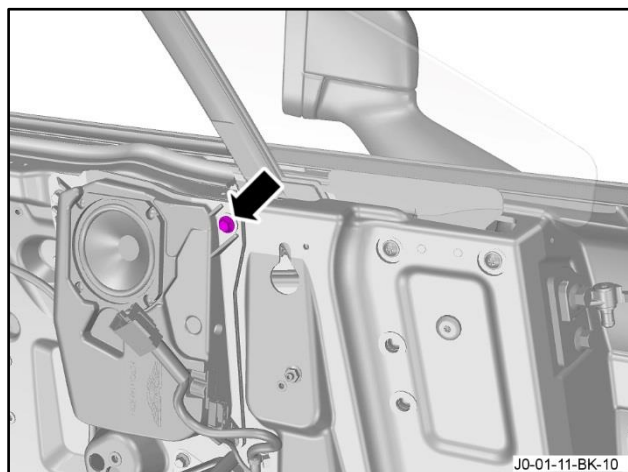


Figure 27

13. Put the bolt, spacer and washers into position (refer to Figure 28).

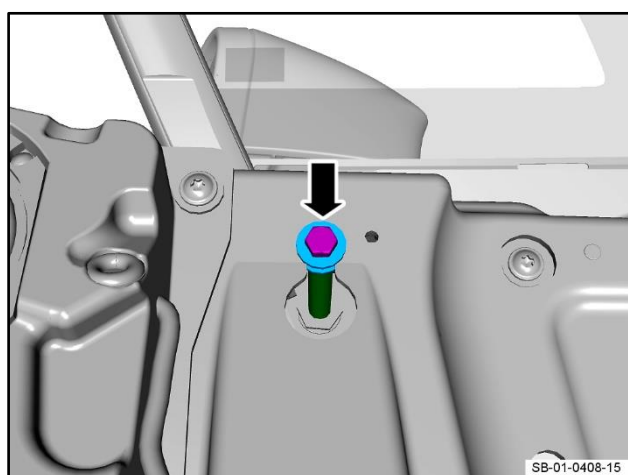


Figure 28

14. Install and torque the bolt to 9 Nm (refer to Figure 29).

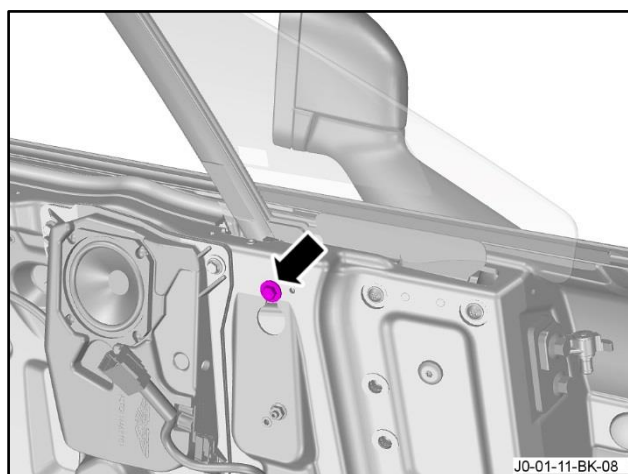


Figure 29

15. Install a new sealing pad (refer to Figure 30).

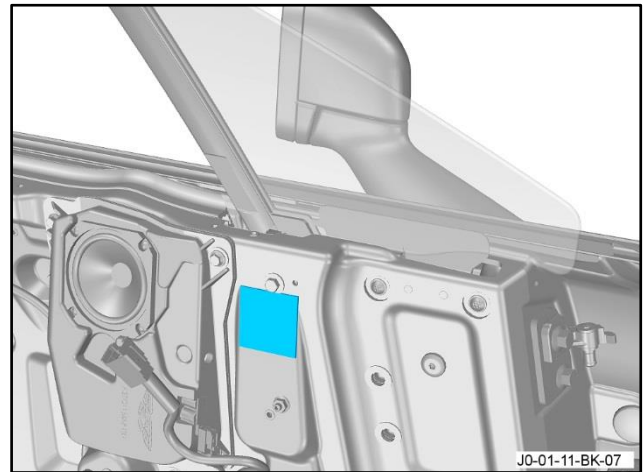


Figure 30

16. Install the clip that attaches the electrical connector for the exterior mirror to the door (refer to Figure 31).

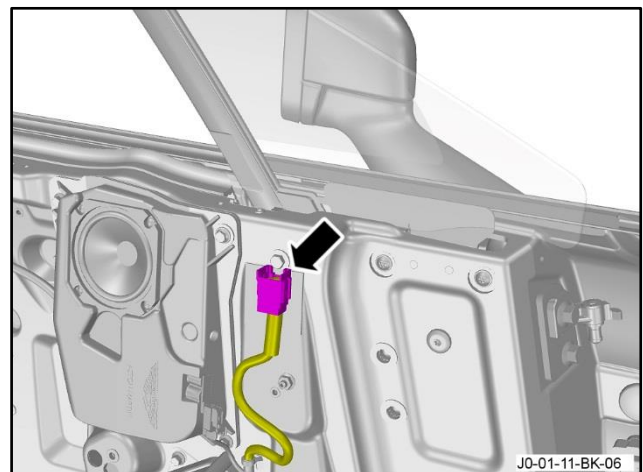


Figure 31

17. Connect the electrical connector for the exterior mirror (refer to Figure 32).

