



Audi A3 1997 ➤

General Body Assembly Exterior (Repair groups 50, 55, 57, 58, 60, 63, 64, 66)

Edition 09.1996

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List of Workshop Manual Repair Groups

Audi A3 1997 ➤

General Body Assembly Exterior (Repair groups 50, 55, 57, 58, 60, 63, 64, 66)
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Repair Group

50 - Body front

55 - Bonnet, Flaps

57 - Front doors/Door components/Central locking system

58 - Rear doors/Door components

60 - Sliding/tilting roof

63 - Bumpers

64 - Glazing

66 - Exterior equipment

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Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.

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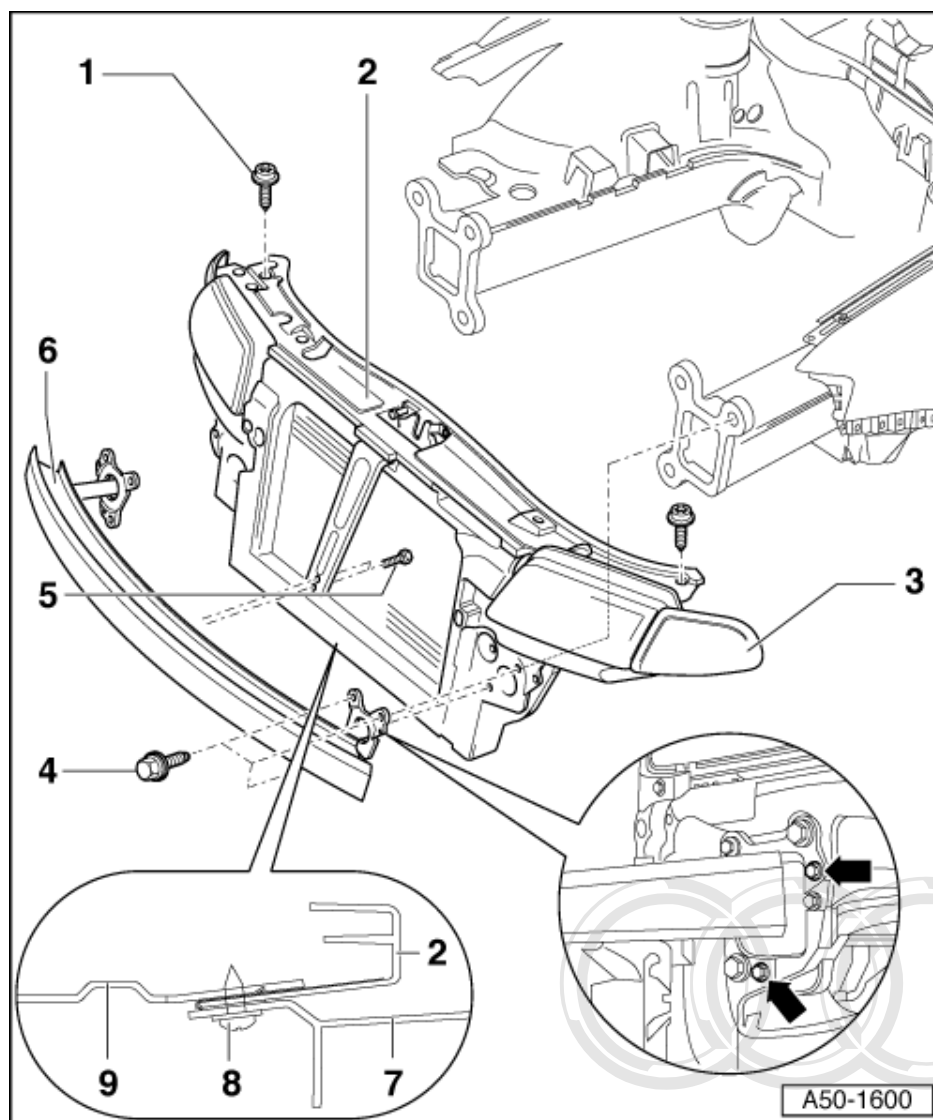


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50 - Body front

1 - Body, front

1.1 - Body, front



1.2 - Removing and installing lock carrier with ancillary components

1 Torx bolt

- ♦ 23 Nm

2 Lock carrier

- ♦ Before removing, detach bumper trim => Page 129

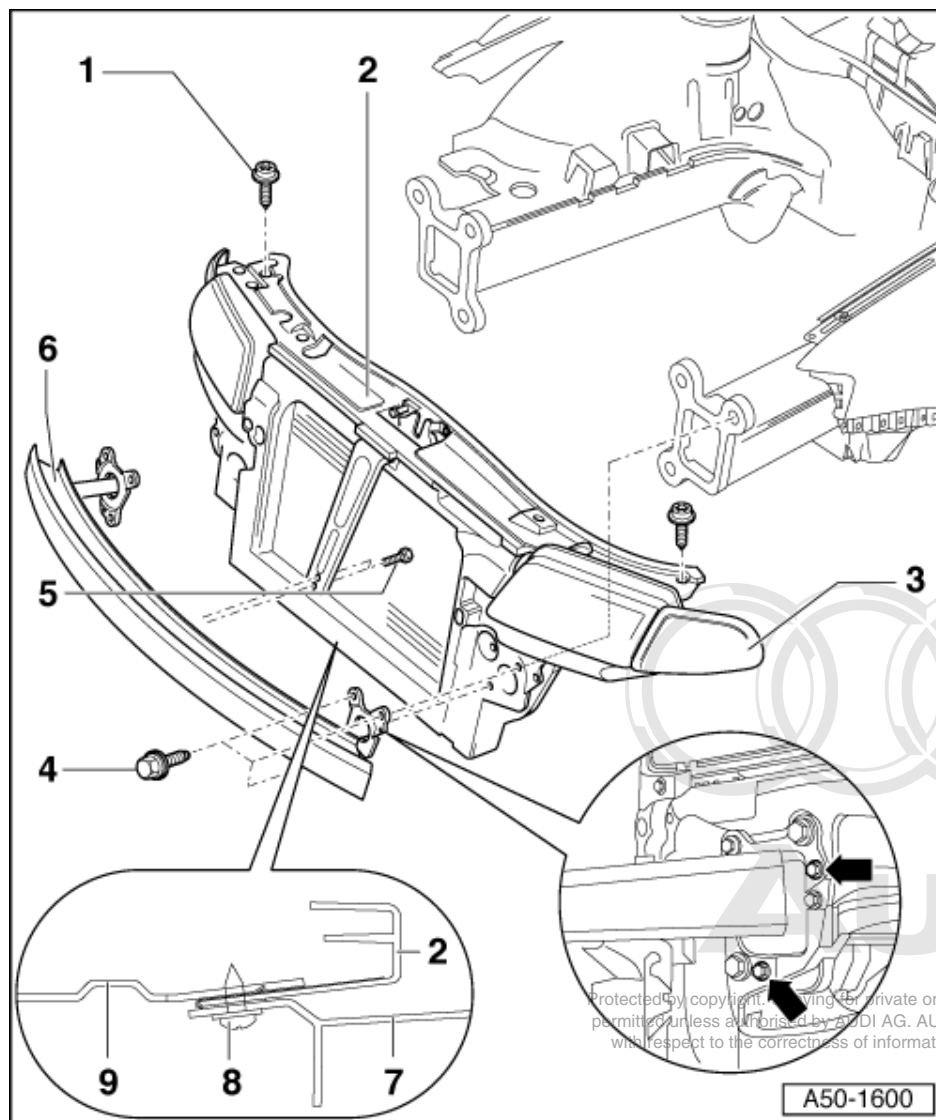
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Note:



Lock carrier can be removed with headlights and radiator fitted.

- ♦ If radiator is also to be removed, drain coolant beforehand.
- ♦ Detach electrical connections for headlights.
- ♦ Turn-signal unit removed.
- ♦ Remove bonnet lock => Page 23



- ♦ To remove, unscrew bolts -1- and -4-.
- ♦ Bolts -arrows- are used to locate bumper on lock carrier and are not unscrewed.
- ♦ Remove lock carrier to front.

3 Turn-signal indicator

4 Hexagon bolt

- ♦ 35 Nm

5 Torx bolt

- ♦ 6 Nm

6 Bumper

- ♦ Removing => Page 129

7 Bumper cover

- ♦ Removing => Page 129

8 Self-tapping screw

- ♦ 7.5 Nm

9 Noise insulation

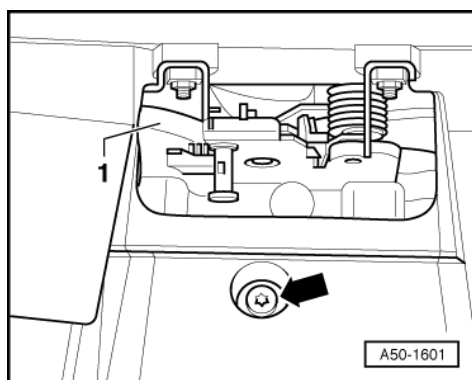
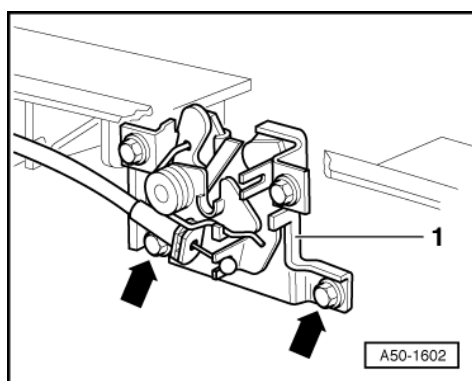


Fig.1-> Removing and installing support for lock carrier

- Unscrew Torx bolt -arrow-.

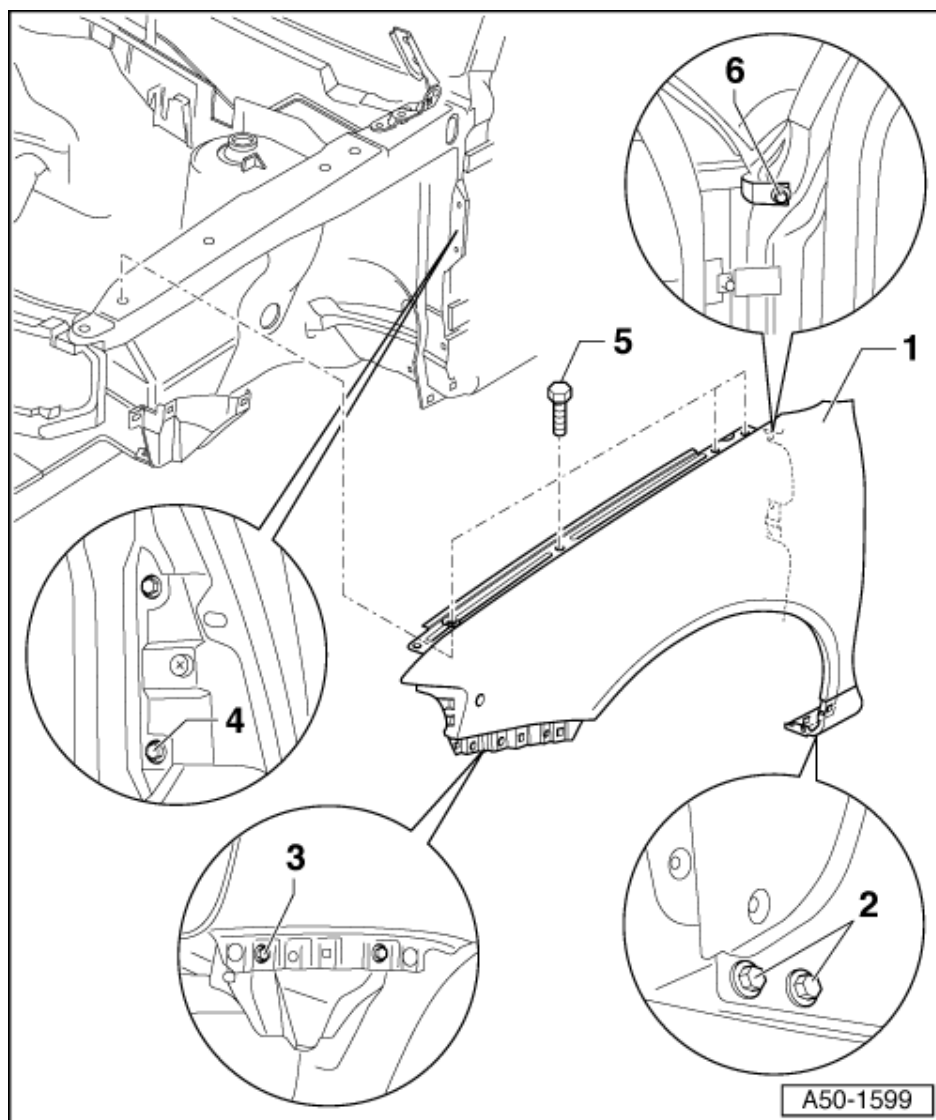


- Unscrew lower bolts -arrows- at bonnet lock.
- -> Unscrew bolts on bumper and remove support.

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1.3 - Removing and installing wing (except S3)



1 Wings

- ◆ Before removing, detach bumper trim and wheel housing liner => Page 129 .
- ◆ To remove, unscrew bolts -5- at wing flange.
- ◆ With door open unscrew hexagon bolt -6-.
- ◆ Unscrew self-tapping screws -3- at guide piece and self-tapping screws -4- under locking piece and remove wing.

2 Hexagon bolt

- ◆ 10 Nm

3 Self-tapping screw

- ◆ 1.5 Nm

4 Self-tapping screw

- ◆ 1.5 Nm

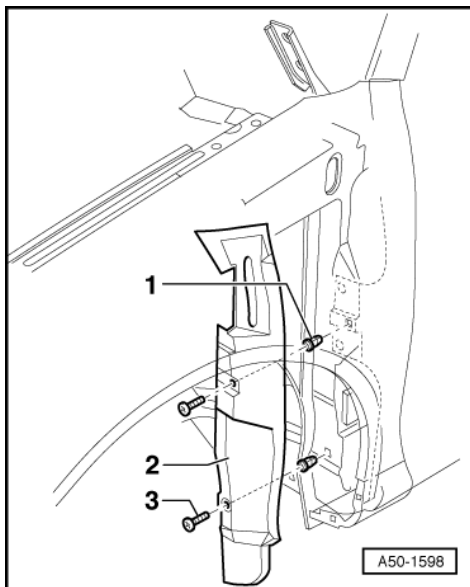
5 Hexagon bolt

- ◆ 15 Nm

6 Hexagon bolt

- ◆ 15 Nm

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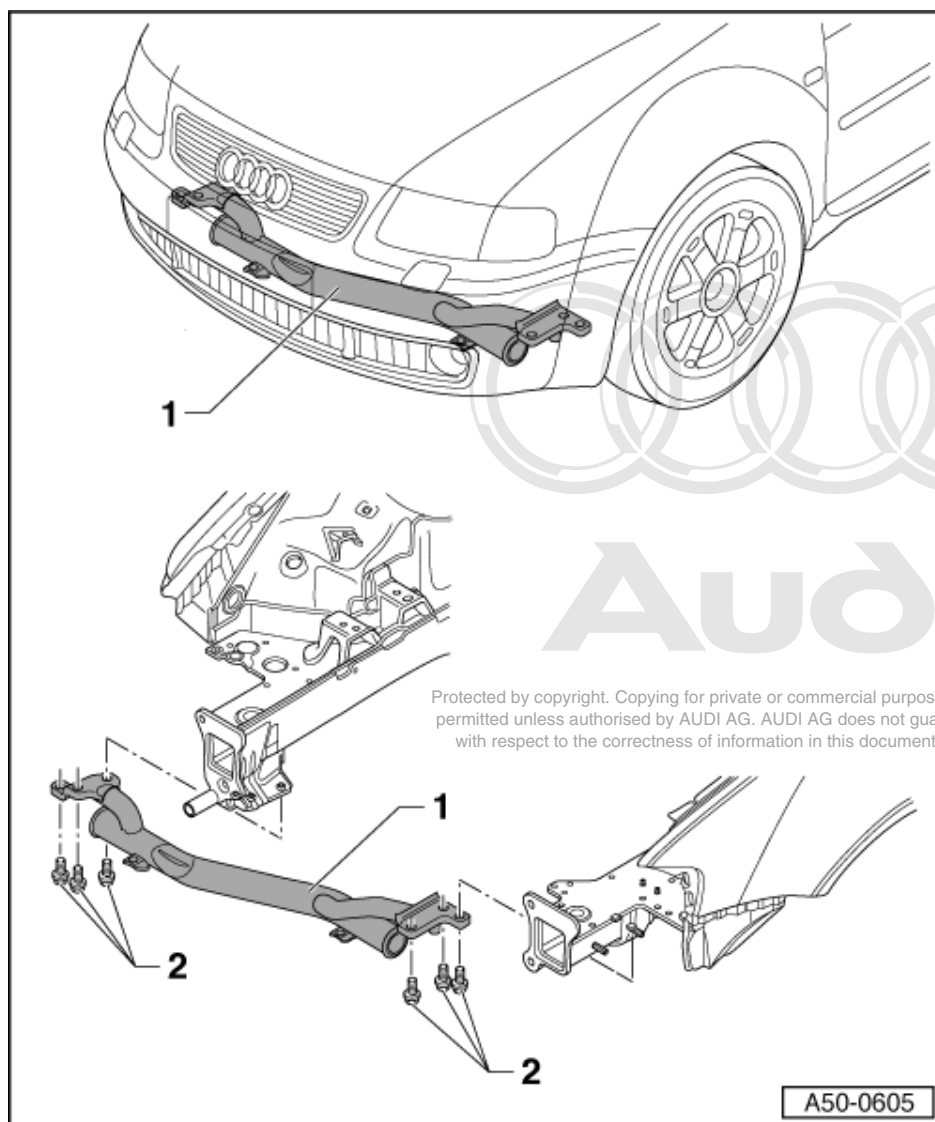
-> Fig.2 Removing and installing locking piece

- Remove wheel housing liner => Page 184 .
- Unscrew bolts -3- and remove locking piece -2- from wheel housing.
- Clip -3-



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1.4 - Removing and installing tubular member (except S3)

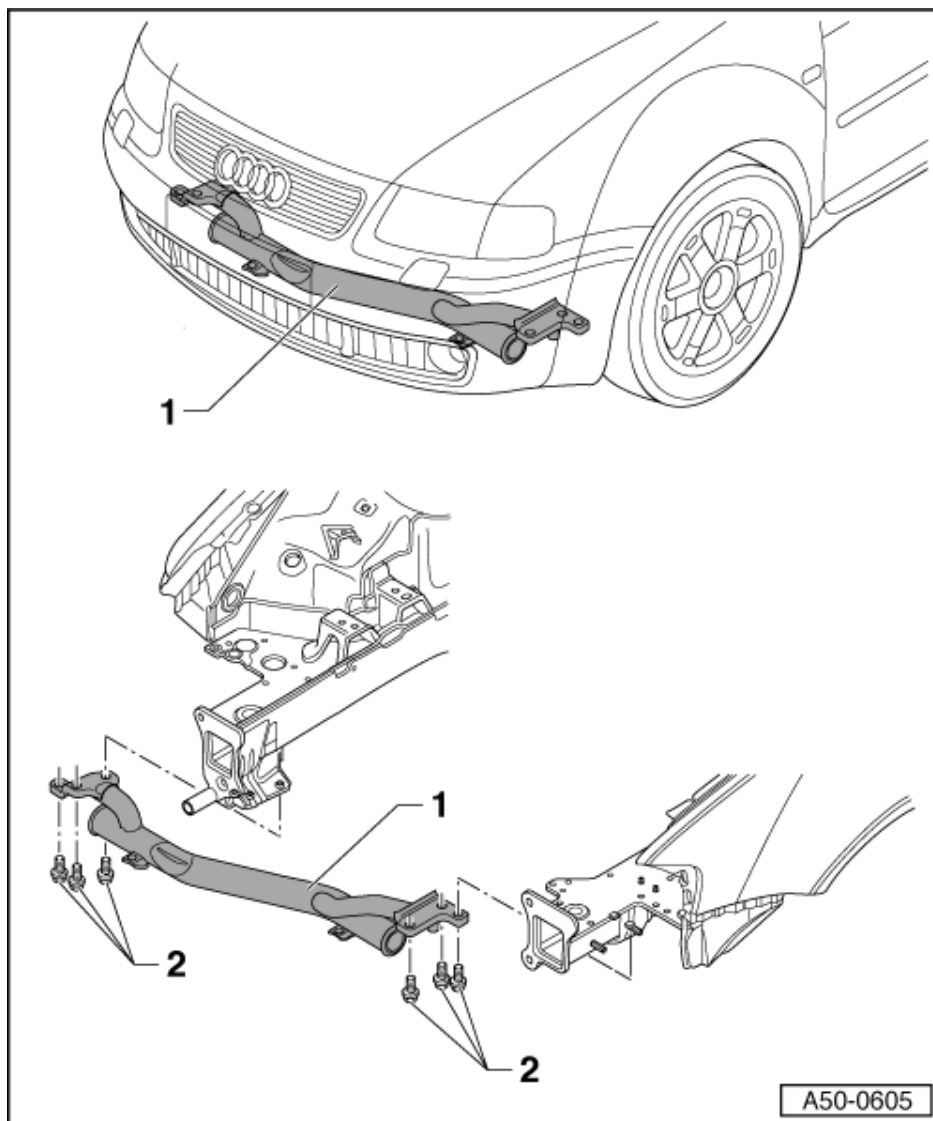


1 Tubular member

- ♦ In addition to reinforcement of the front end, the tubular member serves as a connecting pipe between the two charge air coolers.
- ♦ Removing
 - Remove noise insulation => Page 12 .
 - Remove engine shield => Page 12 .
 - Remove ribbed belt protection => Page 12 .
 - Remove charge air cooling pressure hose on both sides.

=> 4-cylinder Engine (5-valve Turbo), Mechanical Components; Repair group 21; Charge air system with turbocharger

- Unscrew combi bolts - 2 -.
- Remove the tubular member downwards.



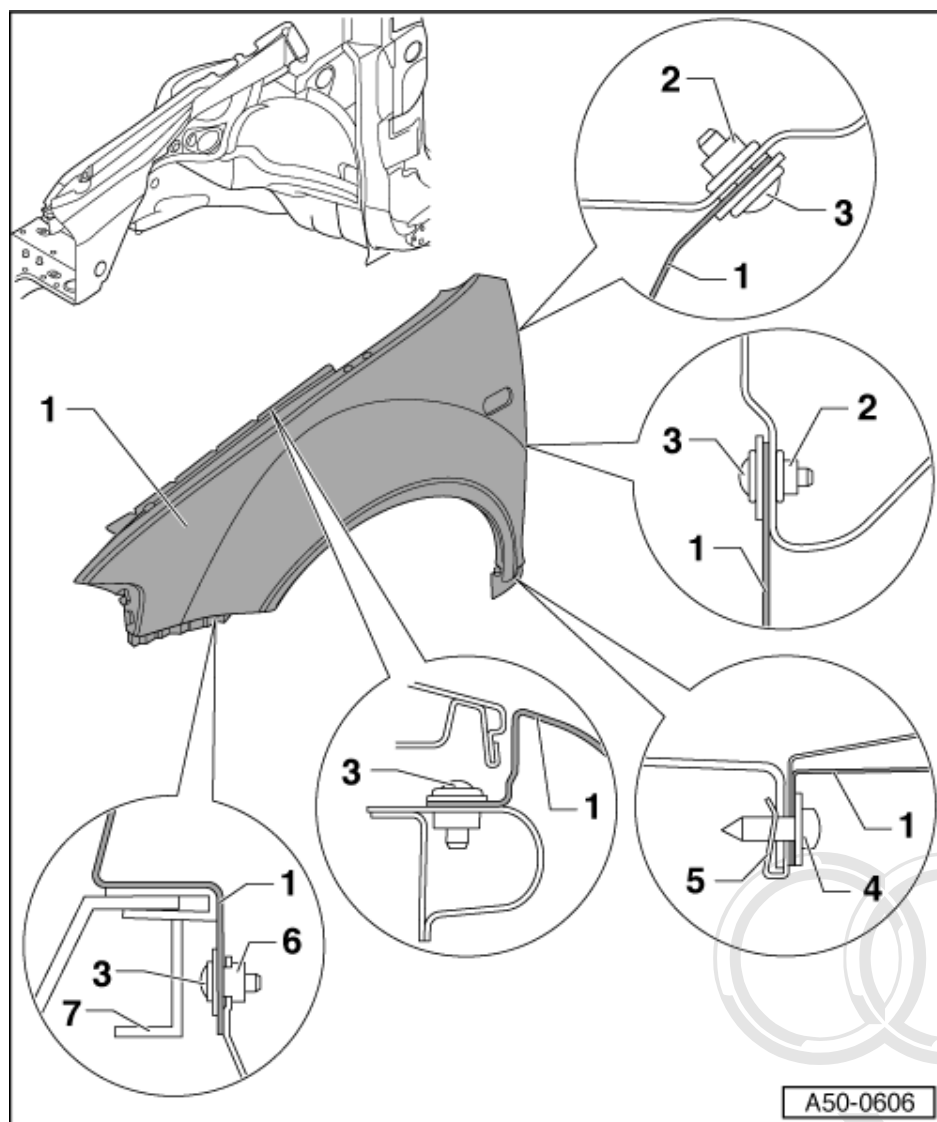
- ♦ Installing
Installation is in reverse order.

2 Combi bolt (6x)

- ♦ 20 Nm

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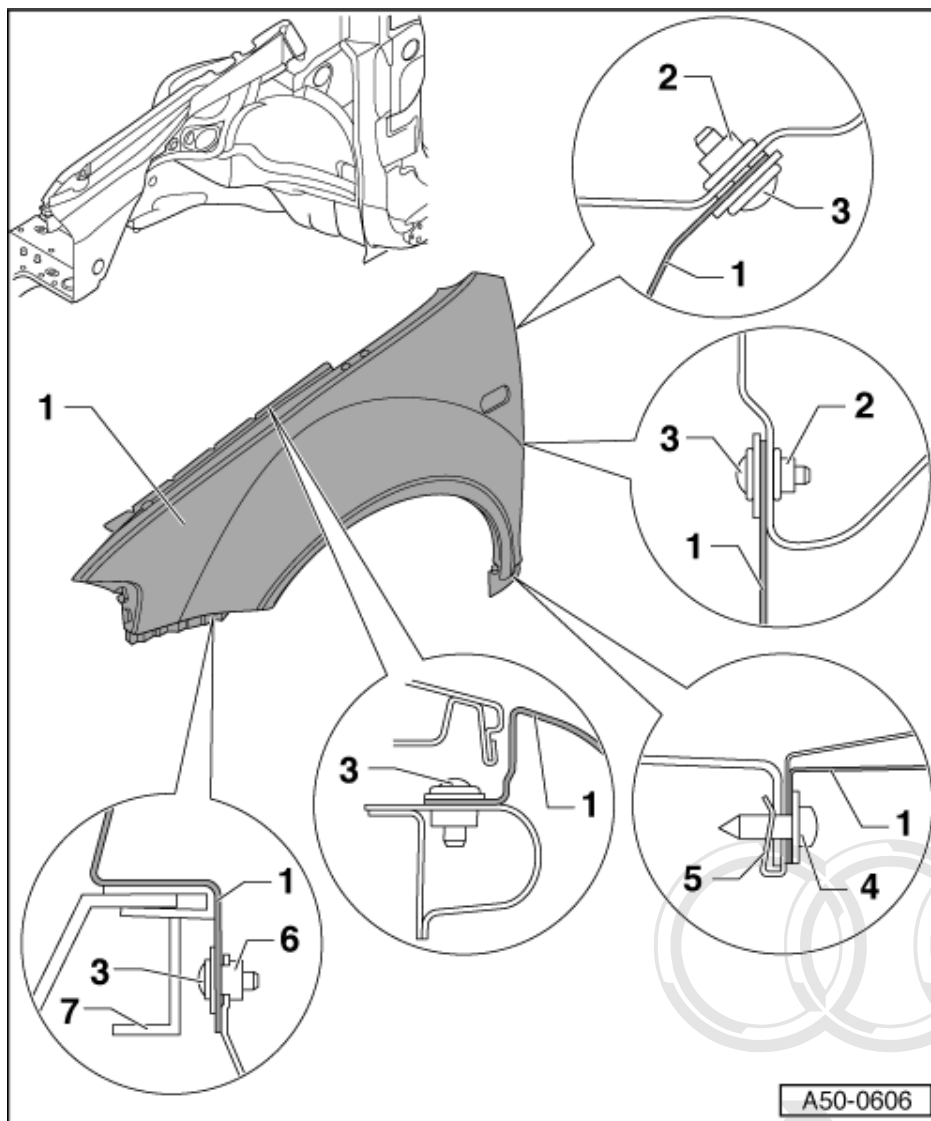
1.5 - Removing and installing wing (S3)



1 Wings

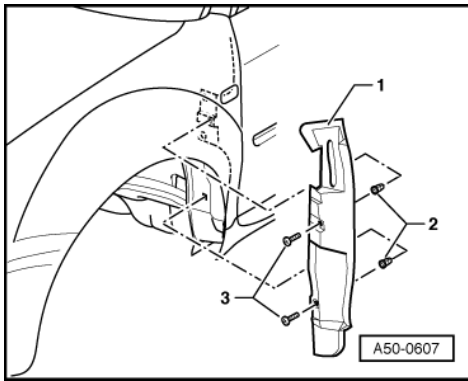
- ♦ Removing
 - Removing front wheel housing liner => Page 185 .
 - Remove bumper cover - 129 .
 - Remove guide piece - 129 .
 - Remove sill cladding => Page 175 .
 - Remove bracket => Page 178 .
 - Remove locking piece => Page 10 Fig. 1
 - Remove Torx bolts - 3 - and - 4 -.
 - Remove wing.
- ♦ Installing
 - Installation is in reverse order.

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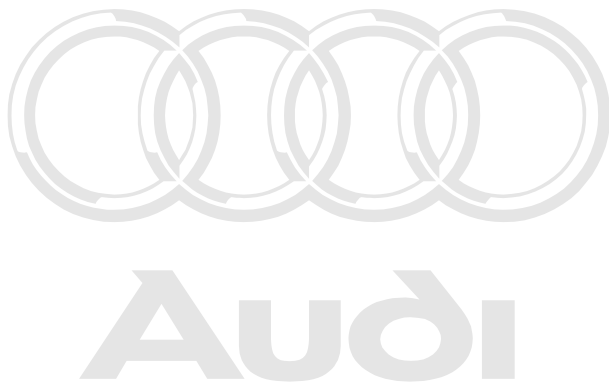
- 2 Blind rivet nut
- 3 Torx bolt
 - ◆ 10 Nm
- 4 Torx bolt
 - ◆ 8 Nm
- 5 Snap nut
- 6 Stamped nut
- 7 Guide piece
- 8 Bumper cover

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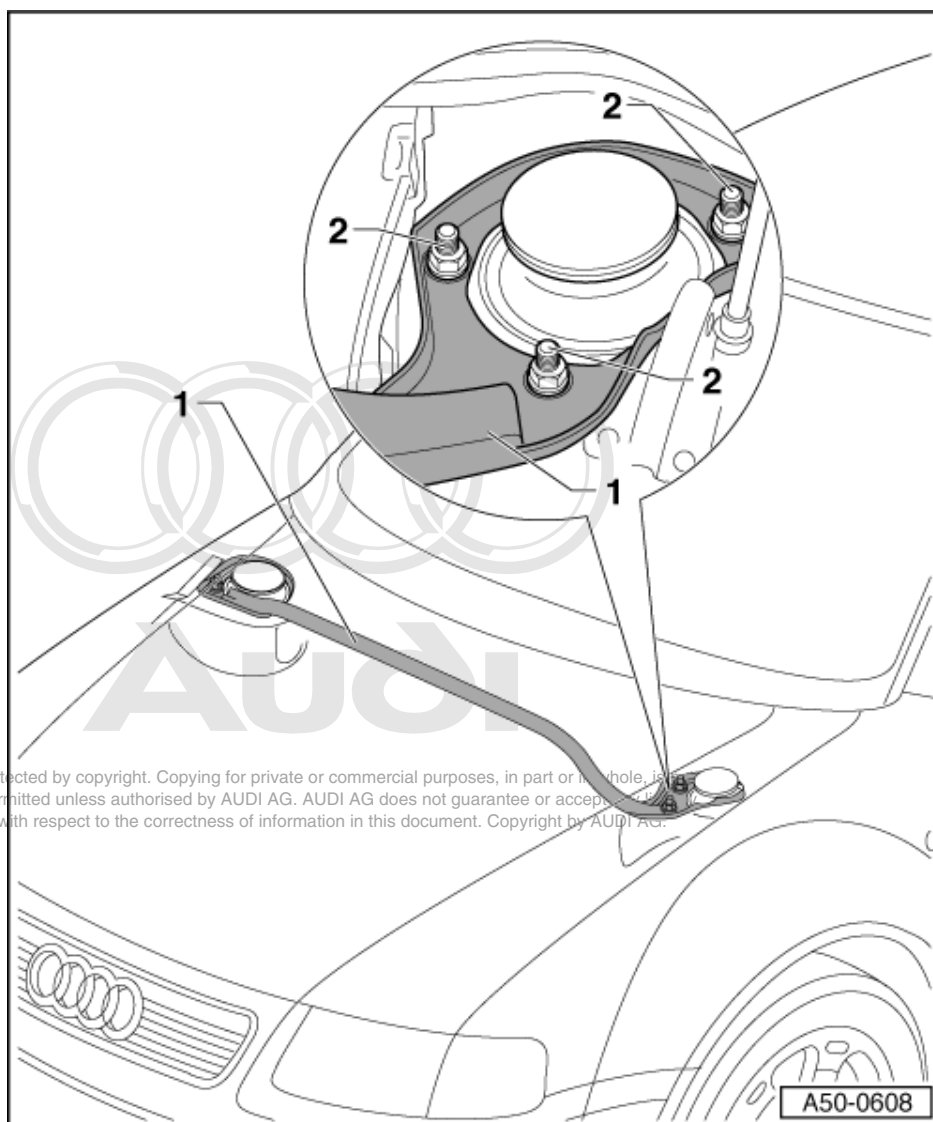
-> Fig.1 Removing and installing locking piece

- Removing front wheel housing liner => Page 185 .
 - Unscrew bolts -3- and remove locking piece -1- from wheel housing.
- 2 - Expanding nut



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1.6 - Removing and installing additional reinforcement (except S3)



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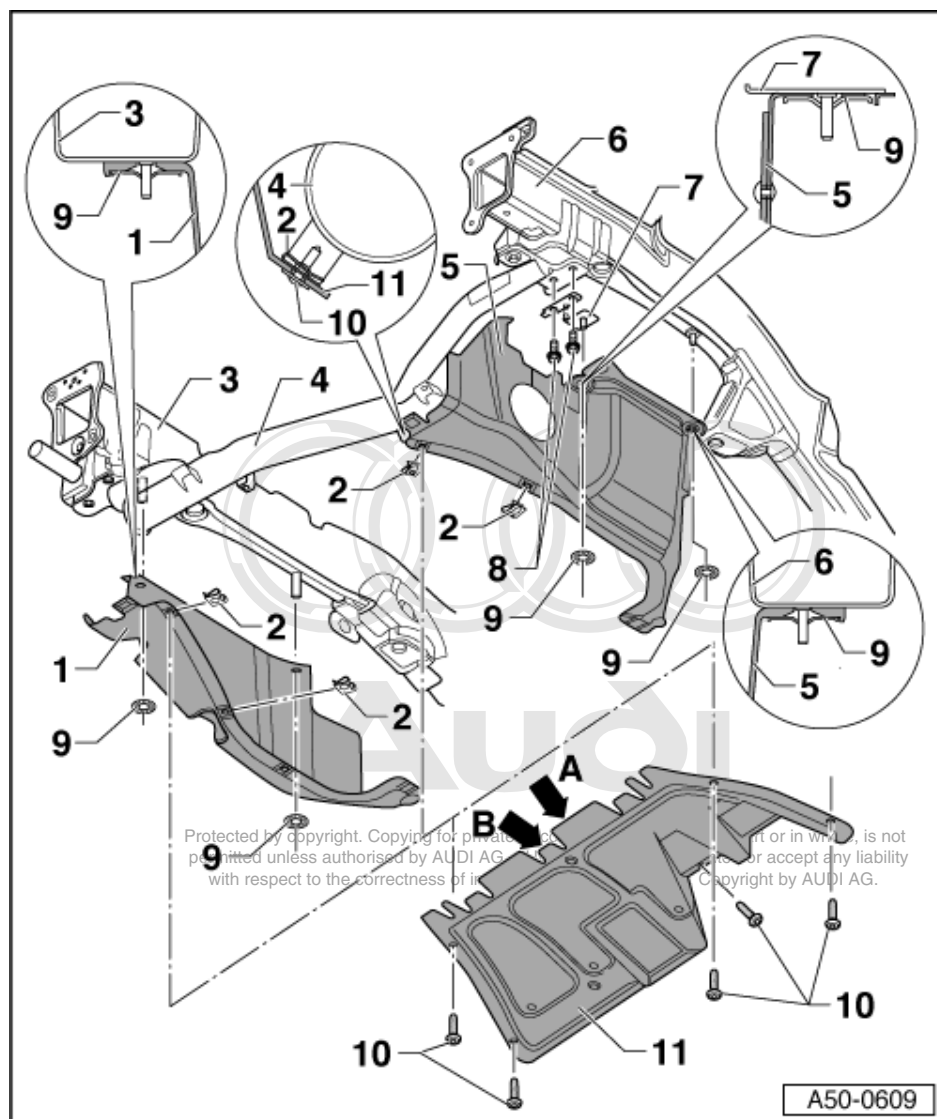
1 Additional reinforcement

- ♦ Open bonnet to remove.
- ♦ Unscrew hexagon nuts - 2 - on both sides and remove additional reinforcement.

2 Hexagon nut

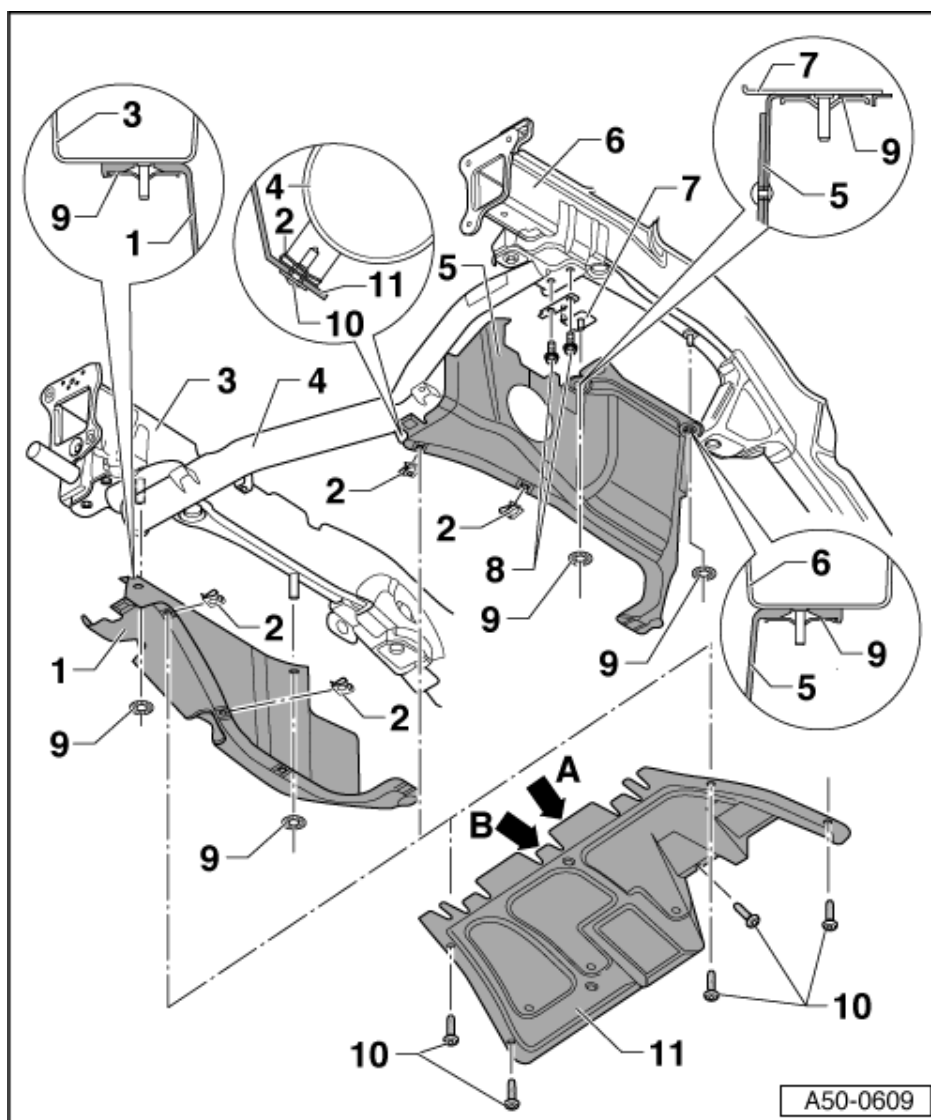
- ♦ 20 Nm

1.7 - Removing and installing noise insulation, ribbed belt protection and engine shield trim (S3)



1 Ribbed belt protection

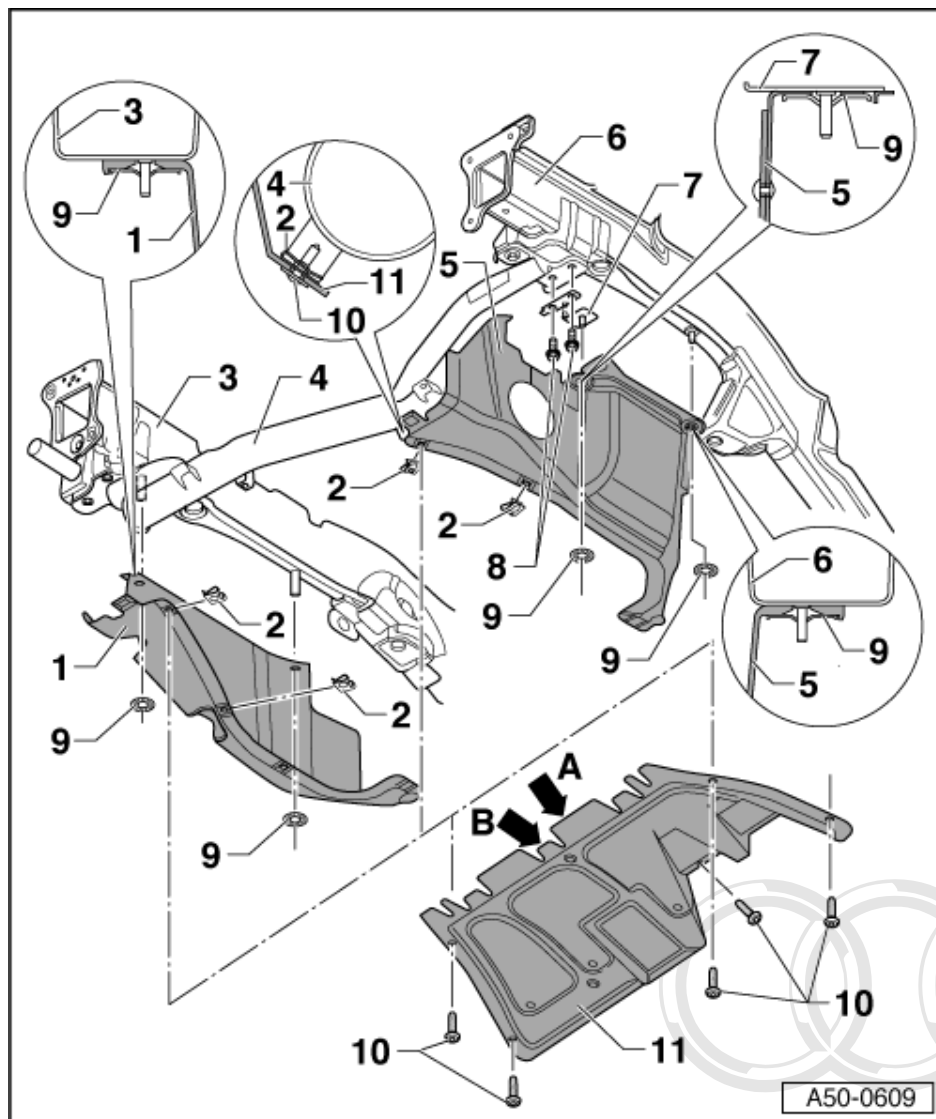
- ◆ In scope of delivery:
 - Snap nut => Item 2
 - Clamping washer => Item 9
- ◆ Removing
 - Remove noise insulation => Item 11.
 - Remove clamping washers - 9 - using a suitable screwdriver and detach ribbed belt protection.
- ◆ Installing
 - Position the ribbed belt protection, inserting the front retaining lugs at the bottom of the lock carrier.
 - Press on clamping washers - 9 -.
 - Install noise insulation => Item 11.



- 2 Snap nuts (5x)
- 3 Right longitudinal member
- 4 Tubular member
- 5 Trim for engine shield
 - ◆ In scope of delivery:
 - Snap nut => Item 2
 - Clamping washer => Item 9
- ◆ Removing and installing
Performed as for ribbed belt protection => Item 1
- 6 Left longitudinal member
- 7 Bracket
- 8 Hexagon collar bolts (2x)
 - ◆ 20 Nm
- 9 Clamping washers (4x)
- 10 Torx bolts (5x)
 - ◆ 2.5 Nm



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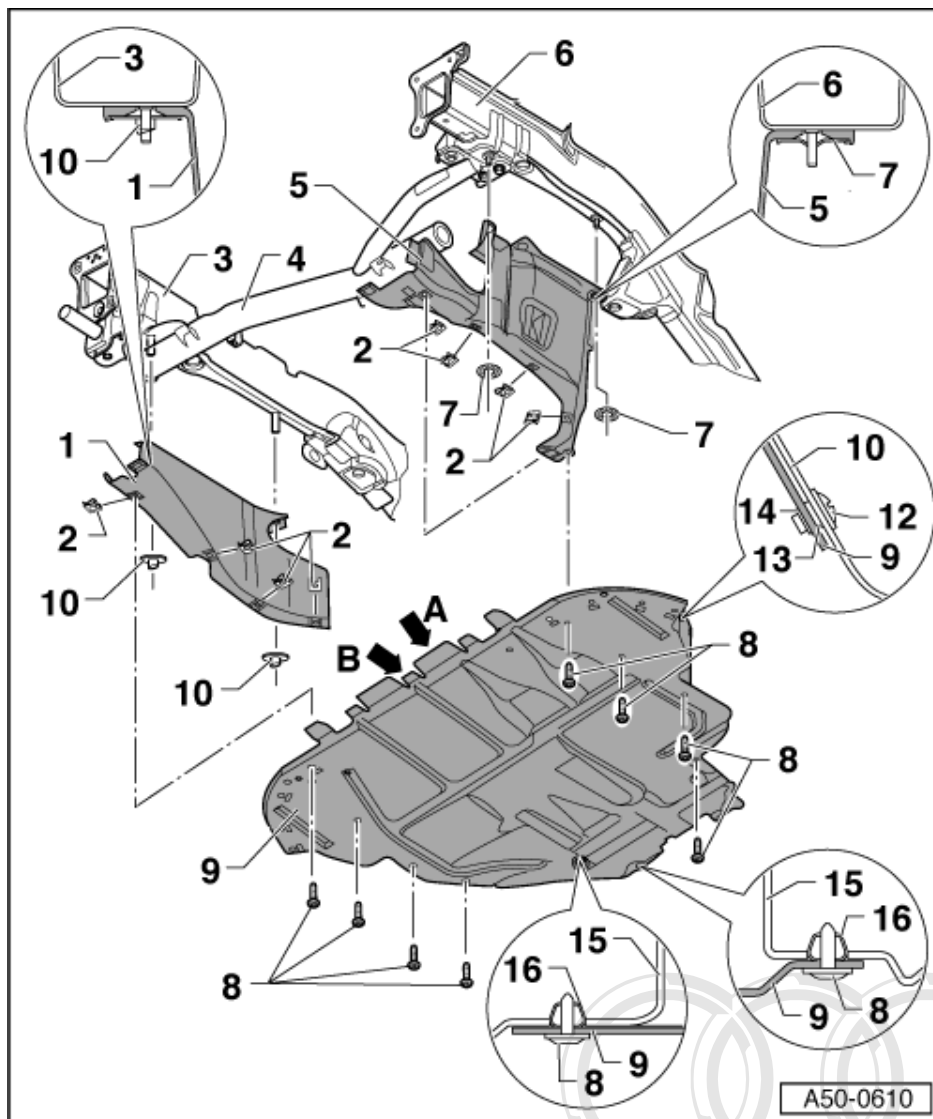


11 Noise insulation

- ♦ Removing
 - Unscrew Torx bolts - 10 -.
 - Pull noise insulation rearwards out of the lock carrier.
- ♦ Installing
 - Insert the lugs on the front noise insulation, -arrow A- above and -arrow B- below the bumper.
 - Insert Torx bolts - 10 - and tighten.

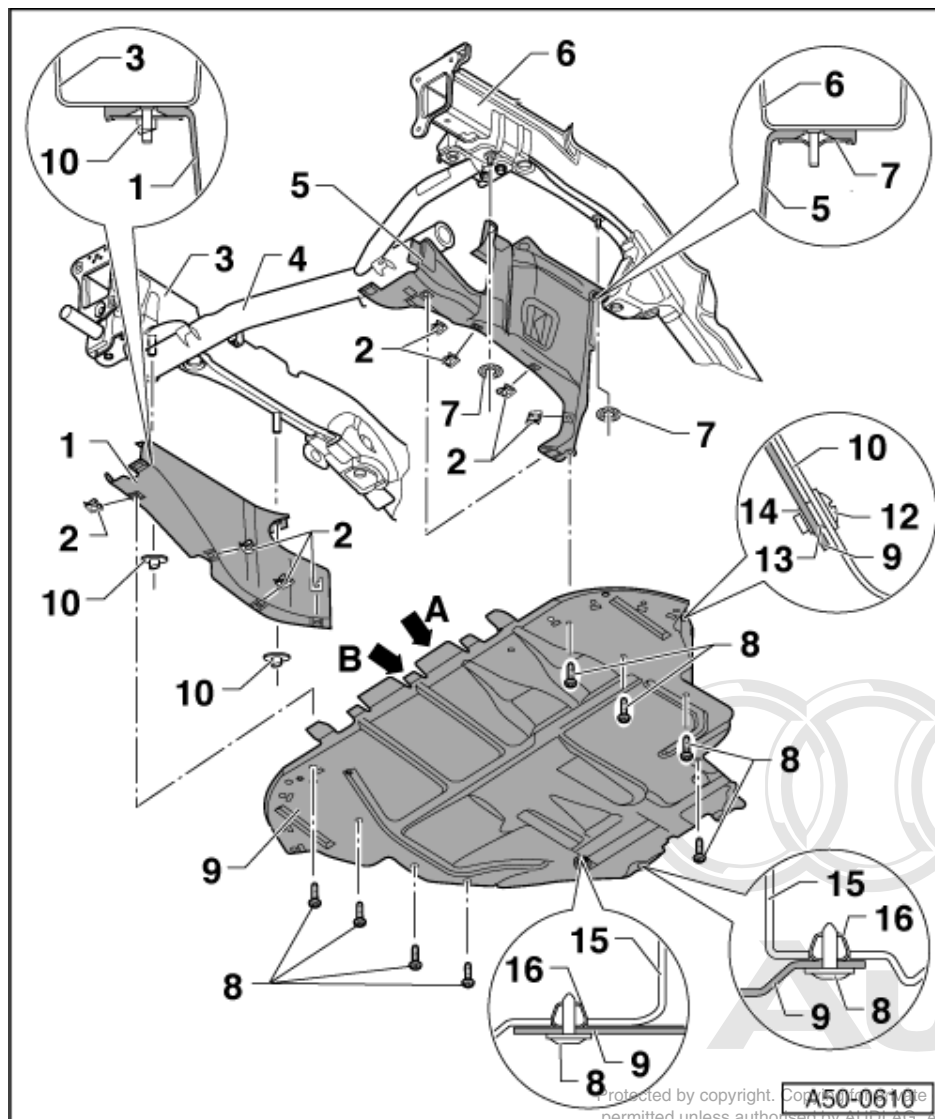
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1.8 - Removing and installing noise insulation, ribbed belt protection and engine shield trim (S3 - Brazil)



1 Ribbed belt protection

- ◆ In scope of delivery:
 - Snap nut => Item 2
- ◆ Removing
 - Remove noise insulation => Item 9.
 - Unscrew speed nut - 10 - and remove ribbed belt protection.
- ◆ Installing
 - Position the ribbed belt protection, inserting the front retaining lugs at the bottom of the lock carrier.
 - Screw on speed nut - 10 - and tighten.
 - Install noise insulation => Item 9.



