

RCI-52-22-006-2: Threaded Fastener Re-use (Threadlocker)

Rivian Automotive, LLC Position Statement and Technical Notes

Document Type	Collision Repair Information Document
Date	5/24/2022
Affected Region(s)	USA
Affected Model(s)	R1T, R1S, EDV
Model Year(s)	2022 +
Vehicle System	52 - Body

Rivian has established important guidelines regarding collision repair and interaction with parts on Rivian vehicles to help ensure the vehicle is repaired to Rivian standards. Certified Collision Centers and the collision industry must follow these guidelines to uphold Rivian's standards of safety and quality.

Rivian vehicles are engineered and manufactured as an integrated assembly of carefully designed and manufactured parts that work together to deliver performance, safety, and durability. To help maintain continued performance, safety, and durability for the life of the vehicle, Rivian provides the collision industry with important information regarding collision repair and parts on Rivian vehicles. Due to the complexity of Rivian vehicles and their sub-systems, to meet Rivian Standards, all repairs should only be performed by Rivian Certified technicians. To meet [Rivian Repair standards](#), repairs should be performed using Rivian approved repair procedures, tools, and Rivian Original Equipment Parts.

Fasteners that are called out in the parts list of the service manual procedure, but are undamaged and have one of the factory-applied thread locking and/or sealing features called out in Table 1, can be reused if a replacement fastener is not readily available.

Some bolts have a seal that is applied from the bottom side of the bolt to keep out moisture. If damaged upon removal, replace with a new seal if available. If a seal is not available, refer to Table 1 for the approved service alternative.

Table 1

Factory Material	Purpose	Location	Visual Identifier (Color)	Approved Service Alternative
ND Microspheres Blue	Medium Strength Thread Locker	Fastener Threads (General assembly and mild stressed fasteners)	Blue low viscosity liquid or anaerobic gel	Loctite 243/290 Permatex 24835 Vibra-Tite VT121/VT125
ND Patch Yellow	Thread sealant and thread locker	Wheel liners and under shields	Yellow viscosity liquid or anaerobic gel	Re-usable 3X. If in doubt replace with NEW fastener with factory applied Yellow Patch
ND Epoxy-Lock ND TA 800 Orange or Red	High Strength Thread Locker	Fastener Threads (structural, heavy mechanical assembly, high stressed fasteners)	Red low viscosity liquid or anaerobic gel	Loctite 263/277 Permatex 26210 Vibra-Tite 140/135
ND ST-3 White	Thread Sealant	Fastener Threads (connection points with liquids present)	White paste	Loctite 5452 Permatex 57535 Vibra-Tite VT420
ND Plastisol Black	Fastener Seal	Fastener mating flange surface (Areas that require moisture protection)	Black sealant	Loctite SI 593 Permatex 80060 Vibra-Tite VT998

Fastener re-use is not possible if:

- The fasteners are torque-to-yield



Note: Some bolts may have the same visual appearance, but the function and placement may affect the operation purpose. Always replace with a new fastener and observe the installation torque values and applicable repair procedure.

- The fasteners are prevailing torque types.
- The fasteners have plastic that is deformed during installation.



Note: The re-use of these types of fasteners can cause failure of the bolted connection.

- The fastener Nuts have Teflon lining.
- The fastener has any damage.
- The parent fastener material has any damage.

If accessible, use chemical cleaner to ensure the area is clean and ready for application. Be sure to remove all debris and residual chemical cleaner prior to application of threadlocker or sealant.

Always refer to the appropriate Rivian Repair procedure for the most up to date information regarding specifications as well as location, position, operation sensitivity, part numbers and any revisions listed.