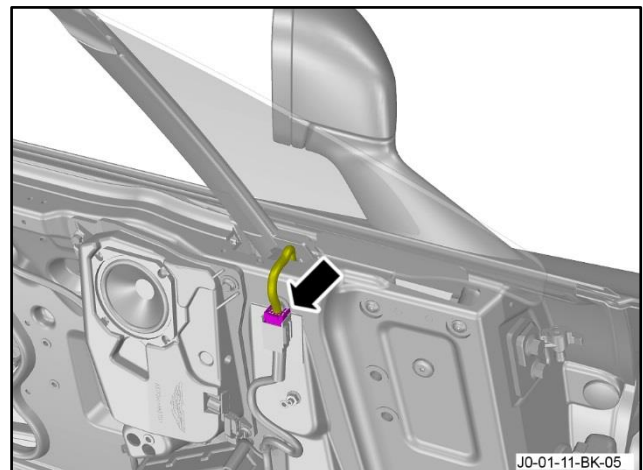


Figure 32

WARNING: PUT ON PROTECTIVE GLOVES AND EYE PROTECTION WHEN YOU HOLD THE DOOR GLASS. THE DOOR GLASS CAN BREAK EASILY AND CAUSE INJURY.

WARNING: DO NOT LET THE DOOR GLASS FALL DURING THE STEPS THAT FOLLOW. THE DOOR GLASS CAN BREAK EASILY AND CAUSE INJURY.

18. Carefully put the door glass into the door (refer to Figure 33).
19. Engage the door glass into the regulator sliders.

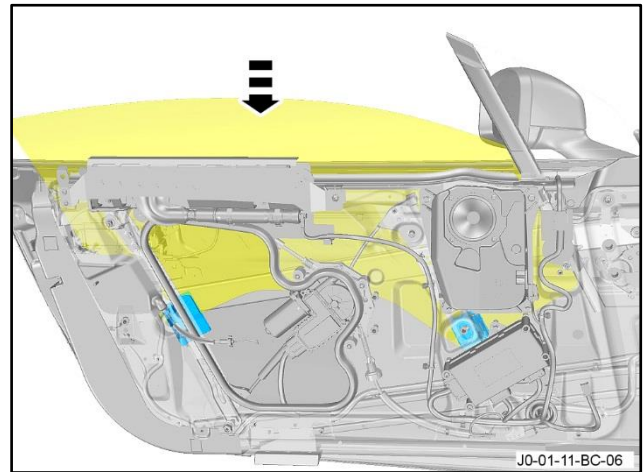


Figure 33

CAUTION: DO NOT TIGHTEN THE CLAMP SCREWS TOO MUCH IN THE STEPS THAT FOLLOW. IF YOU TIGHTEN THE CLAMP SCREWS TOO MUCH, THE DOOR GLASS CAN BREAK.