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2 Snap nuts (8x)

3 Right longitudinal member

4 Tubular member

5 Engine shield trim

♦ In scope of delivery:

- Snap nut => Item **2**
- Clamping washer => Item **7**

♦ Removing and installing

Performed as for ribbed belt protection => Item **1**

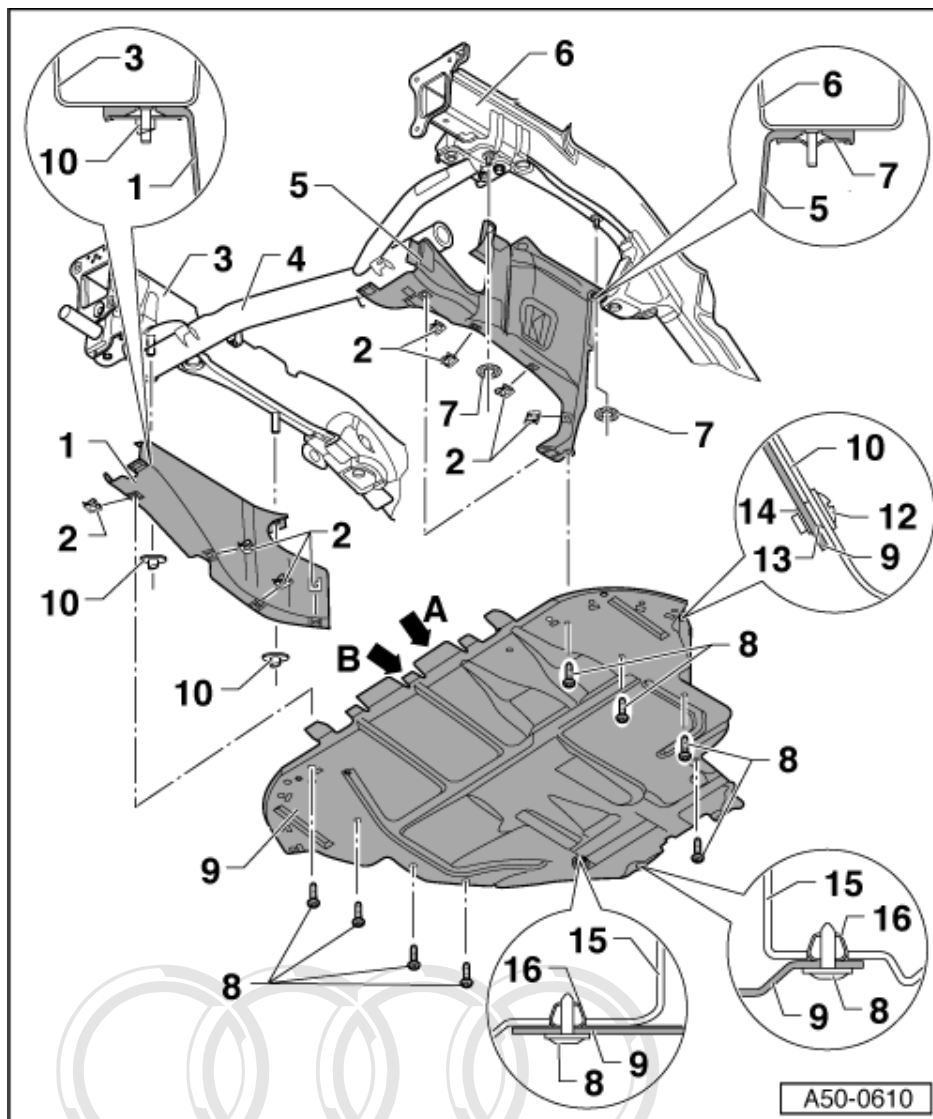
- Remove clamping washers - **7** - using a suitable screwdriver / press on during installation.

6 Left longitudinal member

7 Clamping washers (2x)

8 Torx bolts (10x)

- ♦ 2.5 Nm



9 Noise insulation

- ◆ Removing
 - Unscrew Torx bolts - **8** -.
 - Pull noise insulation rearwards out of the lock carrier.
- ◆ Installing
 - Insert the lugs on the front noise insulation, -arrow A- above and -arrow B- below the bumper.
 - Insert Torx bolts - **8** - and tighten.

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10 Speed nut (2x)

11 Wheel housing liner

12 Pin (4x)

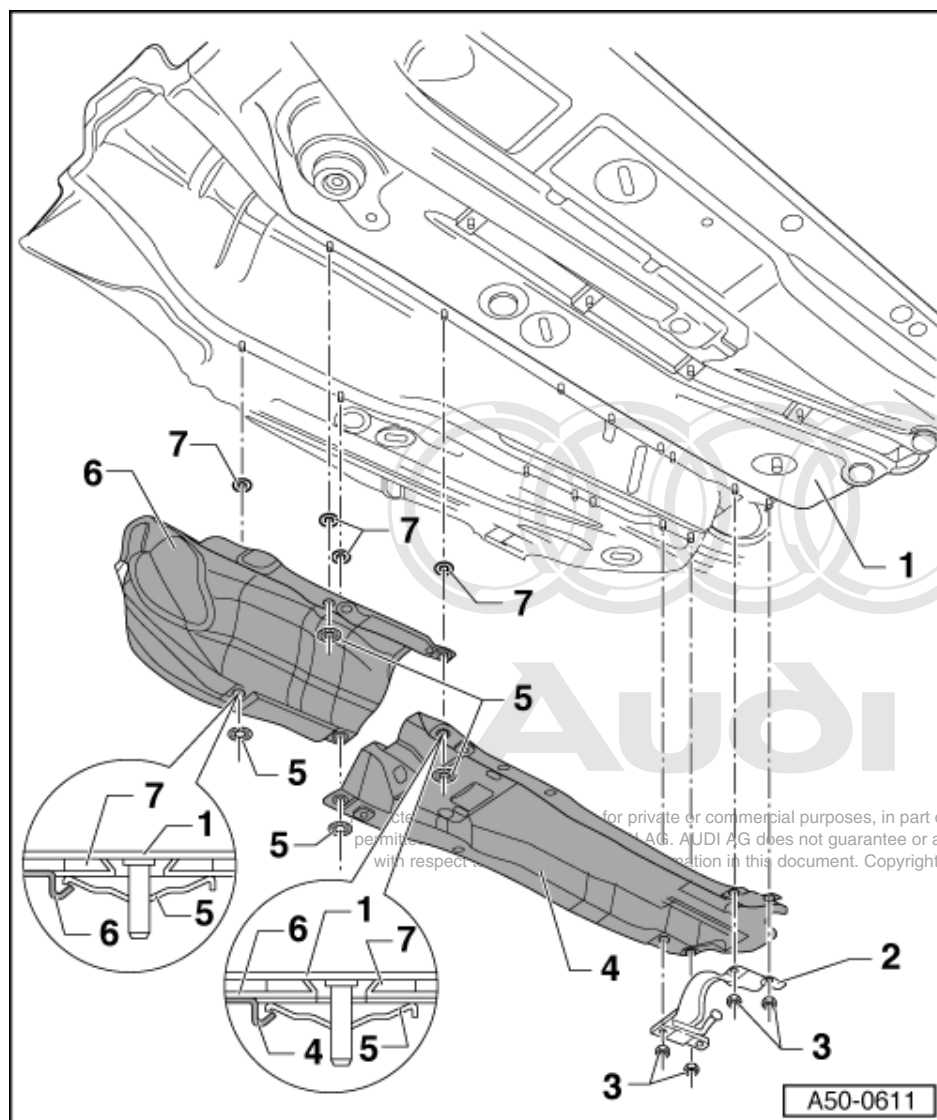
13 Lock washer (4x)

14 Clip (4x)

15 Subframe

16 Speed nut (2x)

1.9 - Removing and installing front and rear heat shields for tunnel (S3)



1 Floor group (tunnel)

2 Bracket

- ♦ For exhaust system

3 Hexagon nut (4x)

- ♦ 23 Nm

4 Heat shield

- ♦ For tunnel (rear)

5 Clamping washers (4x)

- ♦ For removal, unscrew clamping washers with suitable screwdriver.
- ♦ To install only press on the clamping washers.

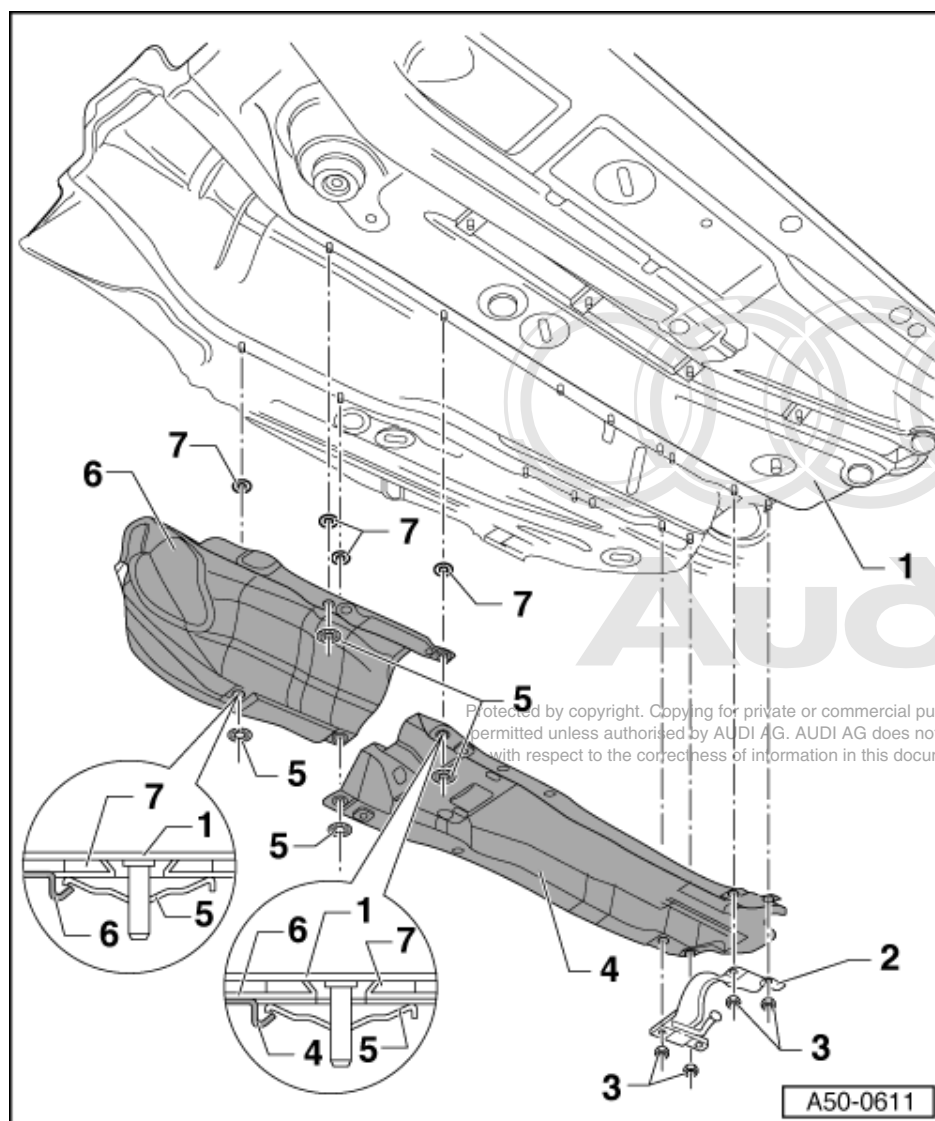
6 Heat shield

- ♦ For tunnel (front)

7 Spacer (4x)

2 - Heat shields

2.1 - Heat shields



2.2 - Removing and installing front and rear heat shields for tunnel (S3)

- 1 Floor group (tunnel)
- 2 Bracket
 - ♦ For exhaust system
- 3 Hexagon nut (4x)
 - ♦ 23 Nm
- 4 Heat shield
 - ♦ For tunnel (rear)
- 5 Clamping washers (4x)
 - ♦ For removal, unscrew clamping washers with suitable screwdriver.
 - ♦ To install only press on the clamping washers.
- 6 Heat shield
 - ♦ For tunnel (front)
- 7 Spacer (4x)



Audi A3 1997 ➤

General Body Assembly Exterior (Repair groups 50, 55, 57, 58, 60, 63, 64, 66) -

Edition 09.1996



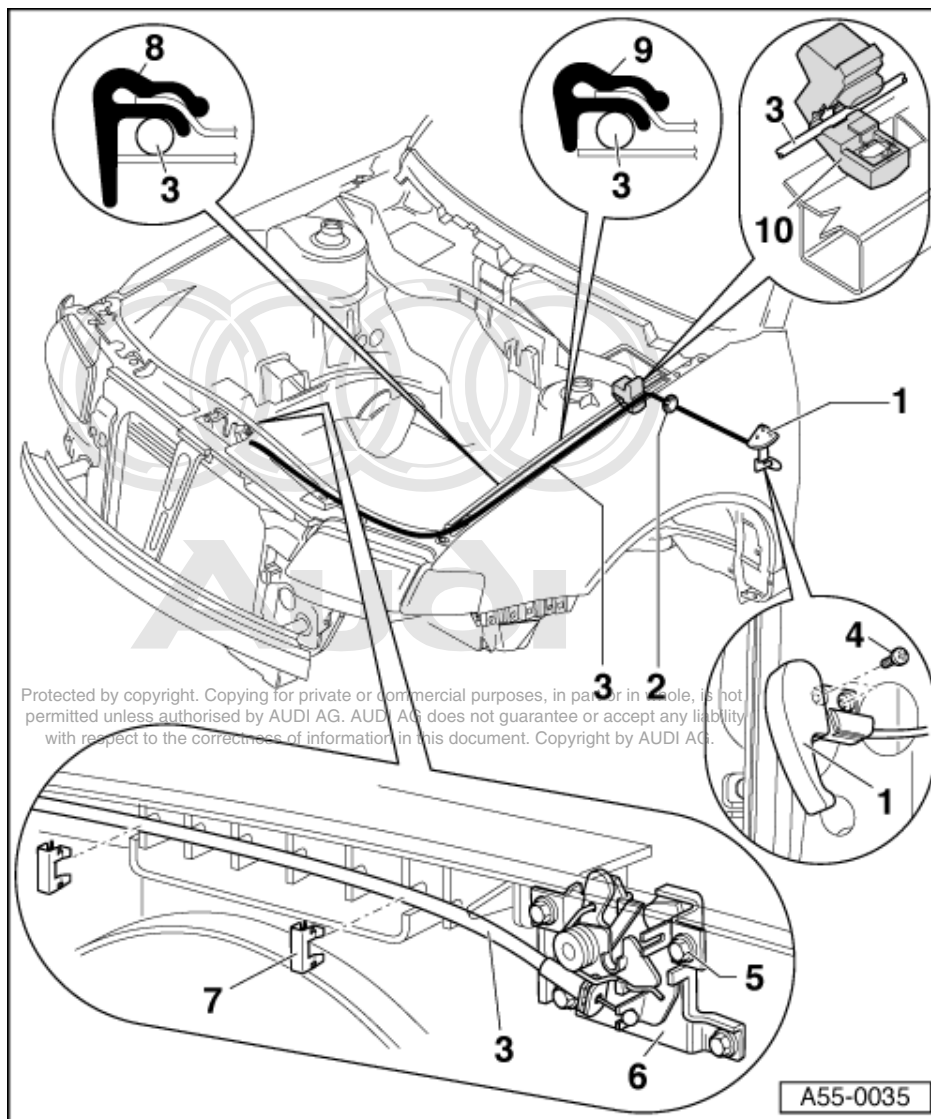
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55 - Bonnet, Flaps

1 - Bonnet

1.1 - Bonnet



1.2 - Removing and installing bonnet lock cable

1 Bonnet lock actuator

- ♦ To remove, unscrew bolts -2- detach cable -3- and remove bonnet lock actuator.

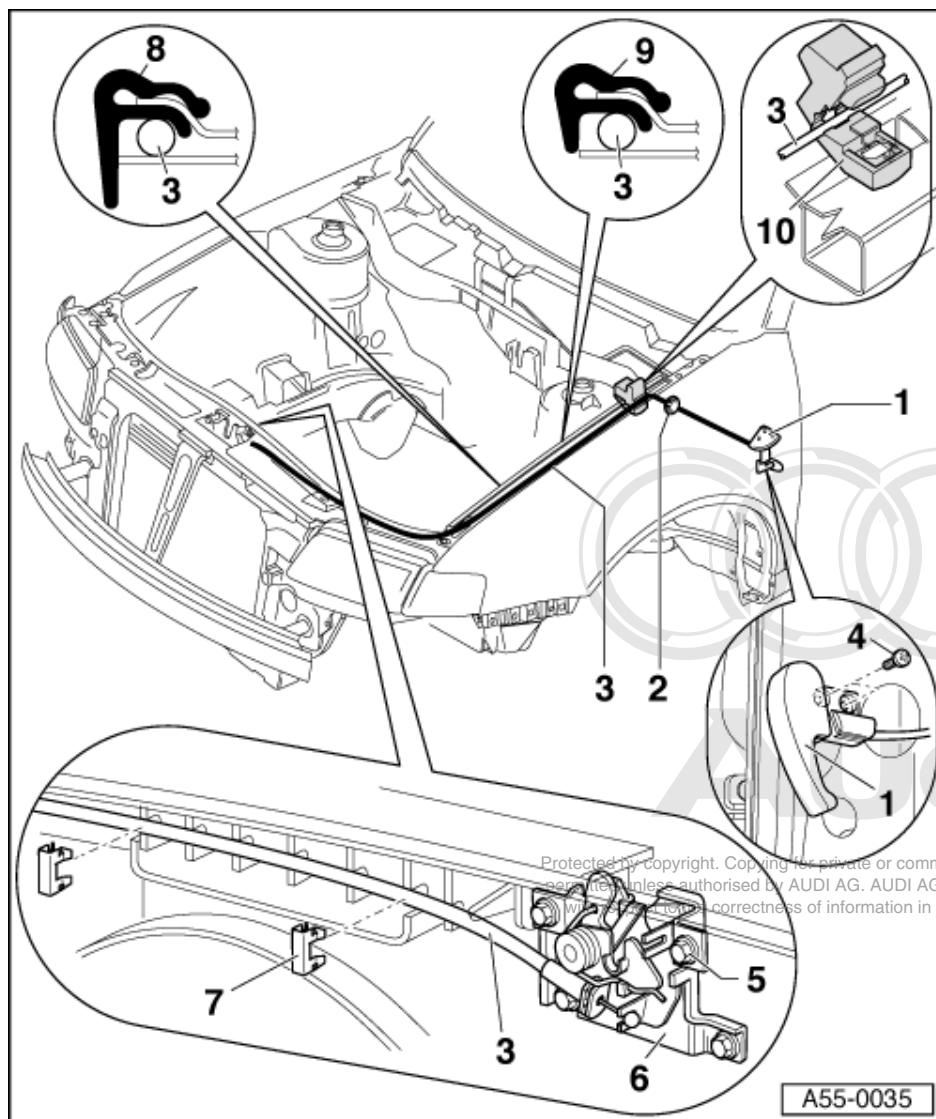
2 Grommet

3 Cable

- ♦ To remove, dismantle bonnet lock actuator -1- detach clamps -7- from lock carrier plate and detach clips -8- and -9- from wing.
- ♦ Detach cable from bonnet lock -6- pull out under wing and pull through sleeve -2- into interior of vehicle.

4 Self-tapping screw

- ◆ 1.5 Nm



5 Hexagon bolt

- ◆ 10 Nm

6 Bonnet lock

- ◆ Removing and installing => Fig. 1

7 Clamps

- ◆ Attach after fitting cable.

8 Front clip

9 Rear clip

10 Sealing channel

- ◆ Cable must run through sealing channel as shown.

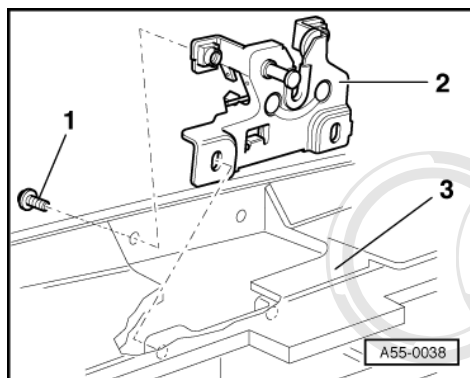
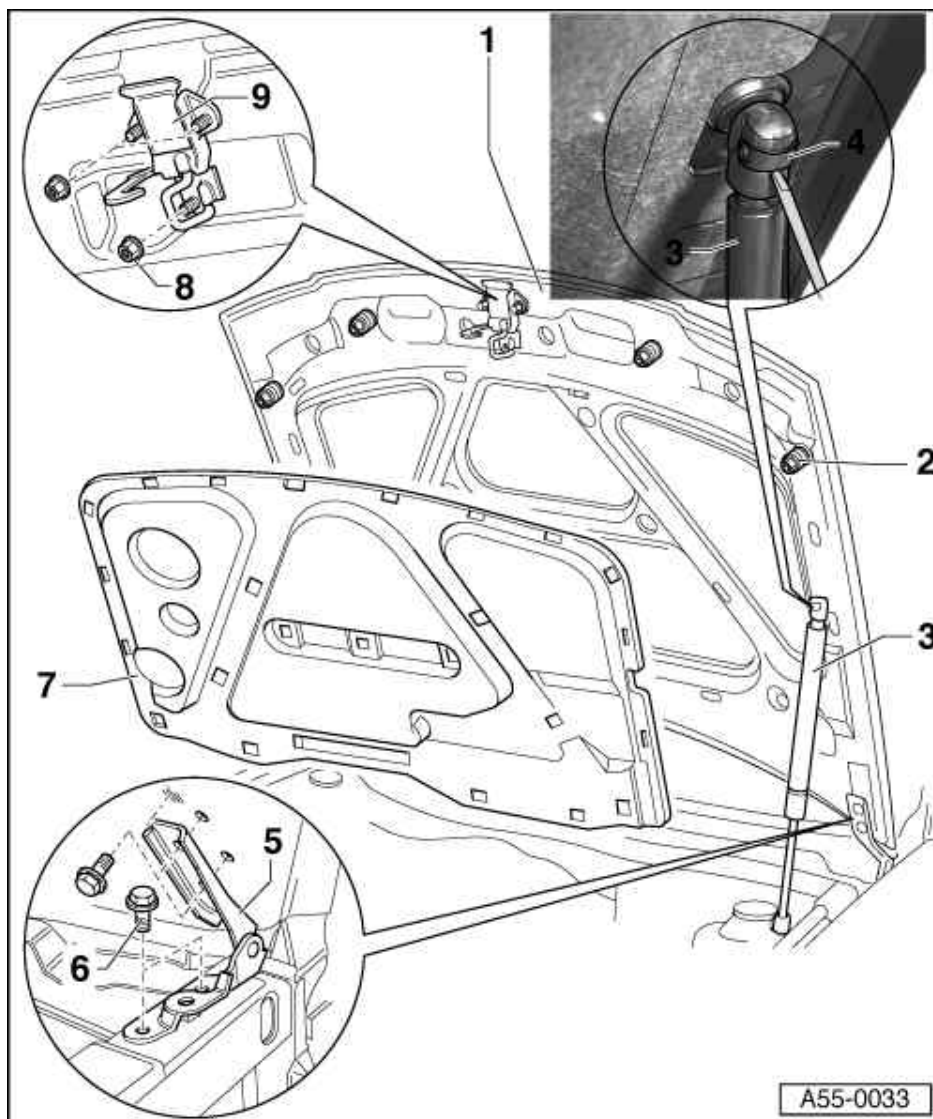


Fig.1 -> Removing and installing bonnet lock

- Detach cable from bonnet lock.
- Unscrew hexagon bolts -1- and take off bonnet lock.
- Tightening torque for hexagon bolt 21 Nm.

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1.3 - Removing and installing bonnet



1 Bonnet

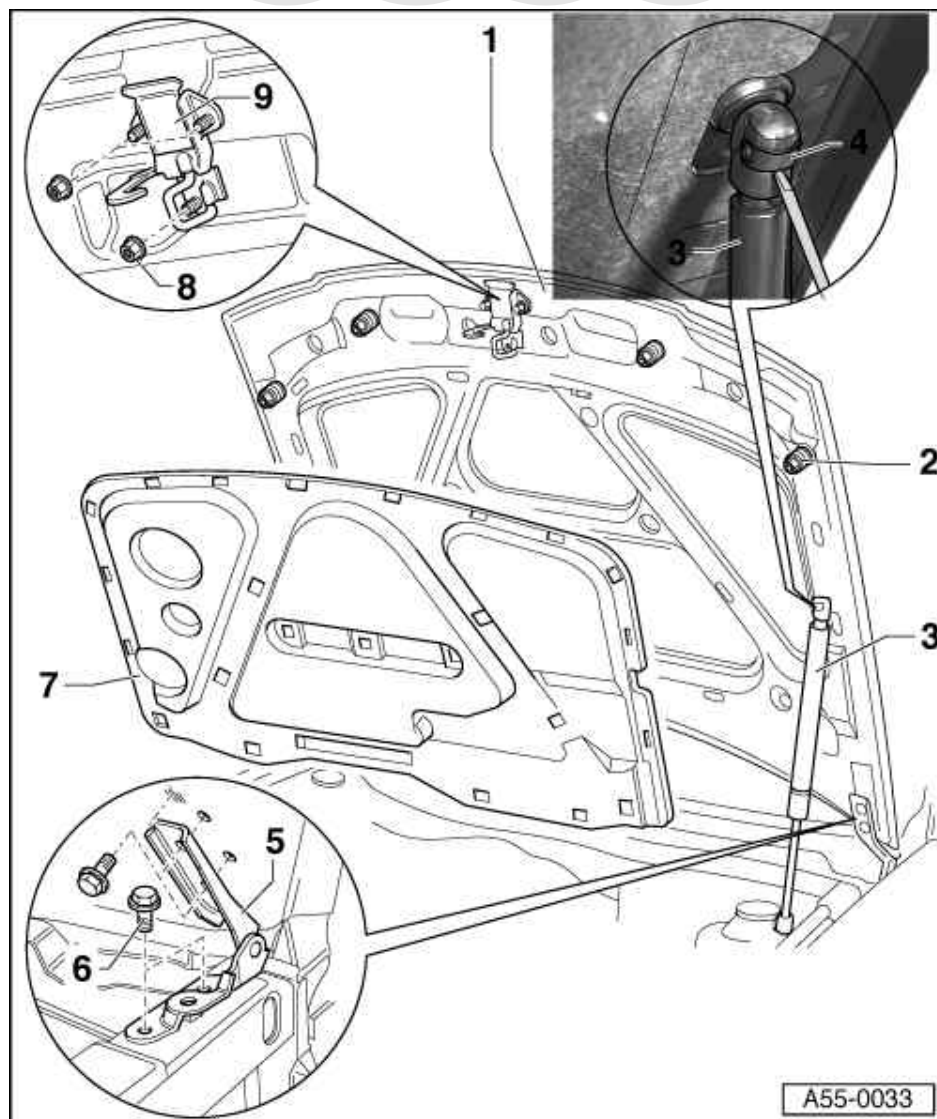
- ♦ To remove, detach gas-filled strut -3- from bonnet.
- ♦ Unscrew hexagon bolts of bonnet hinge on bonnet end and remove bonnet.

2 Buffer

- ♦ The two outer stops can be used to adjust the height of the bonnet.
- ♦ Screw in the two inner stops as far as possible and then slacken off half a turn.

3 Gas-filled strut

- ♦ To remove, slightly raise spring catch -4- with screwdriver and detach gas-filled strut from ball stud.



4 Spring

5 Tailgate hinge

- ♦ Remove bonnet before removing hinge
- ♦ To remove, unscrew hexagon bolt -6- and remove bonnet hinge.

6 Hexagon bolt

- ♦ 21 Nm

7 Insulation

- ♦ Vehicles with diesel engine only

8 Hexagon nut

- ♦ 8 Nm

9 Arrestor

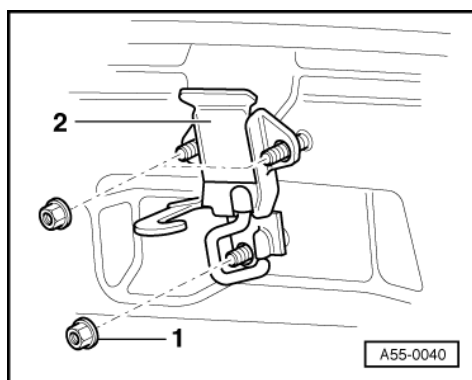


Fig.1 -> Removing and installing arrester

- Unscrew hexagon nuts and remove arrester.
- Tightening torque 8 Nm.

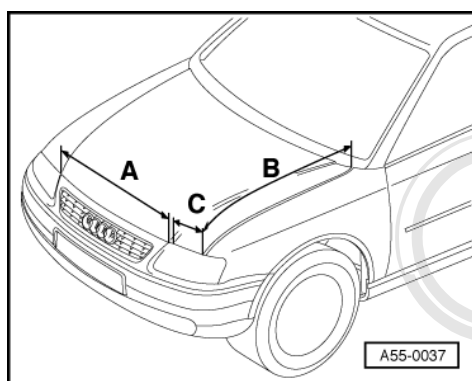
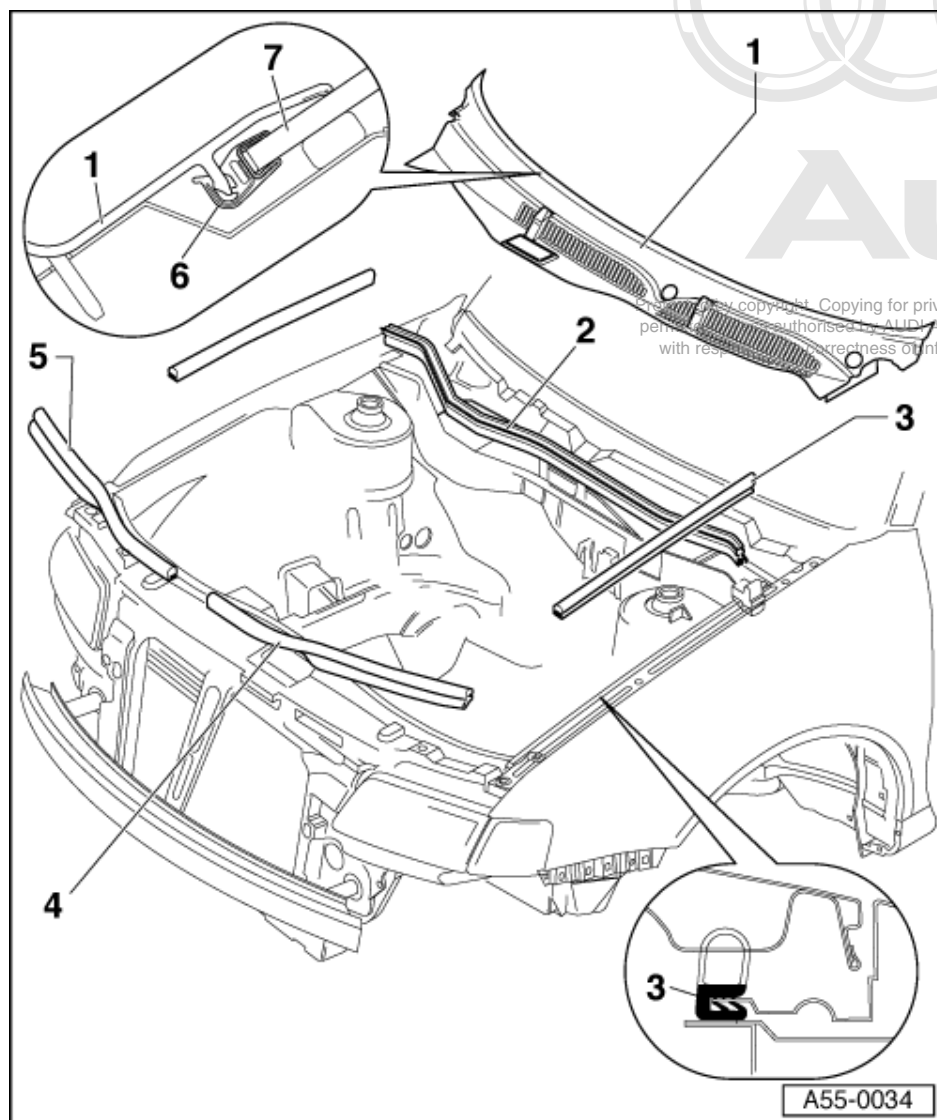


Fig.2 -> Bonnet joint dimensions

Letter	Joint gap (mm)	Parallelism (mm)
A	4.0 -0.5	
B	3.0 +1	
C	5.0 ±0.5	

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1.4 - Bonnet seals



1 Plenum chamber cover

- ◆ Remove windscreen wipers before removing cover
- ◆ To remove, unclip from retainer at windscreen.

2 Plenum chamber seal

3 Wing seal

4 Front seal

5 Front seal

6 Retainer

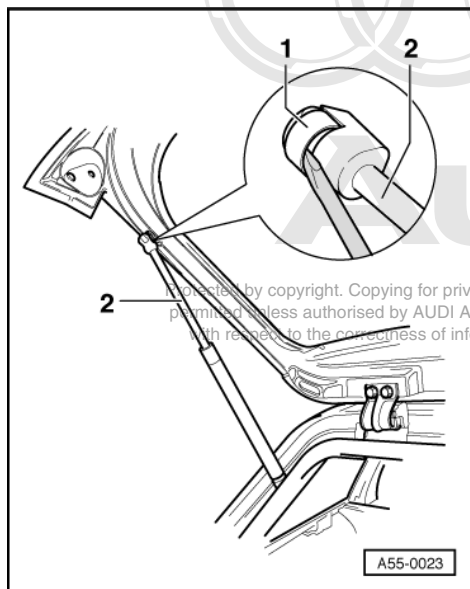
- ◆ Supplied together with windscreen (not available as replacement part).

7 Windscreen

2 - Tailgate

2.1 - Tailgate

2.2 - Removing and installing tailgate



- Remove tailgate interior trim

=> General Body Assembly, Interior; Repair group 70; Trims Trims

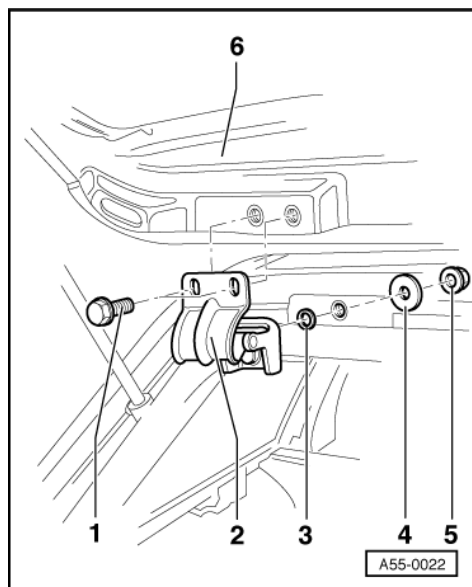
- Detach/unplug electrical connectors, hose for central locking system and hose for rear window washer system.
- Open and support the tailgate.
- -> Use screwdriver to lift retaining spring -1- as shown and detach gas-filled strut from ball stud at top.

Note:

If gas-filled strut is removed completely, note correct position when re-installing:

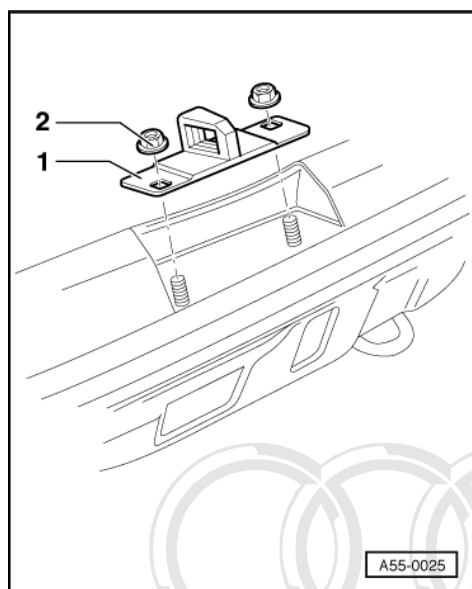
Damping element must be attached at body side.

- To install, press gas-filled strut onto ball stud.



- -> Unscrew hexagon bolts -1- (2x) from tailgate -6-.
- Tightening torque on installation 21 Nm.

2.3 - Adjusting tailgate

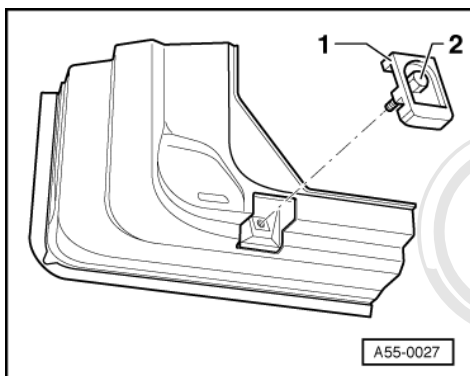


Note:

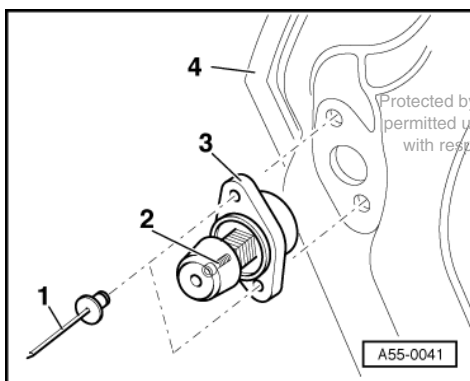
Gas-filled struts must be installed before adjusting new tailgate.

- -> Slightly tighten striker -1- with nuts -2-.

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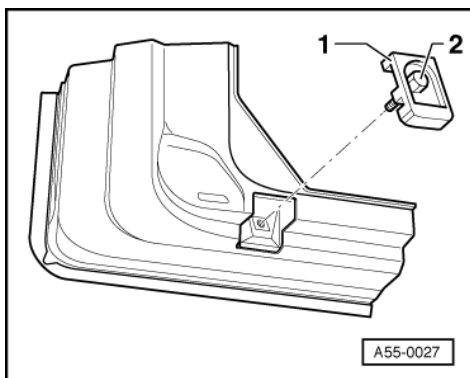
- -> Slightly tighten adjusting stop at bottom -1- (on rear panel trim) with hexagon bolt -2-.



- -> Loosen clamping screw -2- and pull out adjusting stop slightly.
- Close tailgate -4- and move to flush position; tailgate lock should engage in second stop in striker.
- Now set adjusting stops -3- in correct position.
- Open tailgate and tighten clamping screw -2- to 2 Nm.

1 - Blind rivet

- Close tailgate.

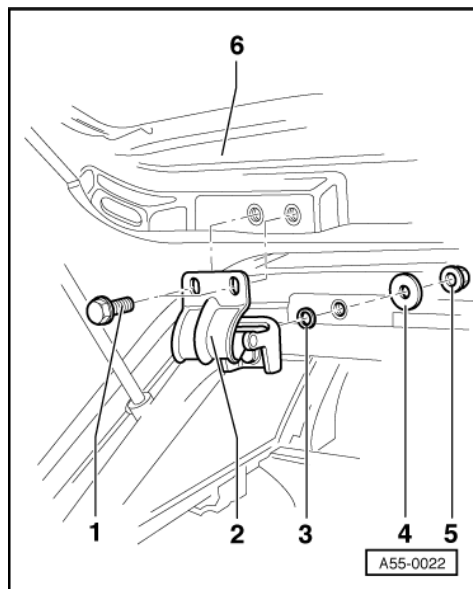


- -> Use feeler gauge to set adjusting stop -1- from inside such that distance from rear panel trim is 1 mm.

Important
 When tailgate is closed, adjusting stops must not make contact with rear panel trim.

- Tightening torque for hexagon bolt: 8 Nm.
- Check joint dimensions in line with table
 =>Page 31 .

2.4 - Removing and installing tailgate hinge

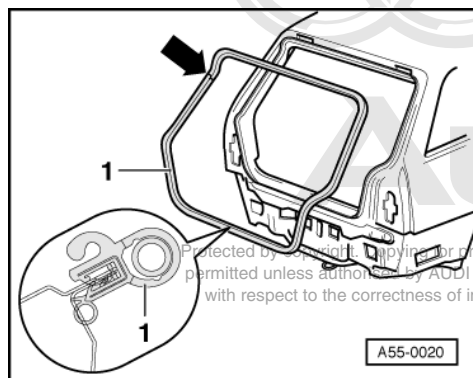


- -> Dismantle rear roof frame trim.

=> General Body Assembly, Interior; Repair group 70; Trims Trims

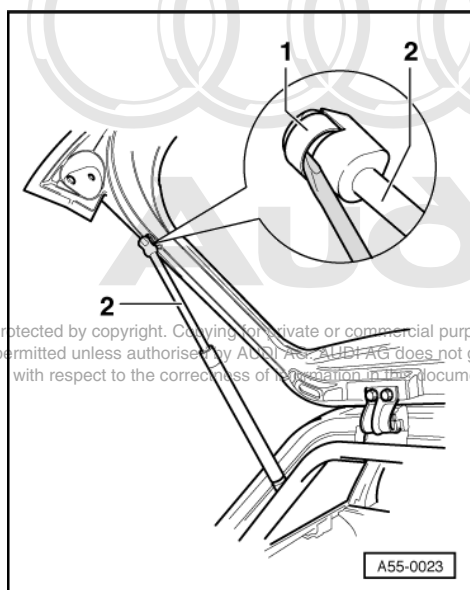
- Unscrew hexagon nut -5-.
- Unscrew hexagon bolt -1-.
- On installation renew seal -3-.
- Tightening torque for hexagon nut and bolt: 21 Nm.

2.5 - Removing and installing tailgate seal



- -> Open tailgate and remove seal.
- On installation, vulcanised joint -arrow- of seal must be on a level with ball stud on body end.
- Press seal -1- onto body as shown.

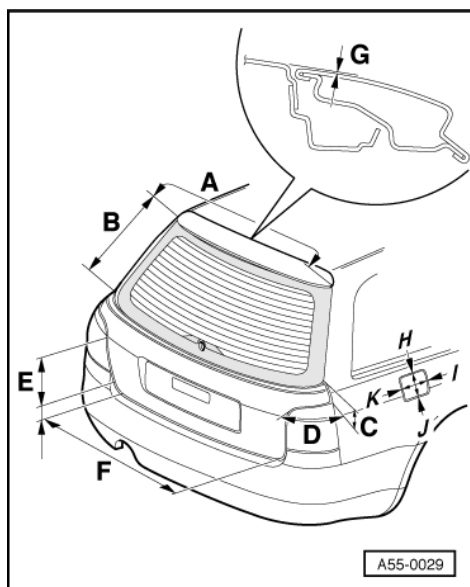
2.6 - Removing gas-filled strut



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- -> Lift spring catch of gas-filled strut -1-; then lever off ball stud.
- On installation, press gas-filled strut onto ball stud.

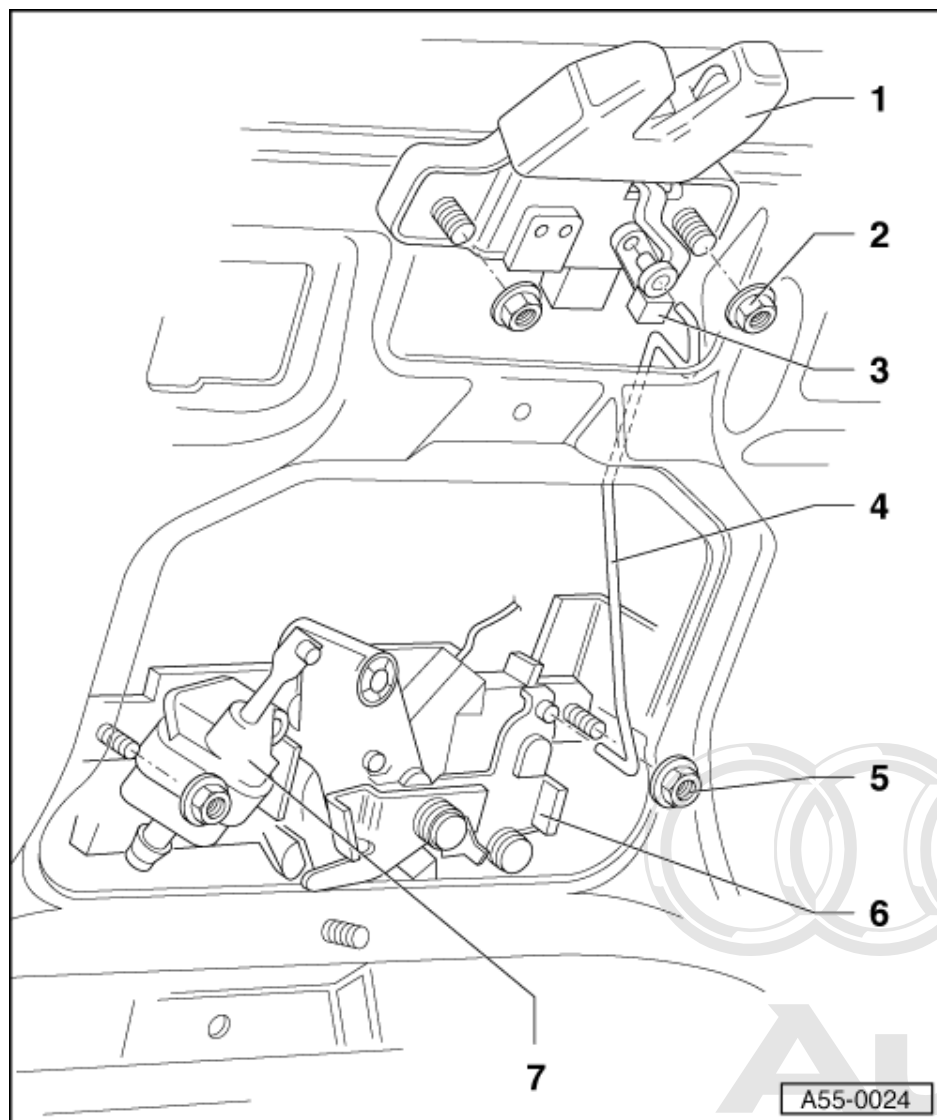
2.7 - Tailgate joint dimensions



Letter	Joint gap (mm)	Parallelism (mm)
A	4.0 +1	0.5
B	5.0 +1	1
C	4.0 +1	0.5
D	3.4 +1	0.5
E	3.4 +1	0.5
F	5.0+1	
G	1.0	
H	2.5±0.1	
I	3.3±0.1	

Letter	Joint gap (mm)	Parallelism (mm)
J	3.3±0.2	
K	3.0±0.4	

2.8 - Removing and installing tailgate lock



1 Tailgate lock

- ♦ To remove, swivel out hinged lever -3- of operating rod -4- and detach operating rod from tailgate lock.
- ♦ Unscrew hexagon nuts -2- and remove tailgate lock.

2 Hexagon nut

- ♦ 8 Nm.

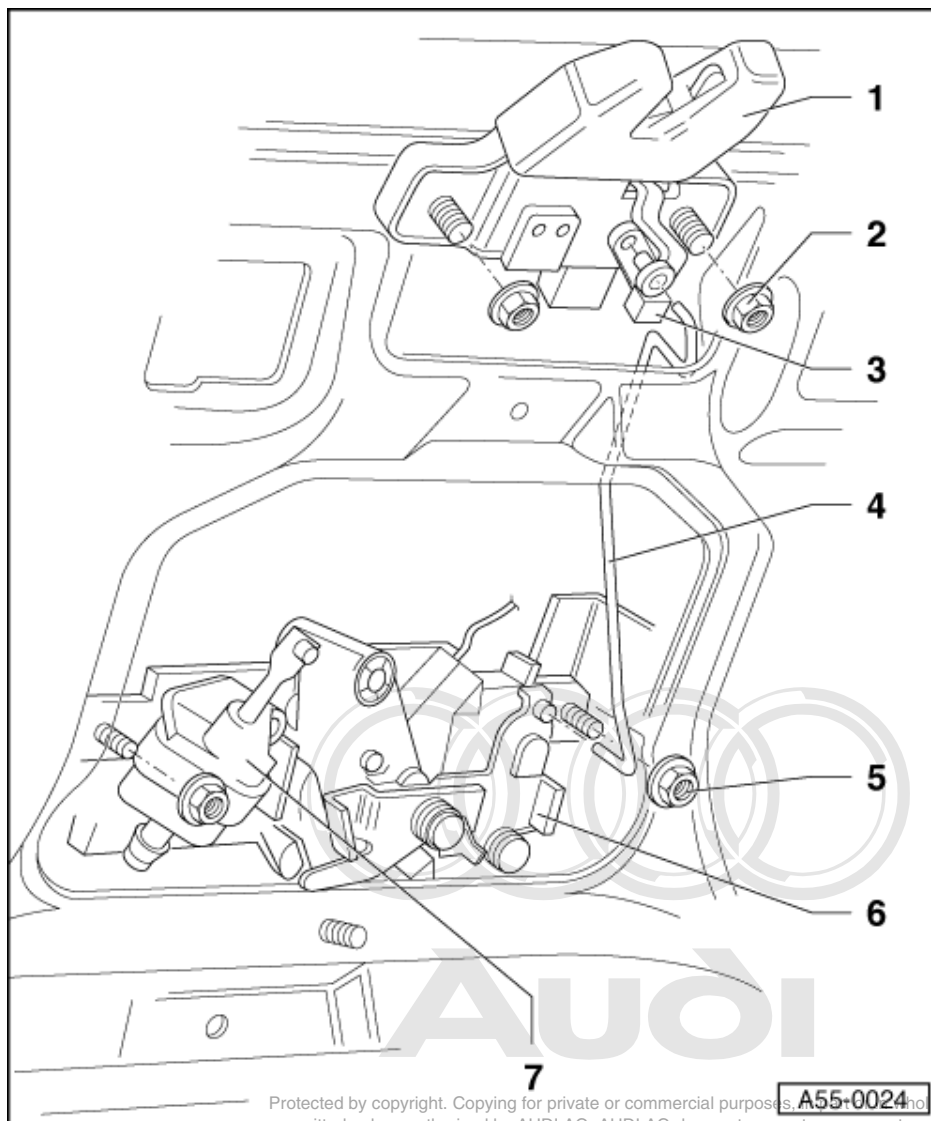
3 Lever

- ♦ Must be swivelled over connecting rod -4-.

4 Connecting rod

- ♦ To remove, first detach from locking system -6-.

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A55-0024

5 Hexagon nut

- ♦ 8 Nm

6 Locking system

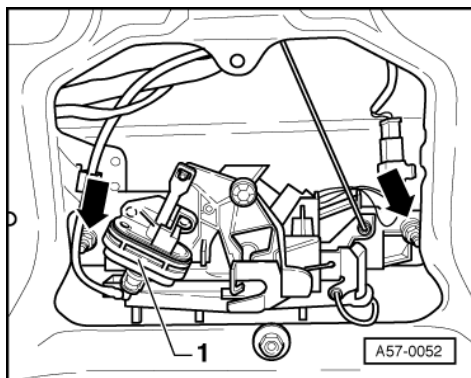
- ♦ Removal => Page 34 .

7 Tailgate lock actuator

- ♦ Removal => Page 82 .



2.9 - Removing and installing locking system



- -> Remove tailgate interior trim.

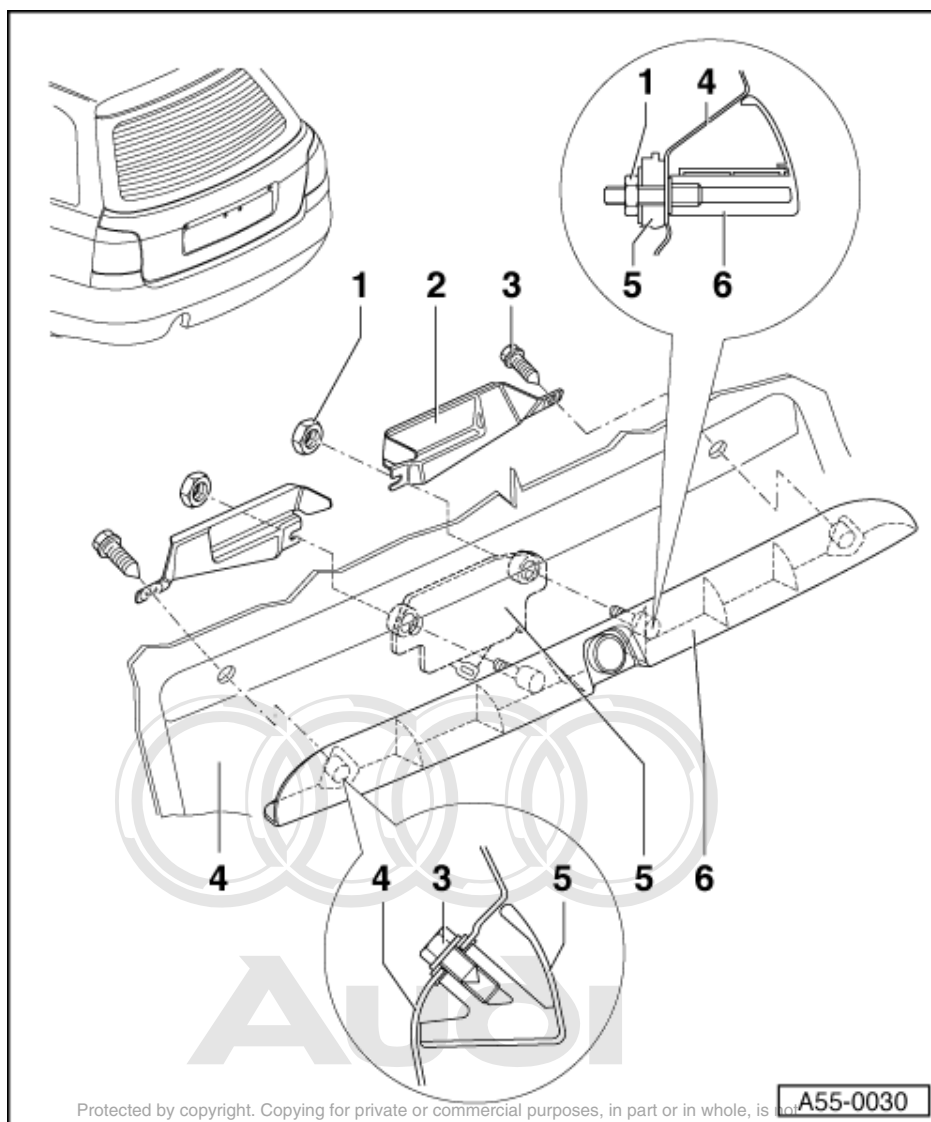
=> General Body Assembly, Interior; Repair group 70; Trims Trims

- Unfasten catch at connector of vacuum line -1- and detach actuator -2-.
- Unclip operating rod -3-.
- Unfasten catches at flaps and pulling out downwards =>Page 38 .
- Unscrew hexagon nuts -arrows- and remove locking system from tailgate.
- Tighten the hexagon nuts to 8 Nm.

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2.10 - Removing and installing grip panel



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1 Hexagon nut

- ♦ 8 Nm

2 Bracket

- ♦ To remove, unscrew hexagon nuts -1- and bolts -3-.

Note:

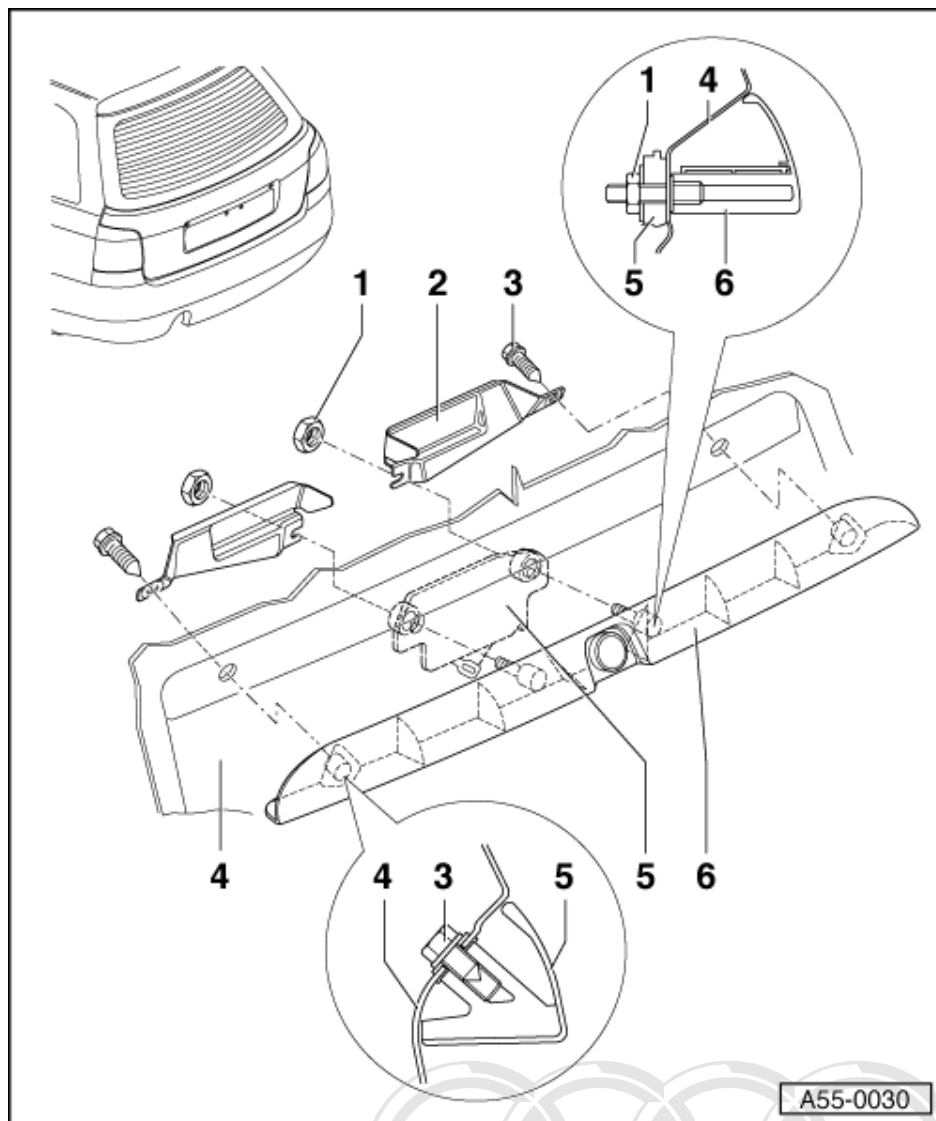
Component was discontinued shortly after start of series production.

3 Hexagon bolt

- ♦ 8 Nm

4 Tailgate

- ♦ Removing and installing => Page 27

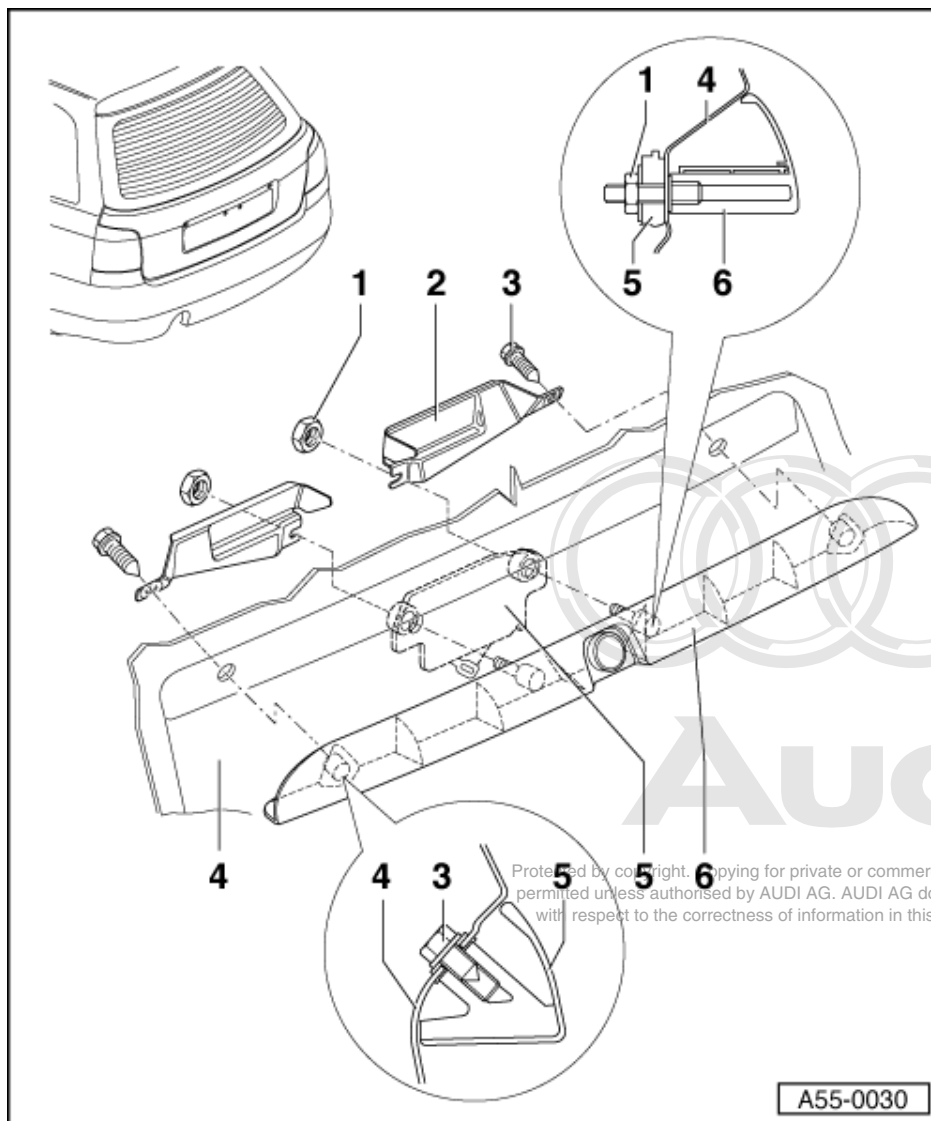


5 Locking system

- ◆ To remove, unscrew hexagon nuts -1-.
- ◆ Unfasten catch at flaps => Fig. 1 and pull out downwards under grip panel.
- ◆ Remove locking system.

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6 Grip panel

- ◆ Before removing, take off tailgate interior trim.

=> General Body Assembly, Interior; Repair group 70

- ◆ To remove, unscrew hexagon nuts -1- and hexagon bolts -3-.
- ◆ Pull grip panel slightly out of tailgate and unplug connector for number plate light.
- ◆ To install, insert grip panel in holes in tailgate.
- ◆ Ease in holder -2- (if still fitted) at locking system and screw to grip panel with outer securing bolt.

7 Actuator

- ◆ Removing and installing => Page 82

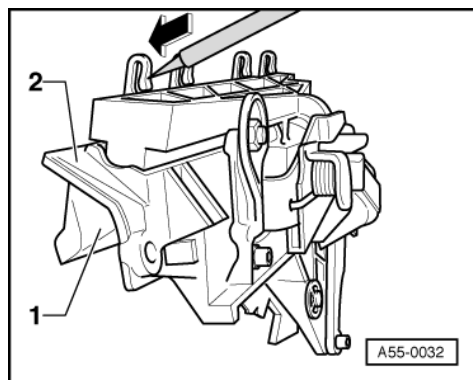
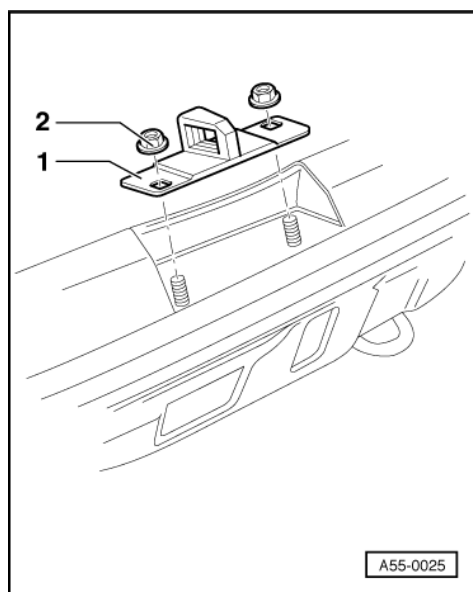


Fig.1 -> Removing and installing locking system

- Depress retaining hook -arrow- on inside of tailgate with screwdriver to release catch.
- Pull flap -1- downwards out of locking system -2- under grip panel.

2.11 - Removing, installing and adjusting striker

- Before removing striker, mark position with soft pencil.



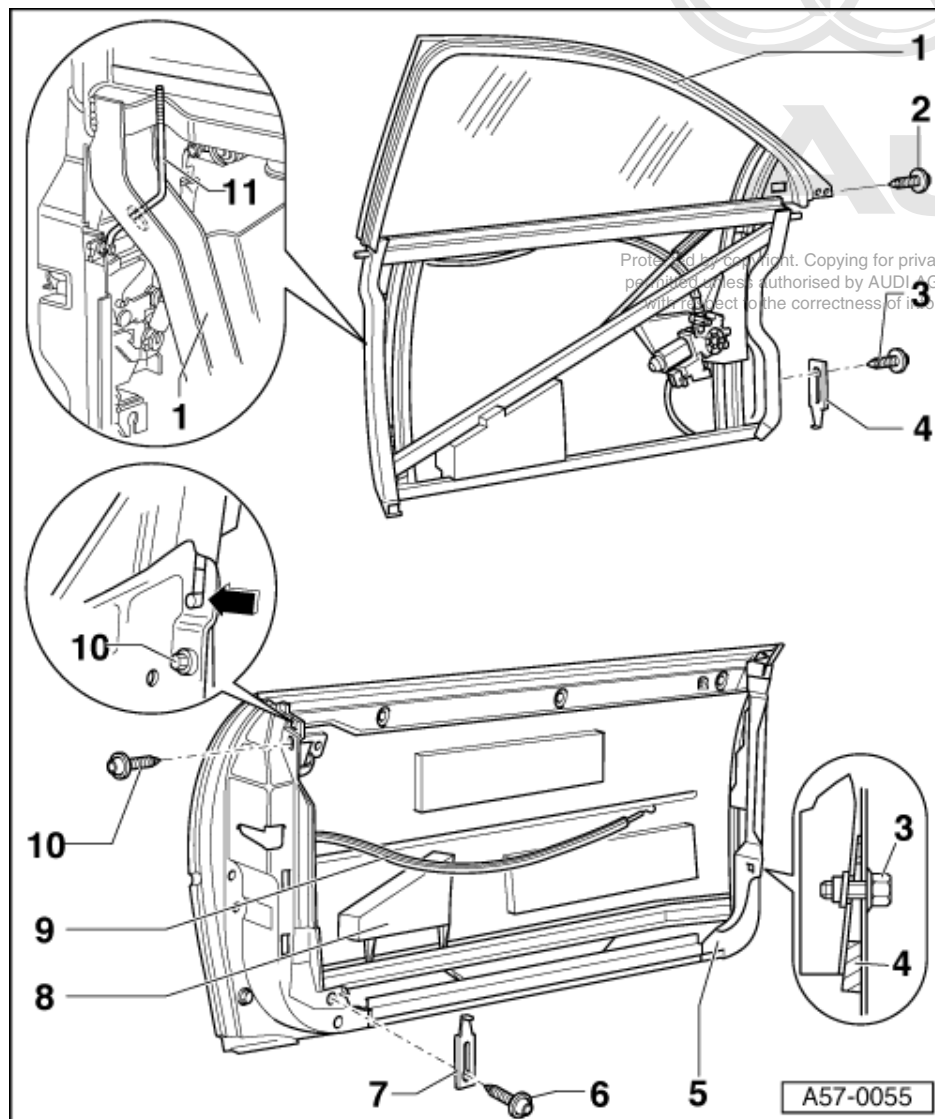
- -> To remove, unscrew hexagon nuts -2- and remove striker -1-.
- Attach new striker plate in marked position and tighten hexagon nuts finger tight.
- Close tailgate until lock engages and align flush with body contour.
- Open tailgate and tighten hexagon nuts to 8 Nm.
- Check that tailgate is properly aligned and closes easily; adjust, if necessary.



57 - Front doors/Door components/Central locking system

1 - Front door

1.1 - Front door



1.2 - Removing and installing front door and door subframe

1 Door subframe

- ◆ Removal:
- Removing door trim.

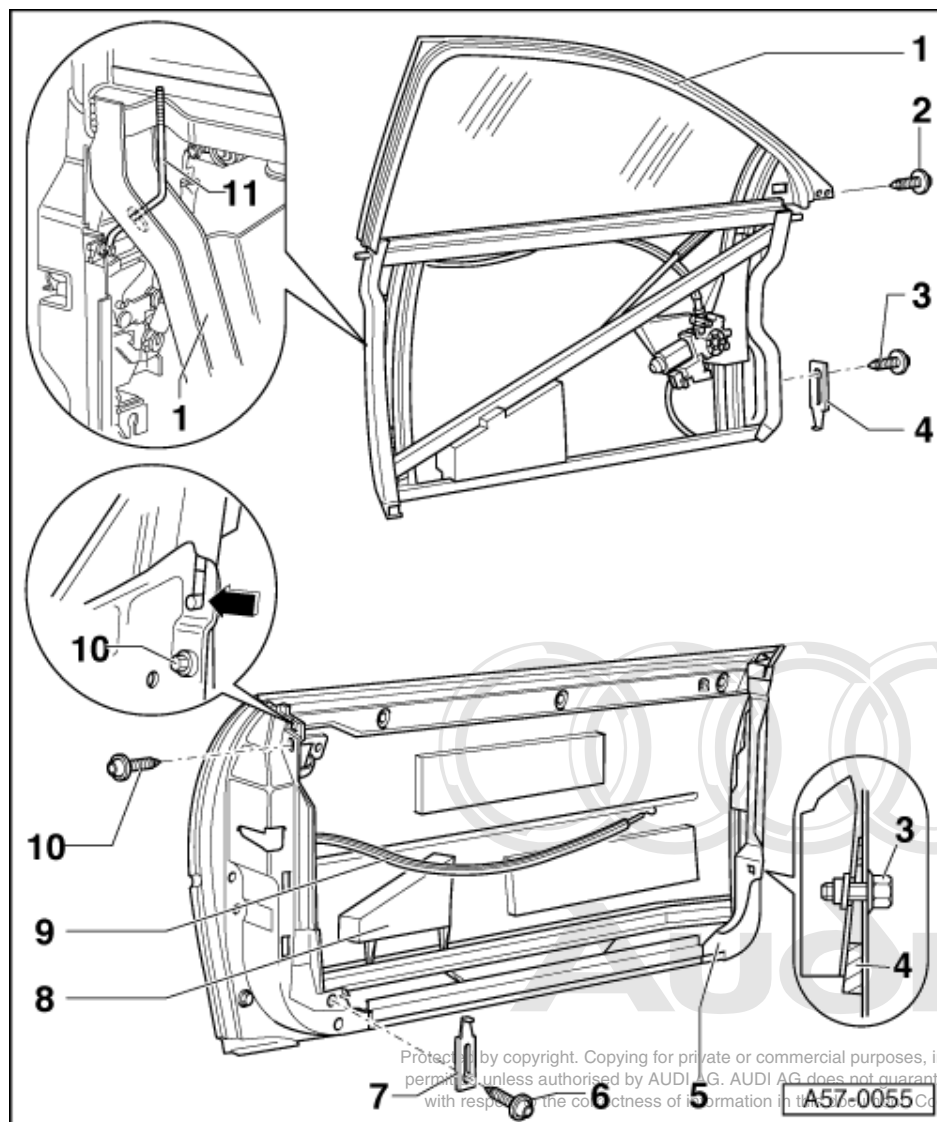
=> General Body Assembly, Interior; Repair group 70; Door trims Door trims

- Disconnect electrical wiring and unclip from door subframe.
- Unscrew hexagon nuts -2-; -3-; -6- and -10- and remove door subframe upwards.
- ◆ Installation:

- Install in reverse order.

Important

Hexagon bolts must be tightened in the following order: 2, 10, 6, 3.



- ♦ Adjusting:
 - With adjuster wedge =>Page 72 .
 - With striker =>Page 72

2 Hexagon bolt (M8 x 26)

- ♦ Tightening torque 30 Nm.

3 Hexagon bolt (M8 x 32)

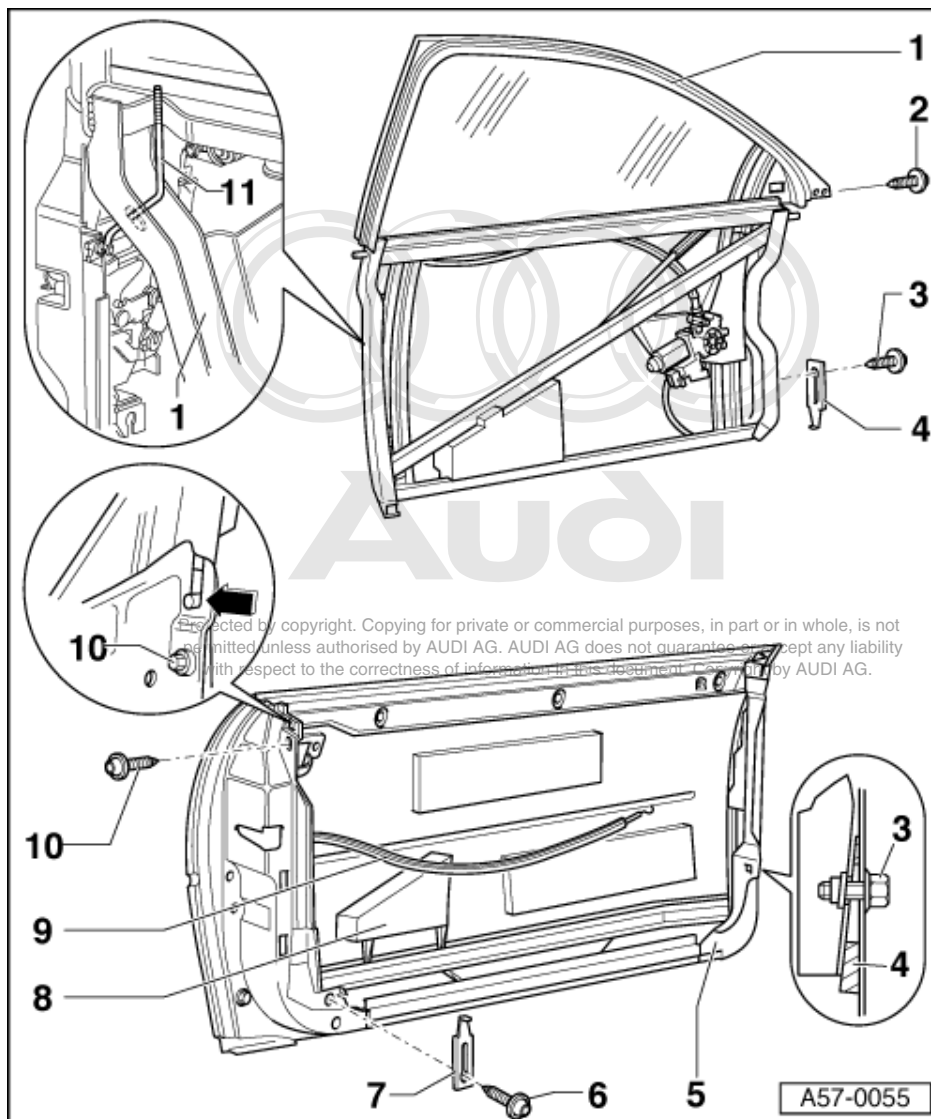
- ♦ Tightening torque 30 Nm.

4 Adjuster wedge

Note:

Adjuster wedge must always be fitted.

- ♦ Tolerances of door subframe can be axially offset by shifting the adjuster wedge -4-.



5 Front door

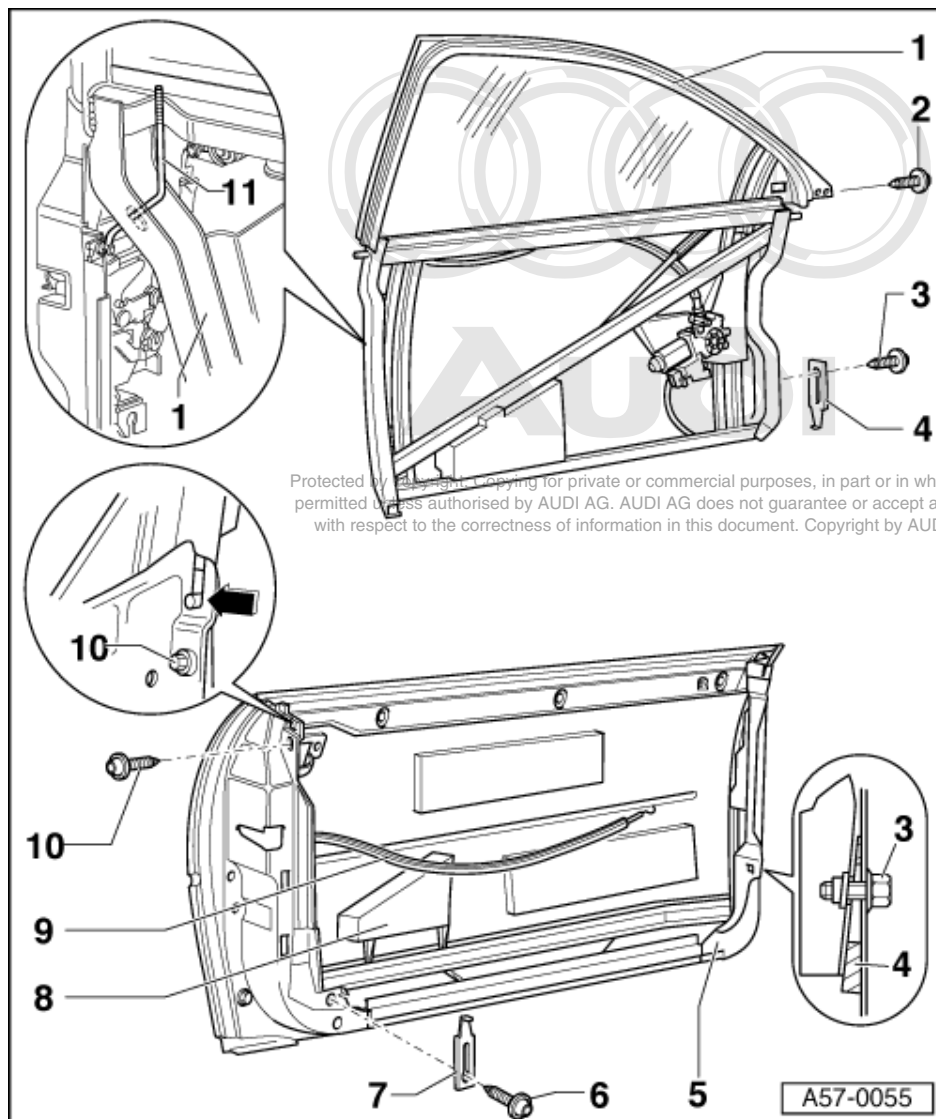
Note:

The front door can also be removed without dismantling the door subframe.

- Remove bottom section of A pillar trim.

=> General Body Assembly, Interior; Repair group 70; Door trims Door trims

- Unplug connectors from A-pillar connector point.
- Unclip bellows between front door and A pillar and pull electric wiring and central locking wiring out from pillar -A-.
- Remove Torx bolts T45 securing top and bottom hinges to door => Page 44 and remove door complete with door subframe.



6 Hexagon bolt (M8 x 32)

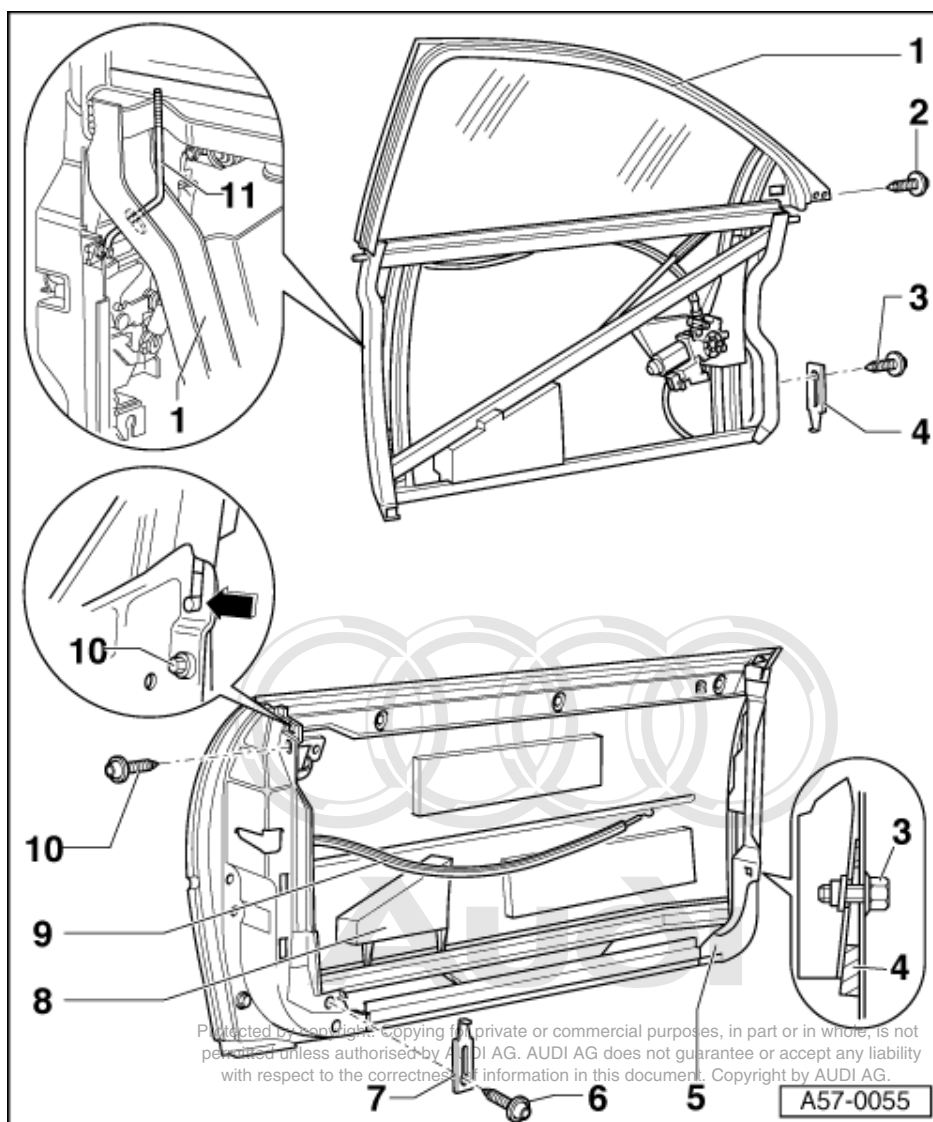
- ♦ Tightening torque 30 Nm.

7 Adjuster wedge

Note:

Adjuster wedge must always be fitted.

- ♦ Inclination of door subframe can be adjusted at pillar -B- by moving adjuster wedge.



8 Side impact protection

- ♦ Removing and installing => Page 48

9 Bowden cable

- ♦ Clip in at door subframe to avoid noise when closing door.

10 Hexagon bolt (M8 x 26)

- ♦ Tightening torque 30 Nm.

11 Securing rod

- ♦ Route through subframe as shown.

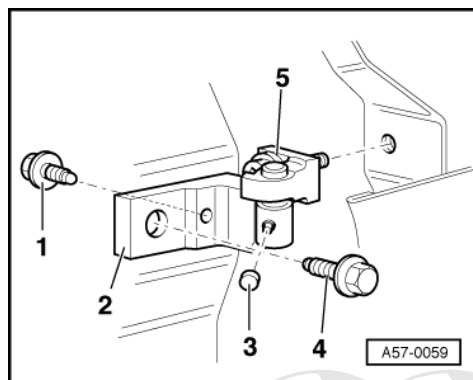


Fig.1-> Upper door hinge.

- Hexagon bolt (fitted from inside of vehicle) 30 Nm.
- Upper door hinge.
- Cap for hexagon bolt (23 Nm).
- Hexagon bolt -4- 30 Nm.
- Torx bolt (T45) 30 Nm.

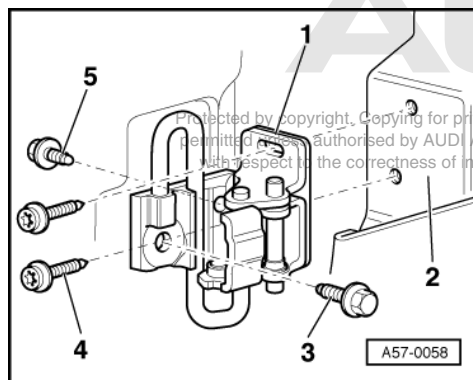
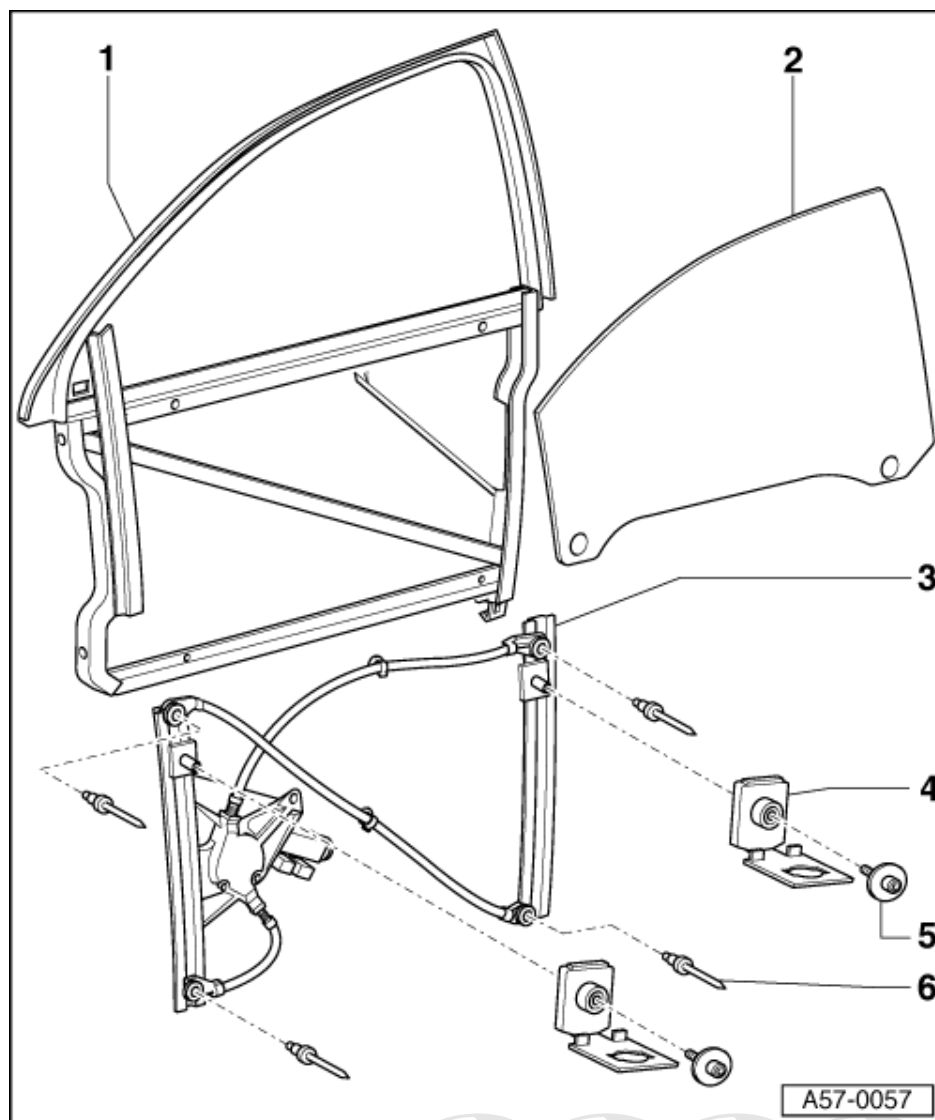


Fig.2-> Lower door hinge.

- Lower door hinge -1-.
- Front door -2-.
- Hexagon bolt -3- 30 Nm.
- Torx bolt -4- 30 Nm.
- Hexagon bolt -5- 30 Nm.

1.3 - Removing and installing window lifter and window



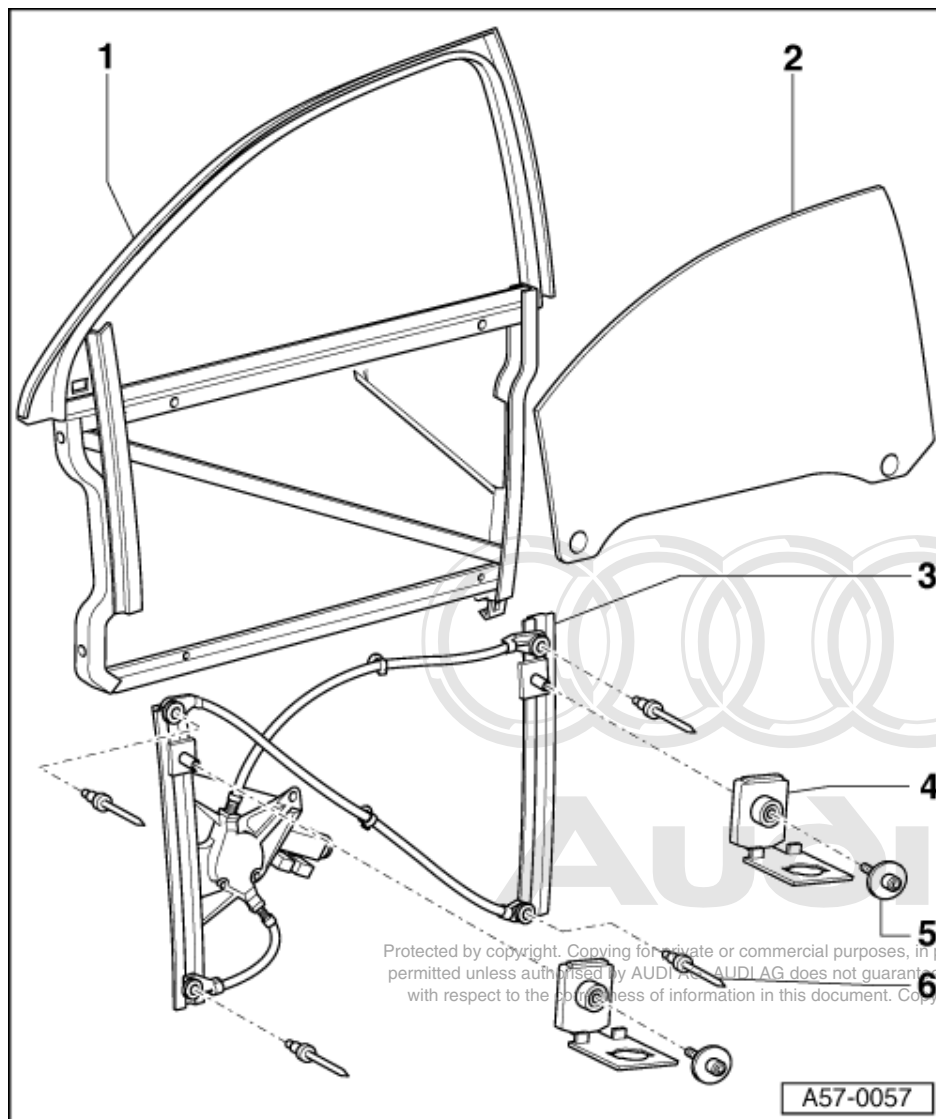
1 Door subframe

- ♦ Removing and installing =>Page 39

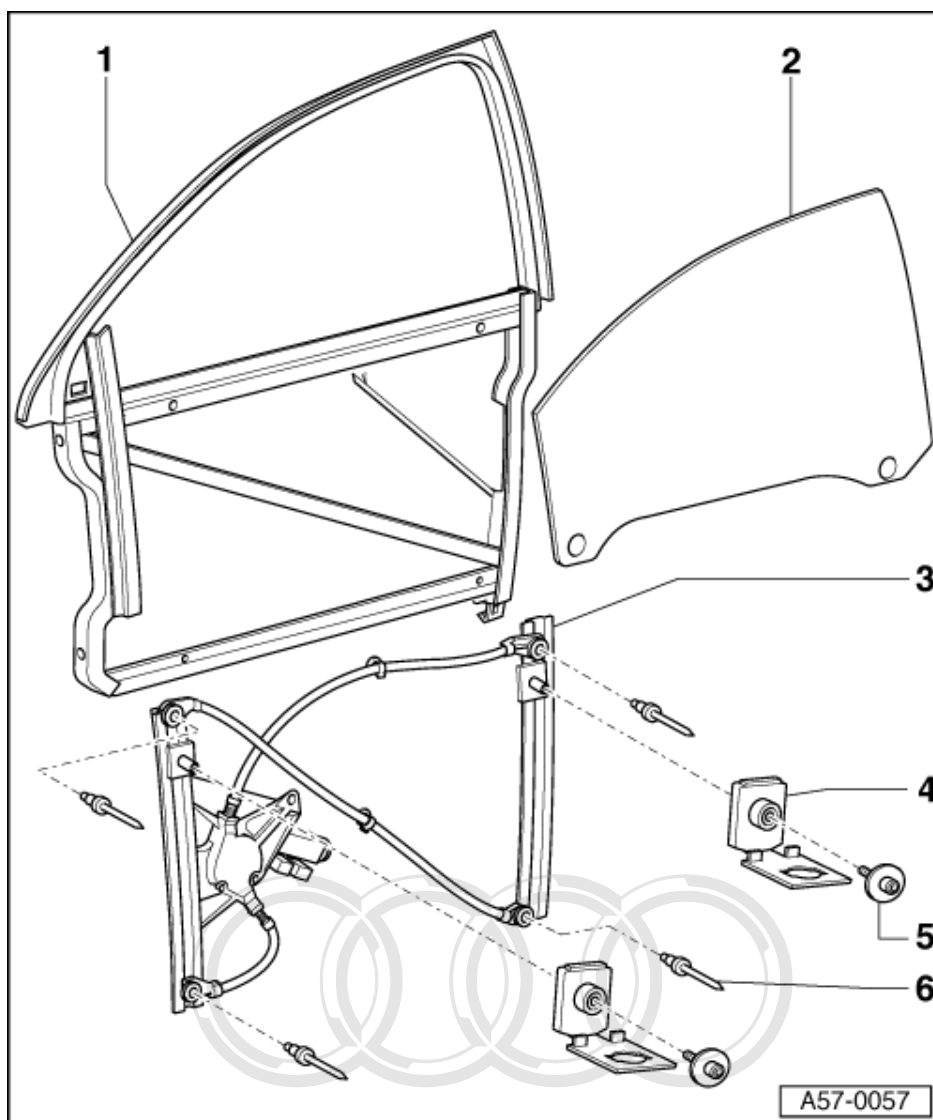
2 Washer

- ♦ Before removing:
 - Lower window.
 - Door sub-frame removed.
 - Before removing, mark positions of corners of window with felt-tip pen at both mounts -4-
 - Unscrew bolts -5-
 - Lift window out of mount -4-.

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- ◆ Installation:
 - Install in reverse order.
 - Enter window into window lifter and align with markings applied before removing.
 - Tighten bolts -5- to 4.5 Nm.
- ◆ Installing a new window:
 - Door subframe removed.
 - To install, enter window into guide and push it back towards pillar -B- as far as it will go.
 - Using window lifter, raise window without bolt -5- as far as it will go.
 - Close mount -4- and tighten bolts -5- to 4.5 Nm.



3 Window lifter

- ◆ Door sub-frame removed.
- To remove, drill heads off hollow rivets -6-, drive out shanks and remove window lifter.
- Shake door subframe so that shanks fall out.

4 Mounting

5 Torx bolt

- ◆ 4.5 Nm

6 Blind rivet

- ◆ Fit using special tool V.A.G 1753.

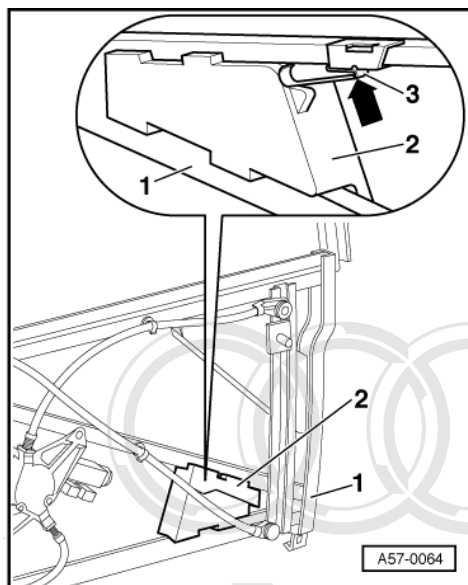
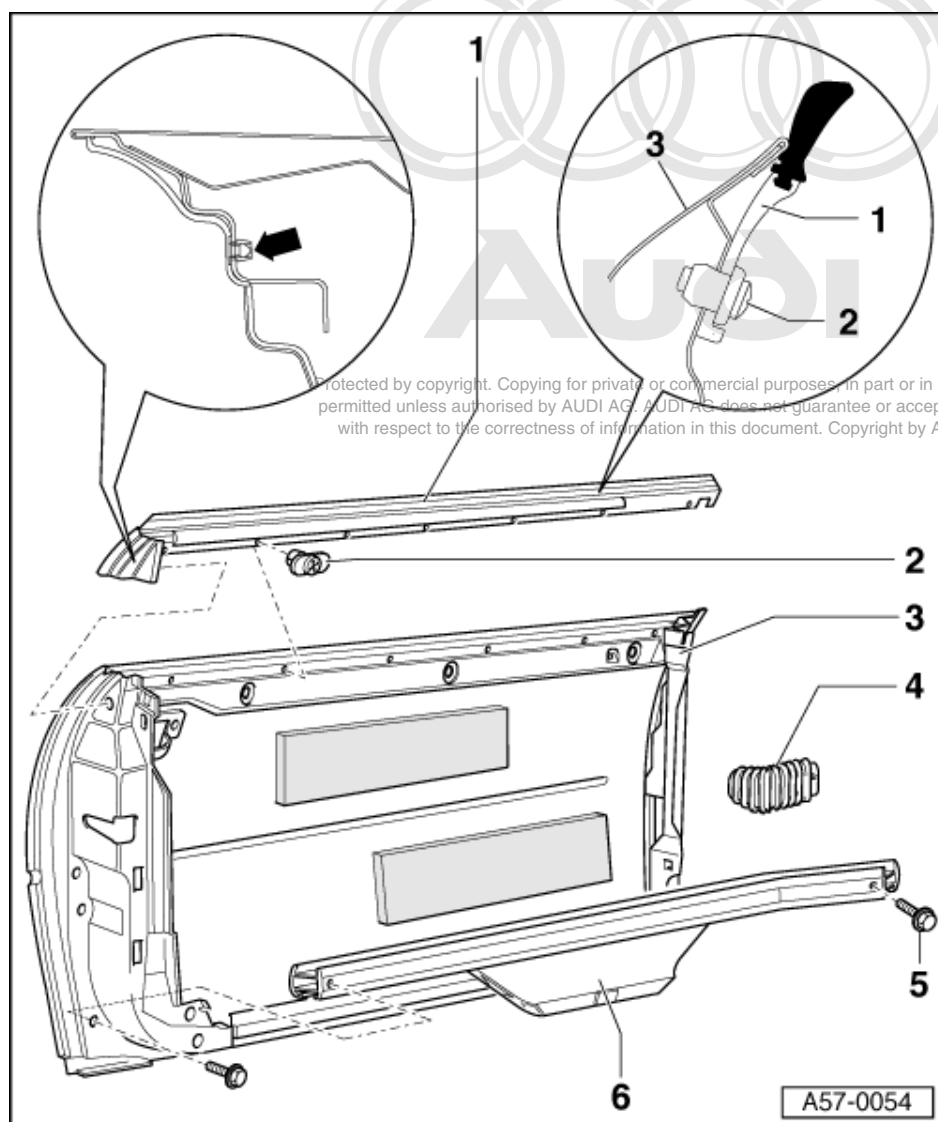


Fig.1-> Installing side padding in door subframe.

- Bonding surfaces for side padding must be clean and free from grease.
- Pull protective film off adhesive strip and firmly insert side padding -2- in door subframe -1- as shown.
- Make sure locking spring -arrow- engages properly.

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1.4 - Removing and installing impact bar



1 Window slot strip

- ◆ Door sub-frame removed.
- ◆ To remove:
 - Unscrew pin from expanding clip -2-.
 - Lever out pin -arrow- in area of pillar -B- and remove window slot strip.
 - Only press in pin on installation.

2 Expanding clip

3 Front door

4 Bellows

5 Hexagon bolt

- ◆ 8 Nm

6 Impact bar

- ◆ Door sub-frame removed.
- Unscrew hexagon nuts -5- and remove side impact bar.

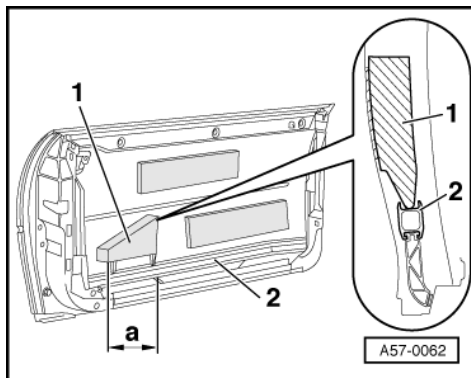
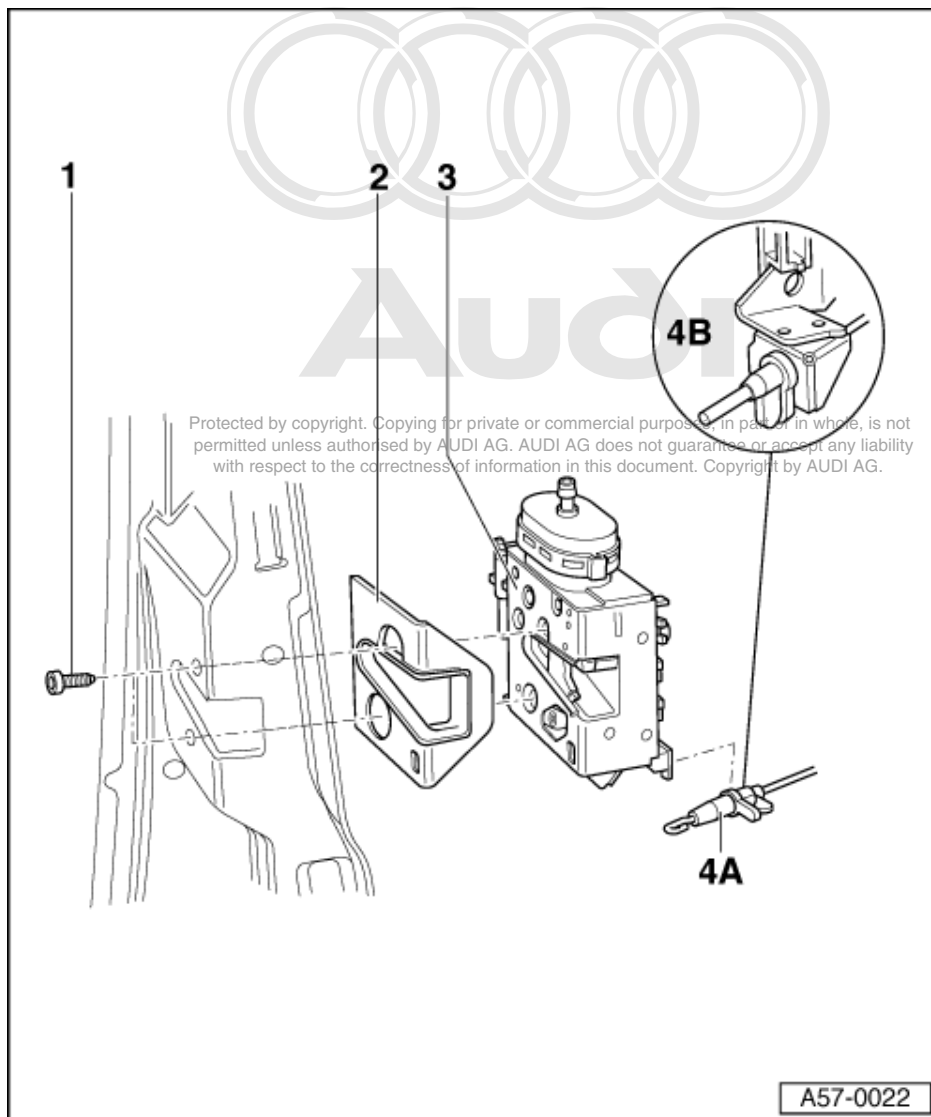


Fig1-> Fitting side padding.

- Bonding surfaces for side padding must be clean and free from grease.
- Pull protective film off side padding, insert in side impact protection -2- and press firmly into front door as shown.
- Dimension -a- = 67mm $\pm$ 5mm.

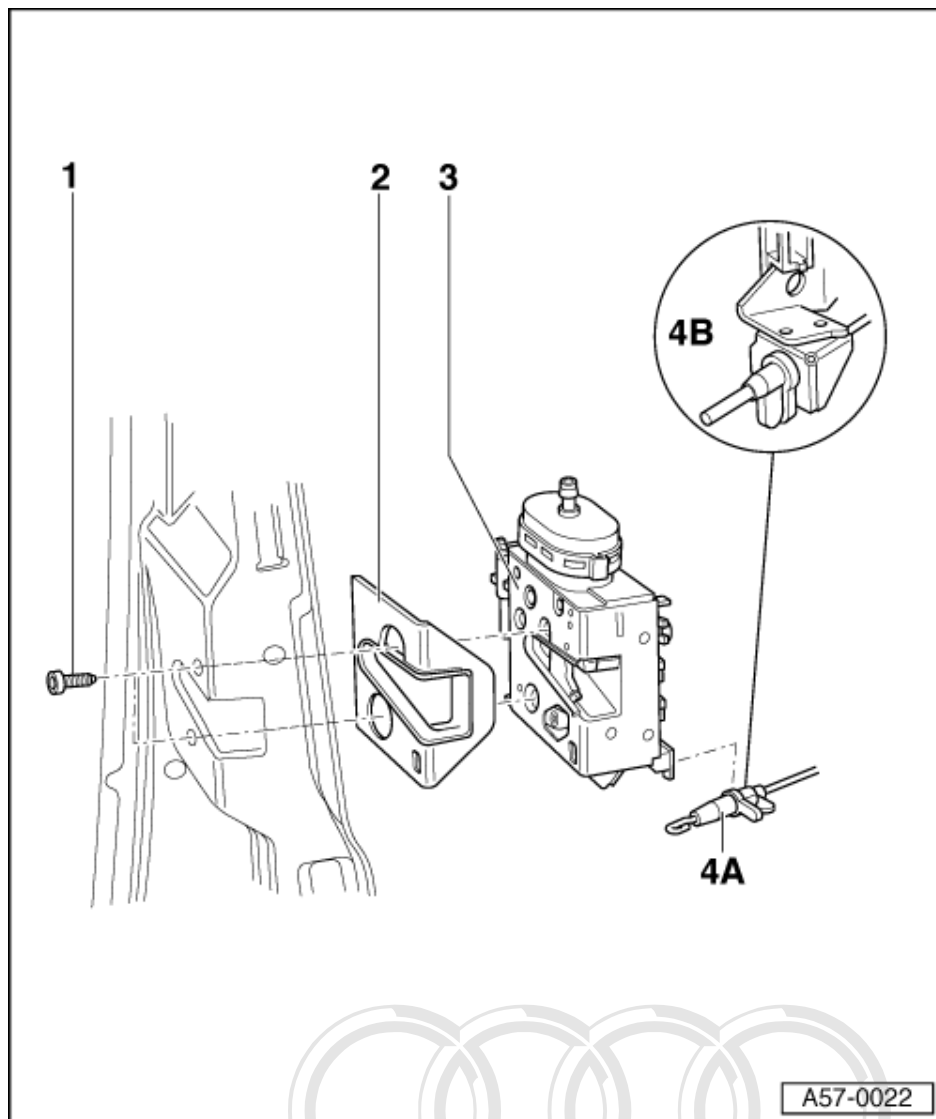
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1.5 - Removing and installing front door lock with operating elements up to VIN 8L XA 000 000



Assembly overview

- 1 Bolt (2x)
 - ♦ Tightening torque 9.5 Nm.
- 2 Lock base plate
- 3 Door lock
 - ♦ Removal:
 - Remove door subframe =>Page 39
 - Remove cover for door lock => Page 53 .
 - Unclip securing and operating rods => Page 53 .