20. Carefully tighten the front clamp screw for the door glass enough to hold the glass (refer to Figure 34).

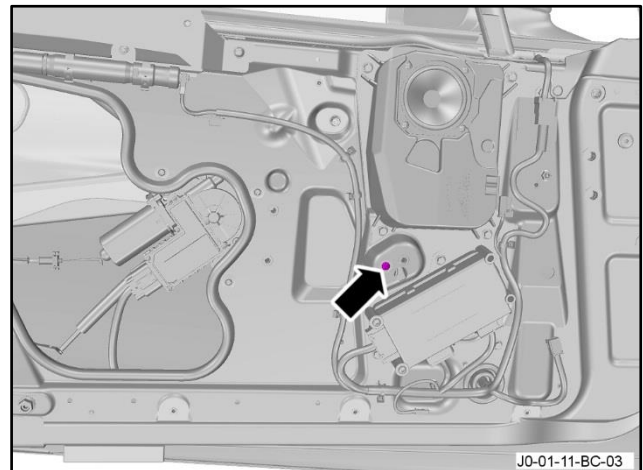


Figure 34

21. Carefully tighten the rear clamp screw for the door glass enough to hold the glass (refer to Figure 35).

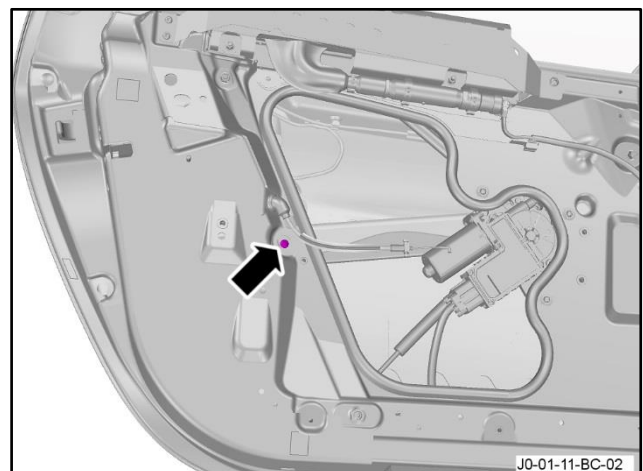
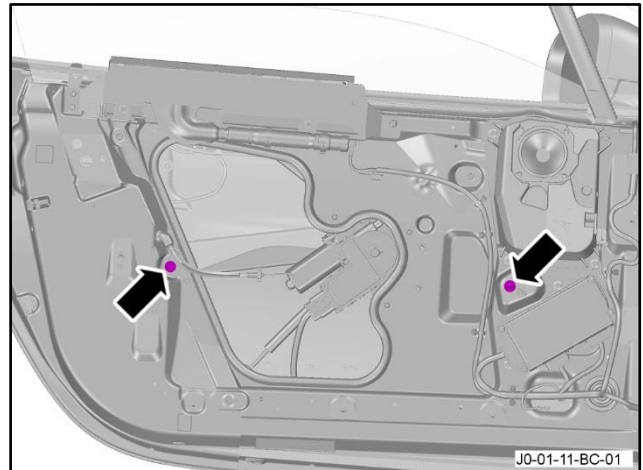