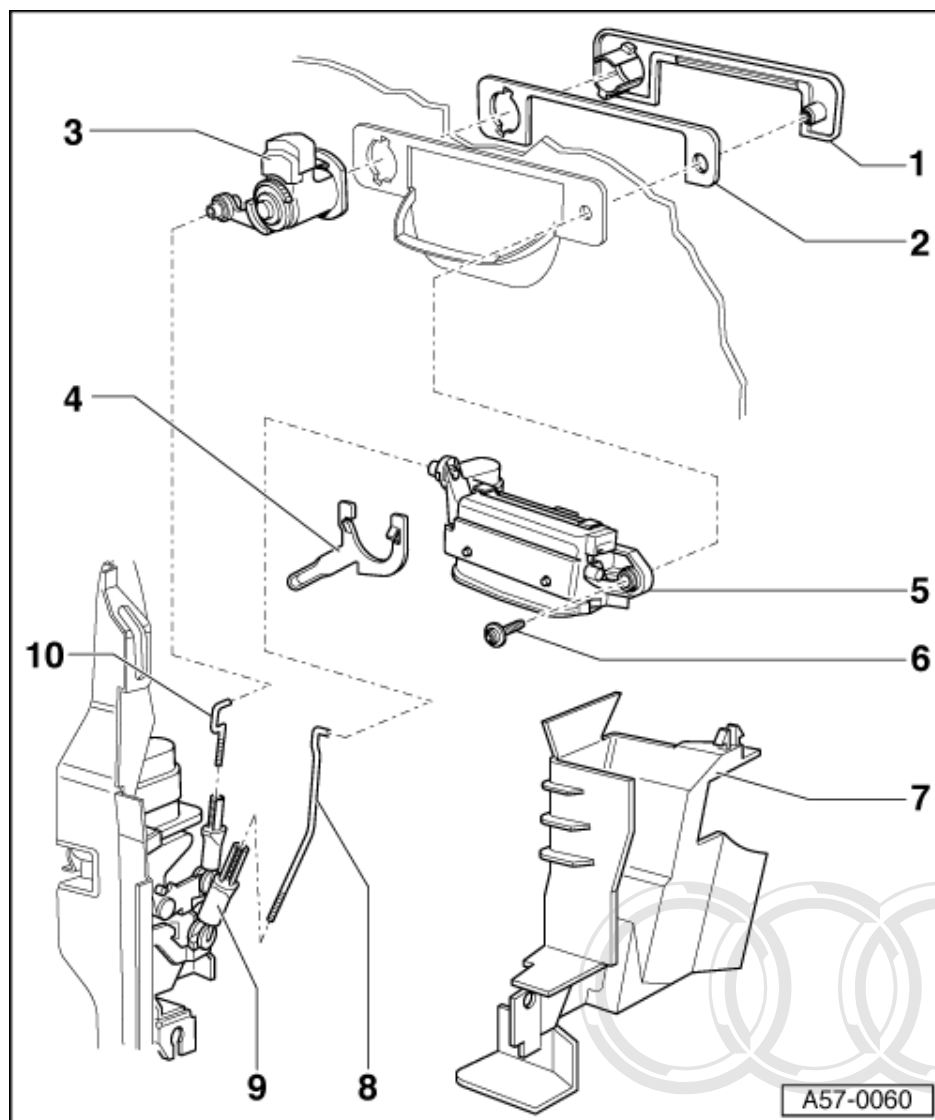


- Detach connecting hose from actuator for central locking system.
- Unscrew bolts -1-.
- Remove door lock and lock base plate -2-
- ◆ Installation:
- Install in reverse order.

4 Bowden cable for interior door handle.

- ◆ Removal:
- Remove door subframe =>Page 39
- Remove cover for door lock =>Page 53.
- Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
- Install in reverse order.

1.6 - Removing and installing front door handle



1 Panel

- ◆ Remove => Fig 3 .

2 Shim plate

3 Lock cylinder

- ◆ Door sub-frame removed.
- ◆ Before removing unclip securing rod -10-.
- ◆ To remove, swivel rotary clip -4- to the rear (away from direction of travel) and remove lock cylinder.

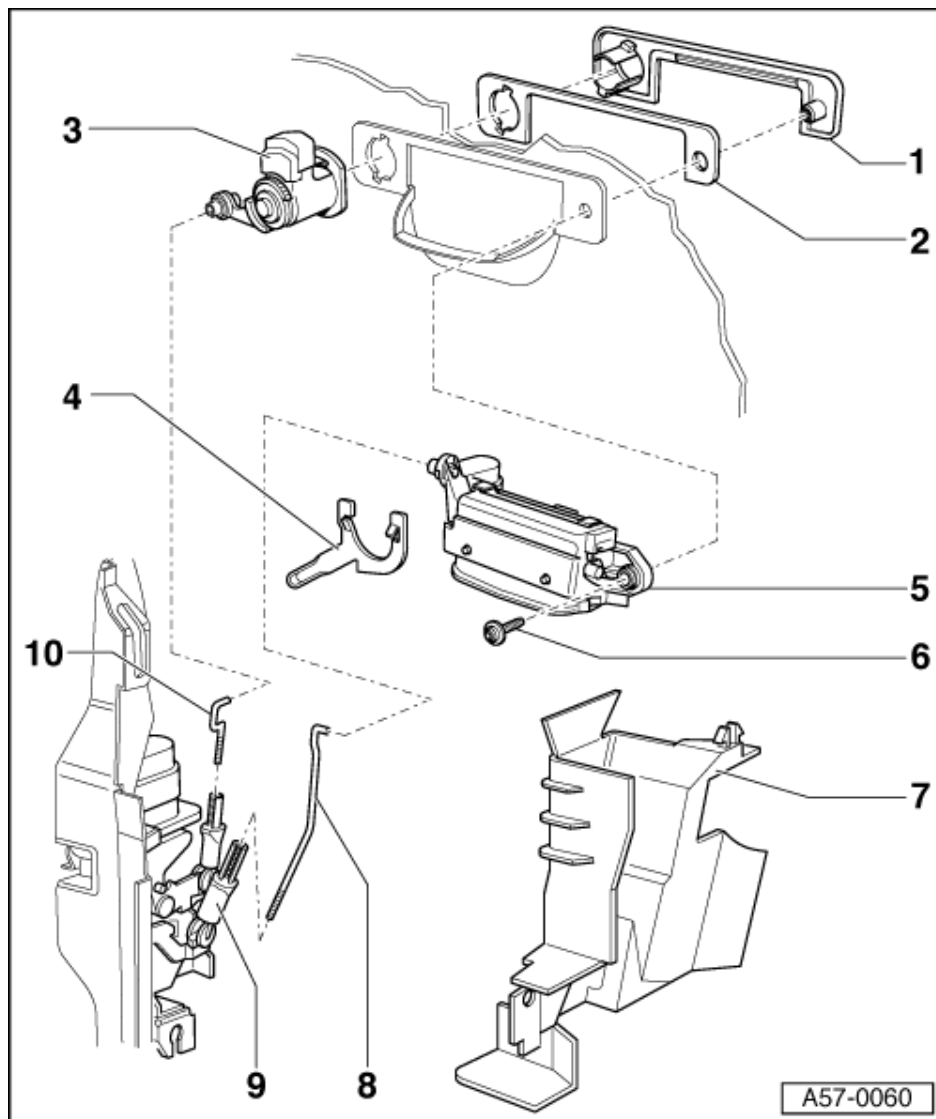
4 Rotary clip

5 Door handle

- ◆ Unclip cover -7-.
- ◆ To remove, detach rotary clip -4- and unscrew bolt -6-.

6 Combi bolt

- ◆ 5 Nm



7 Door lock cover

- ♦ To remove, first unclip cover at top, then pull out of door lock at bottom.

8 Securing rod

- ♦ To remove, unclip at safety piece -9-.

9 Operating clip

- ♦ Installing => Fig. 1.

10 Lock cylinder securing rod

- ♦ Installing => Fig. 1.



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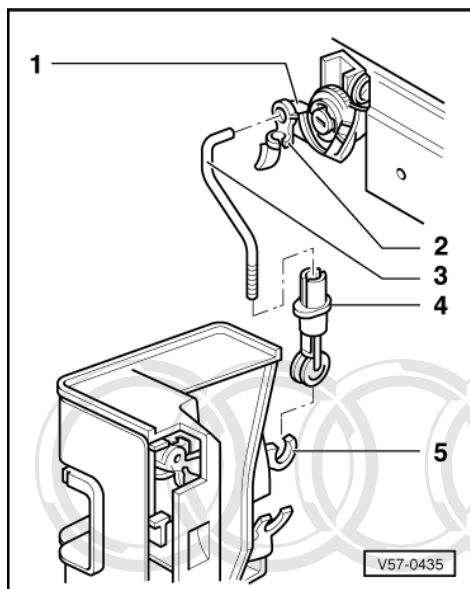


Fig. 1 -> Installing securing rod for locking cylinder

- Clip collar -2- into release lever -1-.
- Insert securing rod -3- for locking cylinder into collar -2- and clip in.
- Insert securing rod -3- for locking cylinder into operating clip -4- and clip in.
- Take care not to strain locking lever -5- at door lock (max. play at locking lever 1 mm =>Fig. 2).
- Push sleeve on operating clip -4- upwards.

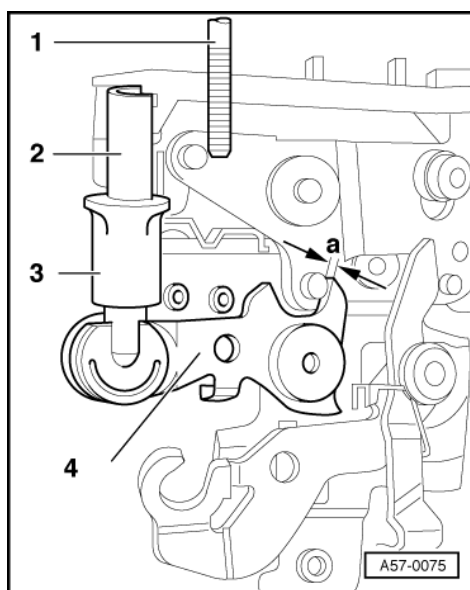


Fig.2 -> Adjusting play for locking lever

- Enter securing rod -1- in operating clip -2- such that dimension -a- at locking lever -4- is approx. 1 mm.
- Push up sleeve -3- at operating clip -2- and lock securing rod -1-.

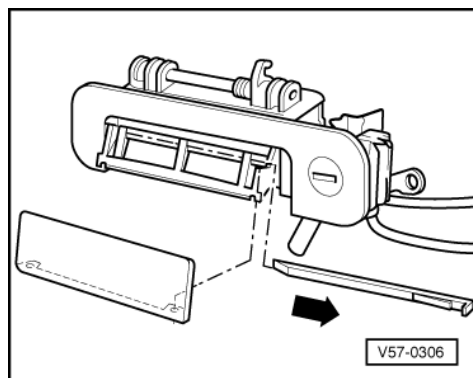


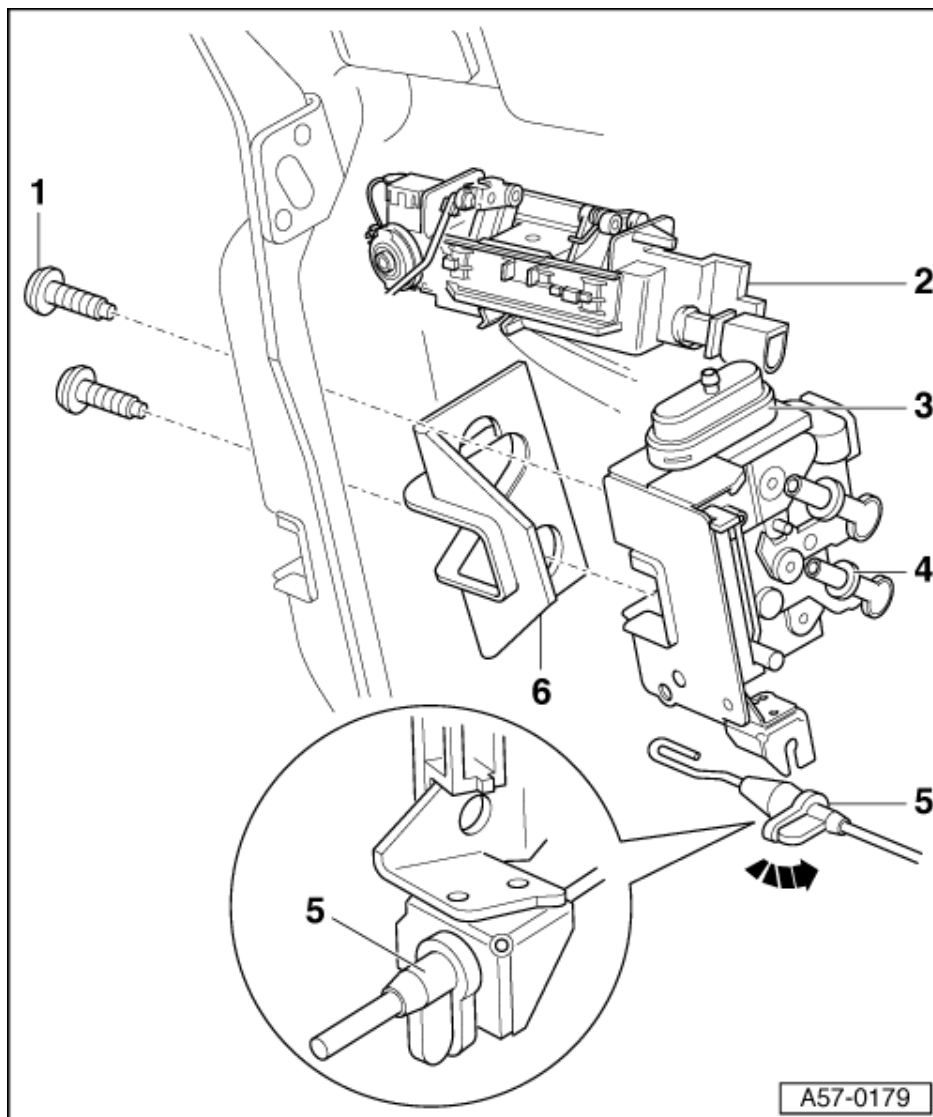
Fig. 3 Removing cover for door handle

- -> Lift door handle.
- Use small screwdriver to lever fastening strip out of door handle in direction of arrow and pull out.
- Remove door handle trim plate outwards.



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1.7 - Removing and installing front door lock with operating elements from VIN 8L XA 000 001



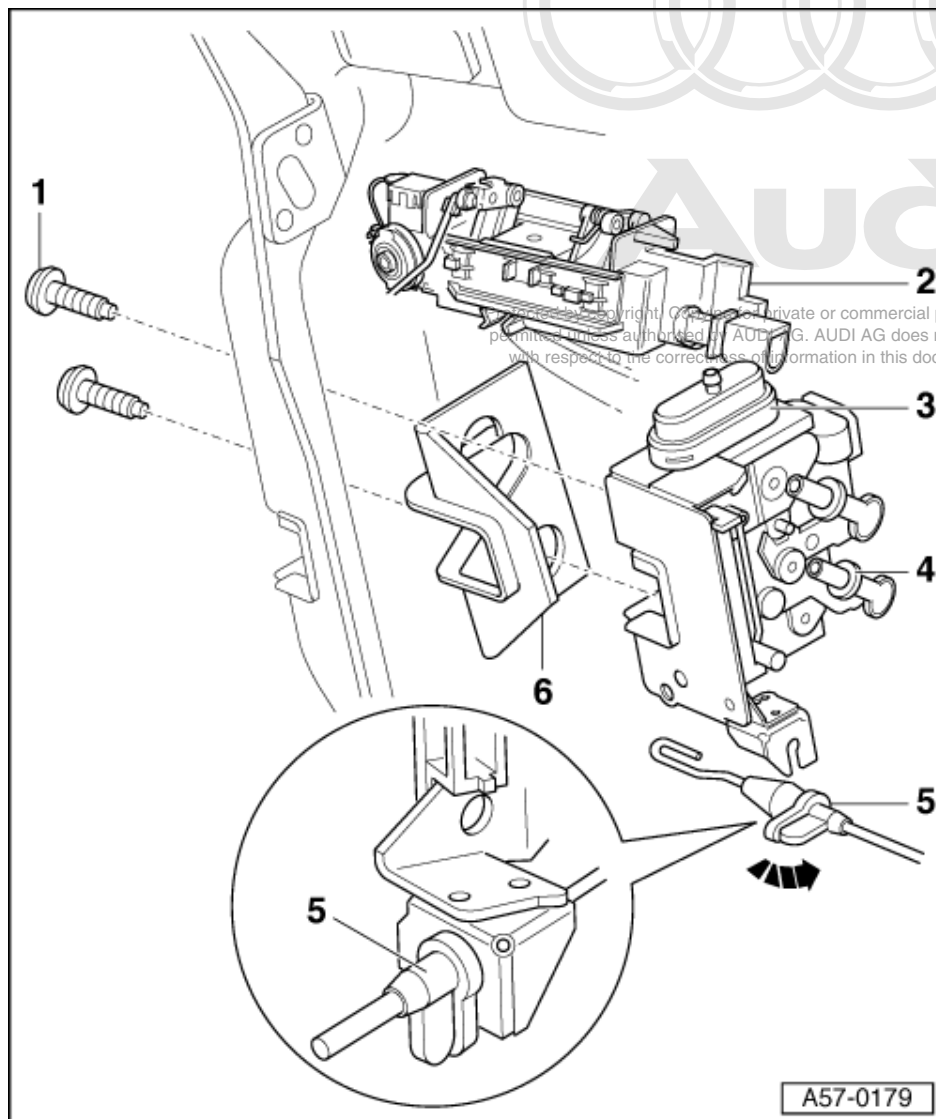
Assembly overview

- 1 Bolt (2x)
 - ◆ Tightening torque 10 Nm.
- 2 Door handle
 - ◆ Removing and installing => Page 65
- 3 Door lock
 - ◆ Removal:
 - ◆ Remove door trim

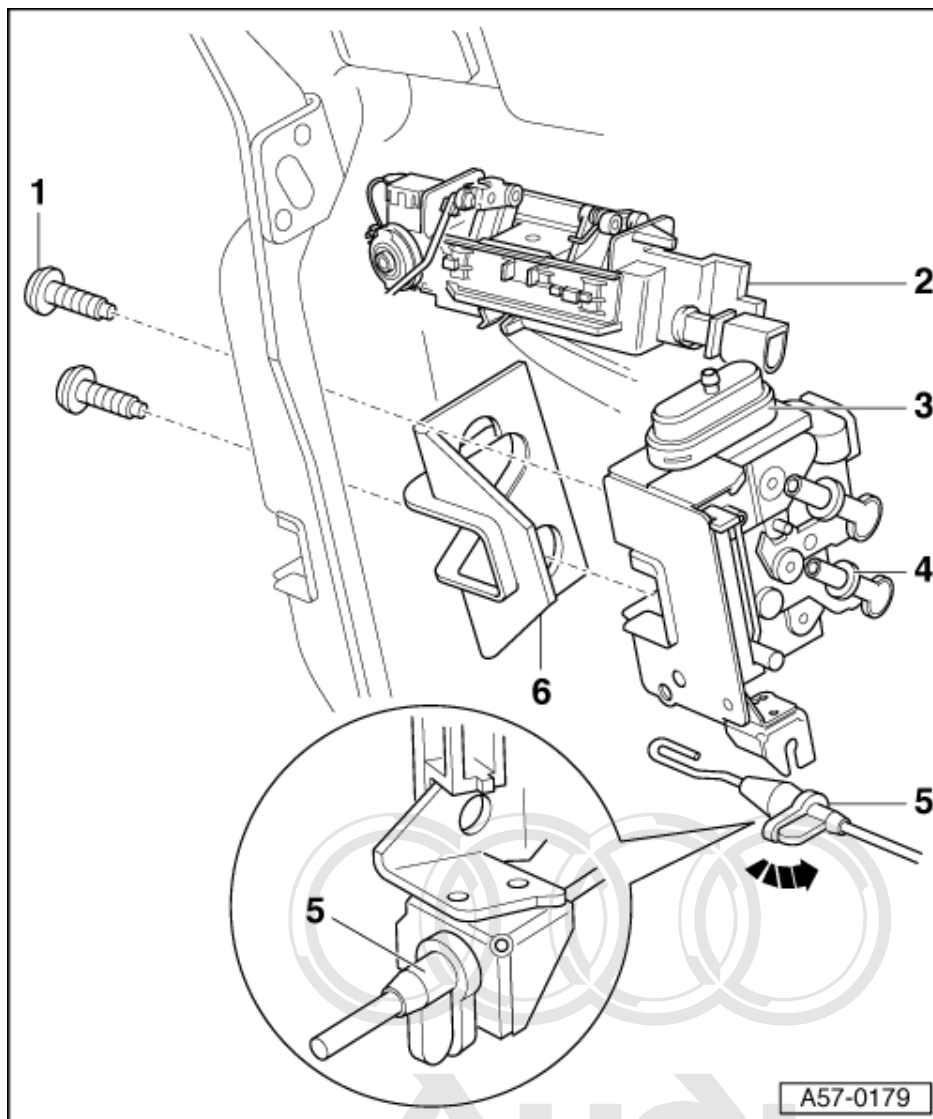
=> General Body Assembly, Interior; Repair group 70; Door trims Door trims

- Door subframe removed.

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- Remove cover for door lock => Page 60 .
- Unclip retaining and operating rods
=>Page 62 .
- Detach connecting hose from actuator for central locking system.
- Unscrew bolts -1-.
- Remove door lock and lock base plate -2-
- ◆ Installation:
- Install in reverse order.



4 Operating clip

- ◆ Installing => Page 62 .

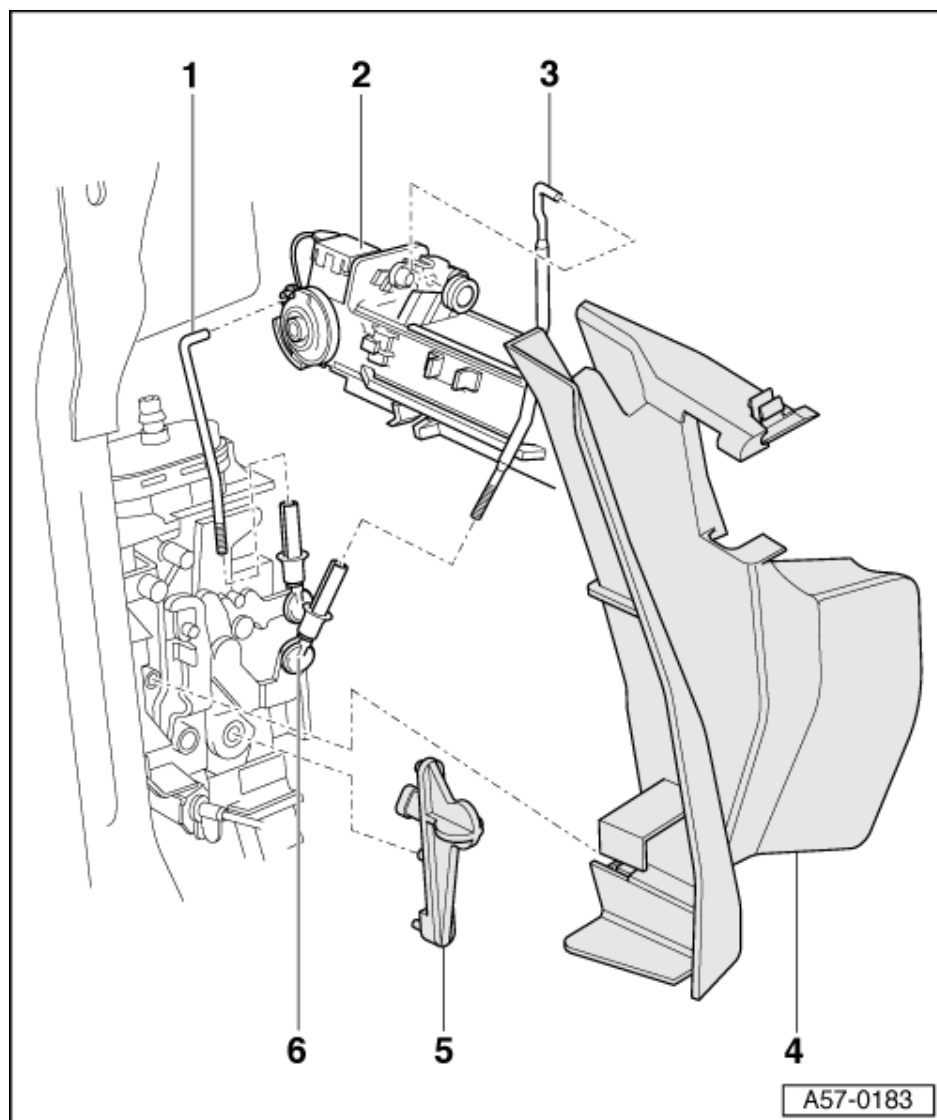
5 Bowden cable for interior door handle.

- ◆ Removal:
 - Door sub-frame removed.
 - Remove cover for door lock =>Page 53 .
 - Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
 - Install in reverse order.

6 Lock base plate



1.8 - Removing and installing cover for door lock



1 Lock cylinder securing rod

- ◆ Clip in bushing on release lever.

2 Door handle

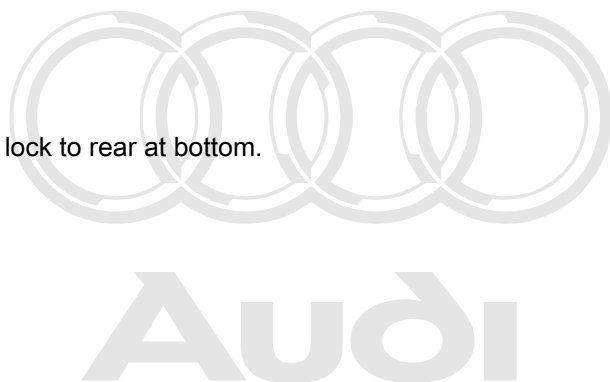
- ◆ Removing and installing => Page 67

3 Door lock operating rod

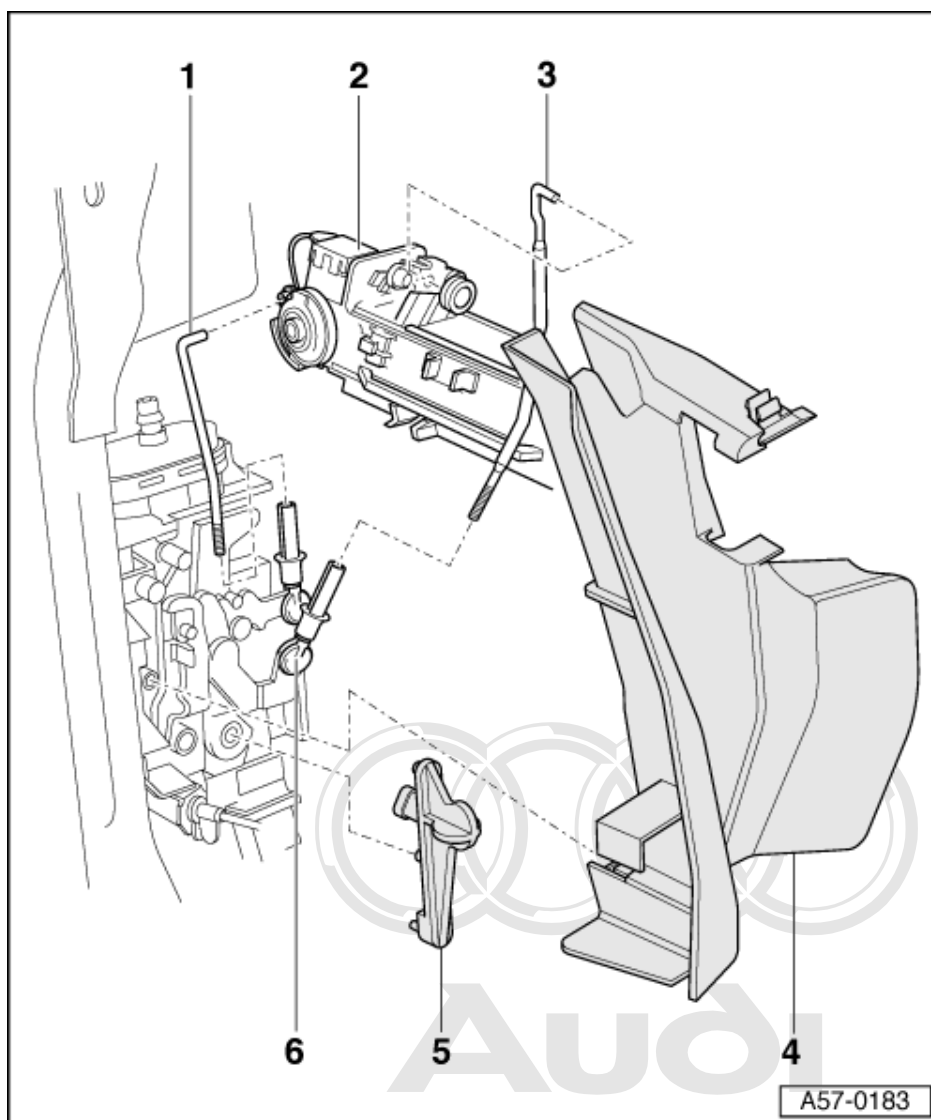
- ◆ Installation as for securing rod -4-.
- ◆ Clipping-in length -a- 13 ± 3 mm.

4 Door lock cover

- ◆ To remove, first unclip at top, then remove from door lock to rear at bottom.



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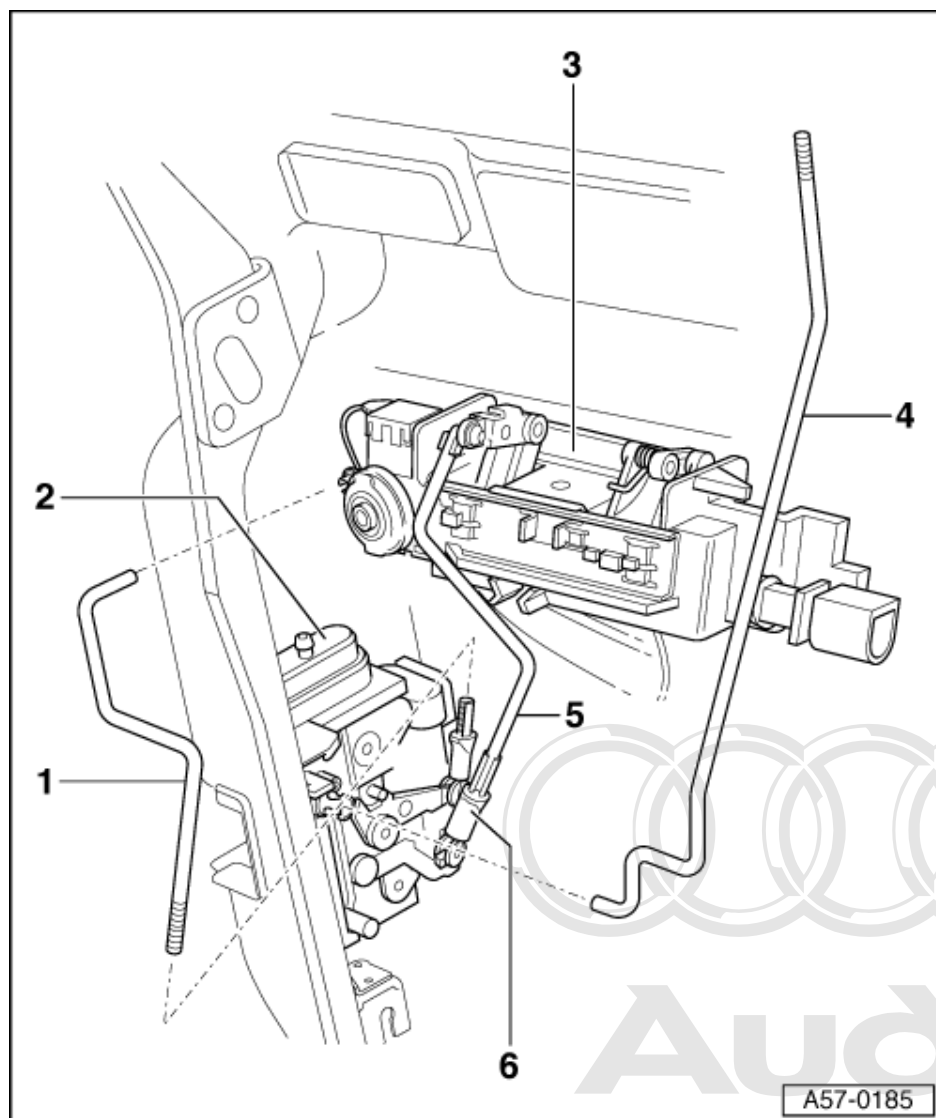
5 Installation pin

- ♦ Only fitted in new parts - serves as locating aid.
- ♦ Only remove door lock once operating rod has been installed.

6 Operating clip

- ♦ Inserting in door lock => Page 62 .

1.9 - Removing and installing operating rods for front door lock



A57-0185

1 Lock cylinder securing rod

- ♦ Installing => Page 62 .

2 Door lock

- ♦ Removing and installing => Page 57

3 Door handle

- ♦ When removing the door handle, the retaining rod and operating rod -5- must be detached from the door handle.

4 Operating rod

- ♦ Unclip from door lock to remove.

5 Operating clip

- ♦ Installing => Page 62 .

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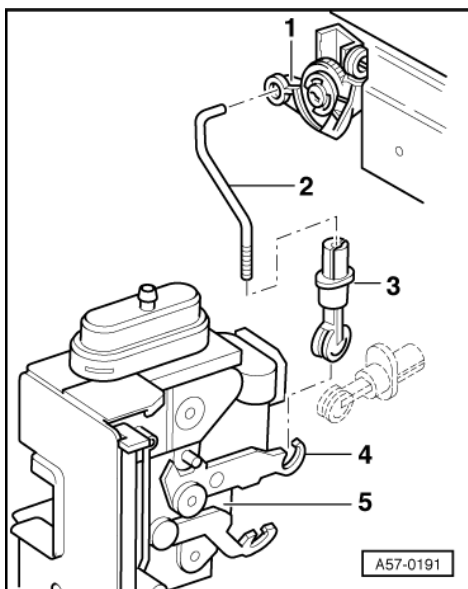


Fig.1 -> Removing and installing retaining rod for lock cylinder

- Insert and clip retaining rod -2- for lock cylinder in bushing on release lever -1-.
- Tilt operating clip -3- at 90° (not visible in illustration), insert in release lever -4- and then swivel upwards.
- Clip retaining rod -2- in operating clip -3-.
- Do not strain locking lever -4- on door lock -5- (max. play at locking lever 1 mm => Fig. 2)
- Push sleeve on operating clip -3- upwards.

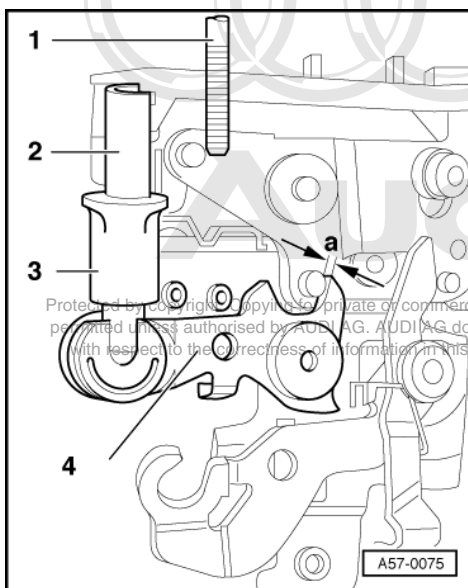


Fig.2 -> Adjusting play for locking lever

- Enter securing rod -1- in operating clip -2- such that dimension -a- at locking lever -4- is approx. 1 mm.
- Dimension -a- = 13 mm (adjustment depth of retaining rod) must be observed => Fig. 3

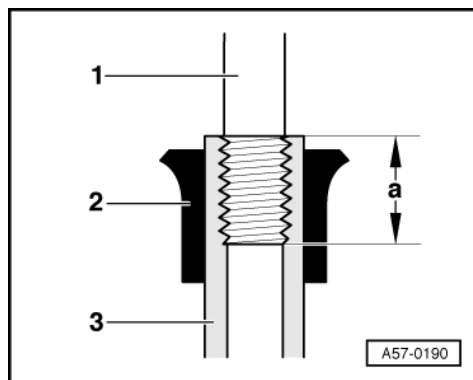
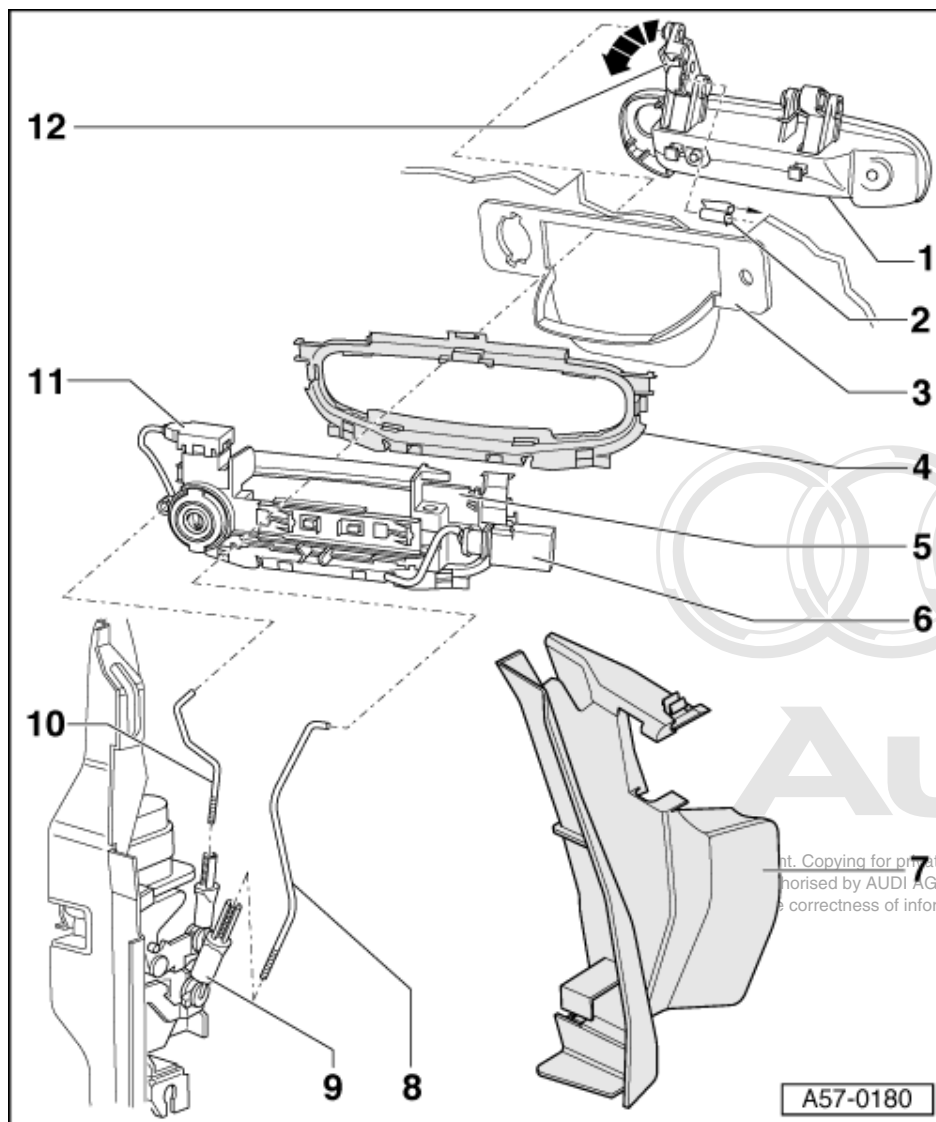


Fig.3 -> Adjustment depth for retaining rod

- When correctly adjusted, dimension -a- of retaining rod must be 13 mm $\pm$ 3 mm.
- After adjustment is complete, push the sliding sleeve -2- upwards from actuation clip -3-.

1.10 - Front door handle - exploded view



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1 Door handle

- ♦ Remove door trim

=> General Body Assembly, Interior; Repair group 70; Door trims Door trims

- ♦ Door sub-frame removed.
- ♦ Removing => Page 67

2 Locking pin

- ♦ When installing, the securing spring must fully engage in spring catch.

3 Front door

4 Seal for door handle

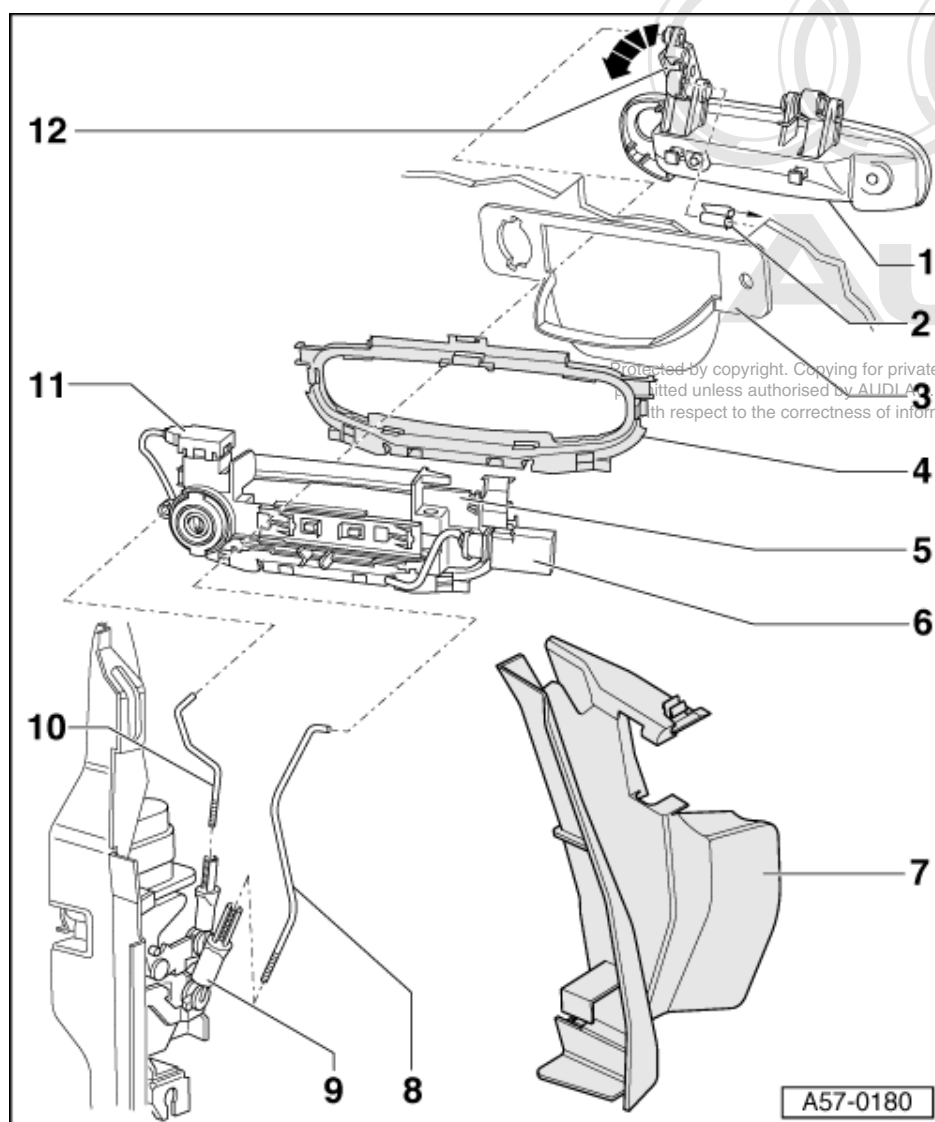
- ♦ Removing and installing => Fig. 2

5 Door handle mount

- ♦ Releasing => Page 68 .

6 Connector

- ♦ Vehicles with anti-theft alarm only.



7 Door lock cover

- ♦ To remove, first unclip at top, then remove from door lock to rear at bottom.

8 Operating rod

- ♦ Detach at clip -9- before removing door handle

9 Operating clip

- ♦ Installation => Page 62 .

10 Lock cylinder securing rod

- ♦ Installation =>Page 62 .

11 Microswitch

- ♦ Vehicles with anti-theft alarm only.
- ♦ Removing and installing => Fig. 1 .

12 Hinged lever

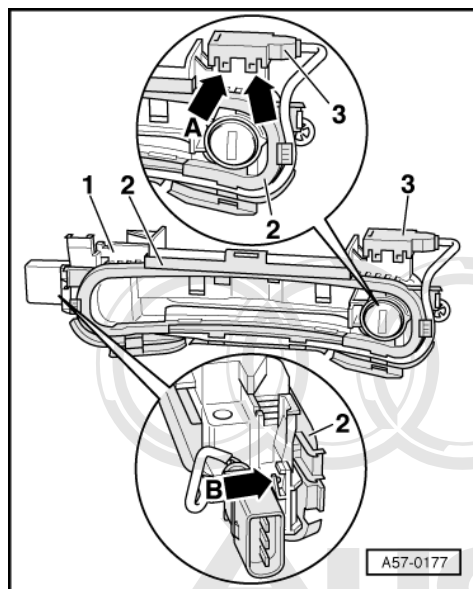


Fig.1 -> Removing and installing microswitch

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- Door handle mount -1- removed.
- Carefully release catches -arrows A- and detach microswitch -3- upwards.
- Push catch -arrow B- back and remove connector from mount by pushing upwards.
- Remove connector cable from seal -2-.
- Ensure when installing that the cable is fully inserted into seal as shown.

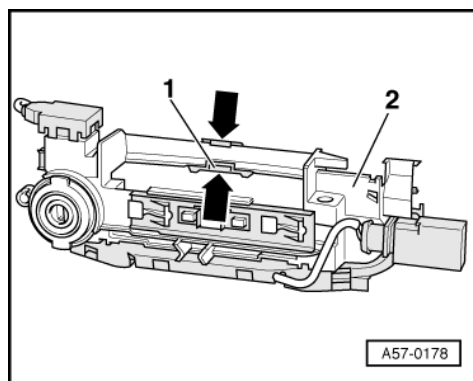
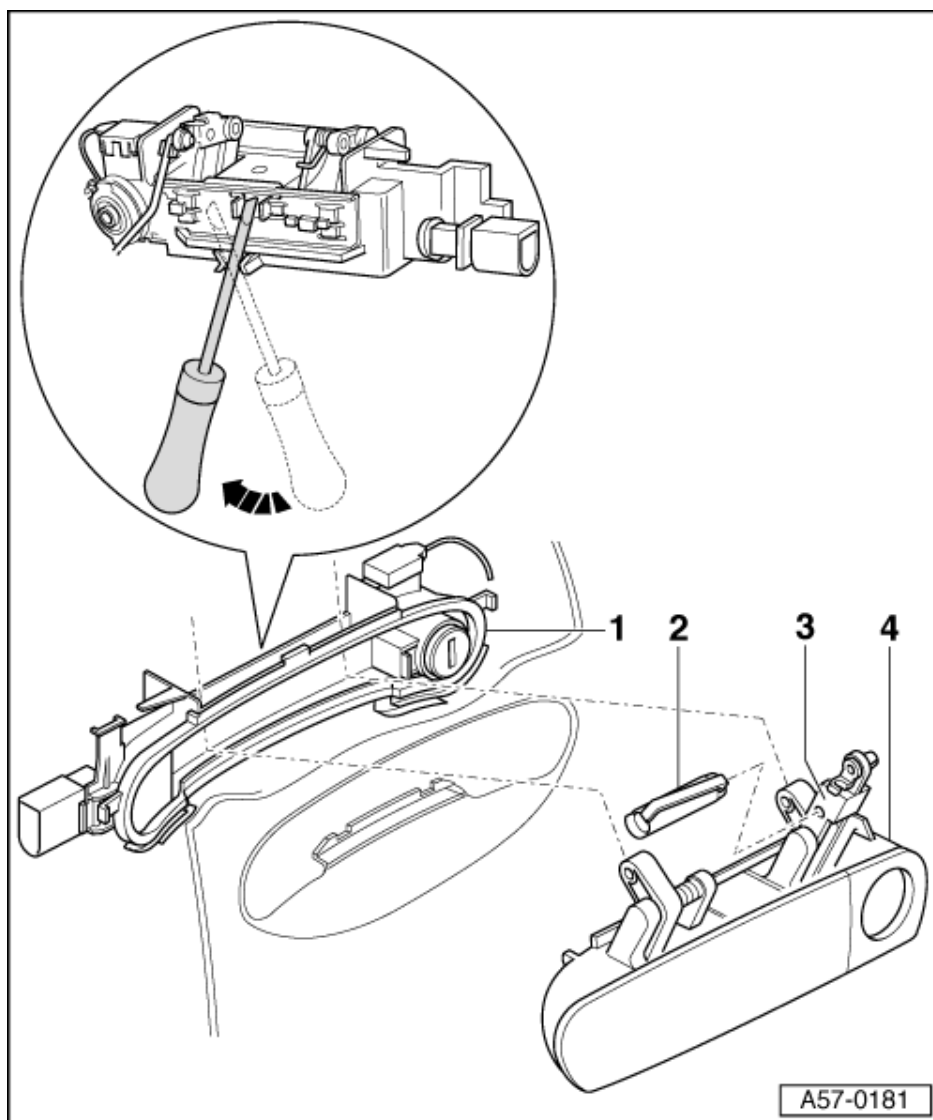


Fig.2 -> Removing and installing door handle seal

- Unclip and detach seal to remove.
- When installing, the seal must engage fully in mount -arrow- to guarantee absence of leaks.

1.11 - Removing door handle



1 Door handle mount

- ♦ The lock cylinder is part of mount and cannot be replaced separately.

2 Locking pin

- ♦ Hinged lever must fully engage in spring catch when installing.

3 Hinged lever

4 Door handle

- ♦ Door trim and door subframe removed prior to removal of door handle.
- ♦ Remove locking pin -2- and fold up hinged lever -3- to remove.
- ♦ Release slide on door handle mount -1- using a screwdriver => Fig. 1.
- ♦ Detach mount for door handle and lock cylinder with door handle.

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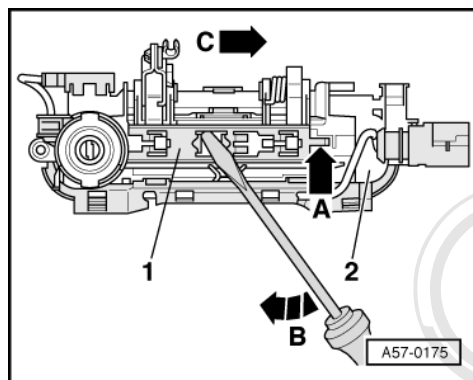


Fig.1 -> Releasing mount for door handle

- Use small screwdriver to release catch for slide, -arrow -A- by raising it slightly.
- Release slide -1- in direction of arrow -C- using a screwdriver which must be pushed in direction of arrow -B-.

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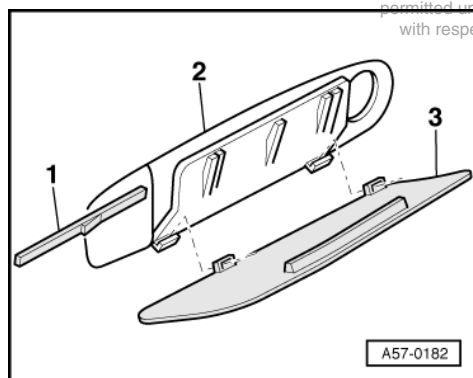
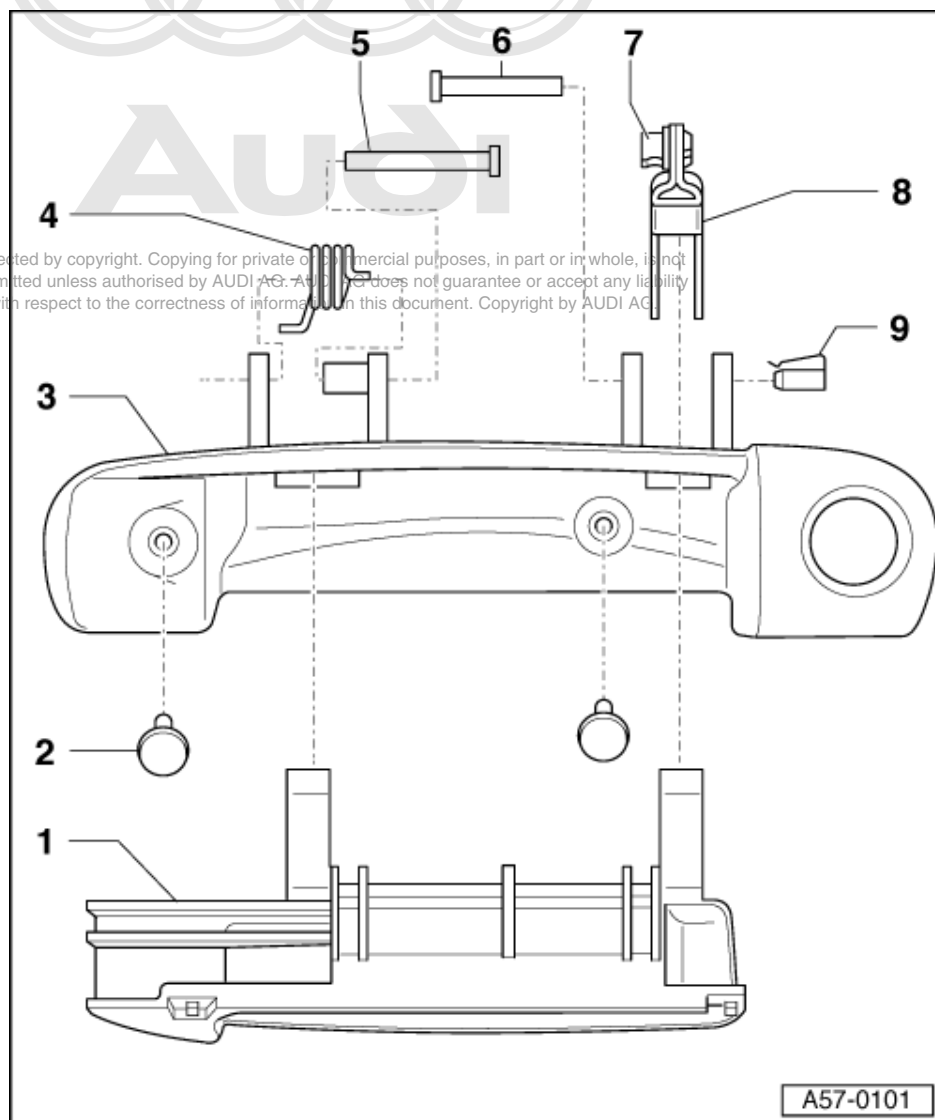


Fig.2 -> Removing cover

- To remove, pull up door handle -2- push out catch -1- in axial direction with small screwdriver and detach trim -3-.

1.12 - Front door handle pre-assembly



Note:

Replacement door handles must be painted and pre-assembled prior to installation.