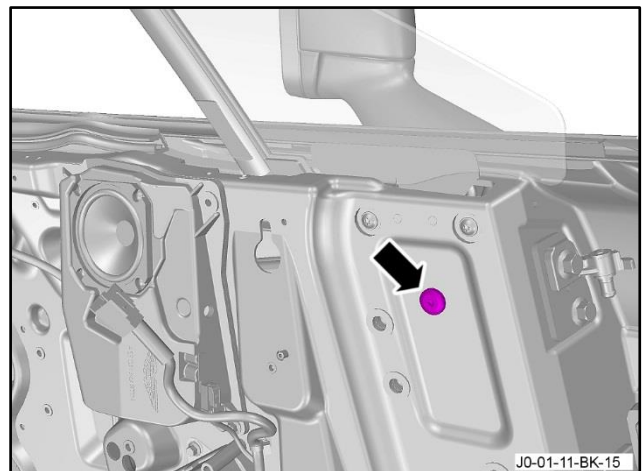
Figure 35

Part E – Adjust the division bar and quarter glass assembly

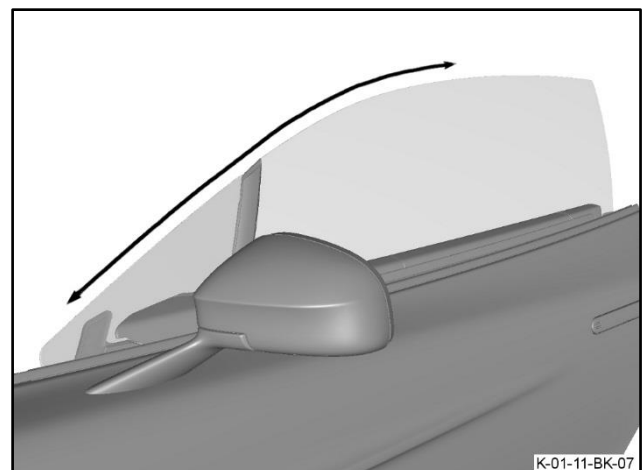
22. Adjust the door glass (refer to Workshop Manual procedure 01.11.BB or 01.11.BD).
23. Install the two blanking plugs (refer to Figure 36).

**Figure 36**

24. Operate the door glass so it engages with the division bar and quarter glass assembly in the short drop position.
25. Torque the bolt that attaches the third bracket of the division bar and quarter glass assembly, to the door, to 6 Nm (refer to Figure 37).

**Figure 37**

26. Make sure that the division bar and quarter glass assembly follows the curve of the door glass (refer to Figure 38).

**Figure 38**

27. If the division bar and quarter glass assembly does not follow the curve of the front door glass, adjust it on its X axis (refer to Figure 39).

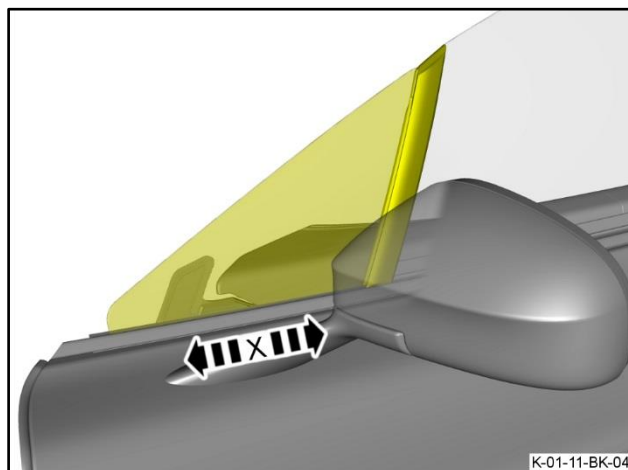


Figure 39

28. Align the division bar and quarter glass assembly with the front edge of the door glass.

29. If the division bar and quarter glass assembly is not correctly aligned, adjust it on its Y axis (refer to Figure 40).

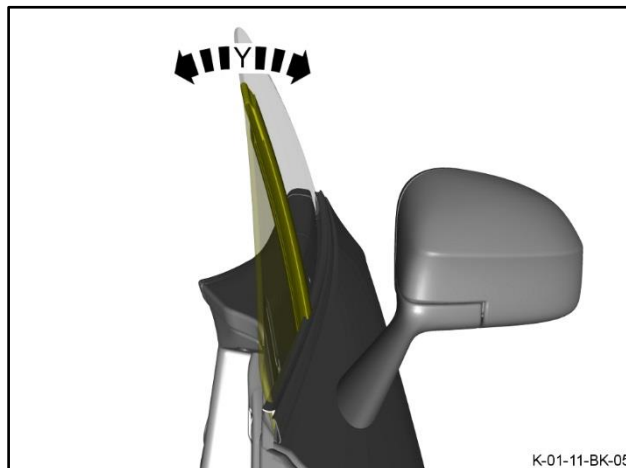


Figure 40

30. Loosen the nut and adjust the adjustment screw one turn at a time (refer to Figure 41).

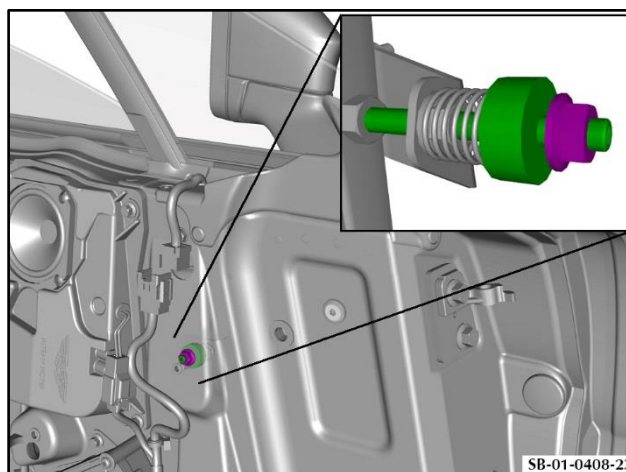


Figure 41

31. Do a check again to make sure the division bar and quarter glass assembly correctly aligns with the door glass. Make sure that when the door glass is operated, it engages and disengages from the division bar and quarter glass assembly correctly.

32. Torque the bolt that attaches the division bar and quarter glass assembly to the door to 6 Nm (refer to Figure 42).

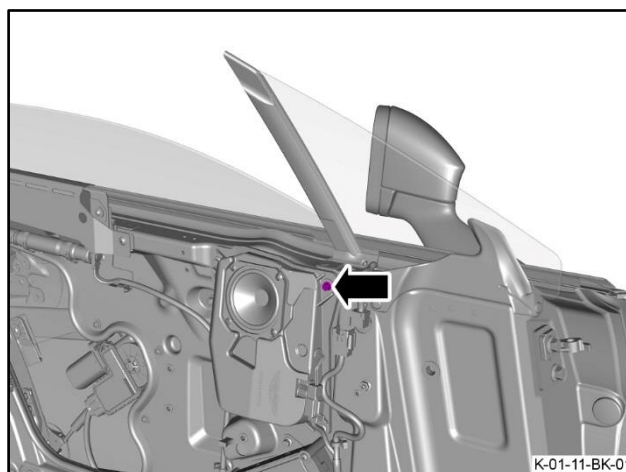


Figure 42

CAUTION: MAKE SURE THAT THE ADJUSTMENT SCREW DOES NOT TURN WHEN YOU TORQUE THE NUT. IF THE ADJUSTMENT SCREW MOVES YOU WILL NEED TO DO THE ADJUSTMENT PROCEDURE AGAIN.

33. Torque the nut that attaches the division bar and quarter glass assembly to the door to 9 Nm (refer to Figure 43).

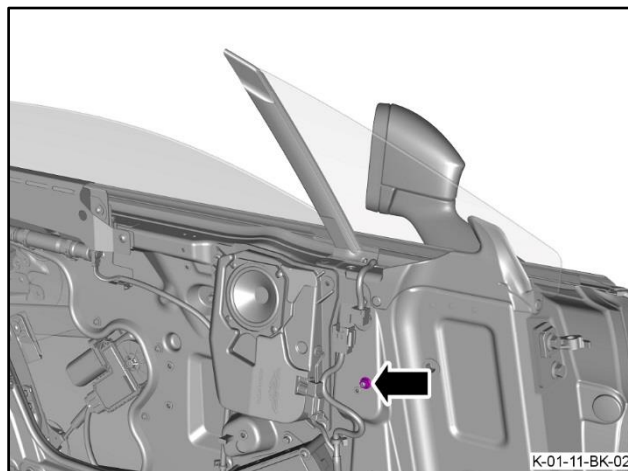


Figure 43

34. Remove the protective backing from the adhesive tape and the butyl rope on a new inner moulding for the door (refer to Figure 44).

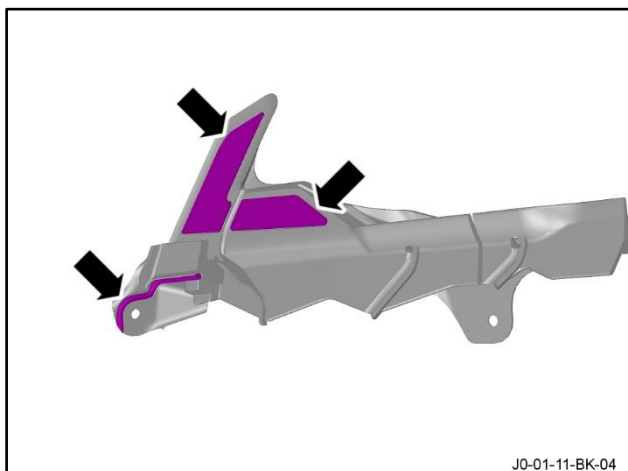


Figure 44

35. Put the new inner moulding for the door in position (refer to Figure 45).
36. Bond the inner moulding to the door and the quarter glass with the two adhesive strips and the butyl rope (refer to Figure 45).