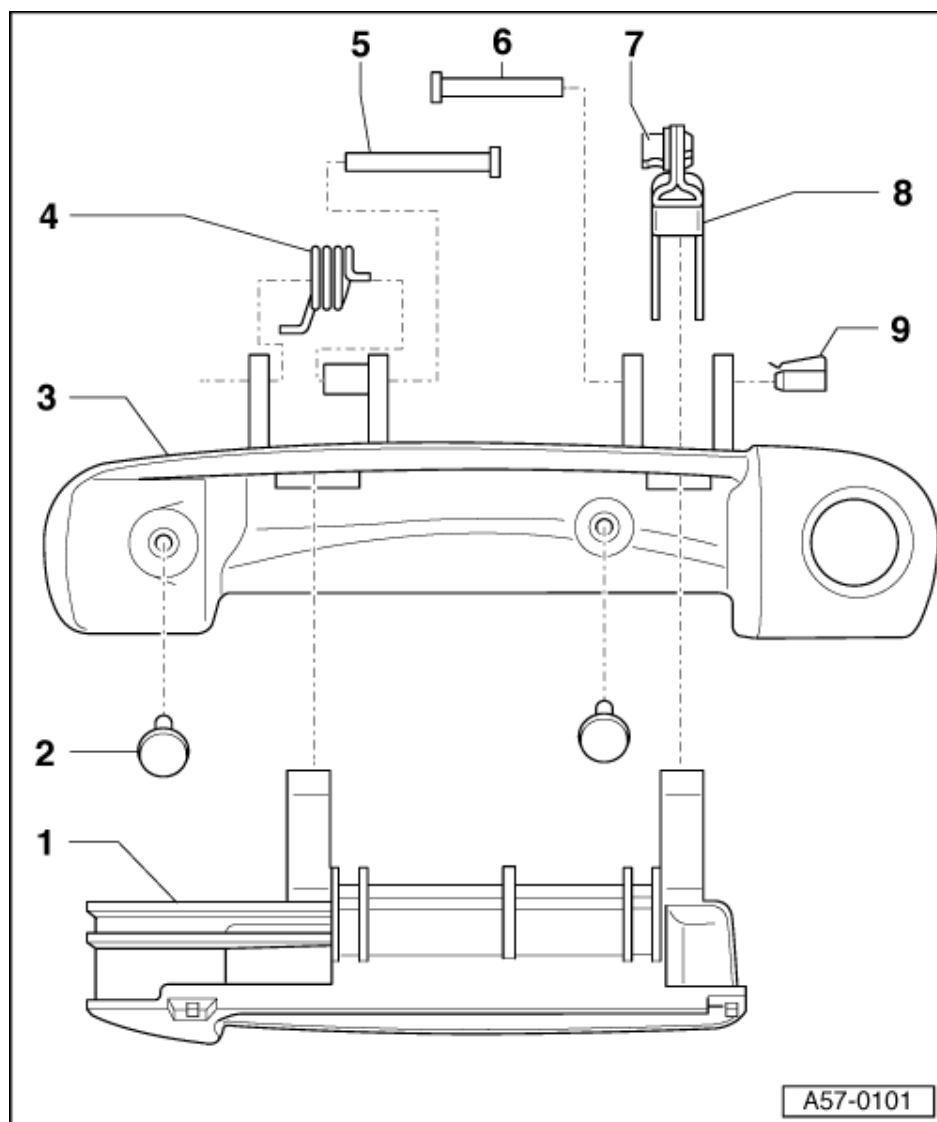
1 Door handle

- ◆ For assembly insert spring -4- in mount.
- ◆ For pre-assembly insert door handle in mount -3- and push on hinged lever -8-.
- ◆ Insert pivot pins -5- and -6- and caulk with centre punch as shown in Fig. 1.
- ◆ Insert spring -4- as shown in Fig. 2.

2 Buffer

- ◆ Insert after painting.

3 Door handle mount



4 Spring

- ◆ Installation position => Fig. 2.
- ◆ Lubricate spring with grease
Lubricate G 052 745 A3.

5 Pivot pin

- ◆ Note different lengths.
- ◆ Caulking => Fig. 1.

6 Pivot pin

- ◆ Note different lengths.
- ◆ Caulking => Fig. 1.

7 Clip

8 Hinged lever

9 Locking pin

- ◆ Assembly => Fig. 3.

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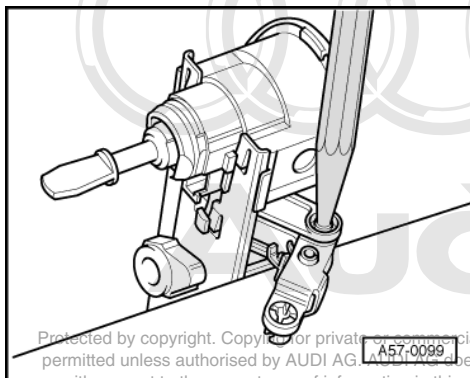


Fig.1 -> Caulking pivot pin

Note:

Before caulking pivot pins, protect painted surfaces with fabric-backed adhesive tape.

- Place pre-assembled door handle on a firm base (e.g. vice jaws).
- Secure pivot pins by tapping gently with a centre punch to stop them falling out.
- Check freedom of movement of hinged lever after caulking.

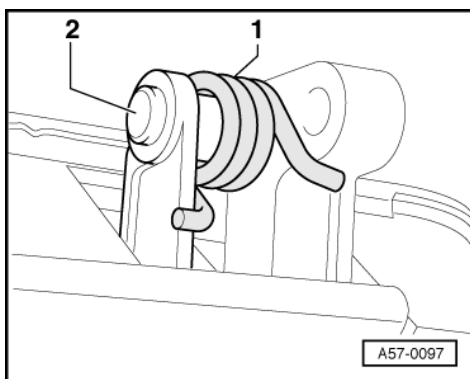


Fig.2 -> Installation position of spring

- Fit spring -1- as shown.
- Lubricate with G 052 745 A3.
- Pivot pin -2-

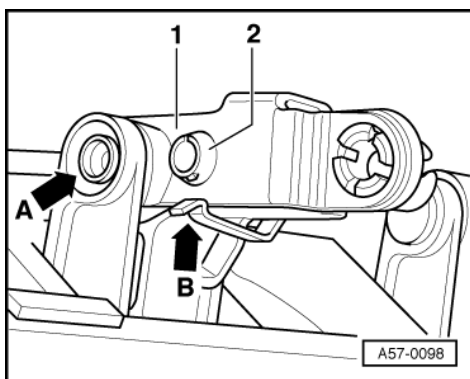


Fig.3 -> Installation of locking pin

- Use improvised tool to fully insert locking pin.
- Spring clip at locking pin, -arrow B- must engage behind hinged lever.

- Arrow -A- caulked pivot pin.

1.13 - Adjusting door

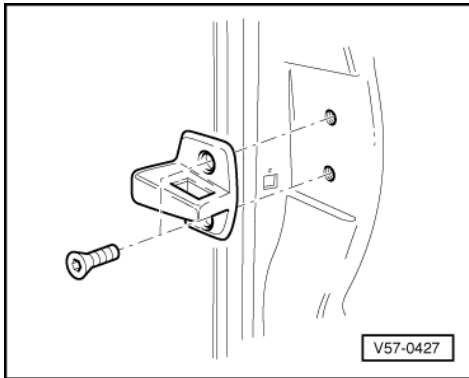


Fig.:1 Adjustment with striker

- -> Release bolts.
- Move striker until door shell is flush with body contour.
- Tighten bolts.
Tightening torque 20 Nm.

Note:

Adjust only towards centre of vehicle; do not adjust height.

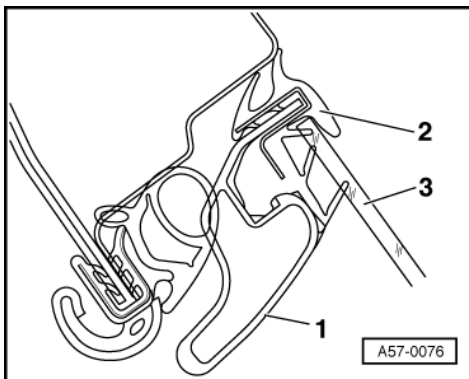


Fig.2 -> Adjusting door subframe

- Front door must be adjusted.
- Door trim removed.
- By moving adjuster at bottom of door adjust position of door subframe as shown =>Page 42 .
- Sealing lip -2- must fit into contours of pillar -A- and roof frame.
- In doing so subframe -1- must be slightly displaced towards centre of vehicle (rubber seal provides restoring force).
- Window -3-.

1.14 - Removing and installing window lifter motor

- Door trim and door sub-frame removed.

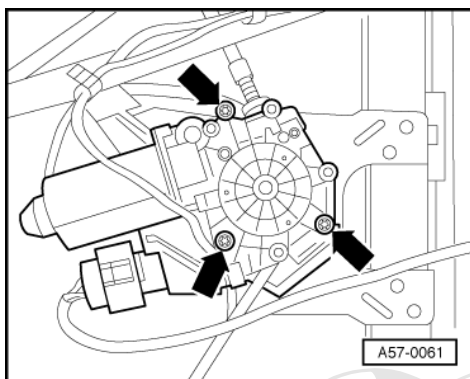
Note:

The window lifter motor can be installed or removed with the motor and door window in any position.

After installing the motor and wiring, first turn the ignition on and off.

Then run the door window up to the top position and hold the window lifter switch for about another 2 seconds.

The window lifter is now in the basic setting and the up/down function is activated.



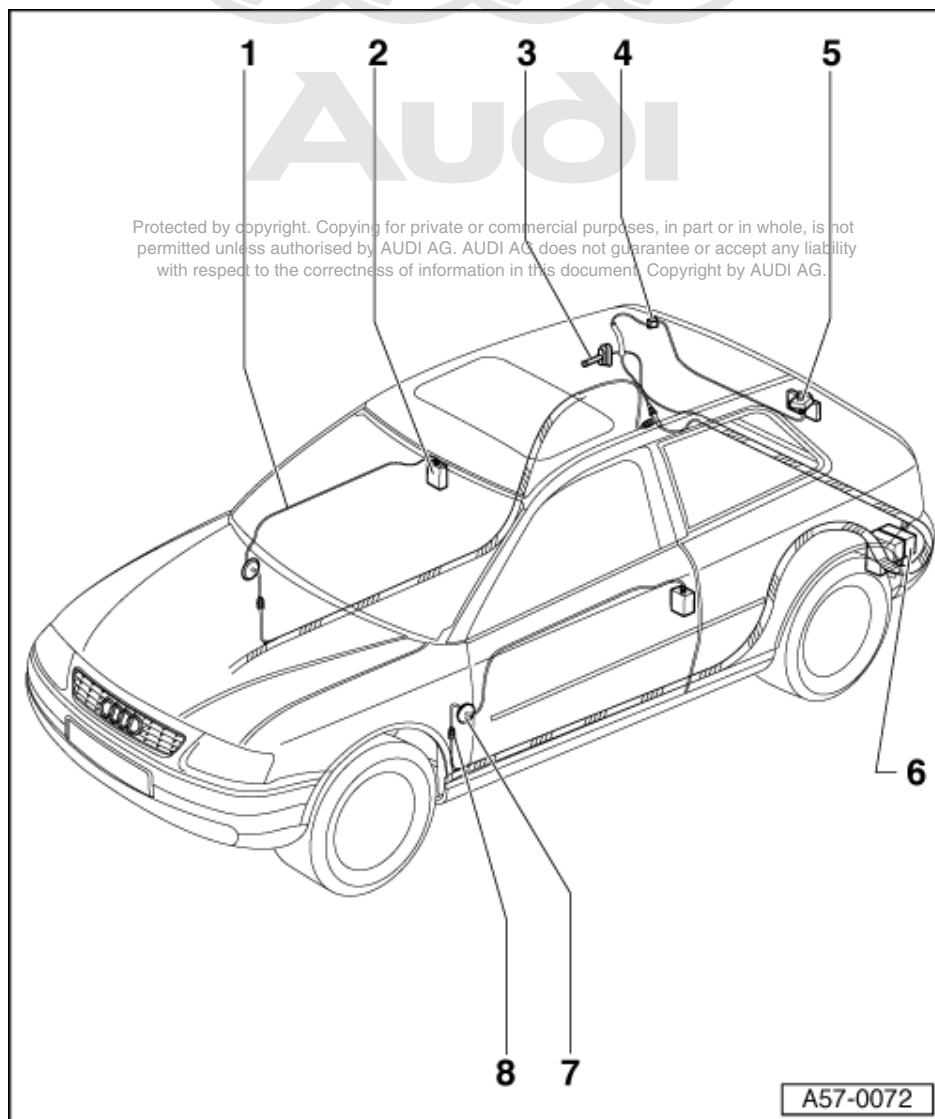
- -> Unscrew Torx bolts -arrows- (T30) and remove motor.
- Tightening torque 6.5 Nm.

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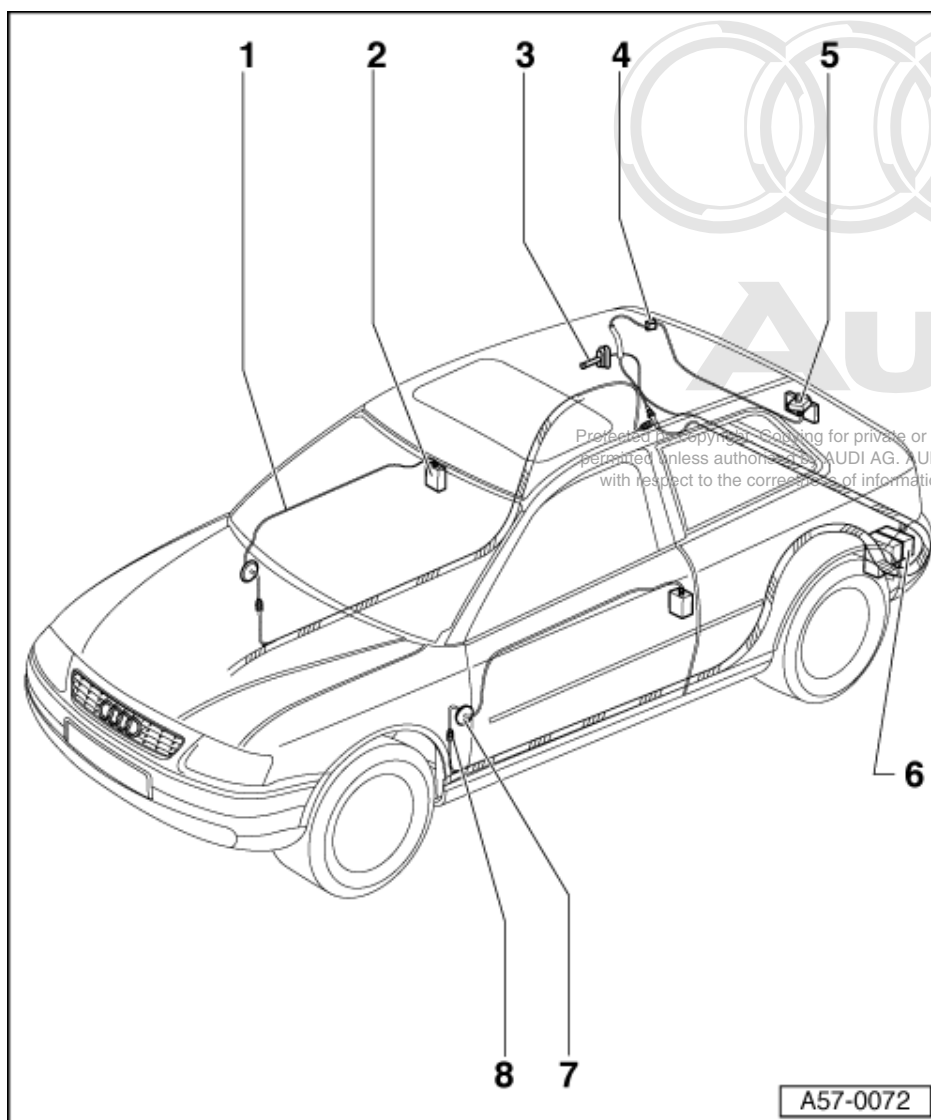
2 - Central locking, 3-door vehicles

2.1 - Central locking, 3-door vehicles



2.2 - Central locking - assembly overview (3-door vehicles)

- 1 **Pressure/vacuum line**
 - ♦ Line routing =>Page 76
- 2 **Front right door actuator**
 - ♦ Actuator is removed and installed together with the door lock => Page 51
- 3 **Actuator for fuel tank flap**
 - ♦ Removing and installing => Page 83
- 4 **Grommet**
 - ♦ Transition to tailgate.
- 5 **Tailgate actuator**
 - ♦ Removing and installing => Page 82



6 Central locking system pump

- ◆ Located behind left side panel in luggage compartment.
- ◆ Removing and installing => Page **83**

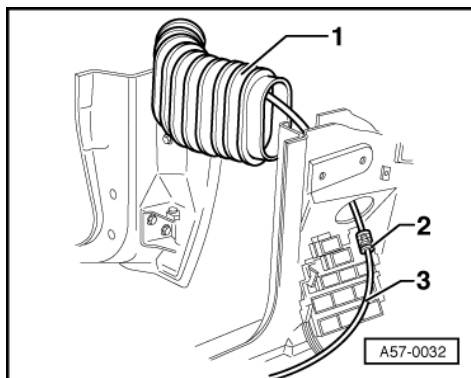
7 Grommet

8 Connector

- ◆ Detach connector => Page **81**

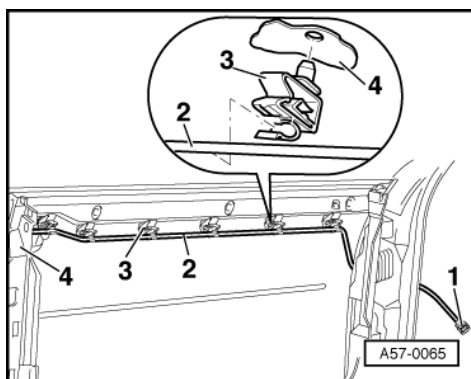


2.3 - -A- pillar connector



- -> Connector -2- at bottom of -A- pillar becomes accessible after removing lower -A- pillar trim.
- Line to central locking pump -3-.
- Bellows -1-

2.4 - Line routing

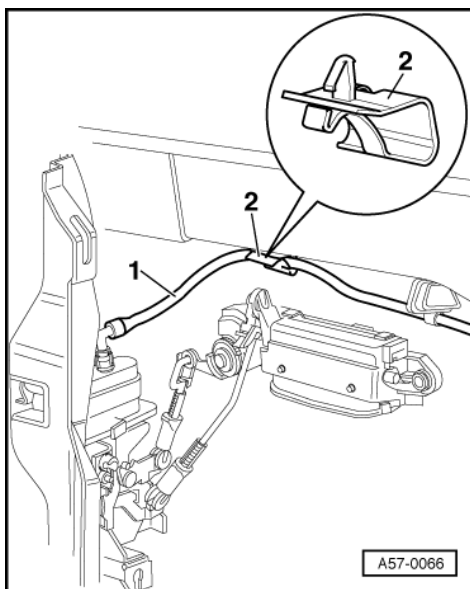


-> Front door

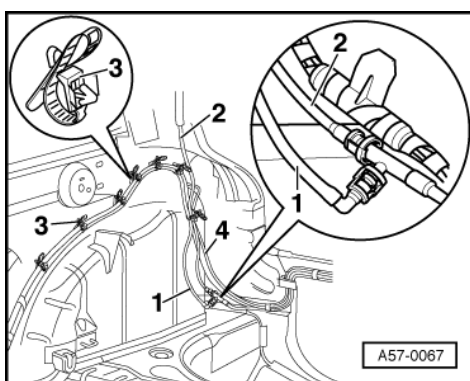
- Connector -1-
- Pressure/vacuum line -2- must engage into clip -3-.



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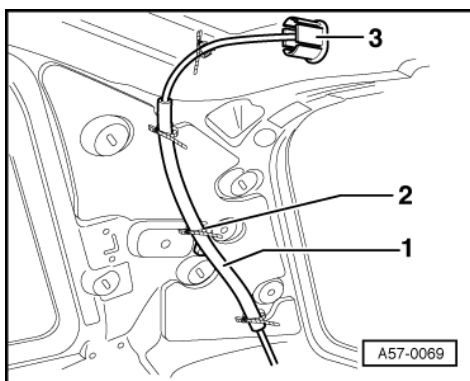


- -> Engage pressure/vacuum line -1- in clip -2-.
- Connector must engage in door lock actuator.



-> Luggage compartment

- Line -1- to right front door
- Line -2- to tailgate
- Clip -3-
- Line -4- to tank flap



-> Pillar -C-.

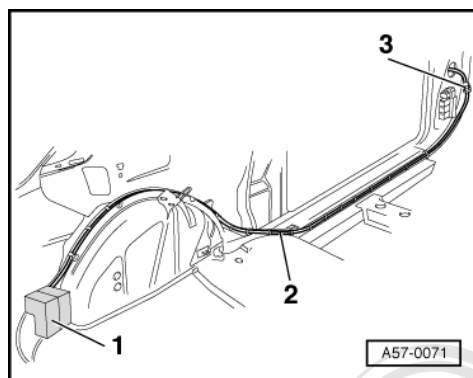
- Route pressure/vacuum line -1- into cable tie -2-.



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- Protective sleeve -3-



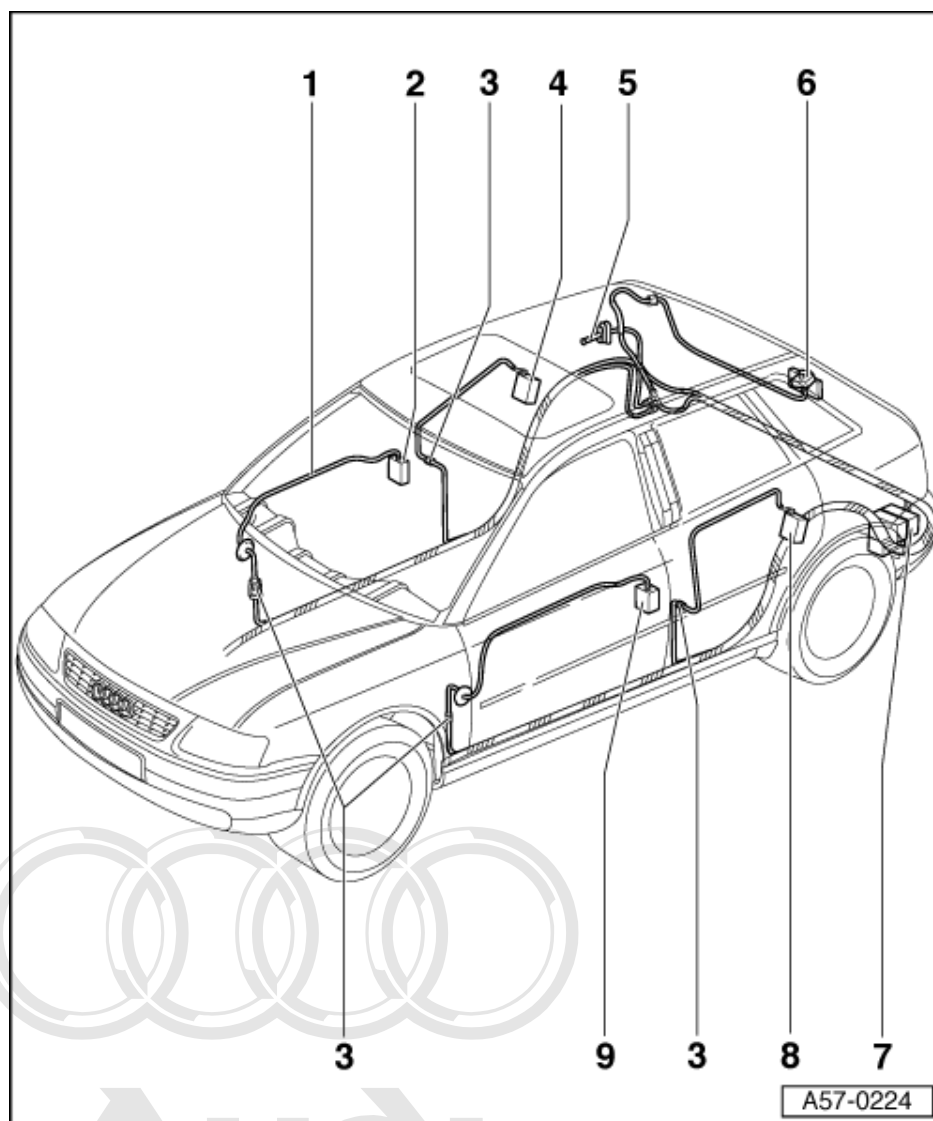
-> Passenger compartment.

- Central locking system pump -1-.
- Route pressure/vacuum line -2- as shown.
- -A- pillar connector

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3 - Central locking, 5-door vehicles

3.1 - Central locking, 5-door vehicles

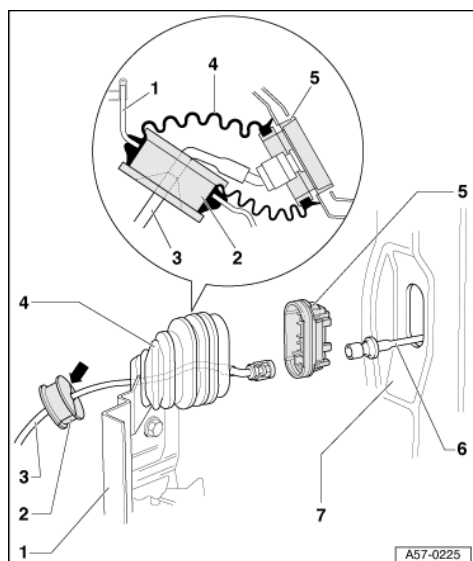


3.2 - Central locking - assembly overview (5-door vehicles)

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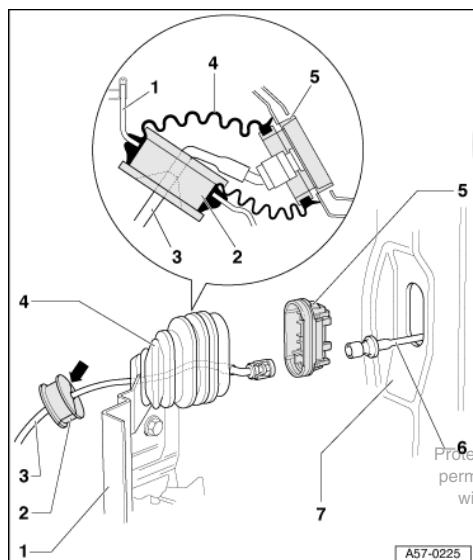
- 1 Pressure/vacuum line
- 2 Connectors.
- 3 Rear right door actuation valve.
 - ♦ Removing and installing => Page 89
- 4 Fuel flap actuator
- 5 Tailgate lock actuator.
- 6 Central locking system pump
- 7 Rear left door actuating valve.
 - ♦ Removing and installing as for right door.
- 8 Front left door actuator.

3.3 - Line routing



B-pillar connector

- 1 Rear door
- 2 Seal
 - ♦ Slit in seal must be horizontal when installing.
- 3 Pressure/vacuum line for rear door
 - ♦ Remove bellows from rear door or B-pillar.
 - ♦ Release the connector catch and detach wiring.
- 4 Bellows
 - ♦ Clip bellows into rear door or duct on B-pillar as shown.



- 5 Duct
 - ♦ Clipped into B-pillar
- 6 Pressure/vacuum line for passenger compartment
 - ♦ Routing => Fig. 1
- 7 B-pillar



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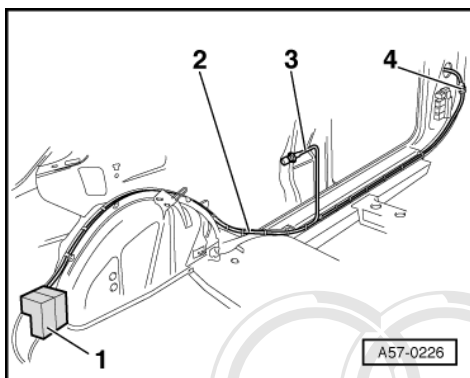


Fig.1 -> Passenger compartment

- Central locking system pump -1-
- Route pressure/vacuum line -2- as shown and secure with cable ties.
- Pressure/vacuum line for rear door.
- Routing of remaining wiring is identical to that for 3-door vehicles.

Servicing central locking system

- For further information refer to current flow diagram and fault finding.

Note:

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If the vehicle has not been used for a long period, or if the pump has been replaced, the central locking system has to be actuated several times before it will operate properly.

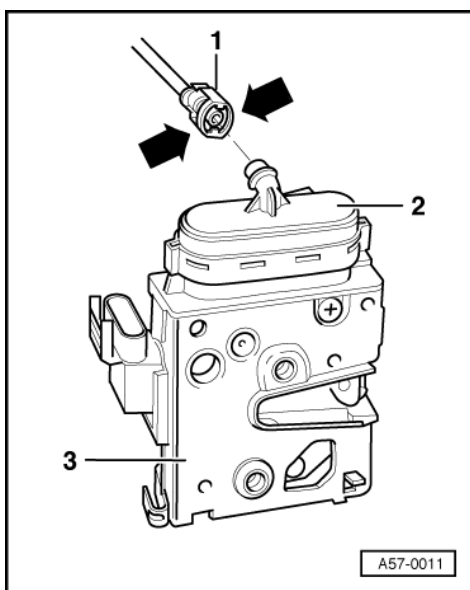
If the system is intact, all locks must be locked after approx. 2 seconds.

If the pump runs for more than 5 seconds, there is a leak in the system.

If the system is leaking, the pump must not run for more than 30 seconds before the control unit in the central locking system pump switches the pump off.

All actuators have special connectors, which should engage positively when fitted.

3.4 - Detaching connector





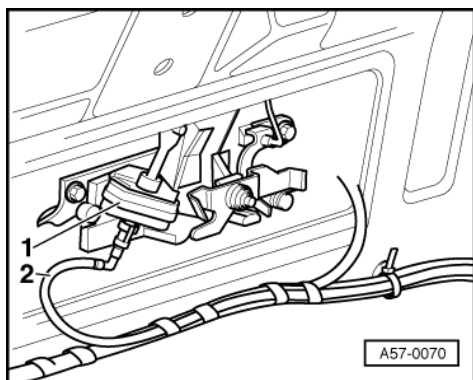
Note:

Do not simply unplug the connectors from the actuators. The catches must be released first.

- -> Press connector together at arrows to release catch.
- Detach connector.

3.5 - Repairing damaged line

- Cut off damaged section with a knife.
- Cut connecting hose, e.g. part no. 533 862 225 to appropriate length and slip over vacuum line.



-> Tailgate

- Route pressure/vacuum line -2- as shown.
- Engage elbow connector in actuator.

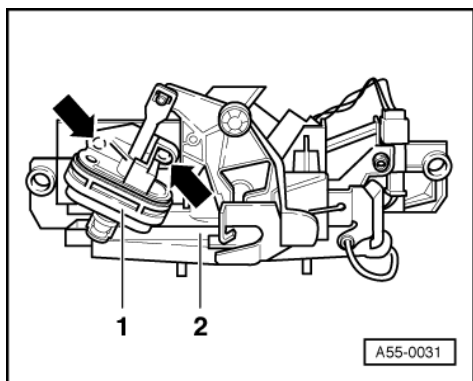


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3.6 - Removing and installing tailgate actuator

- Removing tailgate interior trims

=> General Body Assembly, Interior; Repair group 70

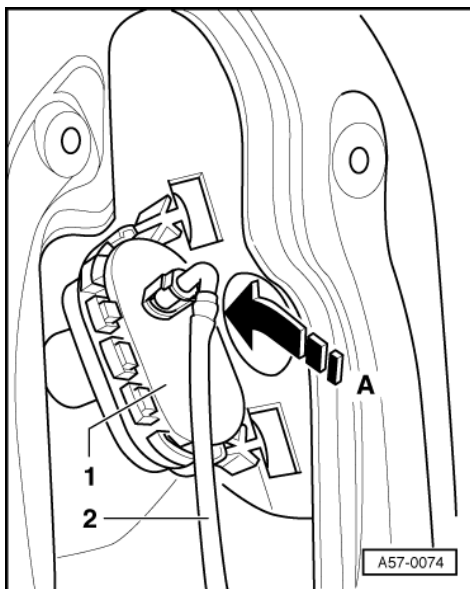


- -> Push through clamping pins -arrow- and detach actuator -1- from lock -2-.
- On installation, securing pins must be pressed back into expanding clips.
- Lever out with screwdriver if necessary.

Note:

The illustration shows the component already removed.

3.7 - Removing and installing actuator for fuel tank flap

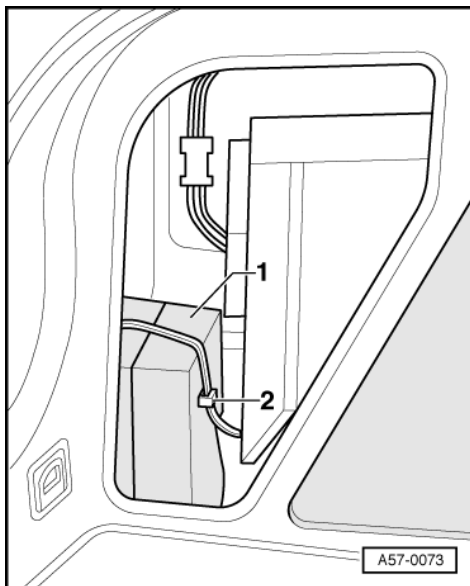


- Remove tail light

=> Electrical System; Repair group 94; Servicing tail light Servicing tail light

- Detach connector => Page 81 .
- -> Release catch on back of actuator -1- via aperture -arrow A- and remove actuator.
- When installing, actuator should engage audibly.
- Engage elbow connector in actuator.

3.8 - Removing and installing pump for central locking system



- Remove storage compartment in left side trim.
- -> Release cable ties -2-, open noise insulation -1-, disconnect electrical and pneumatic connectors, and remove pump for central locking system.



Audi A3 1997 ➤

General Body Assembly Exterior (Repair groups 50, 55, 57, 58, 60, 63, 64, 66) -

Audi Edition 09.1996

Important

Once all three connectors have been detached from the central locking system pump make sure that the centre 6-pin connector for the power supply is always re-attached as the last of the three connectors.

- When installing the central locking pump, ensure that the pneumatic connectors engage properly.



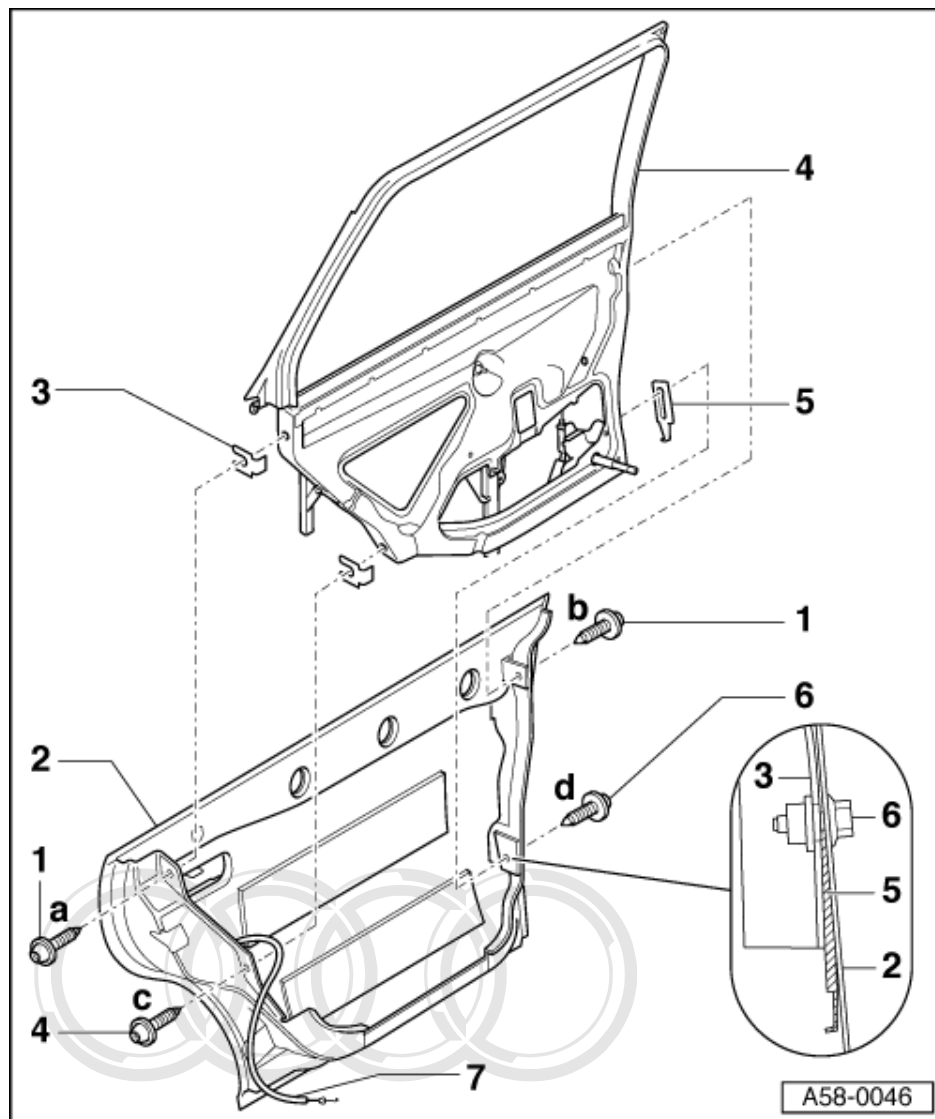
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58 - Rear doors/Door components

1 - Rear door

1.1 - Rear door



1.2 - Removing and installing rear door and door subframe

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◆ 30 Nm

2 Rear door

3 Shim plate

◆ Install as required.

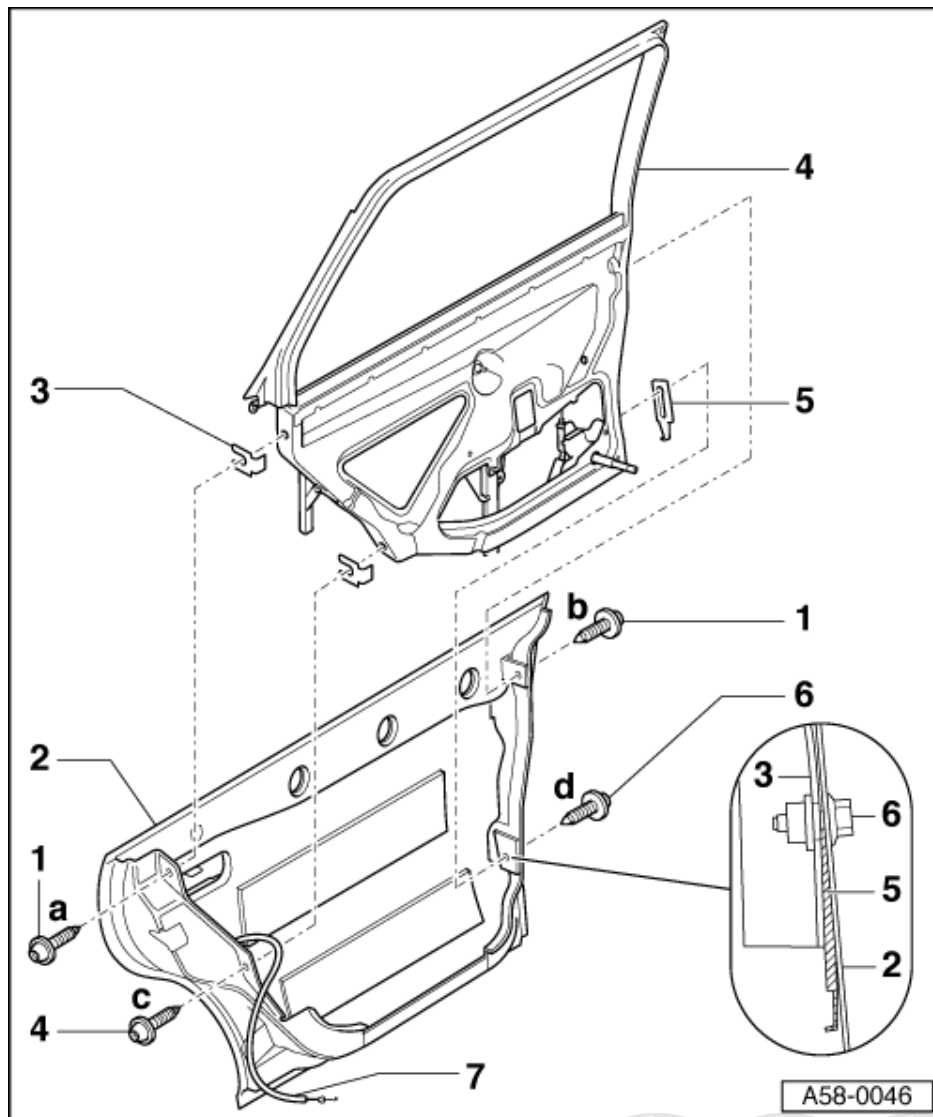
◆ Note the number and thickness of the bases before installation and install the same bases in the same places.

4 Door subframe

◆ Removal:

- Removing door trim.

=> General Body Assembly, Interior; Repair group 70



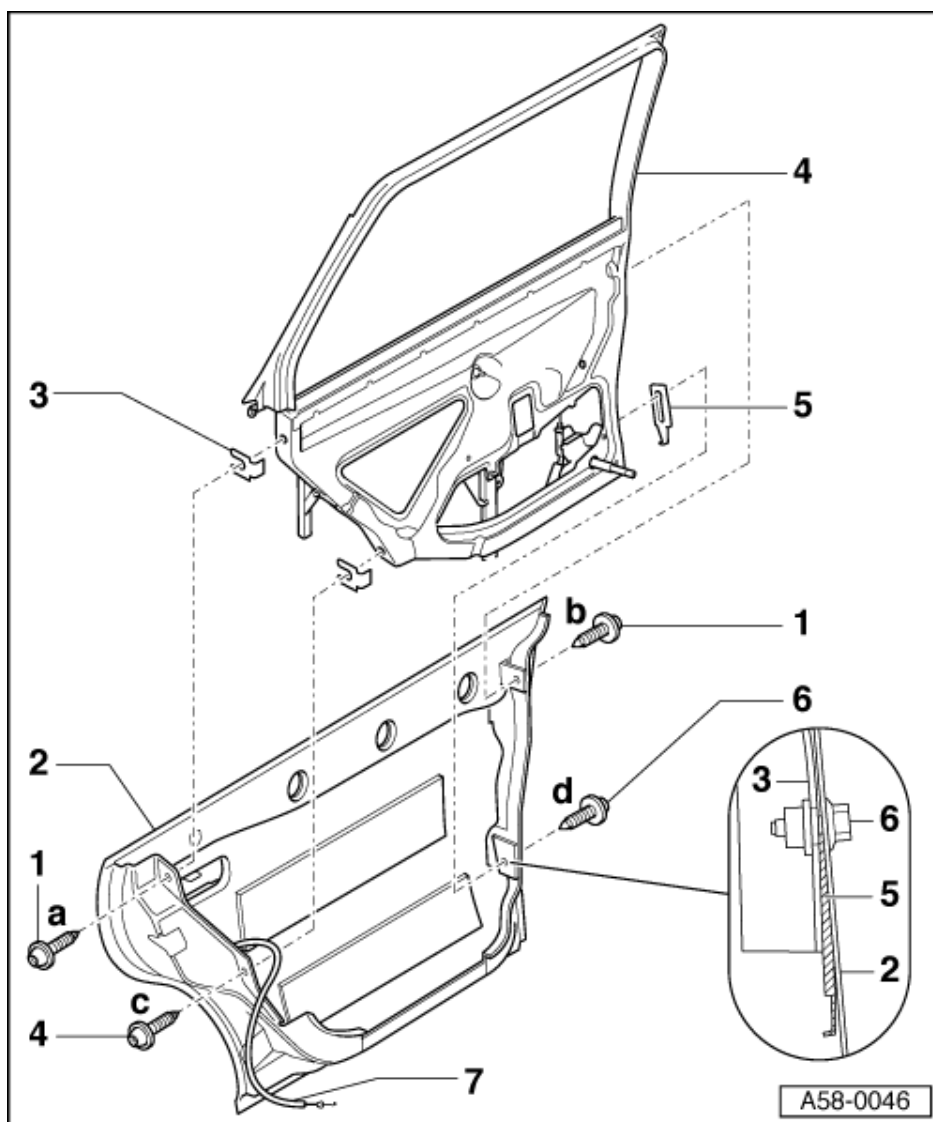
- Remove bolts -1- and -5-.
- Lift out door subframe.
- Detach Bowden cable for door locking => Page 89.
- Disengage bellows at B-pillar and disconnect electrical wiring and pneumatic lines.
- ◆ Installation:

Note:

Door shell -2- must already be adjusted =>Page 104.

- Install in reverse order.
- Insert door subframe in door shell and screw on loosely with bolts -1- and -5- with adjusting wedge -4-.
- Bolts -1- and -5- must be tightened in sequence a; b; c; d.
- ◆ Adjusting:
- Adjusting =>Page 105.

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5 Adjuster wedge

Note:

Adjuster wedge must always be fitted.

- ♦ Angle of door can be adjusted in C-pillar area by shifting adjuster wedge -4- =>Page 105 .

6 Bolt (2x)

- ♦ Tightening torque 30 Nm.

7 Bowden cable

- ♦ Inserting in door lock => Page 89 .

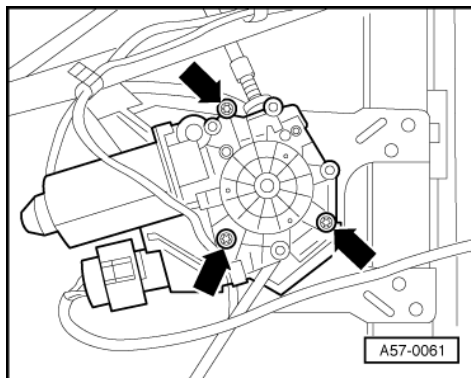
1.3 - Removing and installing window lifter motor

- Door trim and door sub-frame removed.

Note:

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The window lifter motor can be installed or removed with the motor and door window in any position.



- ➔ Unscrew Torx bolts -arrows- (T30) and remove motor.
- Tightening torque 6.5 Nm.

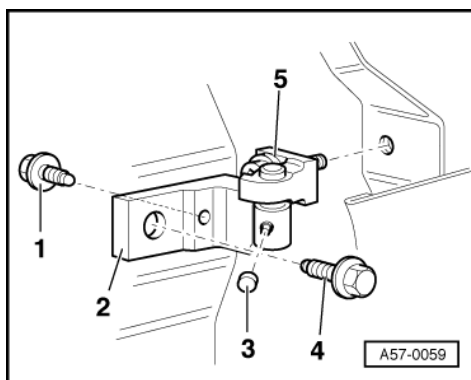


Fig.1-➔ Upper door hinge.

- Hexagon bolt (fitted from inside of vehicle) 30 Nm.
- Upper door hinge.
- Cap for hexagon bolt (23 Nm).
- Hexagon bolt -4- 30 Nm.
- Torx bolt (T45) 30 Nm.

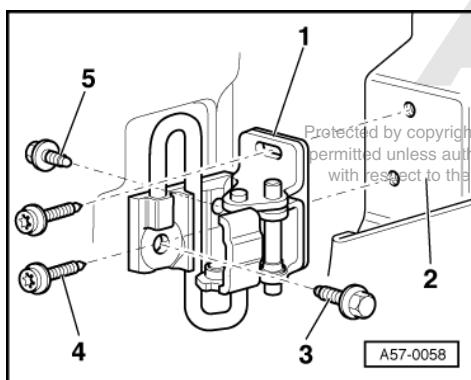
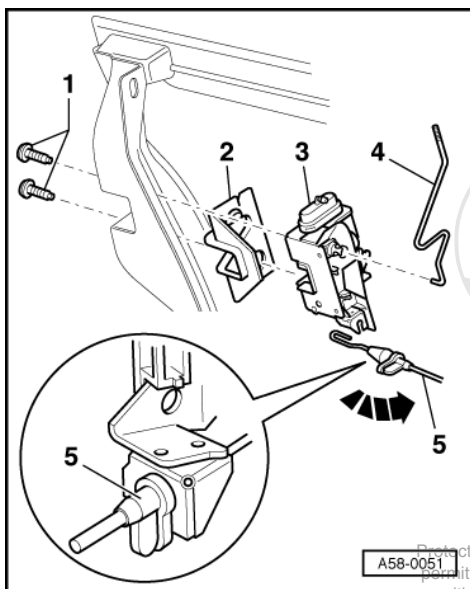


Fig.2-➔ Lower door hinge.

- Lower door hinge -1-.
- Front door -2-.
- Hexagon bolt -3- 30 Nm.
- Torx bolt -4- 30 Nm.
- Hexagon bolt -5- 30 Nm.



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Fig.3 -> Removing and installing door lock

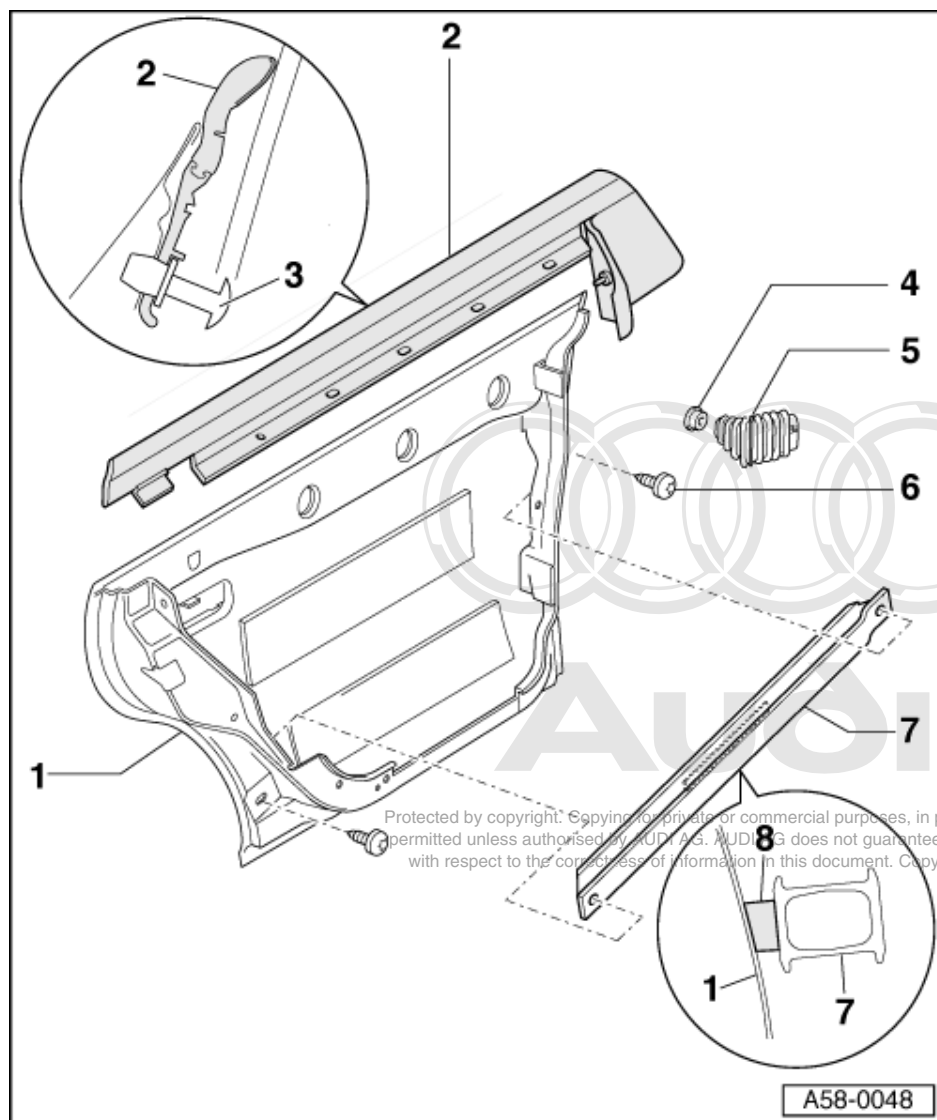
- Rear door trim removed.
- Remove door subframe =>Page 85
- Unclip pipe for central locking system.
- Unclip operating rods -4-.
- Unscrew bolts -1- and remove lock -3- with base -2- inwards.
- Remove Bowden cable -5- as follows:
- Turn Bowden cable 90° and remove from door lock turning downwards.

Note:

The Bowden cable is shown released in the illustration section.

- To install, insert in door lock as shown in illustration section and then lock by turning 90°.

1.4 - Removing and installing door components



1 Rear door

2 Window slot strip

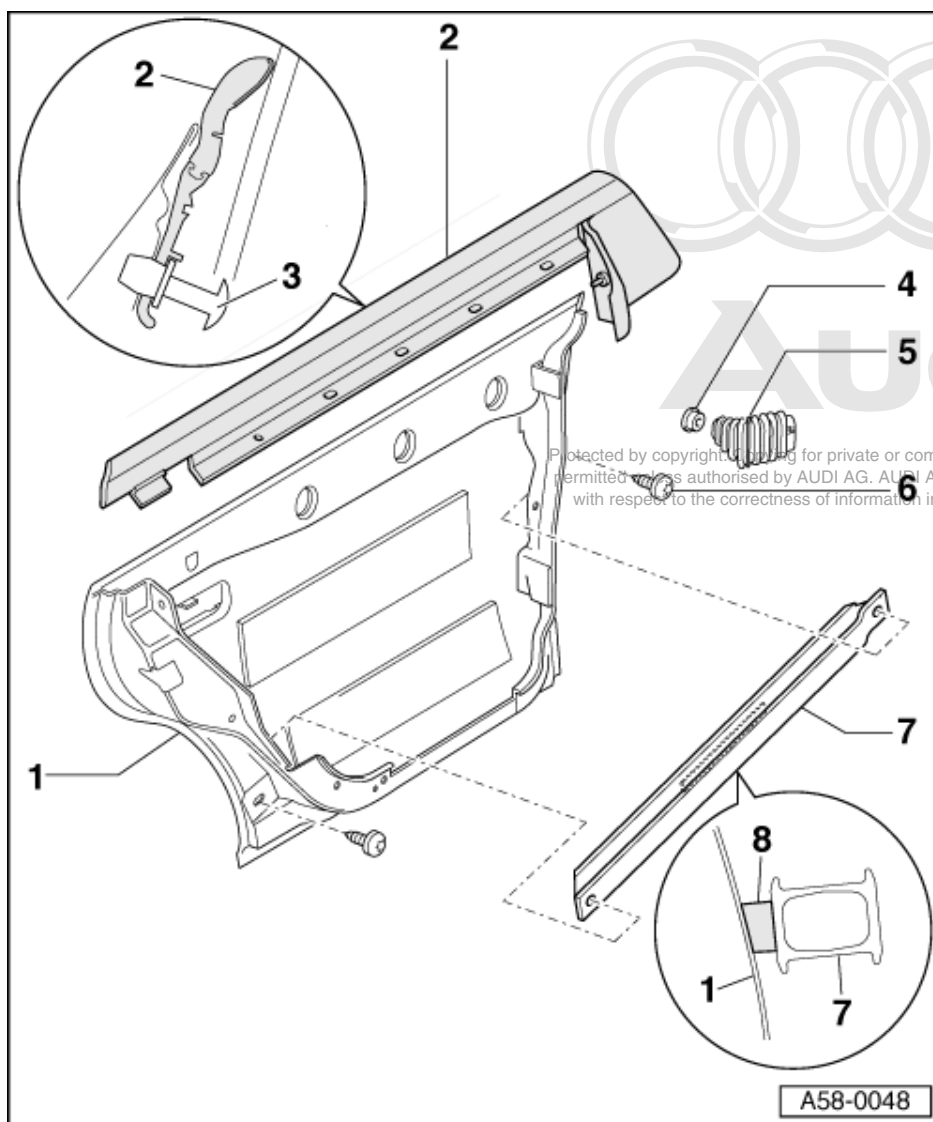
- ♦ Trim for rear door and door subframe removed.
- To remove, remove clip -3- from sleeve.
- Unclip window slot strip in -B- pillar area from rear door and detach.

3 Clip

- ♦ 5x

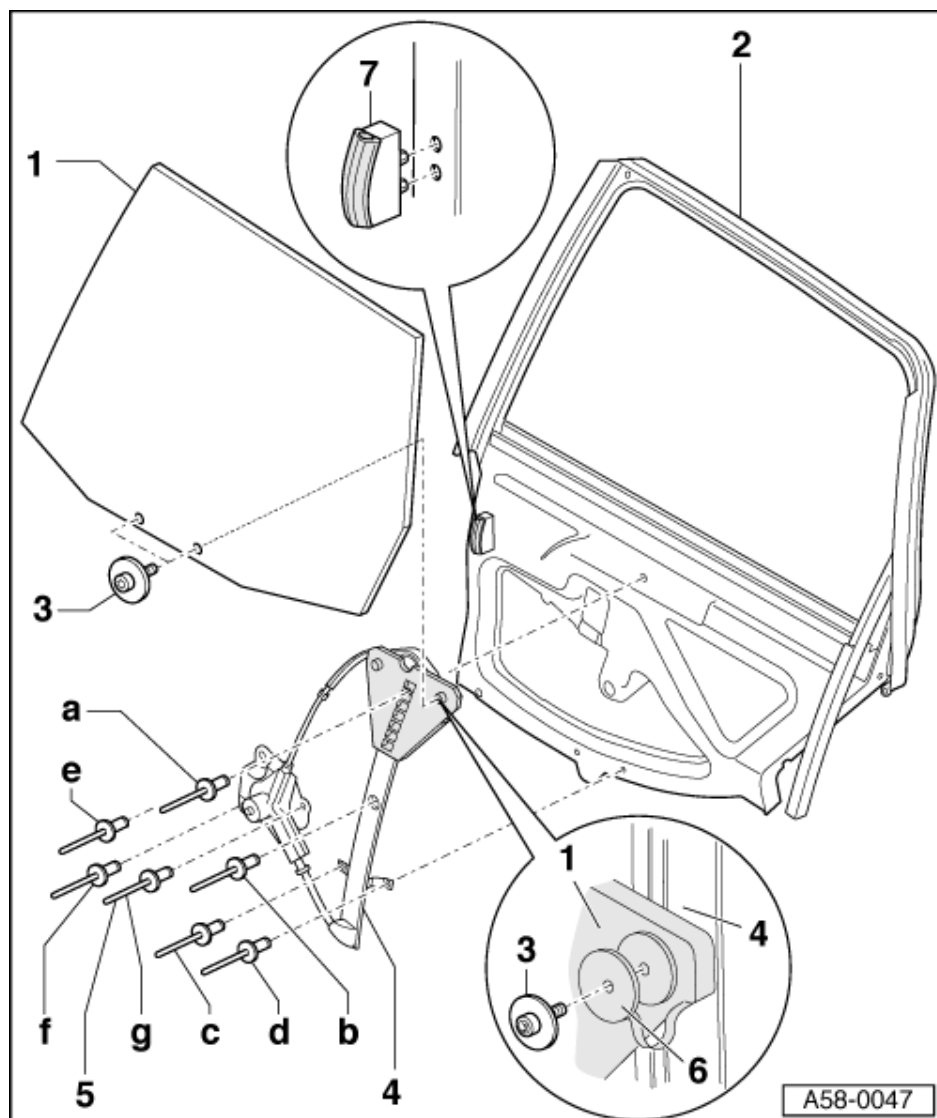
4 Seal

- ♦ Once wiring has been installed, insert into bellows from inside of door.



- 5 Bellows**
- ♦ Use soap solution as lubricant for easier installation.
- 6 Torx bolt**
- ♦ 8 Nm
- 7 Side impact protection**
- 8 Foam strips**
- ♦ Self-adhesive

1.5 - Removing and installing window lifter and door window from/to door subframe



1 Door window

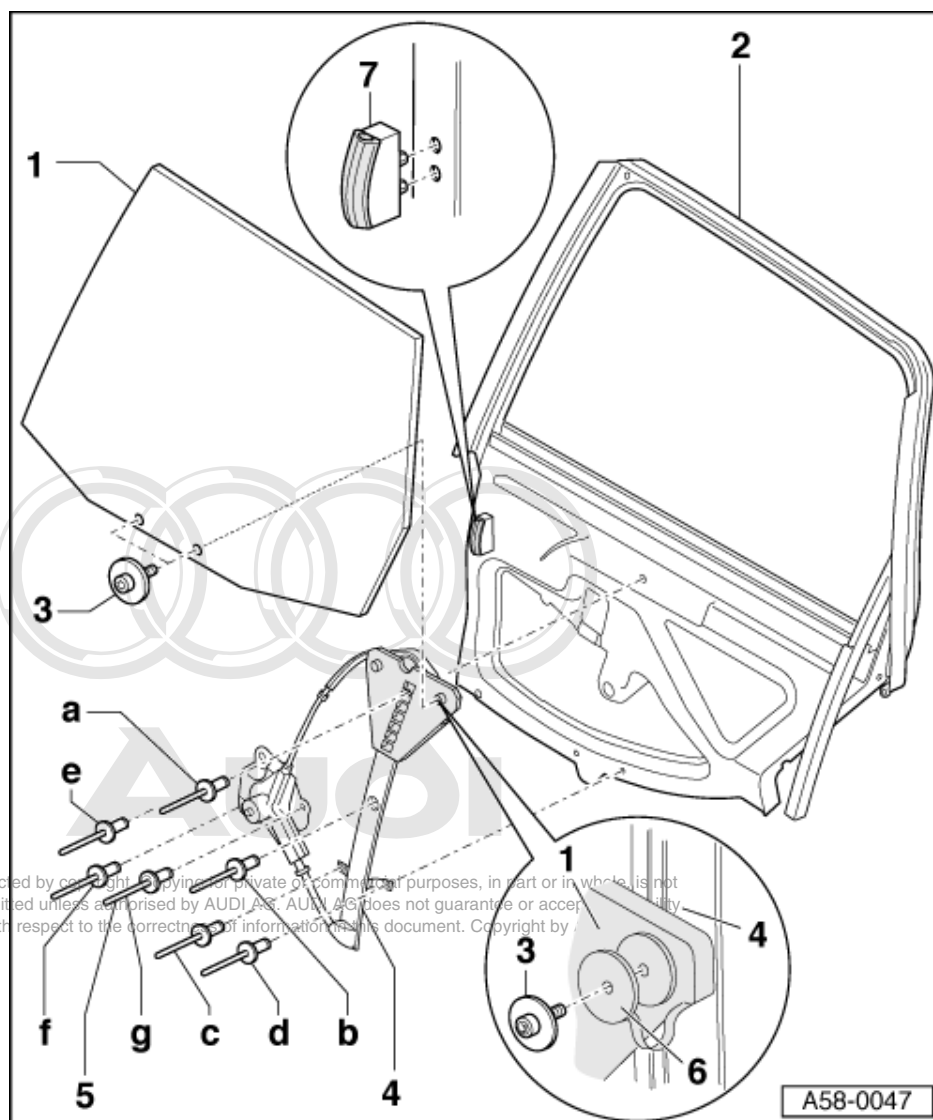
- ◆ Removing:
 - Remove door subframe -2-.
 - Lower window lifter -4- fully.
 - Unscrew bolts -3-.
 - Unclip window -6- and pull door window downwards out of guides.
- ◆ Installation:
 - Insert window into guides from below.
 - Clip in clip -3-.
 - Adjusting =>Page 95 .

2 Door subframe

- ◆ Removing and installing => Page 85



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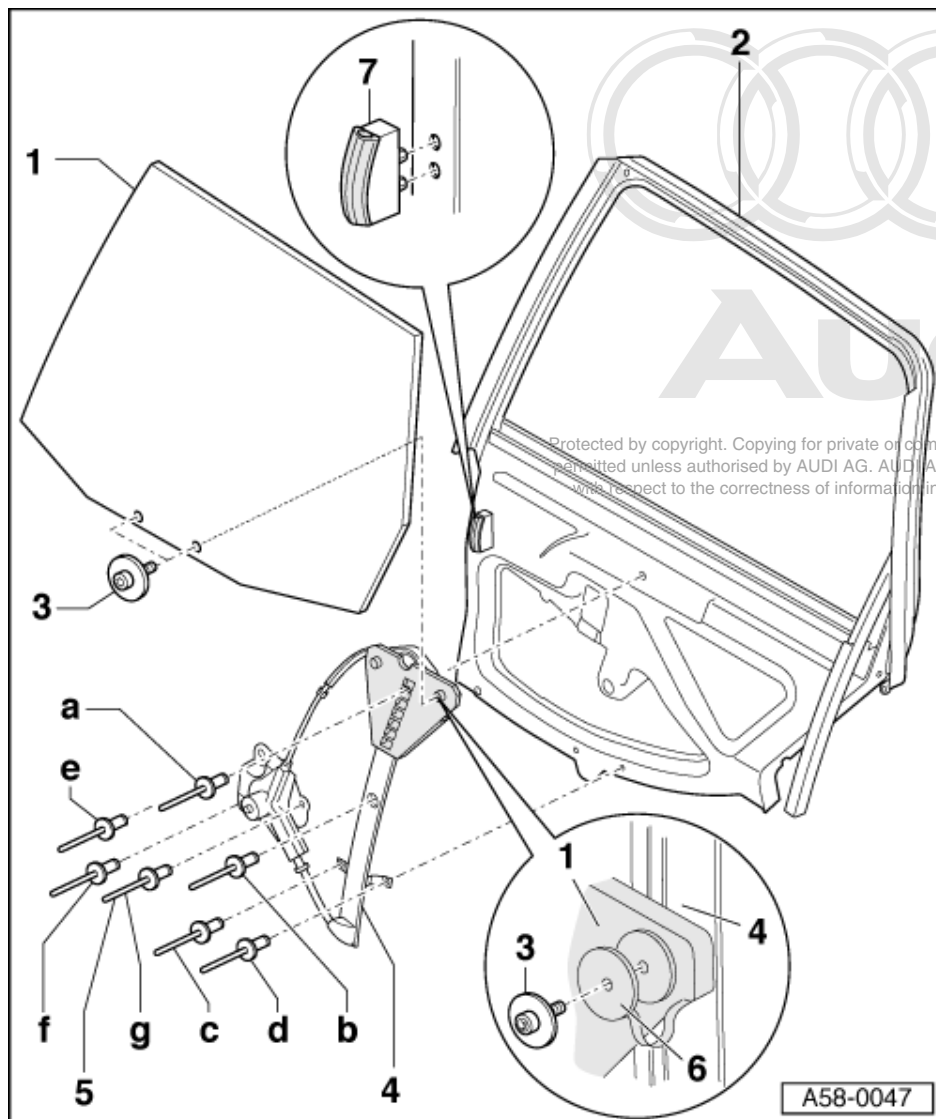


3 Bolt (2x)

- ◆ Tightening torque 4 Nm.

4 Window lifter

- ◆ Removal:
 - Remove door subframe -1-.
 - Unscrew bolts -3-.
 - Unclip and take out window.
 - Drill out rivets -5-
 - Take out window lifter.
- ◆ Installation:
 - Install in reverse order.
 - ◆ Observe the sequence for riveting to avoid straining the window lifter.



5 Rivets

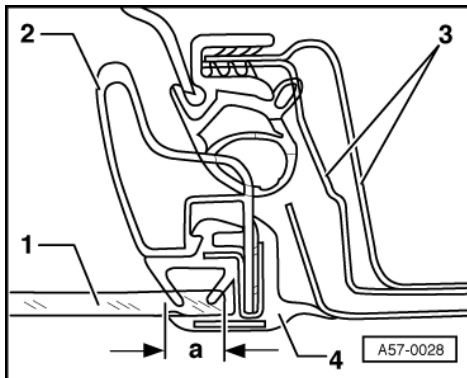
- ◆ Observe riveting sequence.
- Rivet in sequence a; b; c; d; -e- and -f-.
- Fit using V.A.G 1753 B.

6 Clamping washer

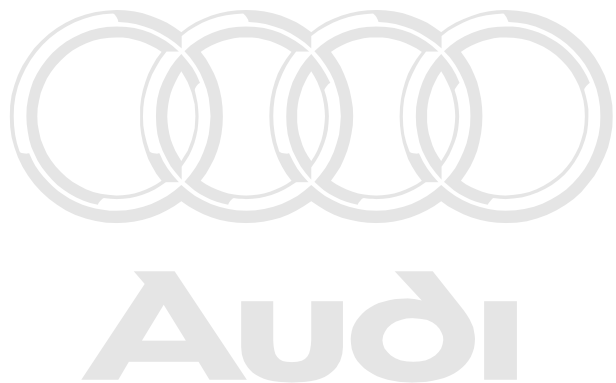
- ◆ Is supplied together with window lifter.

7 Buffer

1.6 - Adjusting rear window

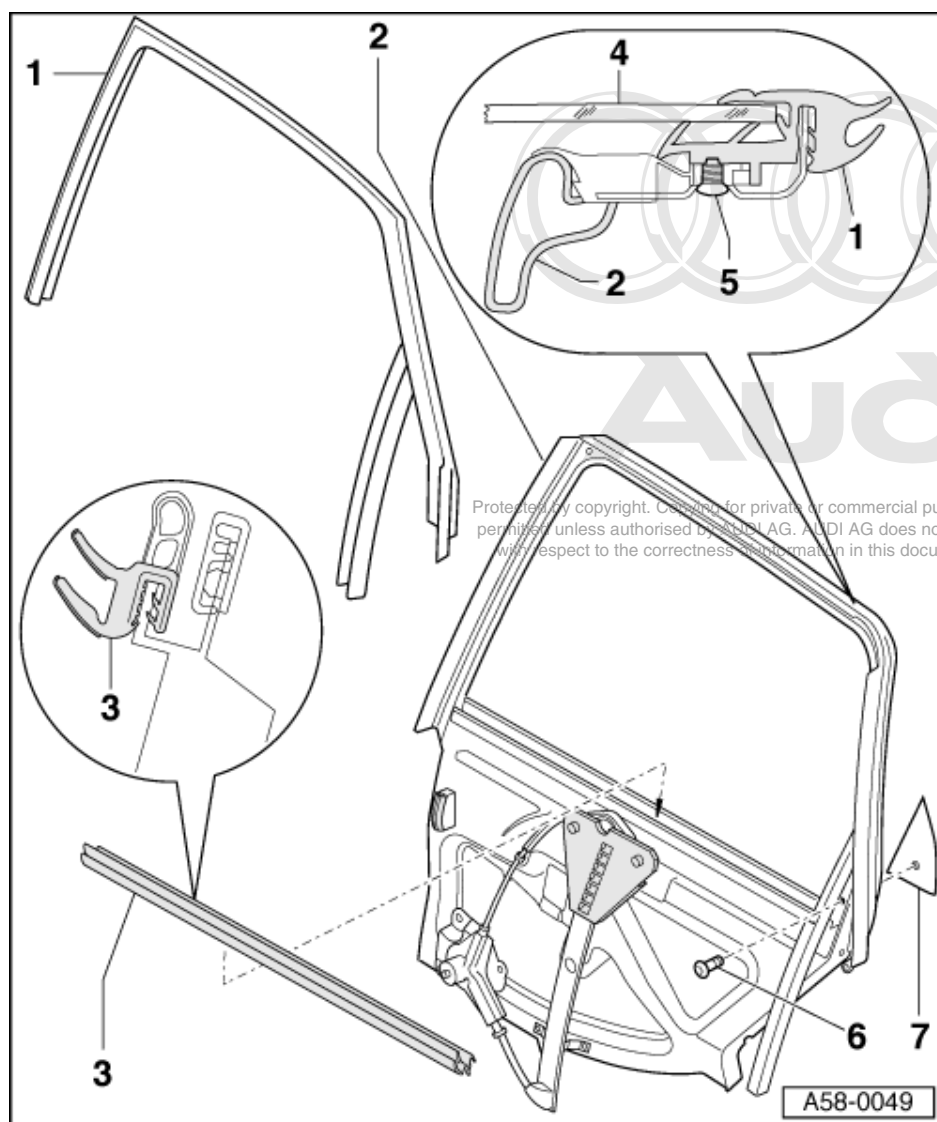


- -> Insert door window in window lifter.
- Raise window until shortly before stop.
- Window -1- and seal -4- for door subframe must run parallel in roof and C-pillar area.
- Press window -1- towards B-pillar -3-.
- Raise window -1- as far as it will go.
- Tighten bolts on window lifter mount.
Tightening torque 2.5 Nm.



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1.7 - Removing and installing rear window seal



- ◆ Remove door trim

=> General Body Assembly, Interior; Repair group 70

- ◆ Door subframe
- Removing and installing => Page 85
- ◆ Door window
- Removing and installing =>Page 92 .

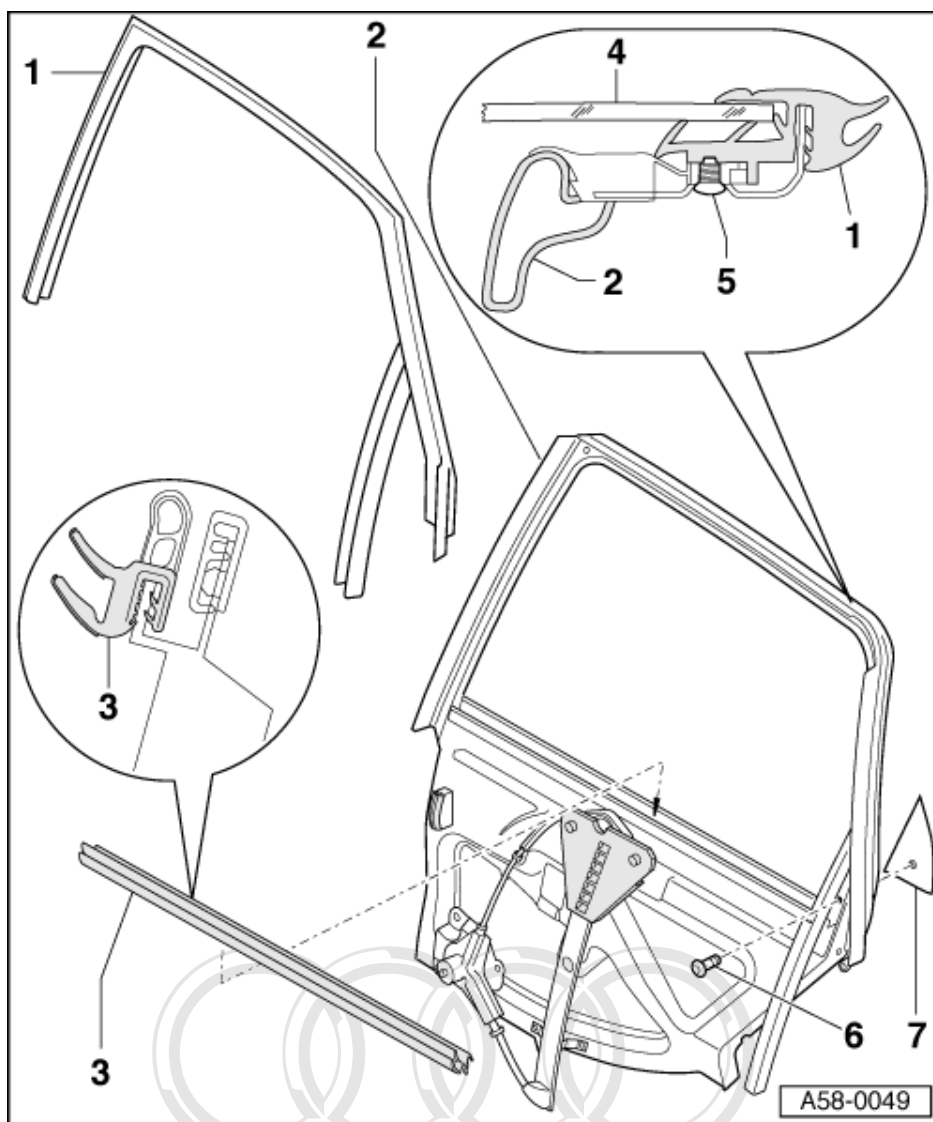
1 Door window seal

Removal:

- Unscrew cross head bolt -6- and detach cover -7-.
- Unscrew cross head bolt -5-
- Detach door window seal from guides.

Note:

Always replace window seal -1- as dismantling stretches fastening strip.



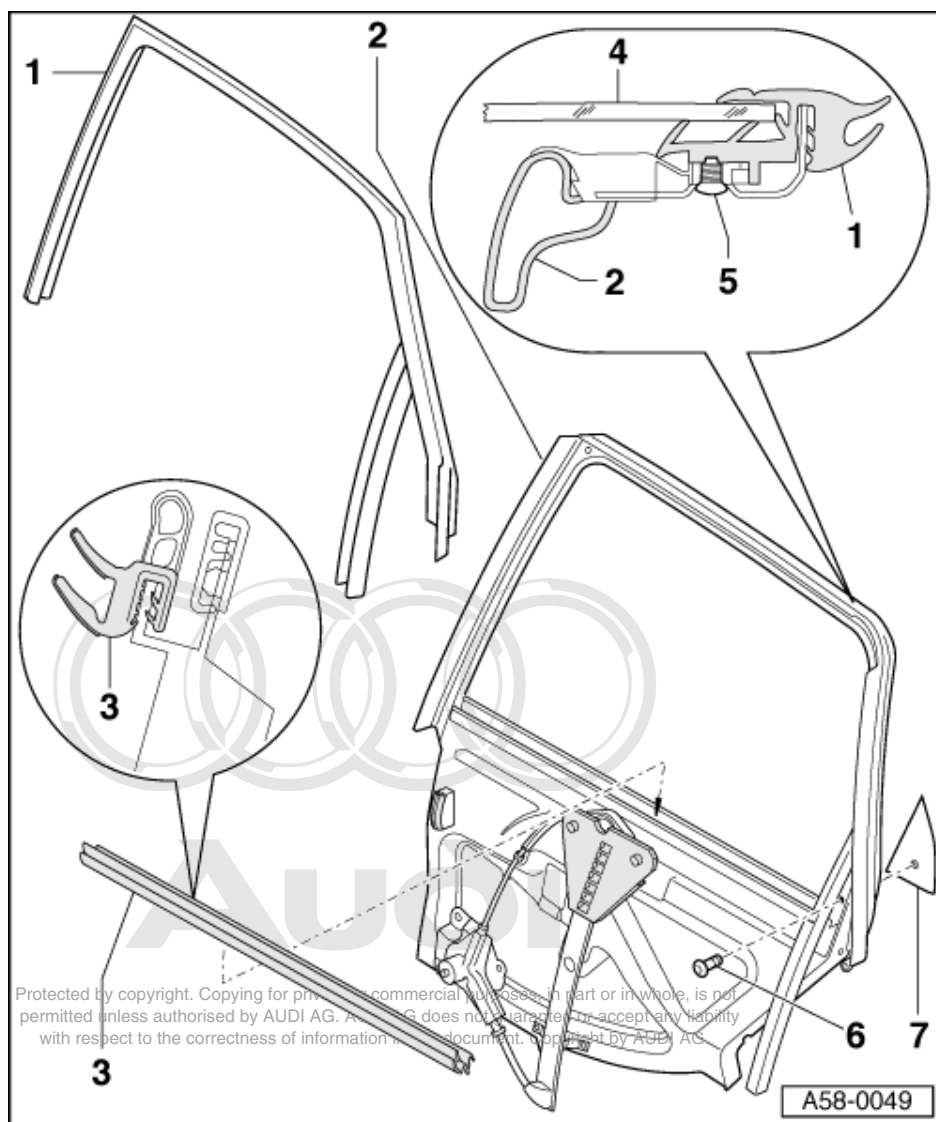
Installation:

- Coat the door window seal -1- and guides on door subframe -2- with soapy water.
- Attach window seal -1- at bevelled corners and press on by hand.
- Install window -4-
- With window closed, gently roll door seal -1- with, e.g. wallpaper roller.

Note:

Window guide -1- must not be driven into position, as this could lead to buckling and subsequent damage.

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2 Door subframe

3 Slot seal

- ♦ To remove, detach upwards or press on when installing.

4 Door window

5 Panel

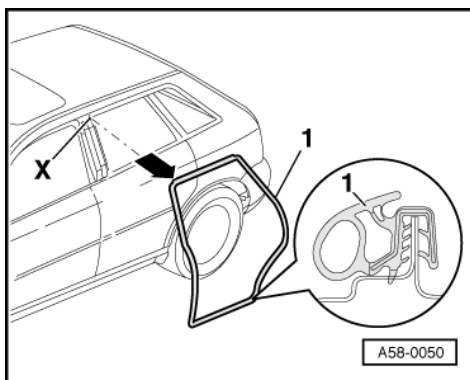
- Unclip trim from inside.
- To remove, unscrew bolt -6- and detach trim.

6 Torx bolt

- ♦ 5 Nm

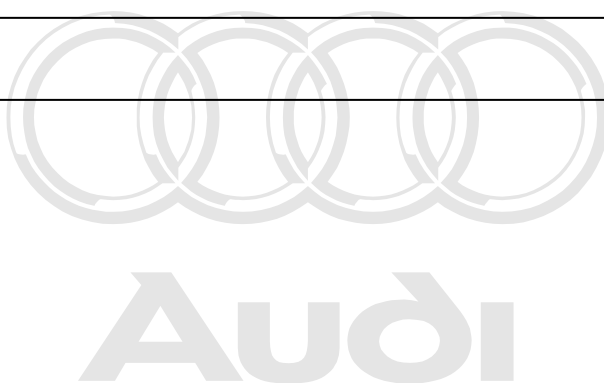
1.8 - Removing and installing inner door seal

- Upper B-pillar trim removed.
- C/D-pillar trim removed.
- Sill panel trim removed.
- To remove, detach door seal from door flange.



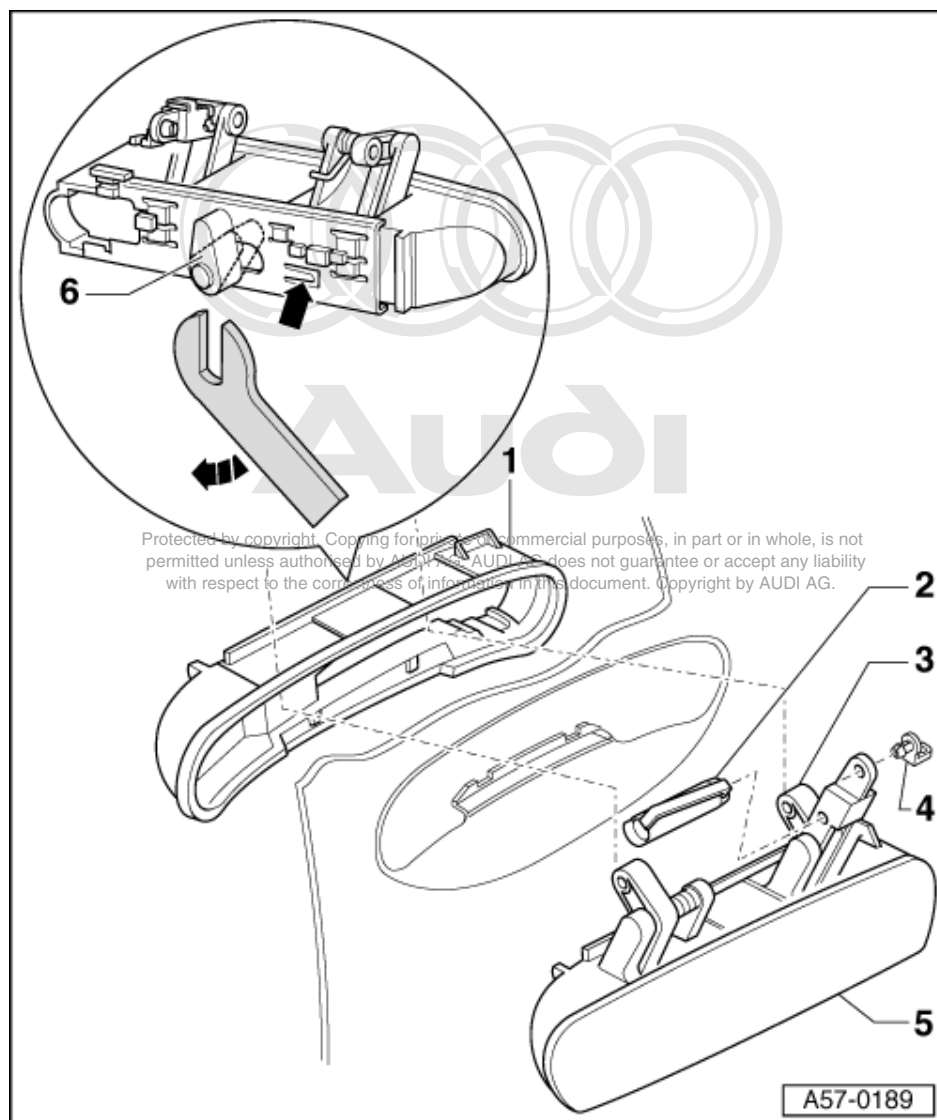
- -> When installing, the end of the lip -arrow- must be positioned on the mark -X- in the rear quarter panel frame flange.
- Press the door seal onto the flange along its entire length.

Important
Door seal must not be attached with force.



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1.9 - Removing and installing rear door handle



1 Door handle mount

- ♦ Remove door handle by releasing with open-ended wrench.

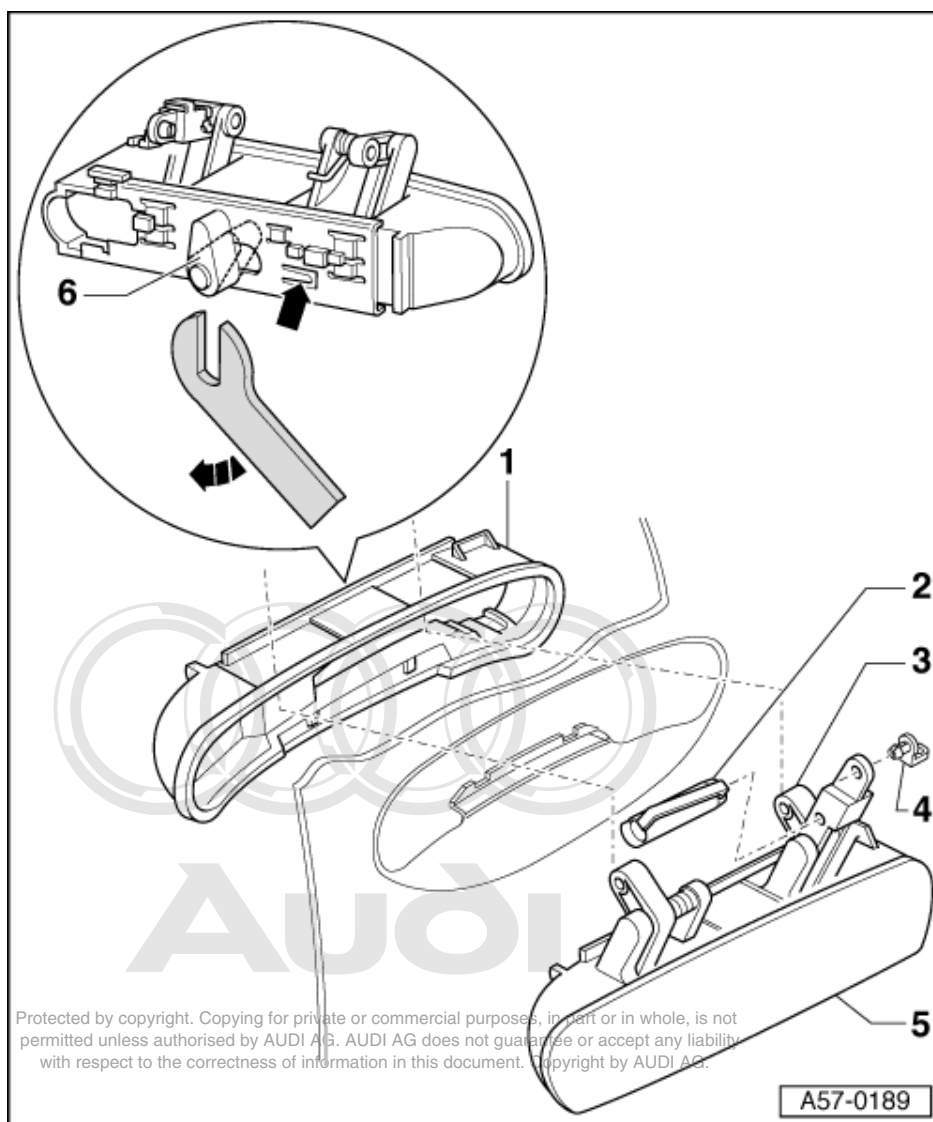
2 Locking pin

- ♦ Hinged lever must fully engage in spring catch when installing.

3 Hinged lever

4 Clip

- ♦ Unclip operating rod for door lock here when removing door handle -5- =>Page 102 .



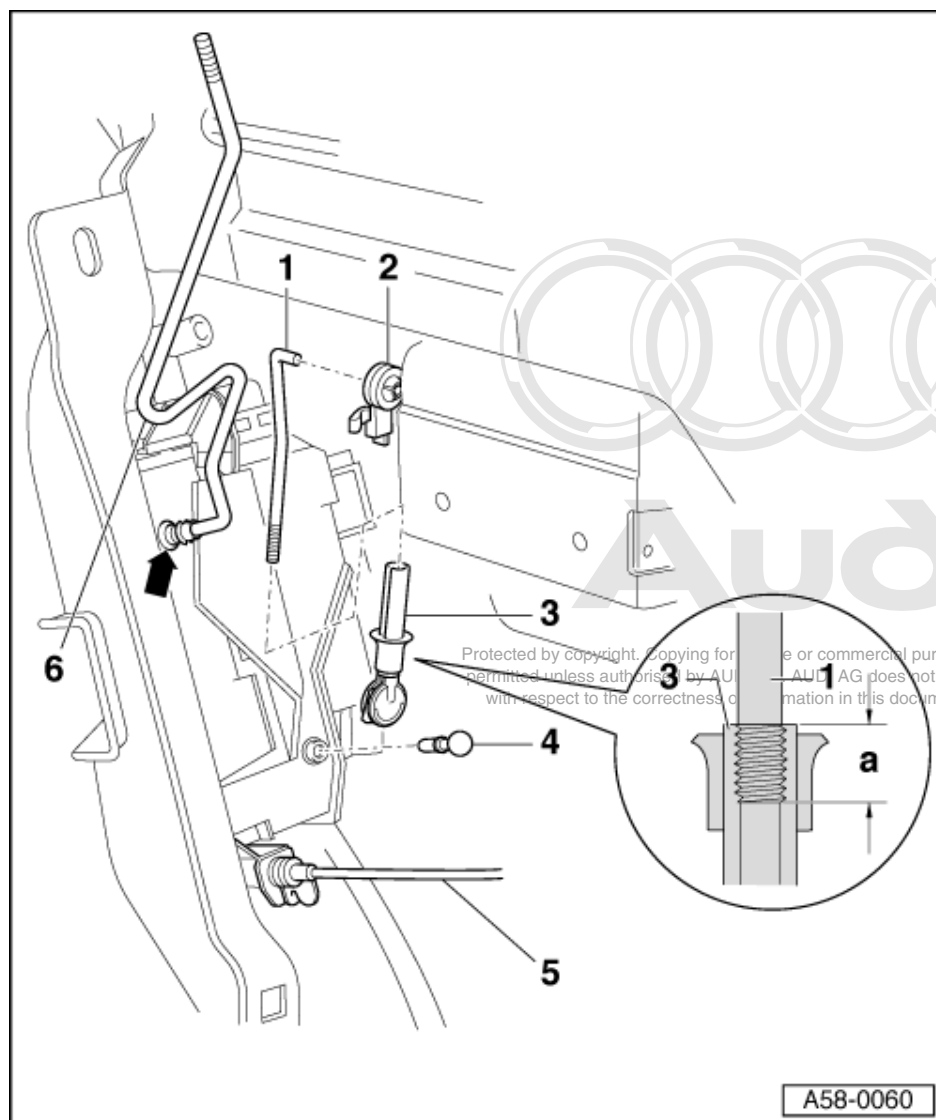
5 Door handle

- ◆ Removing
- Door trim and door sub-frame removed.
- Detach operating rod from hinged lever =>Page 102 .
- Release catch -arrow -A- for slide with a small screwdriver by lifting slightly.
- With an open-ended wrench, turn cam -6- in direction of arrow -B-, thus releasing the slide.

6 Cam

- ◆ To release door handle mount.

1.10 - Removing and installing operating rods for rear door lock

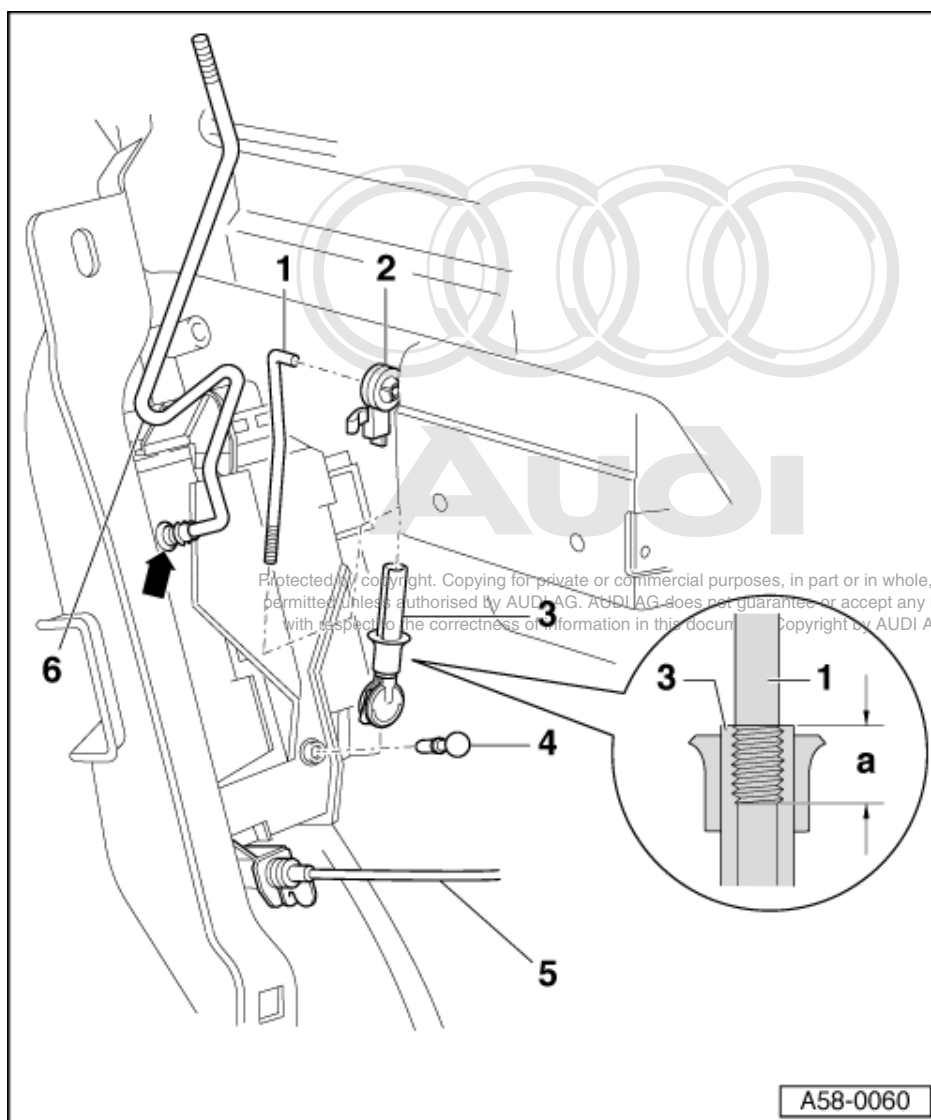


1 Operating rod

- ◆ Adjusting:
 - Insert operating rod in hinged bushing -2-.
 - Clip operating rod into operating clips -3- without straining door lock release lever (max. play 1.5 mm).
 - Push sleeve onto operating clip -4-.
 - Insertion length -a- = 13 ± 3 mm.
 - Do not remove locating pin -5- from door lock until operating rod has been installed.

2 Hinged bushing

3 Operating clip



4 Locating pin

- ♦ Only available for replacement part, locates the basic setting.
- ♦ Do not remove until operating rod -1- has been installed.

5 Bowden cable for interior door handle.

- ♦ Releasing from or attaching to door lock => Page 89 .

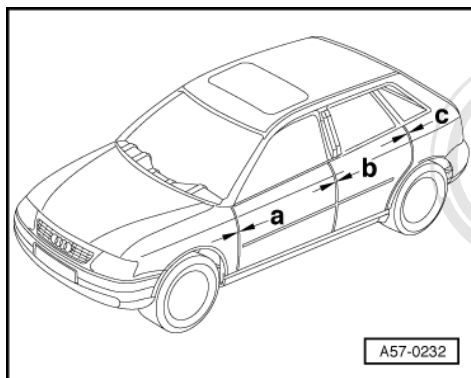
6 Securing rod

- ♦ To remove, unclip at retainer -arrow-.

1.11 - Rear door handle pre-assembly

- Pre-assembly of the rear door handle is the same as for the front door handle.

1.12 - Adjusting door - adjustment sequence



-> Joint dimensions:

Note:

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- ♦ Door shell at rear must be already adjusted or this work must be performed.
- ♦ The joint dimensions can be checked using the special tool 3371.

- $a = 3.5 \text{ mm} + 1 \text{ mm}$
- $b = 4.5 \text{ mm} \pm 0.5 \text{ mm}$
- $c = 3.5 \text{ mm} \pm 0.8 \text{ mm}$

Adjusting to body contour:

- The door is adjusted by the hinge screws on the B-pillar and sliding the door (oversized drilled holes in hinge).

Note:

Rear part of door is adjusted to centre of vehicle using striker plate =>Fig.: 1.

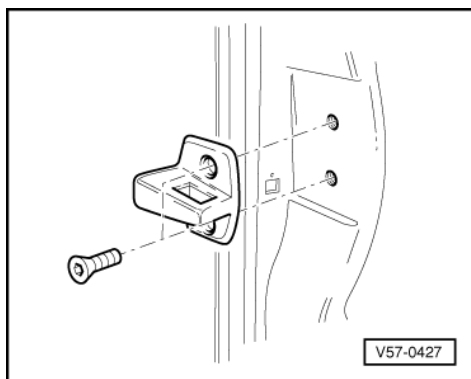


Fig.:1 Adjustment with striker wedge

Note:

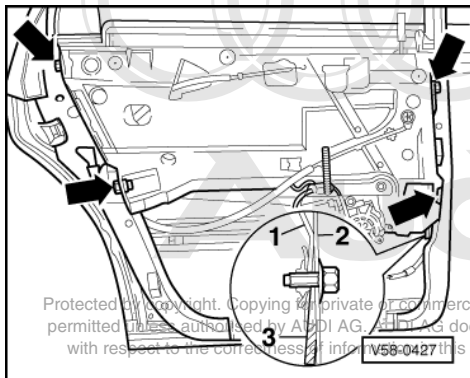
Rear part of door is adjusted at striker plate.

When installed, there must not be any torsion between striker plate and door lock.

- -> Release bolts.
- Move striker plate until door shell is flush with body contour.
- Tighten bolts.

Tightening torque 20 Nm.

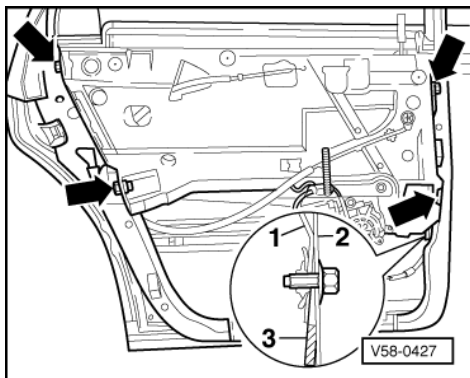
1.13 - Adjusting door subframe



Note:

Door shell must already be adjusted.

- -> Screw on bolts -arrow- so that door subframe -1- can just still be adjusted (bolt at adjuster wedge -3- is only to be fitted but not tightened).
- Have second mechanic sit in vehicle
- Close door.



- -> Have second mechanic press door subframe from inside against roof and B-pillar. Subframe must be forced slightly to allow for resilience of rubber seal.
- First mechanic checks correct positioning of door subframe from outside.
- Push adjuster wedge -3- upwards, until it contacts the surfaces of the door shell -2- and the door subframe -1-.

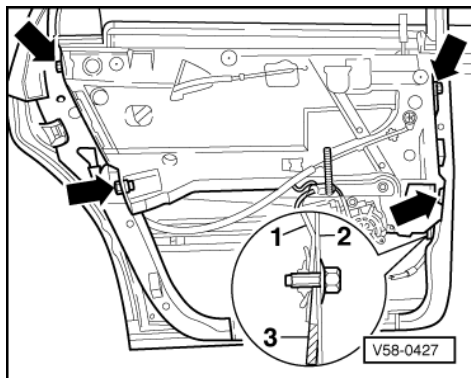
Important

Adjuster wedge -3- must always be installed.

Angle of door can be adjusted in C-pillar area by shifting adjuster wedge -3-.

For example, if the door protrudes too far at the back, the adjuster wedge must be pushed further up.

The bottom of the door consequently slopes towards the centre of the vehicle and the top of the door leans outwards.



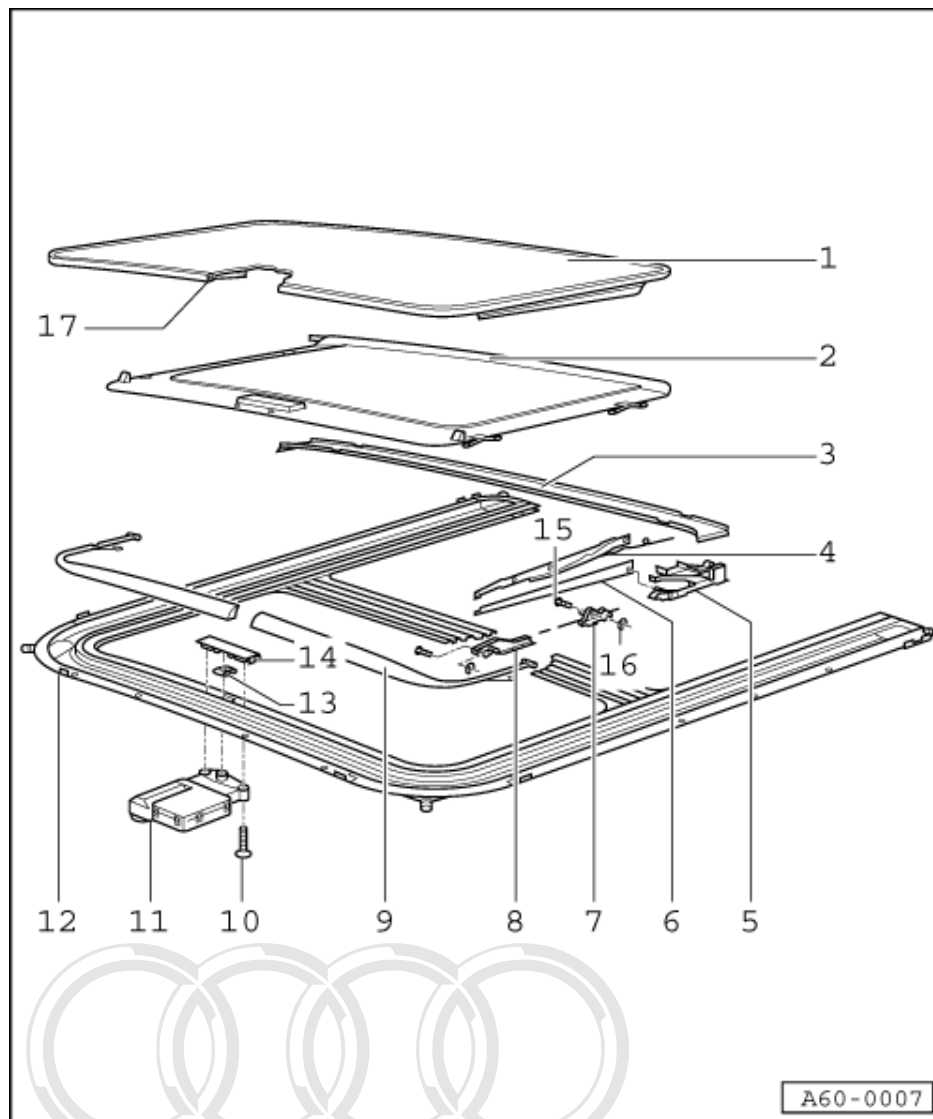
- -> Carefully open door and tighten bolts -arrow-.
Tightening torque 30 Nm.
- Close door and check adjustment of door subframe -1-.
- Procedure must be repeated if the adjustment of door subframe is still not correct.

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60 - Sliding/tilting roof

1 - Servicing sun roof up to approx. 10.97 (Rockwell)

1.1 - Servicing sun roof up to approx. 10.97 (Rockwell)



1.2 - Assembly overview

1 Sun roof panel

- ♦ Removing and installing => Page 112
- ♦ Adjusting => Page 112

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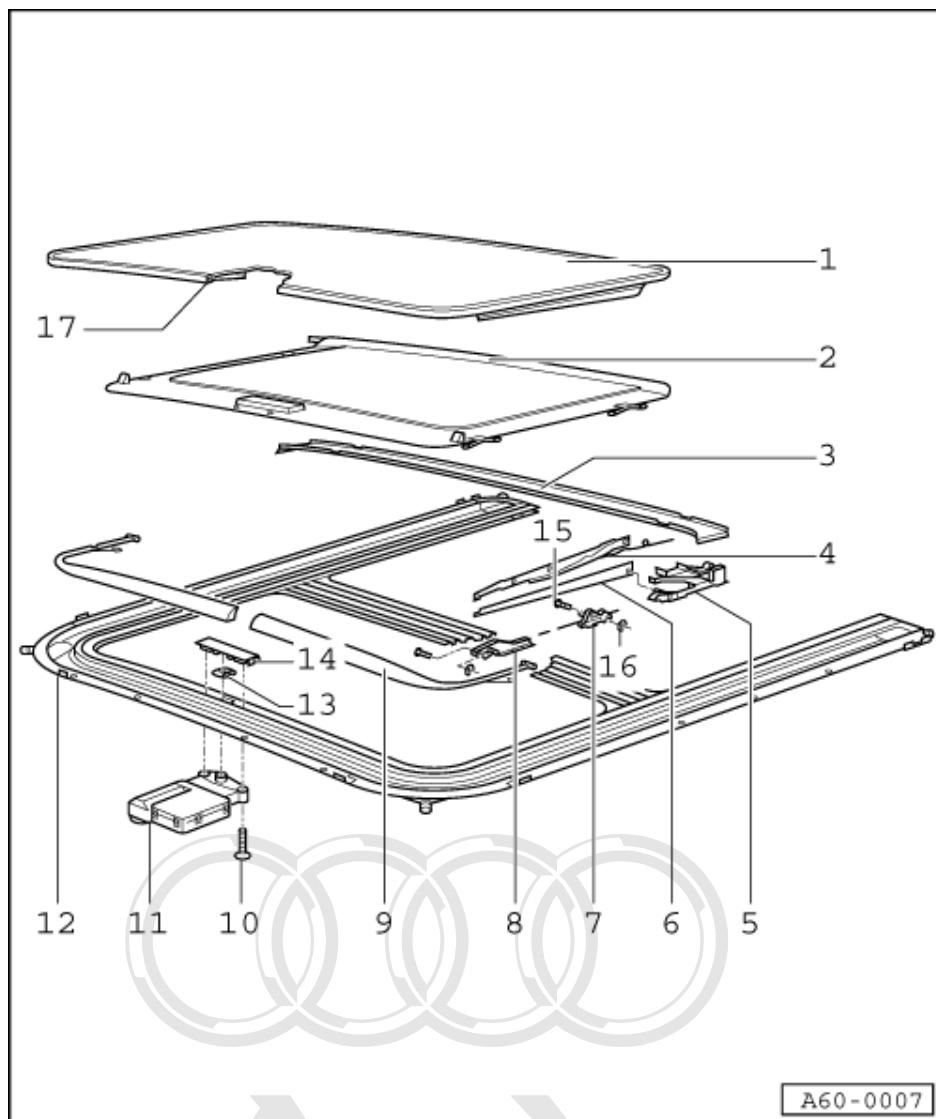
2 Sliding headlining

- ♦ Removing and installing => Page 115

3 Drain channel

- ♦ Before removing, remove sun roof panel
=> Page 112.
- Unfasten clips by pressing them forwards and lift out drain channel

=>Fig. 3.