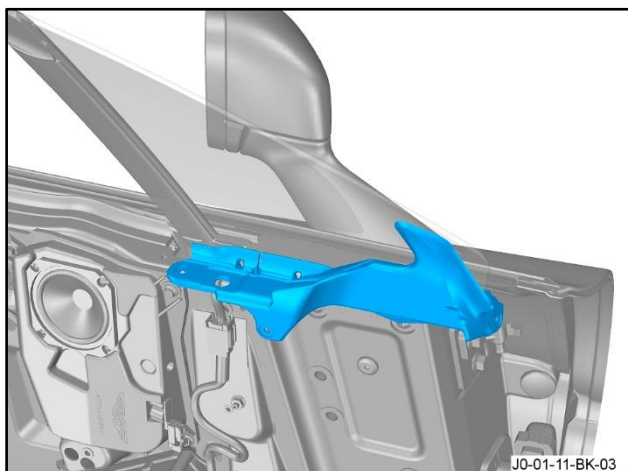


Figure 45

37. Install the three clips that attach the new inner moulding to the door (refer to Figure 46).

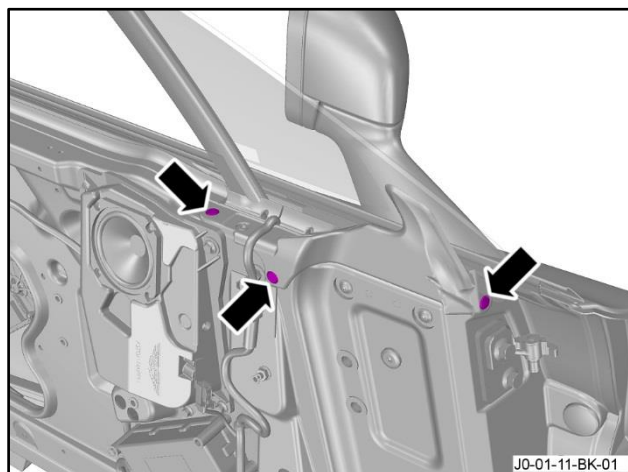


Figure 46

38. Install the inner waist weather strip for the applicable door (Refer to Workshop Manual procedure 01.07.AF or 01.07.AG).
39. Install the trim panel for the applicable door (refer to Workshop Manual procedure 01.05.GB or .01.05.GQ).
40. Connect the AMDS to the vehicle and clear all of the Diagnostic Trouble Codes (DTCs) (refer to Workshop Procedure 00.06.AD).

Part Data

Description	Part Number	Quantity
Assembly, Division Bar and Quarter Glass, Left Side	CD33-C262A37-BD	1
Assembly, Division Bar and Quarter Glass, Right Side	CD33-C262A36-BD	1
Screw and Washer, M6 x 20.	6G33-FA0115-AB	1 each assembly
Sealing Pad, Al Butyl 35 x 35	6G43-F78410-AA	1 each door
Moulding, front door trim (Right side)	CD33-C20920-BB	1 for right door
Moulding, front door trim (Left side)	CD33-C20921-BB	1 for left door

Procedure and Labour Time

Description	Labour Time	ROT Code
Remove the division bar and quarter glass assembly (2 fixing point) and install the division bar and quarter glass assembly (3 fixing point)	2.6 hours	01.11.BS

Appendix A follows on the next page:

If you have any questions related to this Service Bulletin, please contact: Aston Martin Technical Services
on: +44 (0) 1926 644720, email: askamtech@astonmartin.com,
Or contact your After Sales Manager.

The English version of this Service Bulletin is written in
Simplified Technical English to ASD-STE100™.