4 Guide plate

- ◆ Removing and installing => Page 117
- ◆ Can only be removed after detaching moulded headlining.

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=> General Body Assembly Interior; Repair group 70: Trims Trims

5 Locating hook guide

- ◆ Is removed together with guide plate.

6 Panel

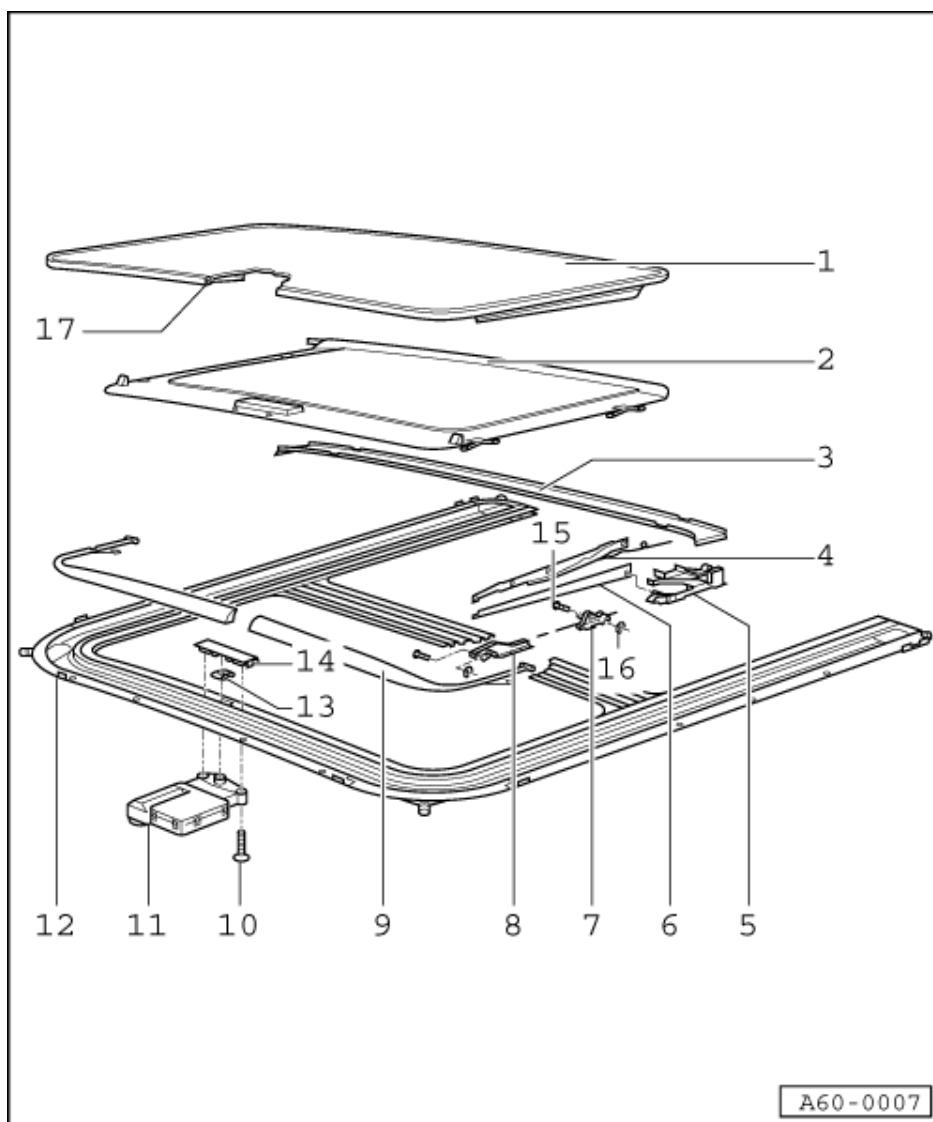
- ◆ Removing and installing => Fig. 2.

7 Rear guide

- ◆ Is removed together with guide plate.

8 Front guide

- ◆ Is removed together with guide plate.



9 Wind deflector

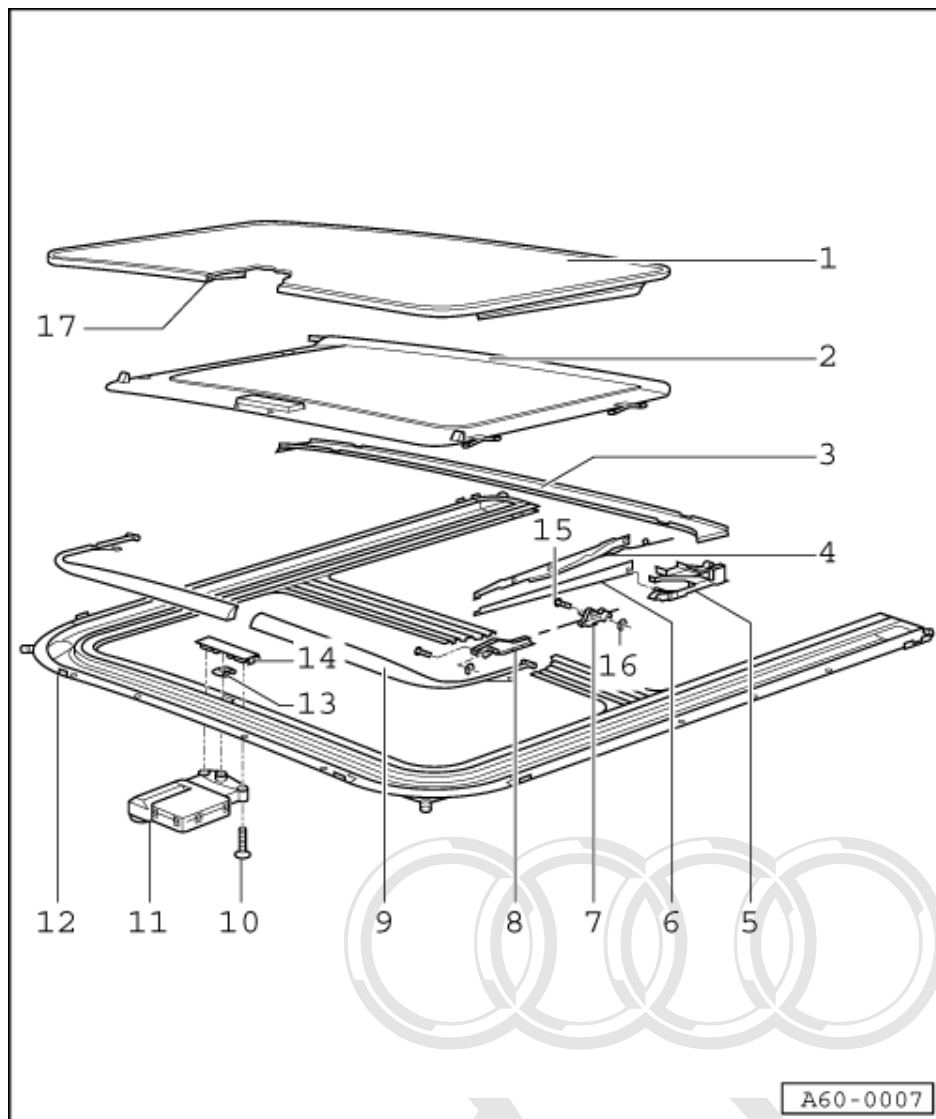
- ♦ Removing and installing =>Fig. 4 .

10 Countersunk screw

- ♦ Micro-encapsulated; use new bolts on installation.
- ♦ Clean tapped holes with tap before installation.
- ♦ 3.5 + 0.5 Nm

11 Sun roof motor

- ♦ Before removing, remove cover for sun roof motor in headlining.
- ♦ Removing => Page 116



12 Frame

- ◆ Before dismantling, remove headlining.

=> General Body Assembly, Interior: Repair group 70: Trims Trims

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- ◆ Removing and installing => Fig. 1

13 Clamp

- ◆ Not a replacement part.

14 Panel

15 Pin

- ◆ Not a replacement part.

16 Circlip

17 Seal for sun roof panel

- ◆ Removing and installing => Page 114
- ◆ Adjusting =>Page 115 .

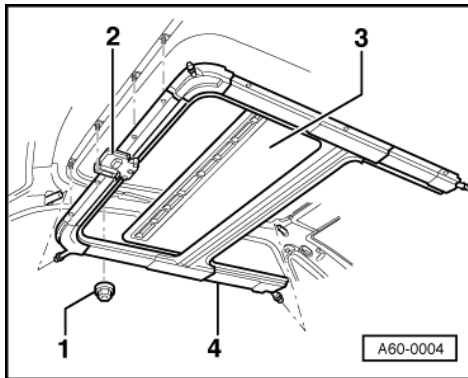


Fig.1-> Removing and installing frame

- Moulded headlining must be dismantled before removing frame -2-

=> General Body Assembly, Interior; Repair group 70; Trims Trims

- Remove drain hoses off frame.
- Unscrew hexagon nuts -1- and remove frame.
- Align frame with reinforcing frame on installation.
- Tighten nuts -1- to 8 Nm starting at front centre.

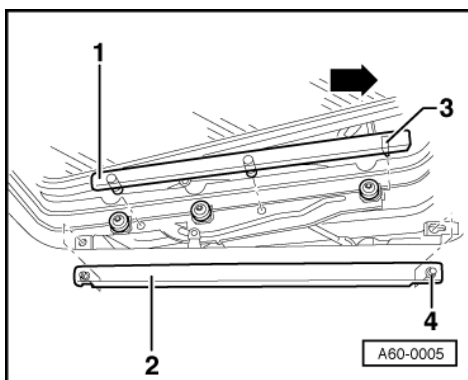


Fig.2 -> Removing cover

- Tilt sun roof.
- Unclip cover -2- towards centre of vehicle, push forwards out of slot and remove.
- Unclip cover -1- at the front and in the centre and remove in the direction of arrow.

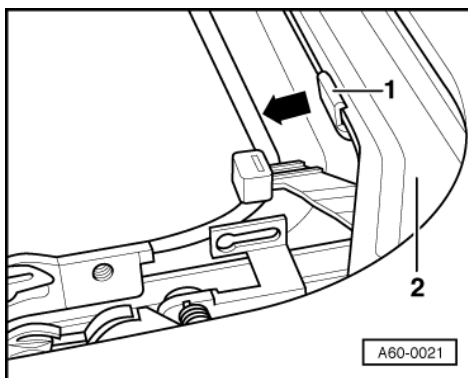
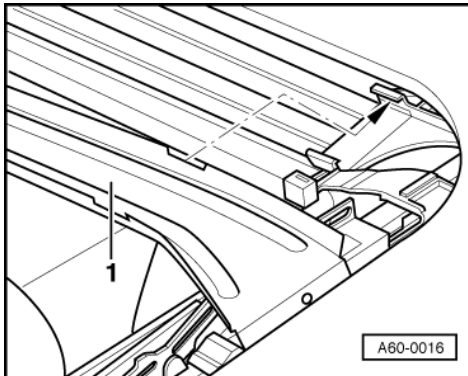


Fig.3 -> Removing and installing drain channel

- Sun roof panel removed.

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- Unfasten clips -1- by pressing forward in direction of arrow and remove drain channel -2- upwards.



- -> To install, insert drain channel in direction of arrow and press into clips at front.

Important

Do not push sun roof backwards into roof of vehicle with drain channel removed.
Retaining clips for drain channel would catch in roof cross strut, making sun roof difficult to close.

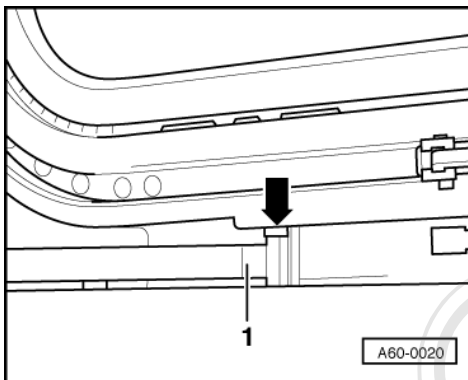
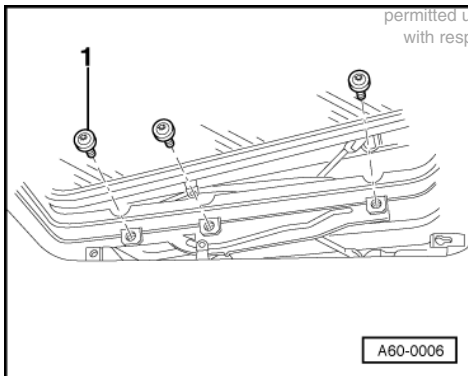


Fig.4 -> Removing and installing wind deflector

- Open sun roof.
- Press wind deflector -1- downwards and at the same press out of guide on both sides (in direction of arrow).
- Take out wind deflector.
- On installation, wind deflector must fully engage in guide.

1.3 - Removing and installing sun roof

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- Open sun roof to tilt position.
- Detach left and right covers towards centre of vehicle => Fig. 2.
- -> Unscrew Torx bolts (3*) on left and right.

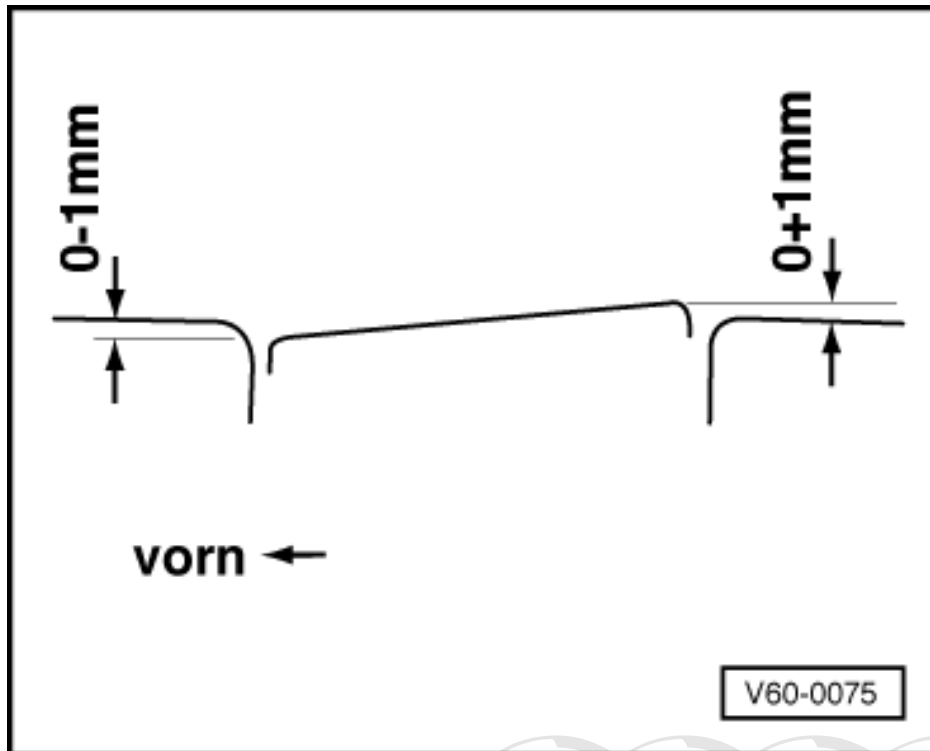
- Lift out sun roof panel.

Important

Do not run sun roof backwards into roof of vehicle with panel removed.
Drain channel would catch in roof cross strut, making sun roof difficult to close.

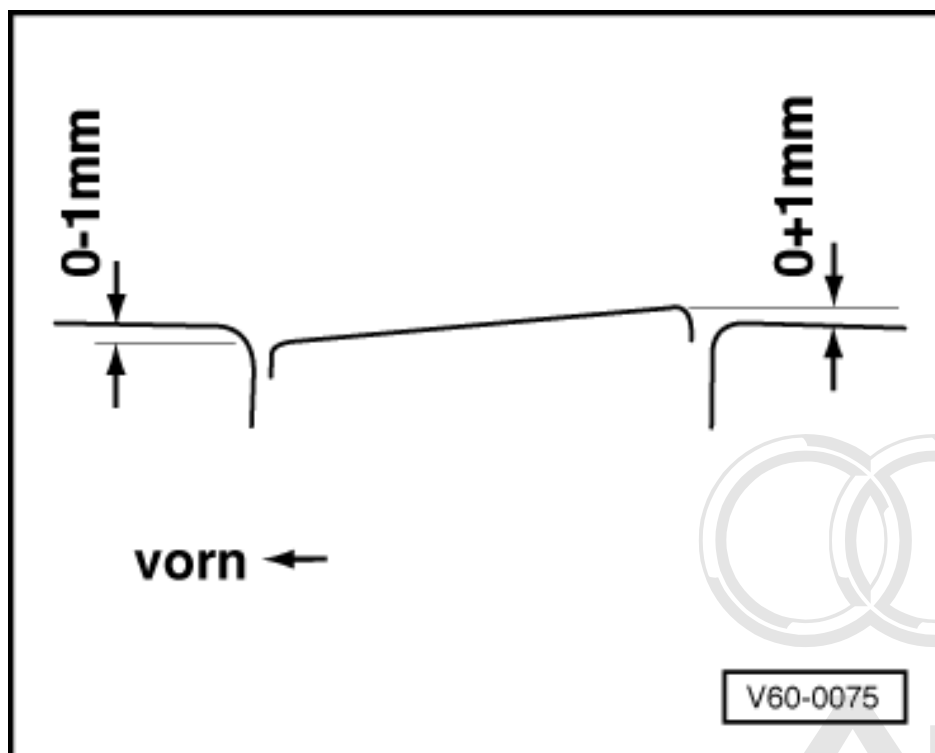
- Tightening torque for Torx bolts on installation: $4.5 + 0.5 \text{ Nm}$.

1.4 - Adjusting sun roof panel



- -> To avoid wind noise, adjust the sun roof panel at the front and rear as shown.
- Check height adjustment in each case at end of roof-opening radii towards centre of vehicle.

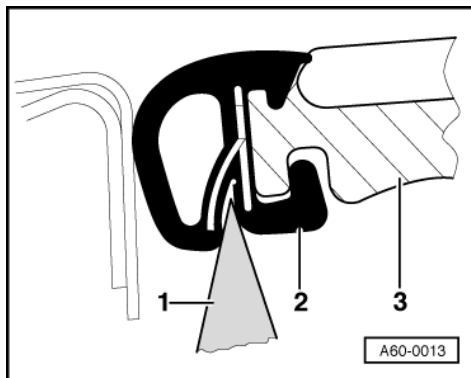
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- -> The sun roof panel should at no point be higher or lower than the roof at the front and rear respectively.
- When performing height adjustment, start by running the sun roof from the open position (i.e. not tilted open) into the closed position.

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1.5 - Replacing seal for sun roof panel



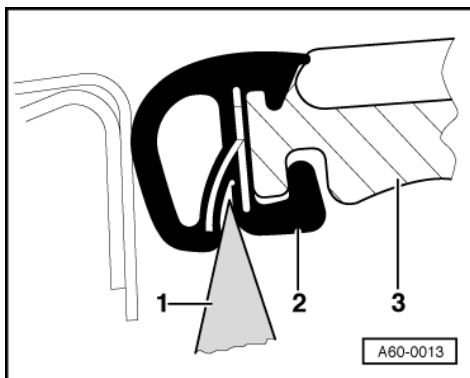
- Remove sun roof panel.
- Detach seal -2-.
- -> At rear panel, edge centrally attach new seal to sun roof panel -3- starting from underneath and working upwards.

Note:

For easier installation of seal, lubricate edge of sun roof panel with soap solution.

- Trim edge of panel seal after installation.

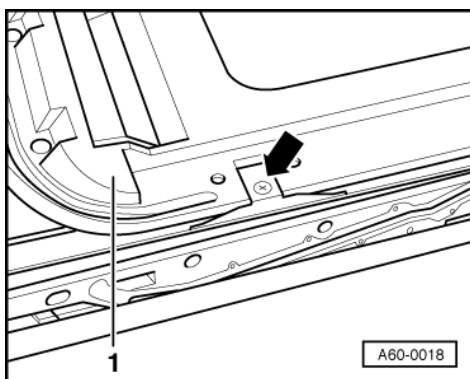
1.6 - Adjusting seal for sun roof panel



- -> Check uniform all-round pretension between panel seal -2- and body using a roughly 0.3 mm thick strip of cardboard (e.g. business card). It must be possible to run the strip of cardboard cleanly through between panel seat and body.
- In the event of insufficient pretension the panel seal can be forced apart with a wedge -1- or squeezed together if the pretension is excessive. Adjusting the panel seat involves removing the glass panel -3-.

1.7 - Removing and installing sliding headlining

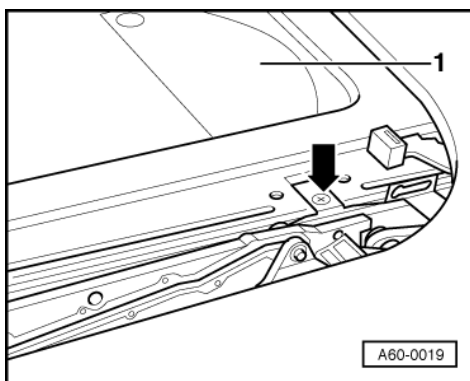
- Open sun roof.



- Remove cover frame for moulded headlining

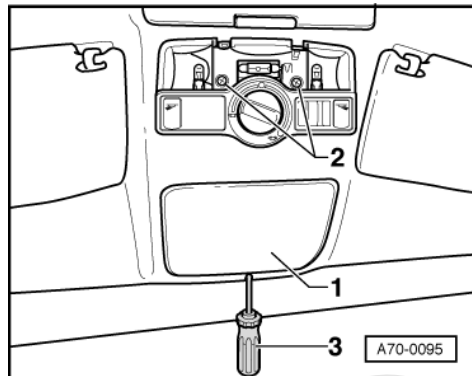
=> General Body Assembly, Interior; Repair group 70; Trims Trims

- Remove sun roof panel.
- Remove sliding headlining.
- -> Unscrew front bolts -arrow- on left and right and push out springs to front over stop -1-.



- Push sliding headlining forwards.
- -> Likewise unscrew rear bolts -arrow-, push out springs to rear and remove sliding headlining upwards.

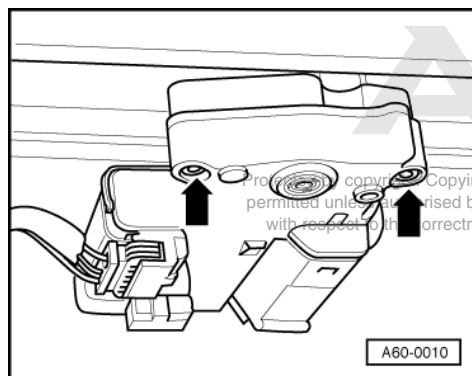
1.8 - Removing and installing sun roof motor



- -> Use screwdriver -3- to lever cover -1- off rear moulded headlining and remove.

Important

Sun roof motor is only to be removed and installed with roof closed, i.e. only in zero setting of cable-operated mechanism and sun roof motor.



- Detach electrical connectors.
- -> Unscrew Torx bolts (T25) -arrows- and remove sun roof motor.
- Use new bolts when installing, and clean threads before installation with a tap.
- Tighten Torx bolts to 3.5 ± 0.5 Nm.

1.9 - Adjusting zero position (motor)

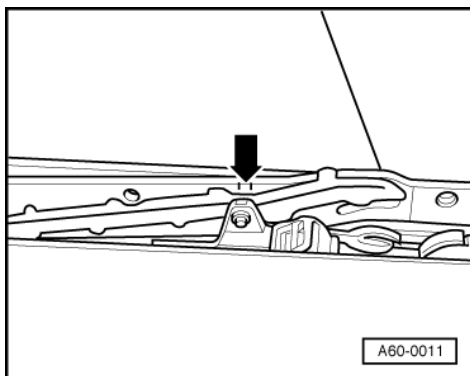
- Motor removed; connectors unplugged.
- Use potentiometer to select "roof closed" on automatic preselection unit.
- Motor runs into zero position and cuts out automatically.
- Install motor in this position with sun roof closed.

1.10 - Checking and adjusting zero setting (guide plate)

Note:

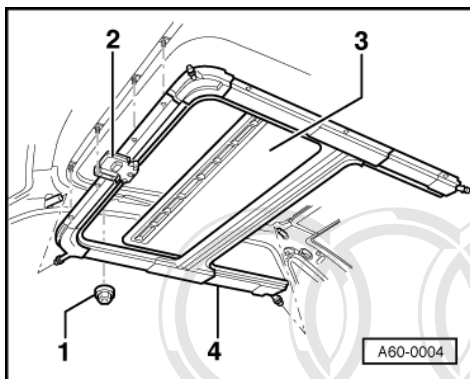
Zero setting can only be made with sun roof motor removed.

- Sun roof motor removed.
- Trims removed.
- Push front guide, rear guide and locating hook guide forwards until lug engages in sun roof frame.



- -> Push rear guides from front to back.
- Guide lugs on either side must be between marks on guide plates -arrow-; shift rear guide, if necessary.
- The guide lugs on both sides should be between the marks on the guide plates -arrow-; alter position of rear guide if necessary.

1.11 - Removing and installing guide plate

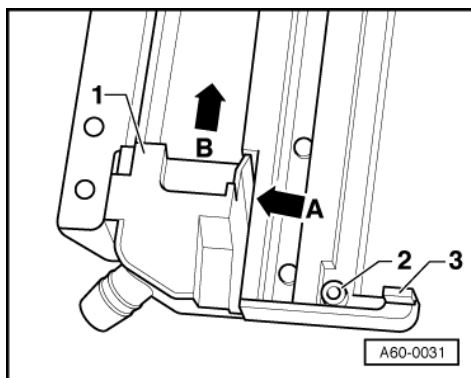


- Remove moulded headlining before dismantling guide plate.

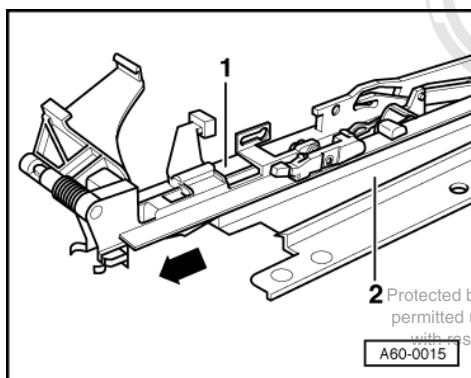
=> General Body Assembly, Interior; Repair group 70; Trims Trims

- Remove sun roof motor.
- Remove drain hoses off frame.
- -> Unscrew nuts -1- and remove frame.
- On installation tighten nuts to 8 Nm starting in front centre.

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- -> Release catch in direction of arrow and detach cap to front.
- Unscrew bolt -1- and remove stop at rear guide rail.
- Tightening torque 3.5 Nm.



- -> Pull locating hook guide -1- as well as front and rear guides with cable and guide plate backwards out of guide rail -2-.

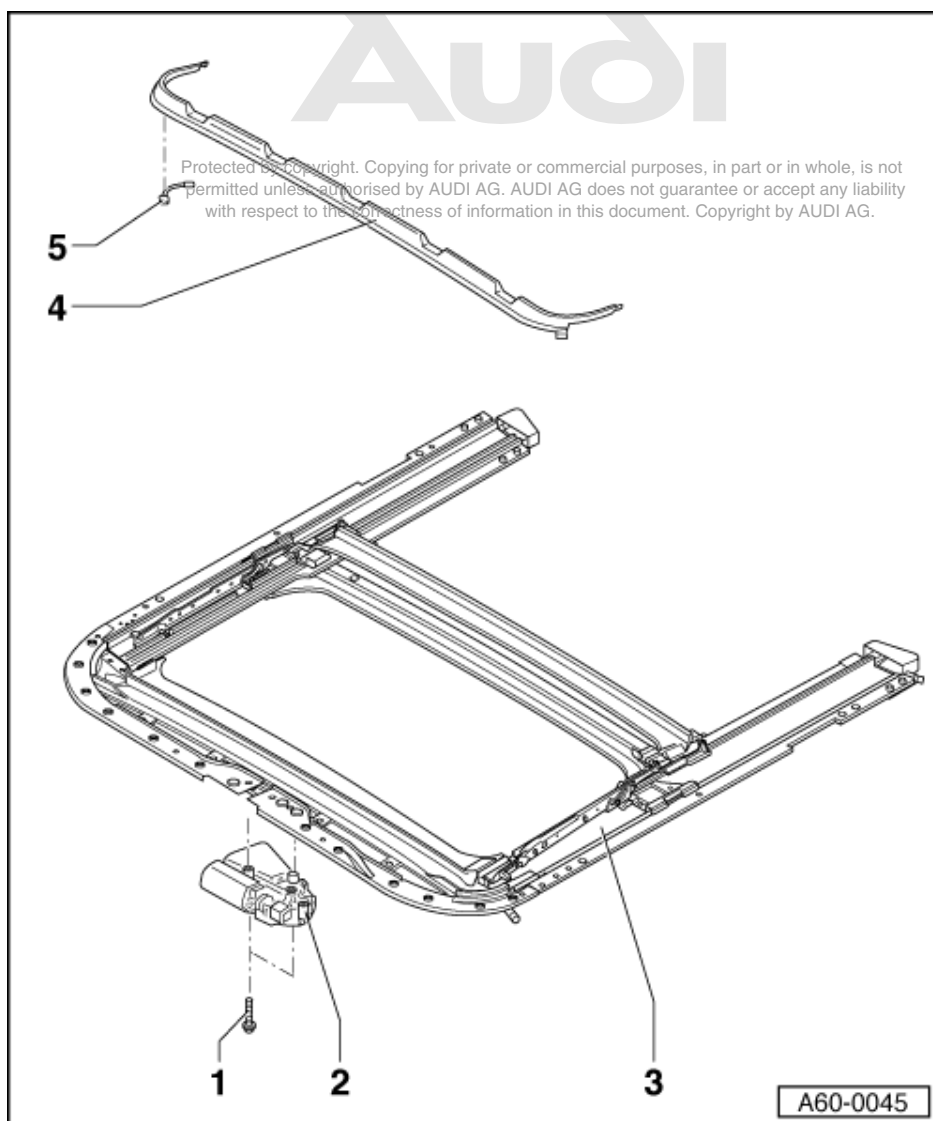
Note:

Always replace guides with cable in pairs.

- Push new guide plates into frame as far as zero setting => Page 117 .

2 - Servicing sun roof from approx. 10.97 (Webasto)

2.1 - Servicing sun roof from approx. 10.97 (Webasto)



2.2 - Assembly overview

Note:

This sun roof was attached to the above using a sliding insert.

These sun roofs can be identified by the Webasto lettering on the rear edge of the panel.

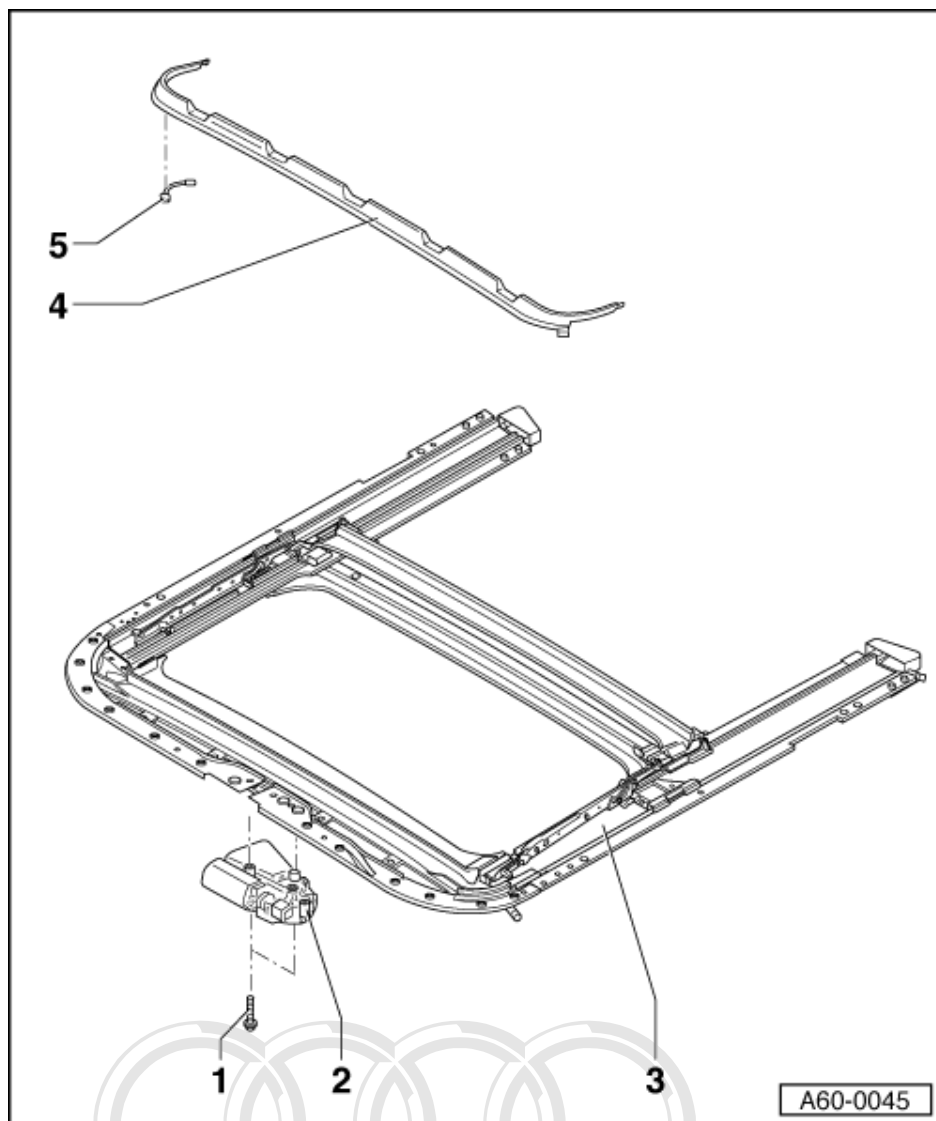
1 Combi bolt (T 25)

- ♦ 3 Nm

2 Sun roof motor

- ♦ Before removing, remove cover for sun roof motor in headlining.

=> General Body Assembly, Interior; Repair group 70; Trims Trims



3 Frame

- ◆ Before dismantling, remove headlining.
- ◆ Remove and install frame as described in Workshop Manual.

=> General Body Assembly, Interior; Repair group 70; Trims Trims

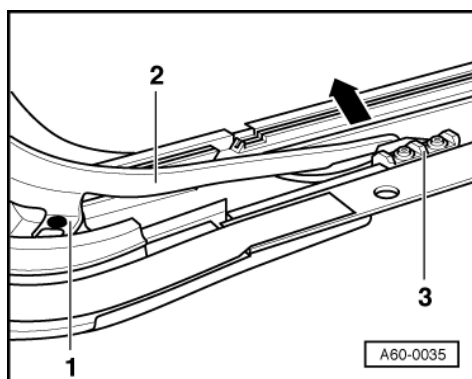
4 Wind deflector

- ◆ Removing => Page 121

5 Spring for tilting wind deflector

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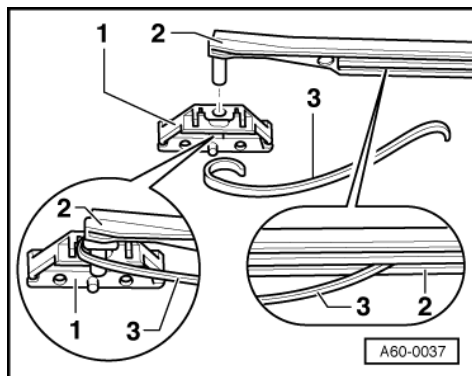
2.3 - Removing and installing wind deflector.



Removing:

- Fully open sun roof.
- -> Press wind deflector -2- out of holder -3- in direction of arrow.
- Pull wind deflector backwards and out of roof cut-out.

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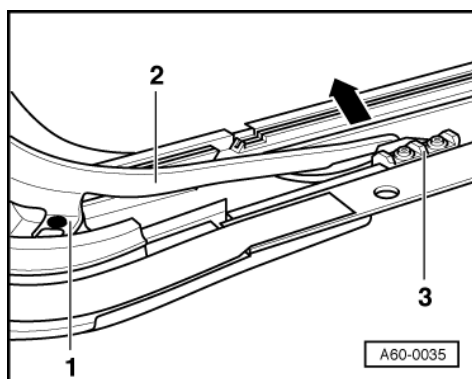


Installing:

- -> Hook spring -3- onto retaining pin of wind deflector -2-.
- Also insert spring into groove of wind deflector.

Note:

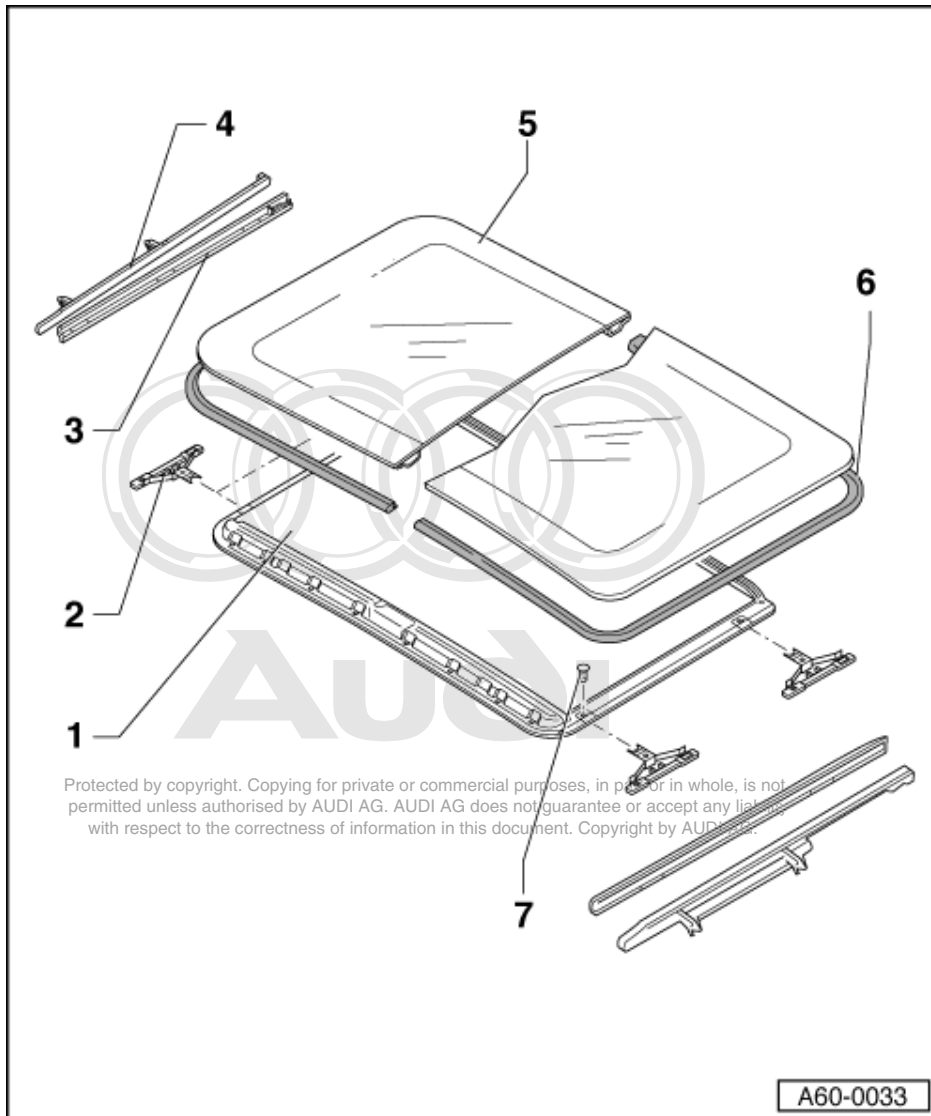
For a clearer illustration, holder -1- is shown removed.



- -> Push stop -1- of wind deflector -2- forwards below the roof cut-out.
- Insert one of the retaining pins of wind deflector into holder -3-.

- On the opposite side push wind deflector in towards centre of vehicle and lock other retaining pin into bracket.

2.4 - Removing and installing sun roof cover (assembly overview)



1 Sliding headlining

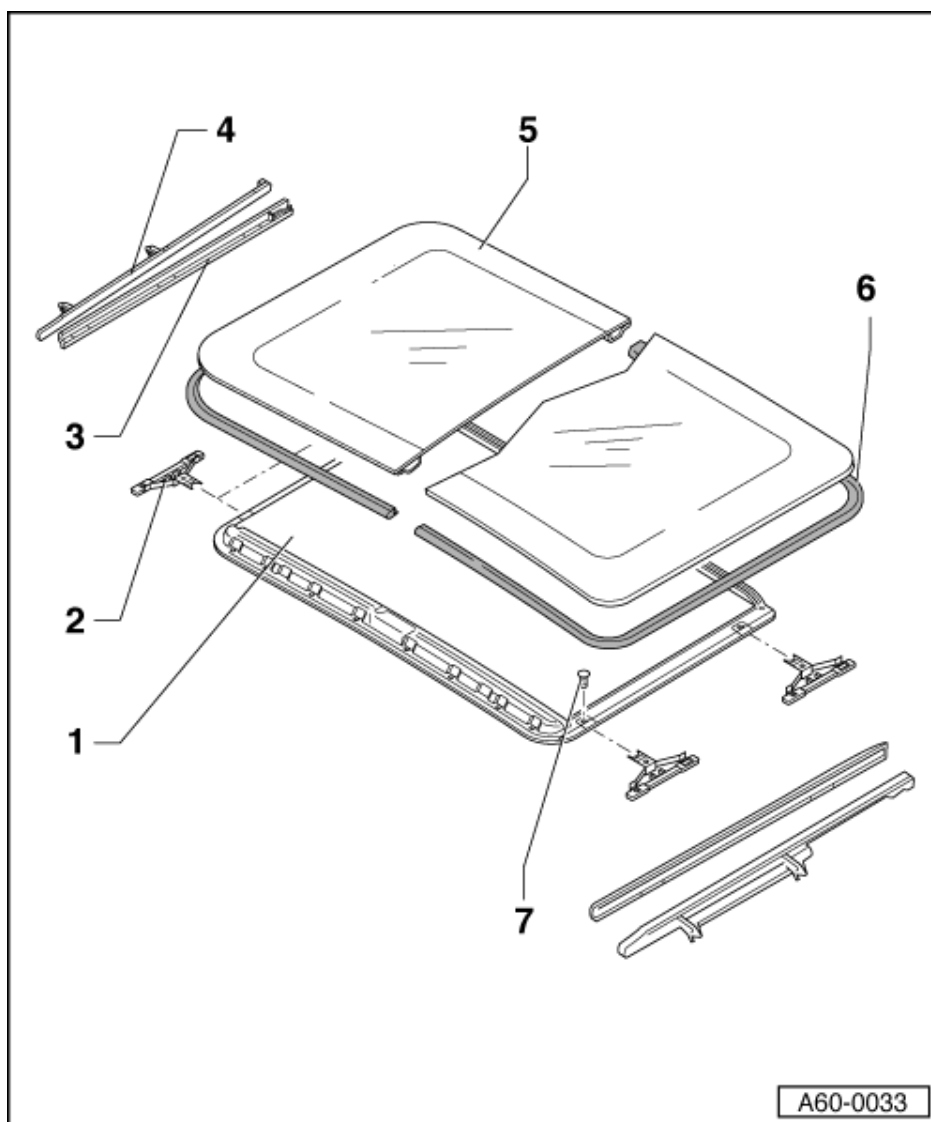
- ♦ Before removing, remove sun roof panel

2 Spring for sliding headlining

- ♦ Before removing, dismantle trim frame for moulded headlining.

=> General Body Assembly, Interior; Repair group 70; Trims Trims

- ♦ To remove, unscrew countersunk screws -6- at front and rear.
- ♦ Push front spring -2- forwards and rear spring backwards off sliding headlining and take out springs.
- ♦ Pull sliding headlining sideways out of guide rail opposite and lift out.



3 Lower trim

- ♦ Removal => Page 124 .

4 Upper trim

- ♦ Removal => Page 124 .

5 Sun roof panel

- ♦ To remove, open sun roof panel to tilt position.
- ♦ Remove left and right trims => Page 124 .
- ♦ Remove Torx bolts (T25) from sun roof panel on left and right and lift out panel =>Page 125 .
- ♦ Adjusting => Page 125

6 Panel seal

- ♦ Removal => Page 126 .

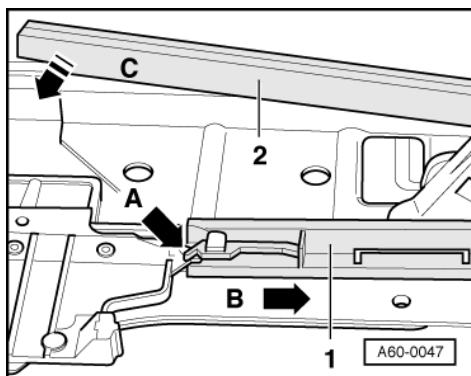
7 Countersunk screw

- ♦ 1.5 Nm.

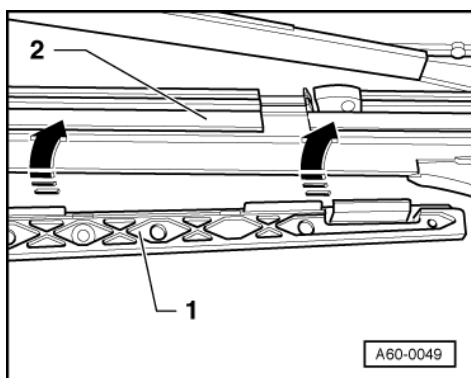
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2.5 - Removing and installing trim

Removing

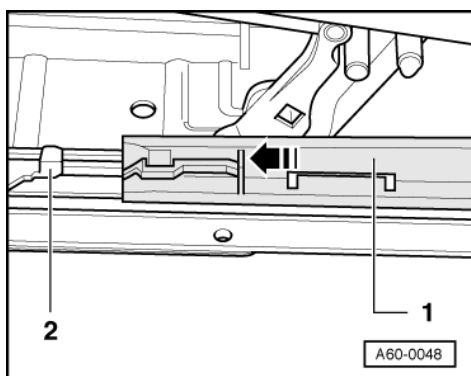


- Tilt sun roof.
- Push the sun roof headlining fully to the rear.
- -> Unfasten lower trim -1- from clip at rear in direction of arrow -A- and push forwards, arrow -B-.
- Pull lower trim off guide rail towards centre of vehicle.
- Unclip cover -1- at the front and in the centre and remove in the direction of arrow.



Installing

- -> Press lower trim -1- onto upper edge -arrows- of guide rail -2-.

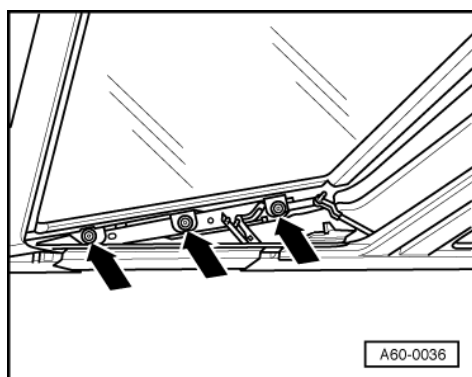


- -> Press lower trim -1- backwards in direction of arrow until the locating hook locks into actuator -2-.
- Press upper trim into guide plate.



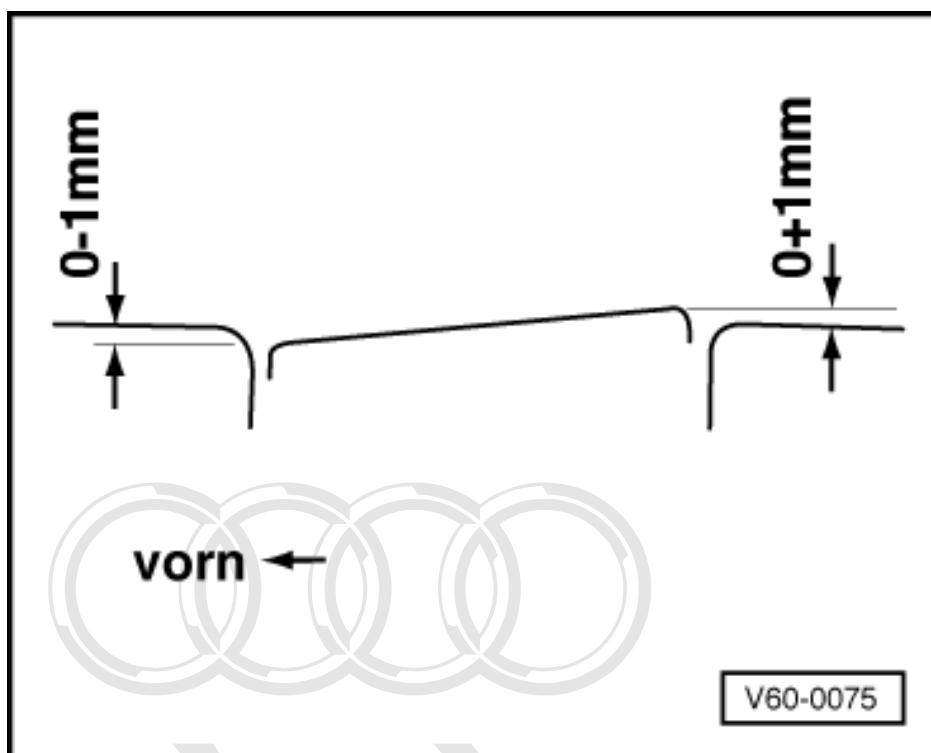
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2.6 - Removing and installing sun roof



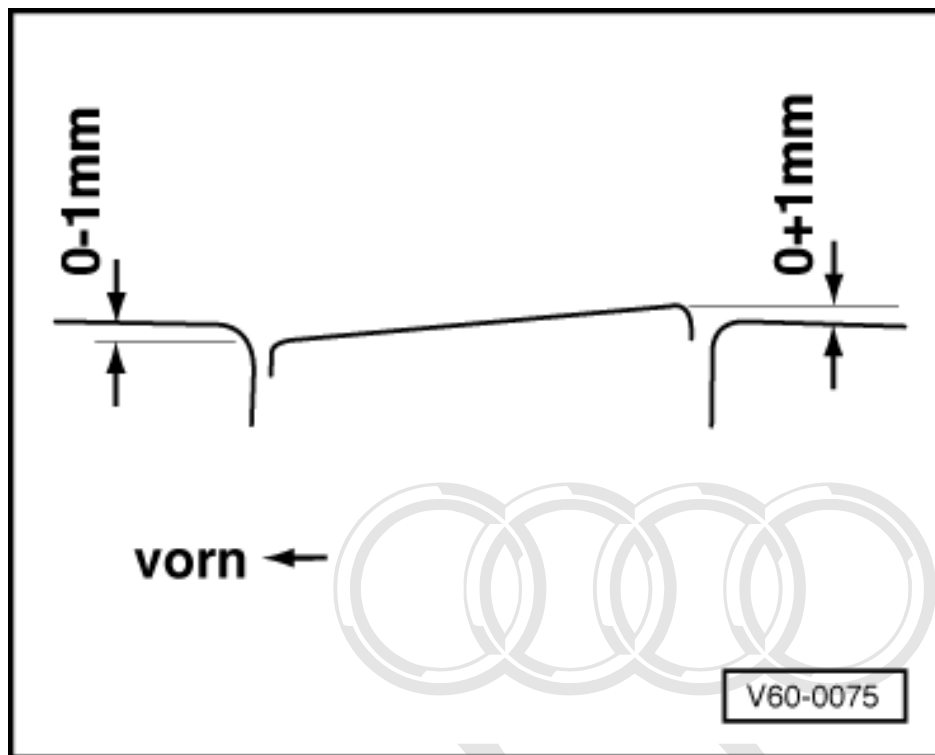
- Trims removed.
- -> Unscrew Torx bolts (T25) -arrows- on both sides and lift out panel upwards.
- When installing, tightening torque 4.5 ± 0.5 Nm.

2.7 - Adjusting sun roof panel



- -> To avoid wind noise, adjust the sun roof panel at the front and rear as shown.
- Check height adjustment in each case at end of roof-opening radii towards centre of vehicle.

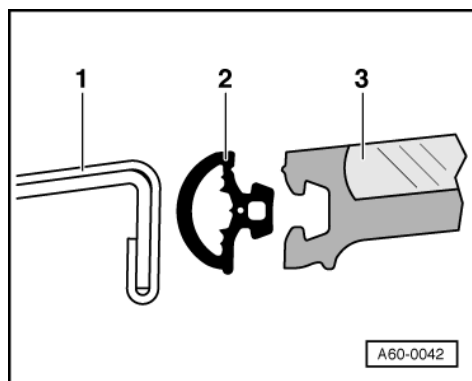
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- -> The sun roof panel should at no point be higher or lower than the roof at the front and rear respectively.
- When performing height adjustment, start by running the sun roof from the open position (i.e. not tilted open) into the closed position.

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2.8 - Replacing panel seal



- Sun roof panel -3- removed.
- Pull seal -2- out of sun roof panel -3-.
- -> Press new seal into sun roof panel -3-, starting from centre of rear edge of sun roof panel.

Note:

For easier installation of seal, lubricate edge of sun roof panel with soap solution.

2.9 - Adjusting zero position (motor)

- Motor removed; connectors unplugged.
- Move rotary control to "roof closed" position.
- Motor runs into zero position and cuts out automatically.

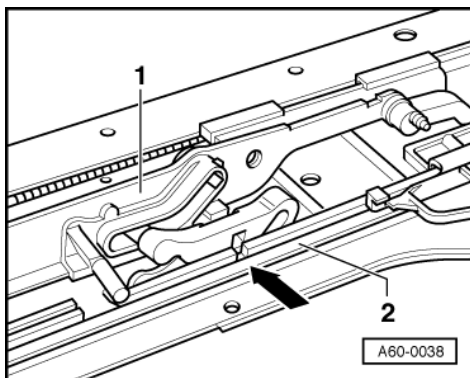
- Install motor in this position with sun roof closed.

2.10 - Checking and adjusting zero setting (guide plate)

Checking

The zero position can be checked using a pocket mirror and a torch, with the sun roof panel installed.

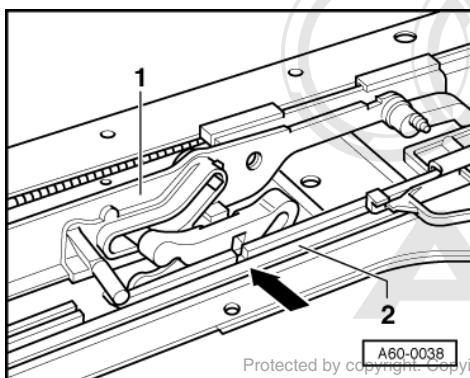
- Trims removed.
- Run sun roof panel back and then into "closed" position.



- Push the sun roof headlining fully to the rear.
- Place pocket mirror onto sun roof panel and visually check zero position from the side.
- -> Given correct zero setting square hole in tilt mechanism of guide plate -1- must be aligned with recess -arrow- on guide rail -2-.

Adjusting

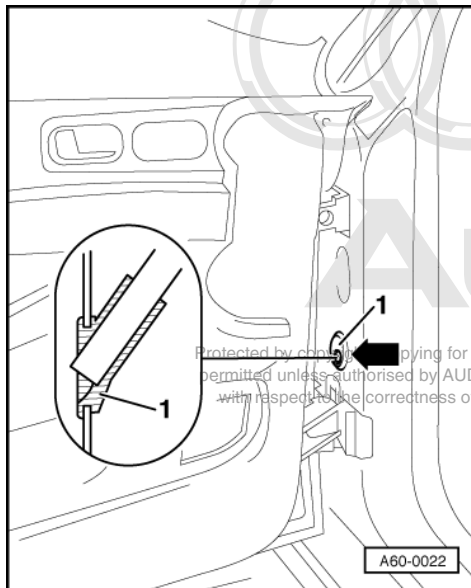
- Sun roof panel removed.
- Sun roof motor removed.
- Trims removed.



- -> Push guide plates -1- forwards on both sides.
- Align square hole in tilt mechanism of guide plate -1- with recess -arrow- at guide rail -2- for sliding headliner.
- The guide lugs on both sides should be between the marks on the guide plates -arrow-; alter position of rear guide if necessary.
- Install motor at zero setting.

3 - Water drain hoses

3.1 - Water drain hoses



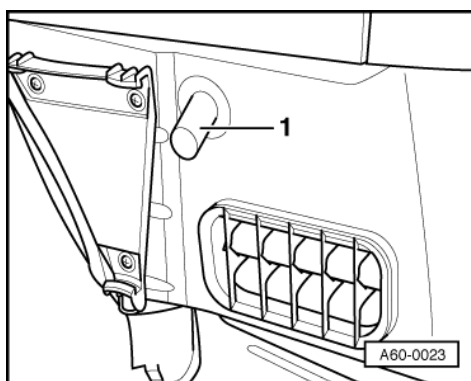
3.2 - Cleaning water drain hoses

Note:

For cleaning it is advisable to make use of an improvised tool approx. 2300 mm long made from speedometer drive cable core.

Front drain hose.

- -> The front water drain hoses run in the A - pillars and end over the bottom hinge -arrow- of the front doors.
- Cleaning is performed from sun roof cut-out.



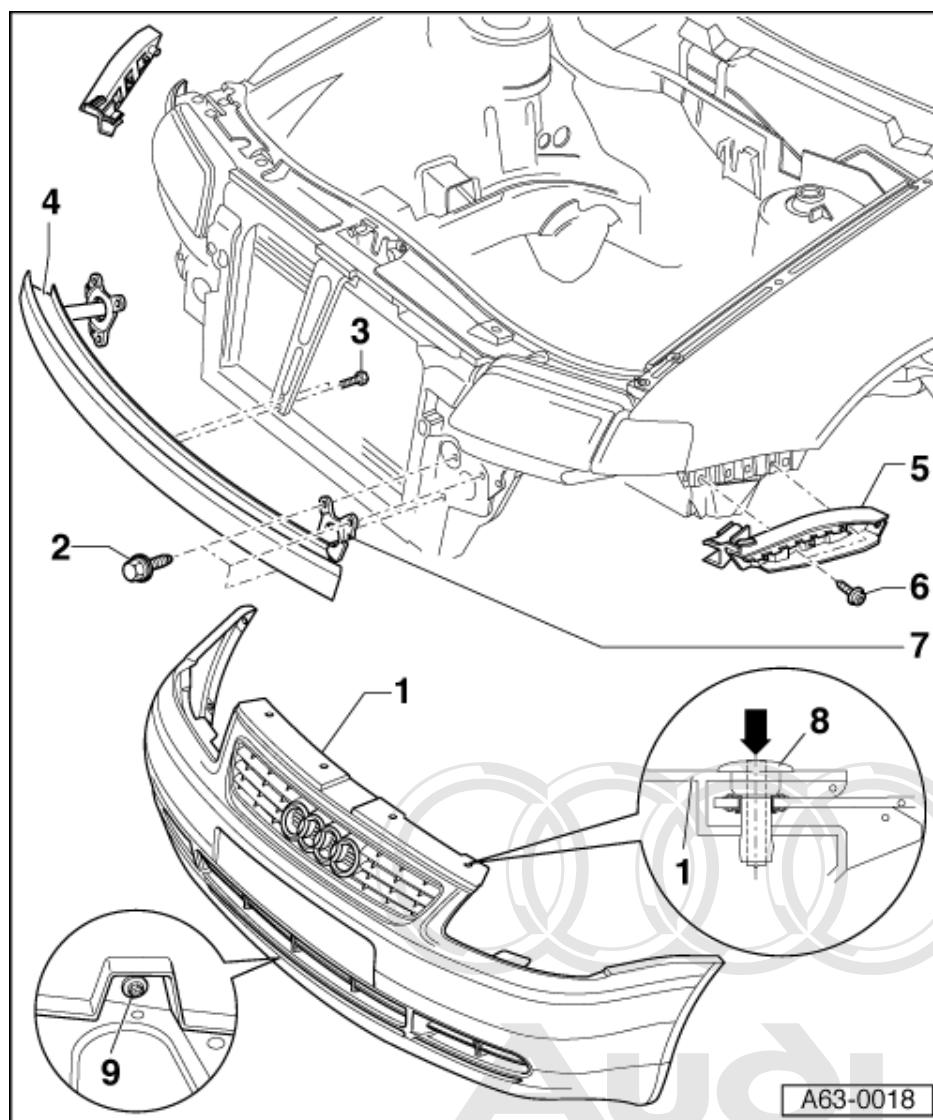
Rear water drain hose.

- -> The rear water drain hoses run in the -C- pillars and end on the side beneath the bumper trim. Cleaning is performed from the lower end of the tube. This involves removing the bumper trim.

63 - Bumpers

1 - Front bumper

1.1 - Front bumper



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1.2 - Removing and installing front bumper

1 Bumper cover

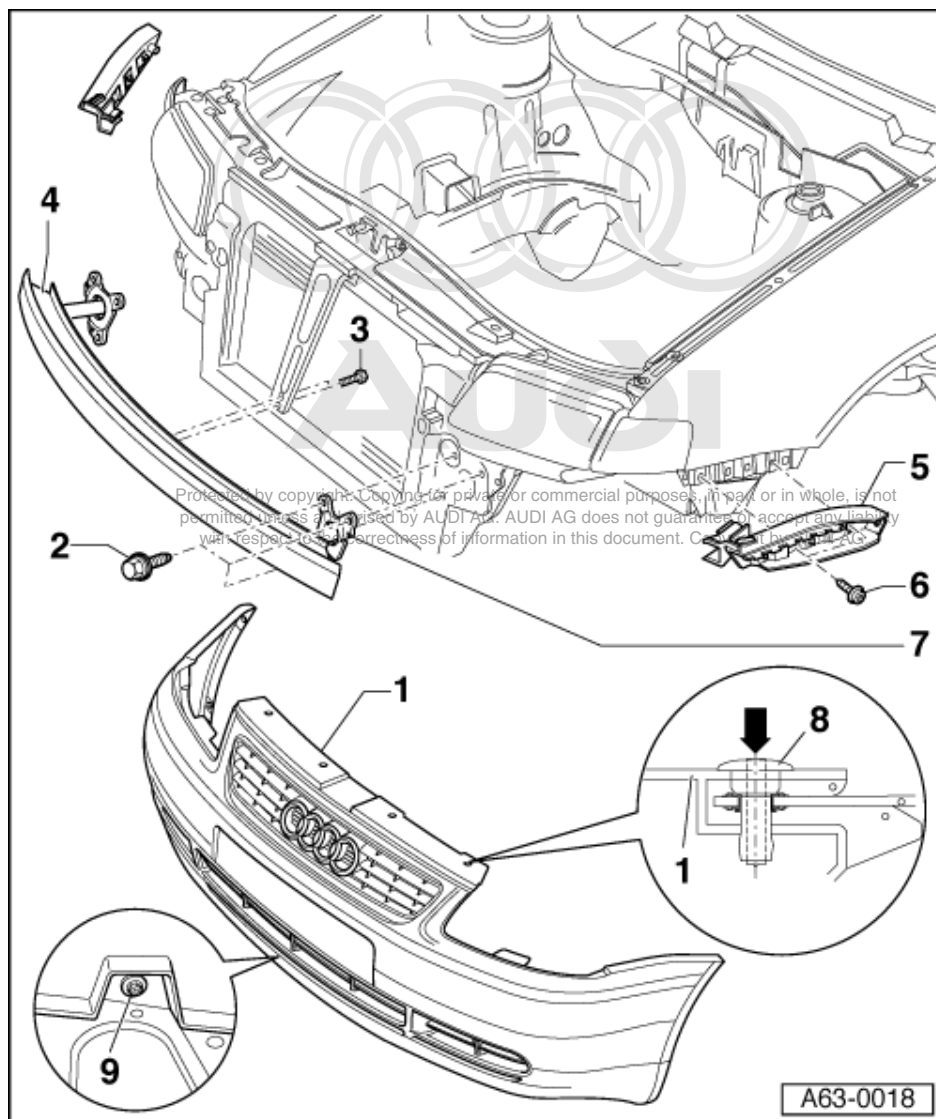
- To remove, press out fastening pins -arrow-at expanding clip -8-.
- Unscrew Torx bolts (T25) at wheel housing liner (3 each) on left and right.
- Unscrew cross head bolts -9- on underside.
- First unclip bumper cover at top from guide piece -5-, then lever over wheel housing liner and remove forwards from lock carrier plate.

2 Bolt

- ♦ 23 Nm

3 Hexagon bolt

- ◆ 6 Nm



4 Bumper

- ◆ Bumper cover removed.
- ◆ Removing from impact absorber
=>Fig. 1.

5 Guide piece

- ◆ To remove, unscrew self-tapping screws -6-.

6 Self-tapping screw

- ◆ 1.5 Nm

7 Impact absorber

- ◆ Remove => Fig 2.

8 Expanding clip

- ◆ To remove, press out fastening pin -arrow-

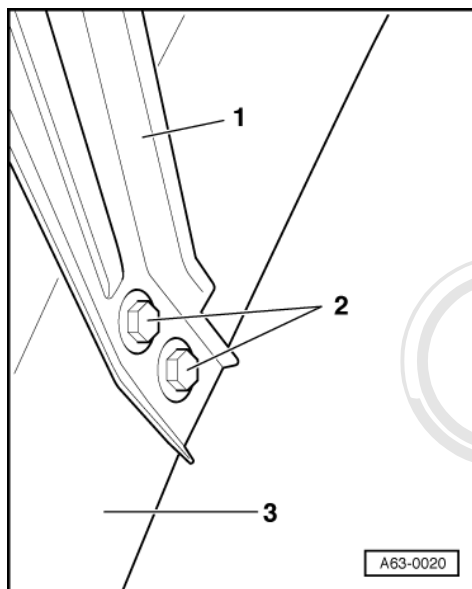
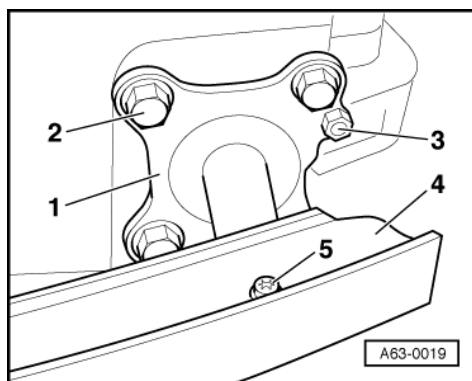


Fig.1-> Removing bumper

- Bumper cover removed.
- Unscrew hexagon bolt -2- from support for lock carrier plate -1-.

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- -> Unscrew hexagon bolt -5- at both impact absorbers -1-.
- Tightening torque 23 Nm.
- Pull bumper -4- out of impact absorber.

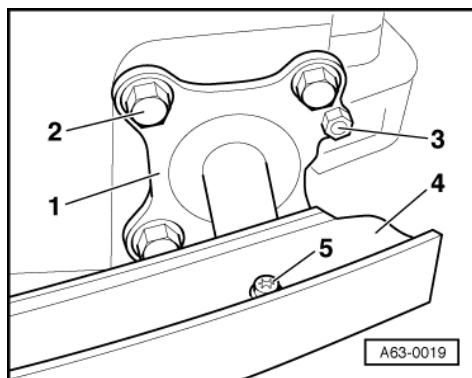


Fig.2 -> Removing impact absorber

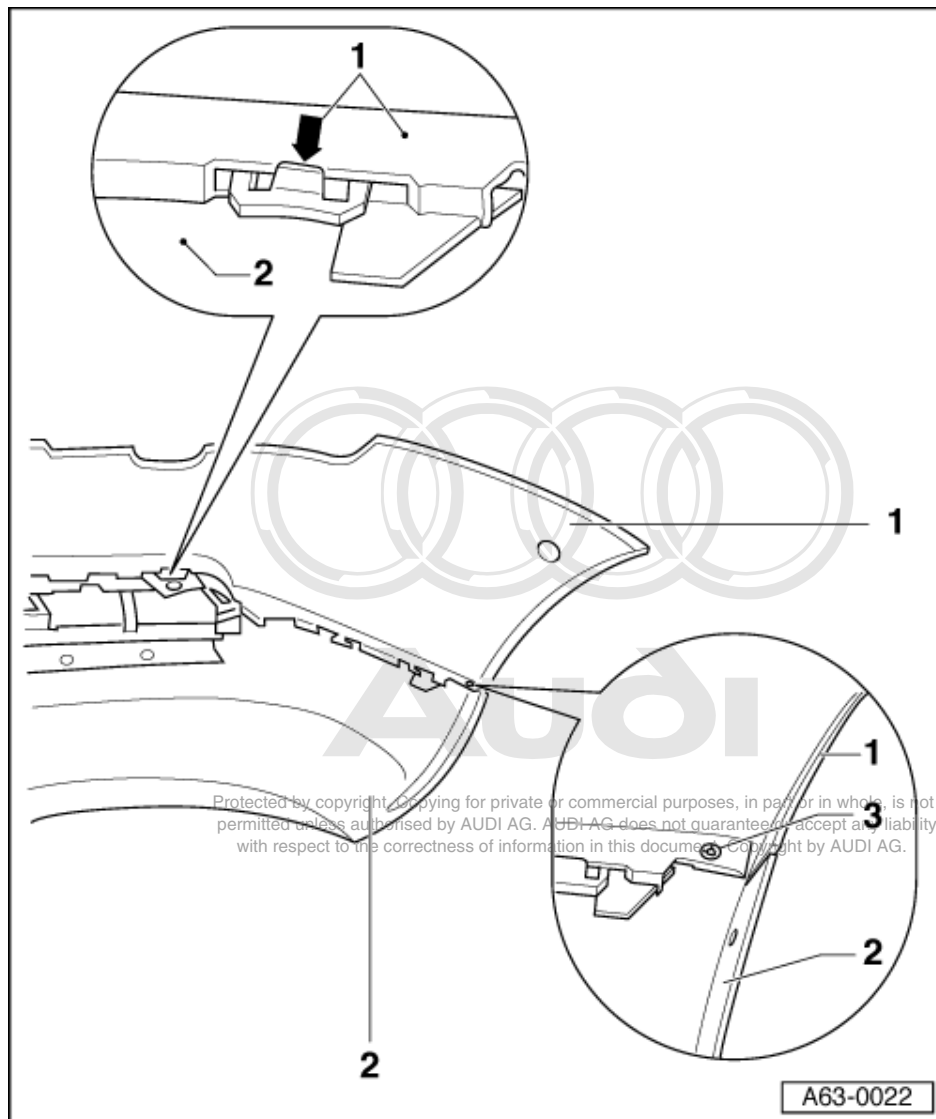
- Unscrew hexagon socket head bolts -5- at both impact absorbers.
- Tightening torque 23 Nm.
- Unscrew hexagon bolts -2- (3x).



- Tightening torque 23 Nm.
- Unscrew hexagon nuts -3- (2x).
- Tightening torque Nm.

2 - Removing and installing spoiler

2.1 - Removing and installing spoiler



1 Bumper cover

- ♦ Removal => Page 129 .

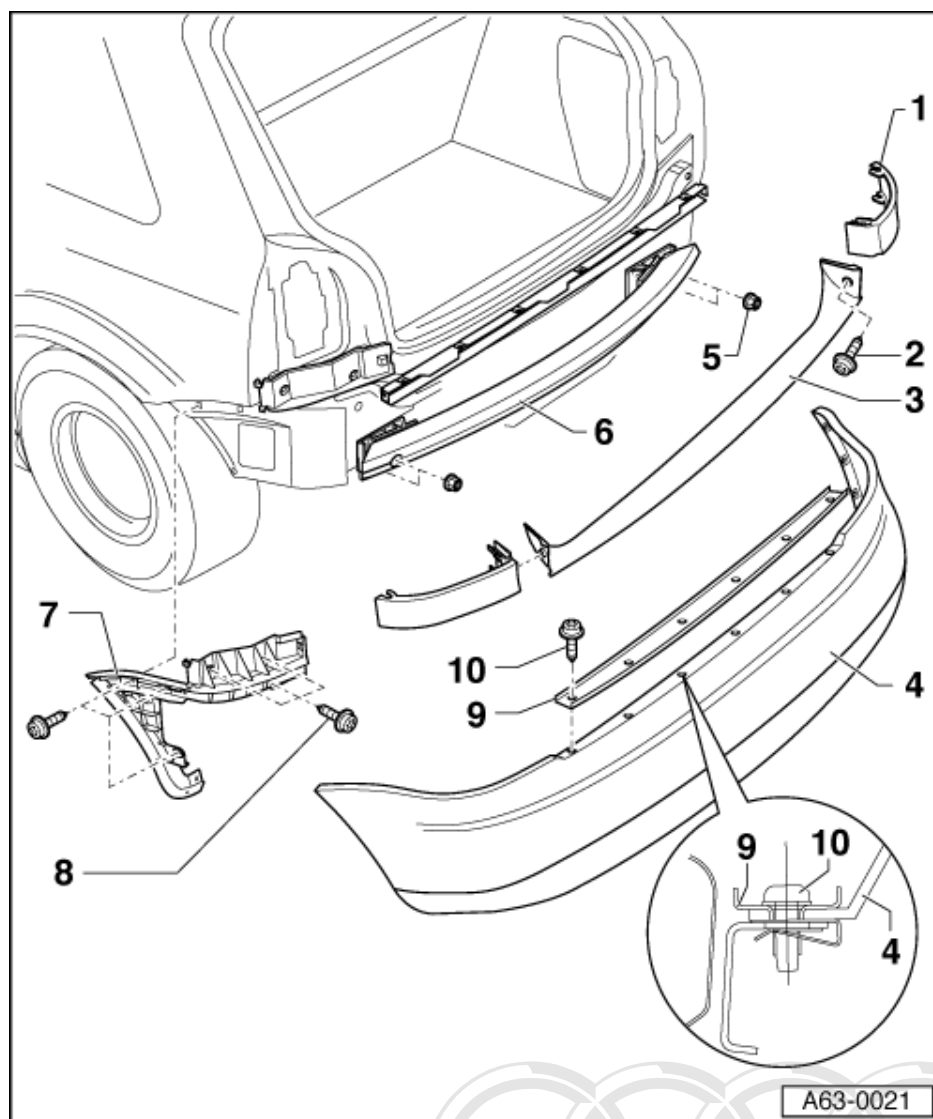
2 Spoiler

- ♦ Take off bumper cover before removing spoiler.
- ♦ To remove, drill off rivet head -3- unfasten catches -arrow- and remove spoiler.
- ♦ On installation, make sure catches engage fully.

3 Hollow rivet

3 - Rear bumper

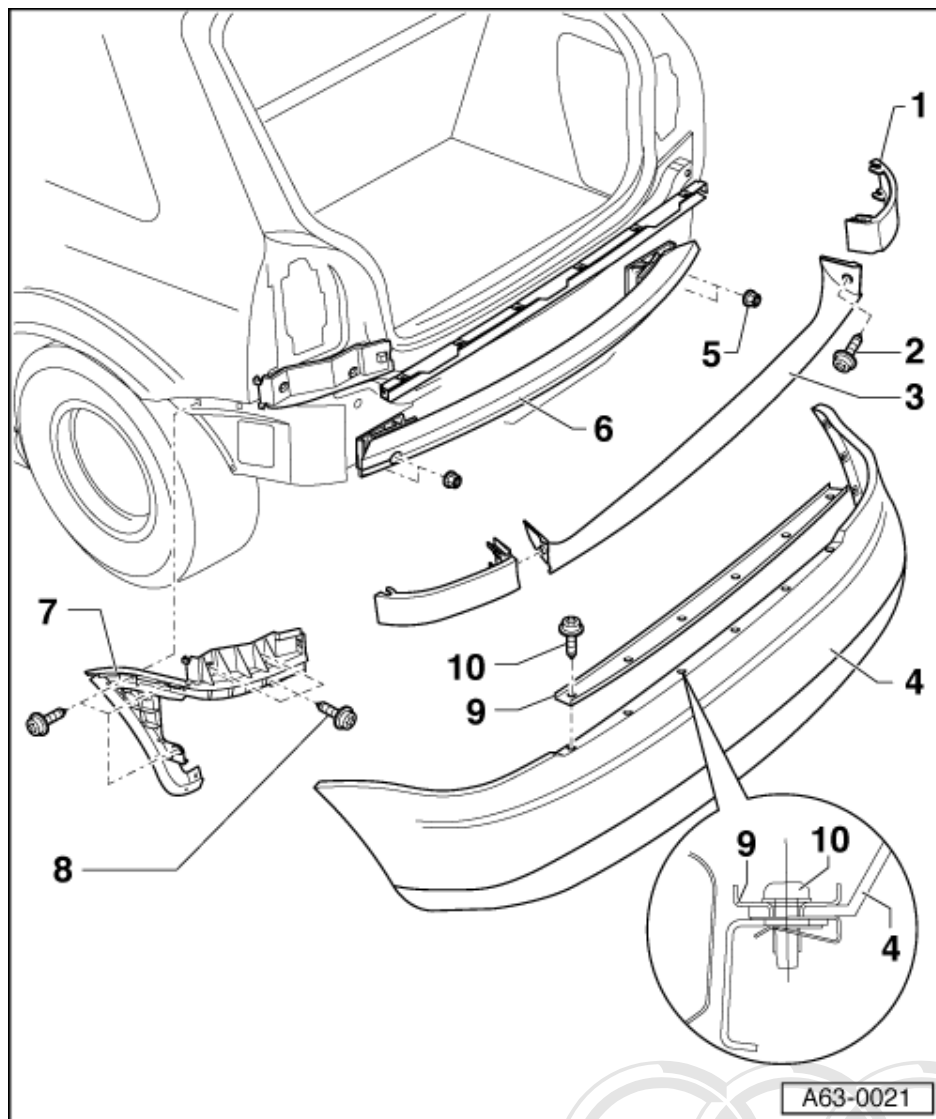
3.1 - Rear bumper



3.2 - Removing and installing rear bumper

- 1 **Panel**
 - ♦ To remove, unscrew bolt -2-.
- 2 **Self-tapping screw**
- 3 **Cover**
 - ♦ To remove, unscrew bolt -2- on left and right and remove both end piece -1- and cover
- 4 **Bumper cover**
 - ♦ Before removing dismantle end piece -1- and cover -3-.
 - ♦ Unscrew Torx bolts -10- and reinforcement -9-.
 - ♦ Unscrew three lower self-tapping screws at wheel housing liner on left and right.

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- ♦ First pull bumper cover out of top of guide -7- at the side, then lever over wheel housing liner and take off to the rear.

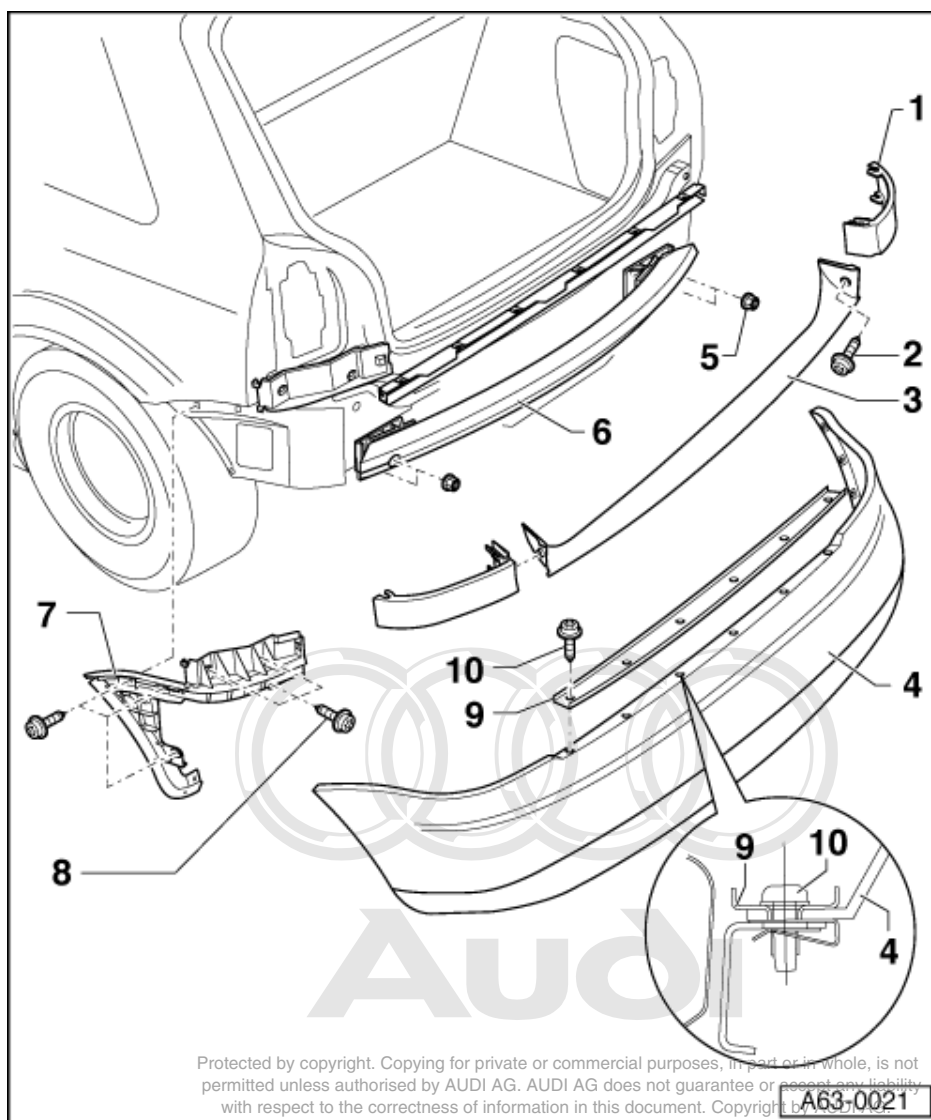
5 Hexagon nut

- ♦ 23 Nm.

6 Bumper

- ♦ End pieces -1- and cover -3- and bumper trim removed.
- ♦ To remove, unscrew hexagon bolts -5- and remove bumper.

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7 Guide piece

- ◆ Bumper cover removed.
- ◆ Unscrew self-tapping screws -8- and remove guide piece.

8 Self-tapping screw

- ◆ 1.5 Nm

9 Reinforcement

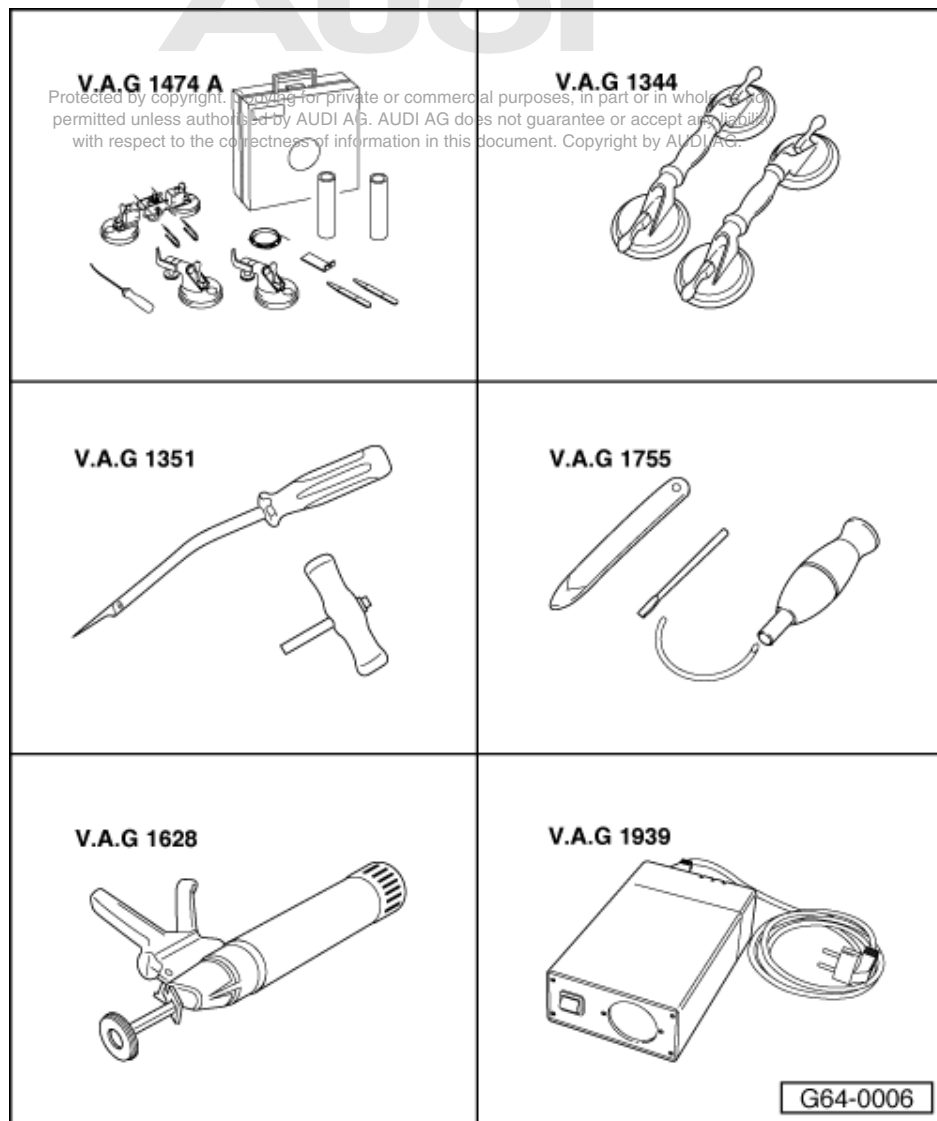
10 Self-tapping screw

- ◆ 1 Nm

64 - Glazing

1 - Flush-bonded windows

1.1 - Flush-bonded windows

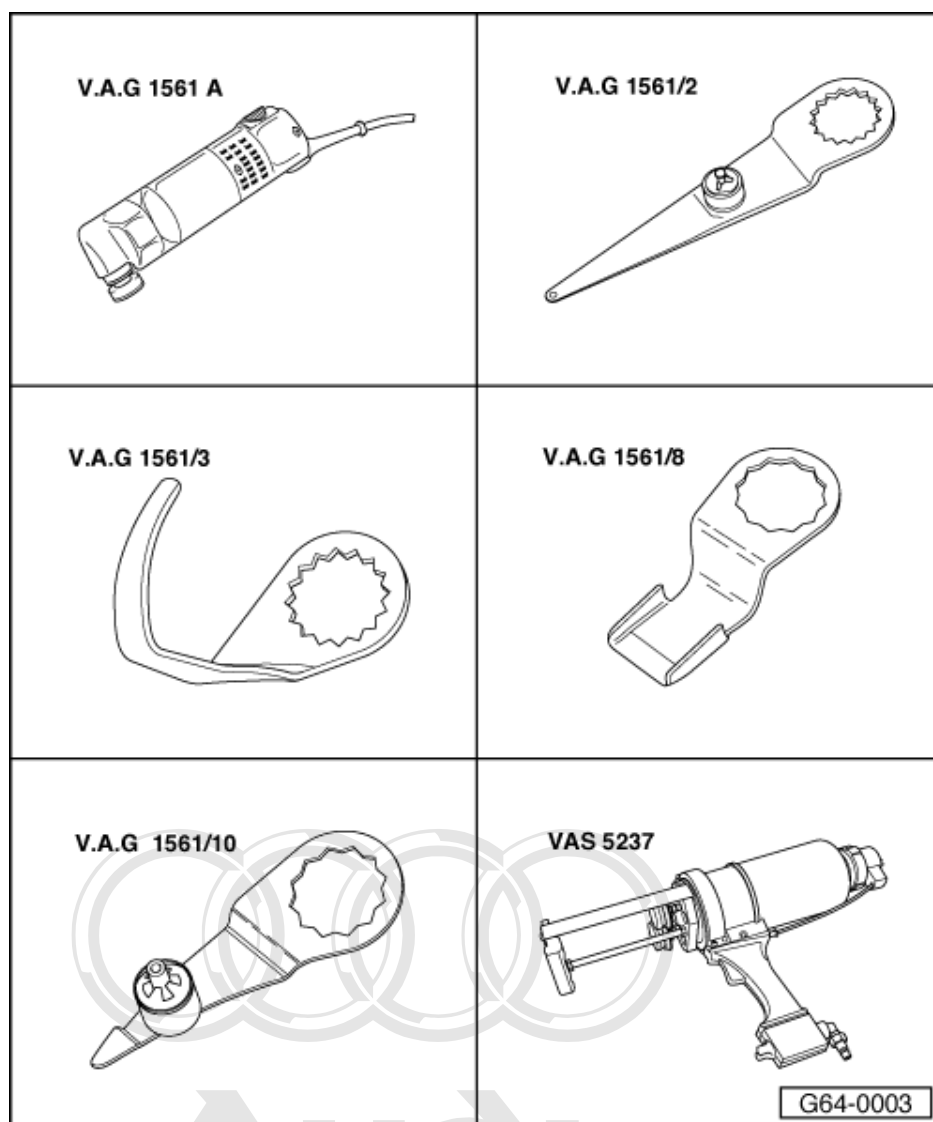


1.2 - Removing and installing flush-bonded windows - general

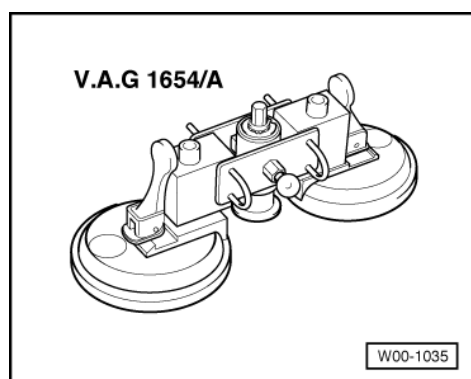
Special tools and workshop equipment required

- ♦ V.A.G 1474 A Cutting device for flush-bonded windows
- ♦ V.A.G 1344 Suction lifter
- ♦ V.A.G 1351 Cutting tool
- ♦ V.A.G 1755 Window removal kit
- ♦ V.A.G 1628 Hand cartridge gun

♦ V.A.G 1939 Cartridge heater



- ♦ V.A.G 1561 A Electric cutter
- ♦ V.A.G 1561/2 Cutting blade
- ♦ V.A.G 1561/3 Cutting blade
- ♦ V.A.G 1561/8 Scraper
- ♦ V.A.G 1561/10 Cutting blade
- ♦ VAS 5237 Double cartridge compressed air pistol





- ♦ Reel V.A.G 1654 A

1.3 - Repair work using special tool VAS 1993

Note:

Windscreens damaged by stone impact can be repaired using the windscreen repair kit VAS 1993.

The damaged areas must not exceed a certain size, and must not be within the main field of view.

For detailed instructions, refer to the manual supplied with each kit.

1.4 - Materials

- 2 component window adhesive DA 004 600 A2 1), 2)	
- 1 component window adhesive DH 009 100 03 3), 4)	
- Glass primer/paint primer	D 009 200 02
- Cleaning solution	D 009 401 04
- Primer applicator	D 009 500 25
- Adhesive remover	D 002 000 10
- Cutting cord	357 853 999
- Cutting wire	357 845 955

- 1) Observe minimum setting time =>Page 138
- 2) Double cartridge pistol VAS 5237 must be used for applying this material.
- 3) Heat according to manufacturer's instructions with cartridge heater V.A.G 1939
- 4) Miniature 110 ml cartridge for sealing and/or for when the 400 ml cartridge is insufficient

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1.5 - Minimum setting times.

Important

For safety reasons, when installing windscreen and rear windows, use only non-conductive 2-component adhesive with the designations listed below.

The vehicle is only safe to operate after the minimum setting times have elapsed, and must not be operated until then.

Type of window	Vehicle	Adhesive sealant	Curing time in hours.
Windscreen	With/without Airbag	DA 004 600 A2	3
Rear window		DA 004 600 A2	3
Side windows		DH 009 100 03	3

Cleaning off adhesive sealant

Adhesive remover D 002 000 10 is the recommended cleaning agent. Always follow the safety instructions.

Important

When cleaning from inside the vehicle passenger compartment, the window just fitted must not be pressed outwards.

Paint areas:

- Clean painted surface with a dry cloth. Remove residual dirt with adhesive remover D 002 000 10.

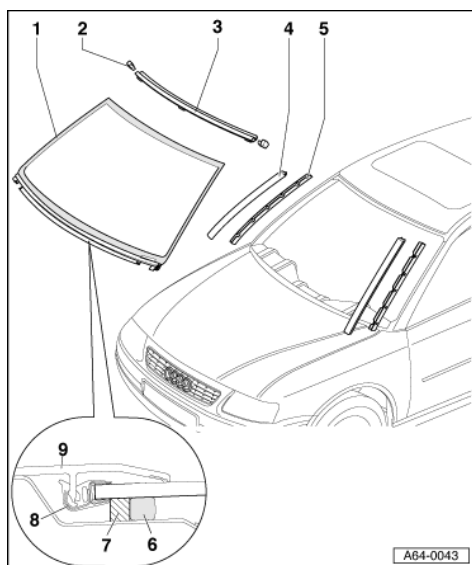
Plastic trim:

- Allow adhesive sealant to set (approx. 1 hour) and then detach.

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2 - Removing and installing windscreen

2.1 - Removing and installing windscreen



2.2 - Assembly overview

1 Windscreen

- ♦ Removing => Page 140
- ♦ Installing => page 144

2 Filler piece

- ♦ Press into end of trim cover

3 Trim cover

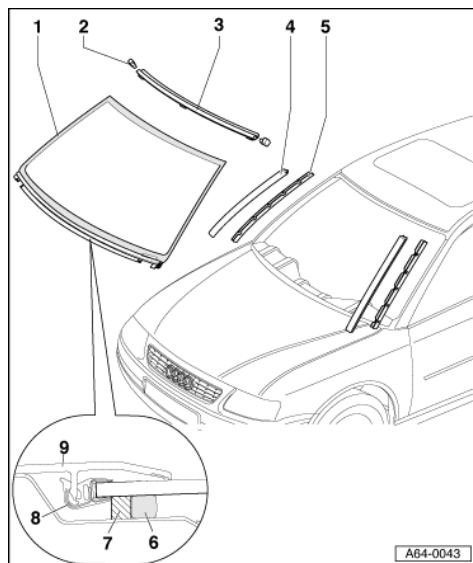
- ♦ Align notch on left and right on edge of windscreen and press on trim cover.

4 Rain gutter

- ♦ Do not press into fastening strip until windscreen adhesive has set.

5 Fastening strip

- ♦ Assembling => Page 143



6 Windscreen adhesive

- ♦ Note setting times => Page **138** .

7 Spacer

- ♦ Number and position => Page **144** .

8 Retaining strip for plenum chamber cover

- ♦ Is supplied together with windscreen.

9 Plenum chamber cover

- ♦ Do not press into retaining strip until windscreen adhesive has set.



2.3 - Removing windscreen

- Remove wiper arms.

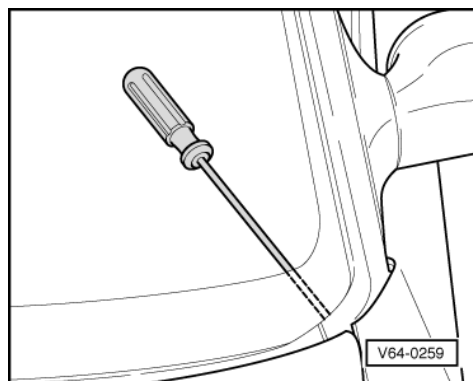
=> Electrical System; Repair group 92

- Remove cowl panel trim.
- Pull water deflector on left and right out of fastening strips starting at top.
- Remove sun visors on left, in centre and on right.

=> General Body Assembly, Interior; Repair group 70; Trims Trims

- Dismantle interior rear-view mirror.

=> General Body Assembly, Interior; Repair group 68; Interior mirror Interior mirror

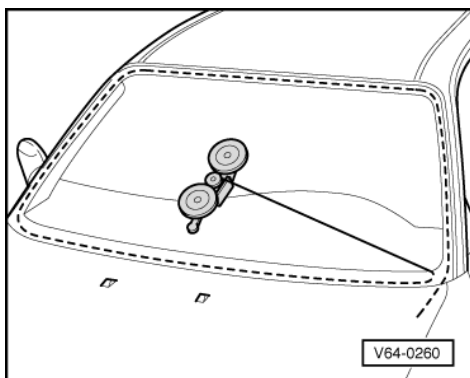


- Dismantle trim on top of A-pillars.

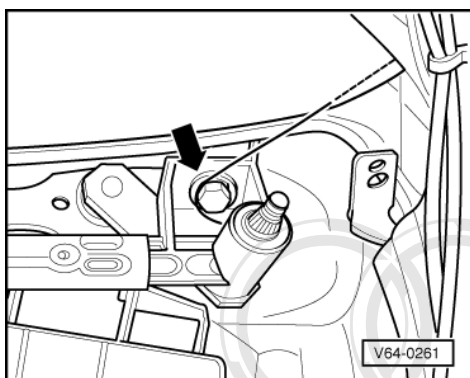
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=> General Body Assembly, Interior; Repair group 70; Trims Trims

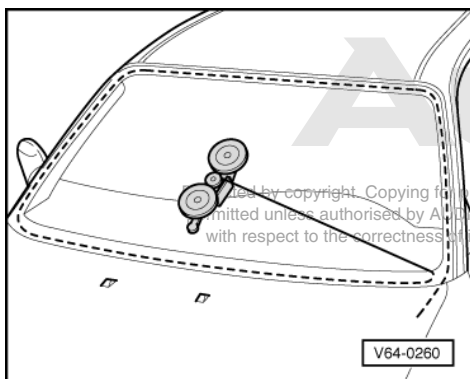
- Using an awl, pierce adhesive bead from inside at bottom left corner of windscreen.
- -> Insert cutting cord into awl and pull through into vehicle interior.



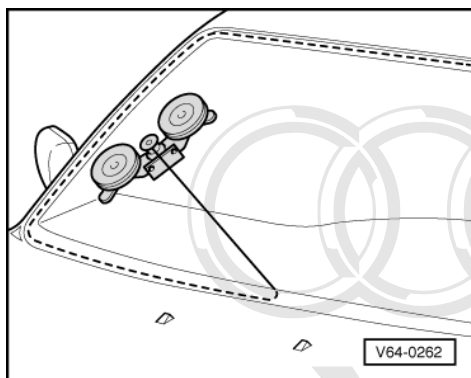
- -> Route cutting cord along entire underside of windscreen.



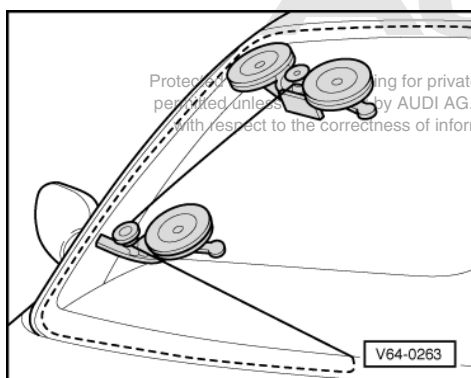
- -> Fasten end of cutting cord at bolt for securing wiper arms.



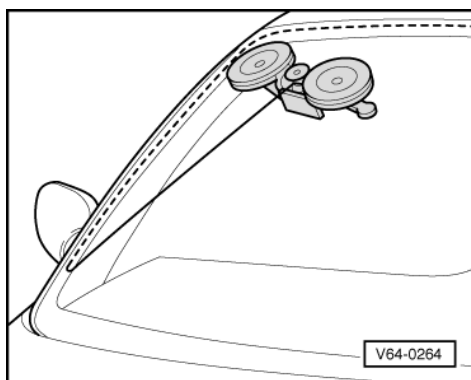
- Insert protective film V.A.G 1474/13 between windscreen and dash panel.
- -> Fasten end of cutting cord in reel and cut out first area (approx. as far as centre of windscreen).



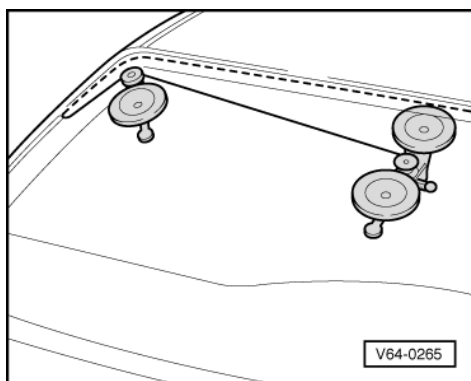
- -> Move reel as shown in illustration and continue cutting.



- -> Move reel as shown in illustration and attach guide roller.
- Route cutting cord as illustrated.
- Cut out glass up to the point where the cutting cord no longer runs in the guide roller.

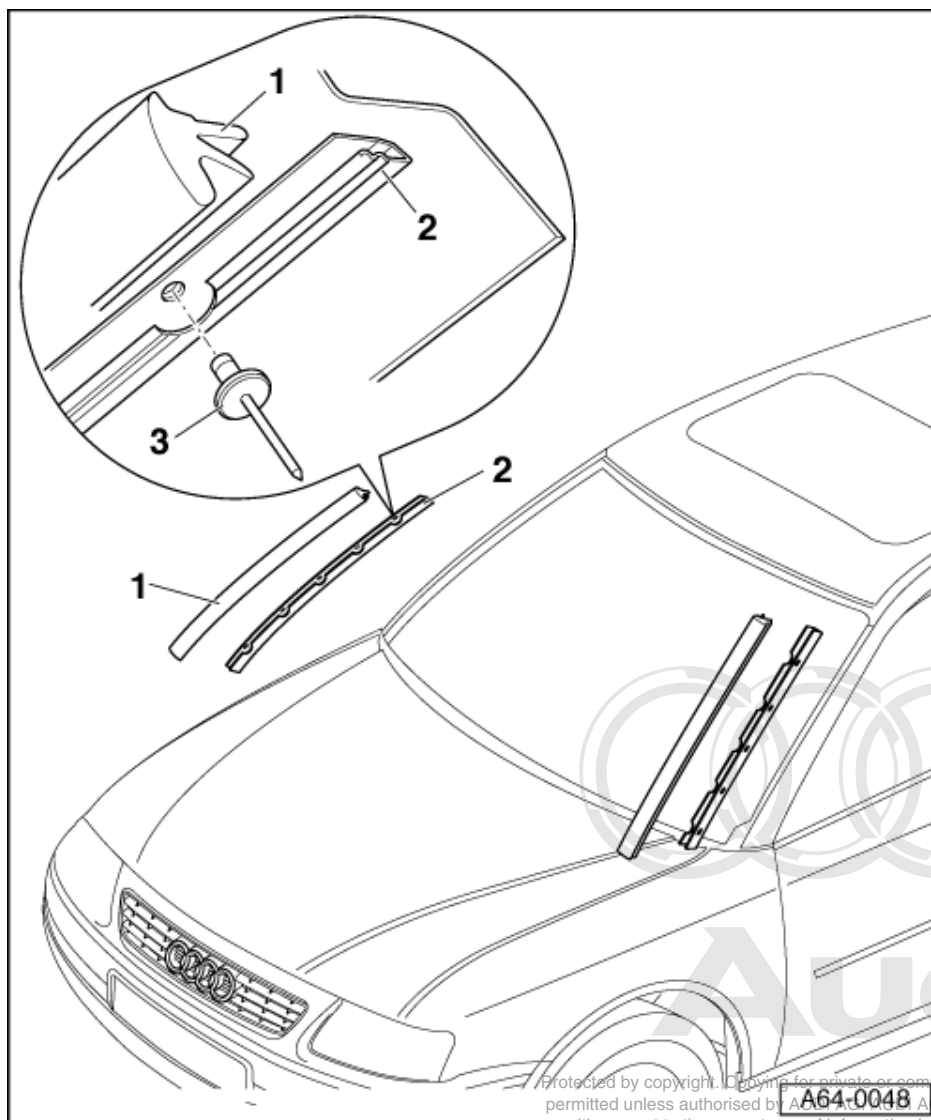


- -> Remove guide roller and continue cutting out window.



- -> Move reel as shown in illustration and attach guide roller in upper corner of windscreen.
- Route cutting cord as illustrated.
- Insert protective film V.A.G 1474/11 between windscreen and moulded headlining.
- Cut out glass up to the point where the cutting wire no longer runs in the relay pulley.
- Remove guide roller and continue cutting out window.
- Now repeat these steps in the top left and bottom left corners of the windscreen.
- Cut out the window glass completely according to these steps.
- Remove glass from window opening with double suction cups.

2.4 - Installing fastening strip for water collector moulding



1 Rain gutter

- ◆ Lever out of fastening strip, starting at bottom.
- ◆ To install, press into fastening strip from top to bottom.

2 Fastening strip

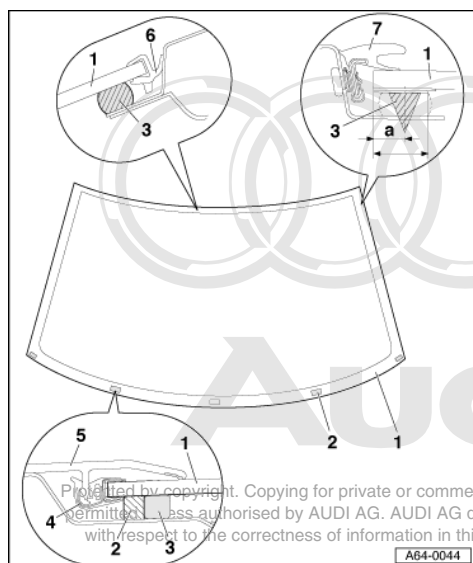
- ◆ Windscreen removed.
- ◆ To remove, drill head off hollow rivet -3-, and knock out shank.

3 Hollow rivet

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A64-0048

2.5 - Installing windscreen



Overview

1 Windscreen

- ♦ Applying primer => Fig.: 1
- ♦ Applying adhesive => Fig.: 2

2 Spacer

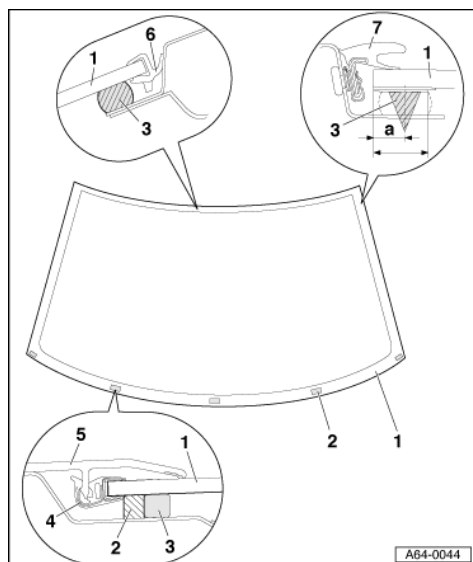
- ♦ Bond to lower edge of windscreen at intervals shown.
- ♦ Rest spacer against retaining strip as shown.

3 Windscreen adhesive

- ♦ Dimension for adhesive bead => Fig. 2
- ♦ Dimension -a- 8 mm $\pm$ 2 from edge of windscreen on all sides.
- ♦ Note setting times => Page 147.

4 Retaining strip for plenum chamber cover

- ♦ Supplied together with windscreen.



5 Plenum chamber cover

- ♦ Do not press into retaining strip until windscreen adhesive has set.

6 Trim cover

- ♦ Is supplied together with windscreen.

7 Rain gutter

- ♦ Do not press into fastening strip until windscreen adhesive has set.

2.6 - Preparation for windscreen installation

Preparing removed undamaged window for glazing

- When reusing an undamaged window, cut back remaining adhesive sealing material on the windscreen glass and body flange until it is even using electric cutter V.A.G 1561 and scraper V.A.G 1561/10. Do not remove adhesive sealing material completely.
- The remaining material serves as a bonding surface for new adhesive sealant to be applied.

Important

Keep bonding surface clean and free from grease.
Do not trim bonding surface until shortly before installation.
Do not prime bonding surfaces and do not treat with cleaning solution.

New window

- Clean bonding area all round windscreen with cleaning fluid (D 009 401 04)
- Apply primer (D 009 200 02) as described below.

Important

Ceramic layer on windscreens is not a primer. Priming must always be performed before applying adhesive sealant.

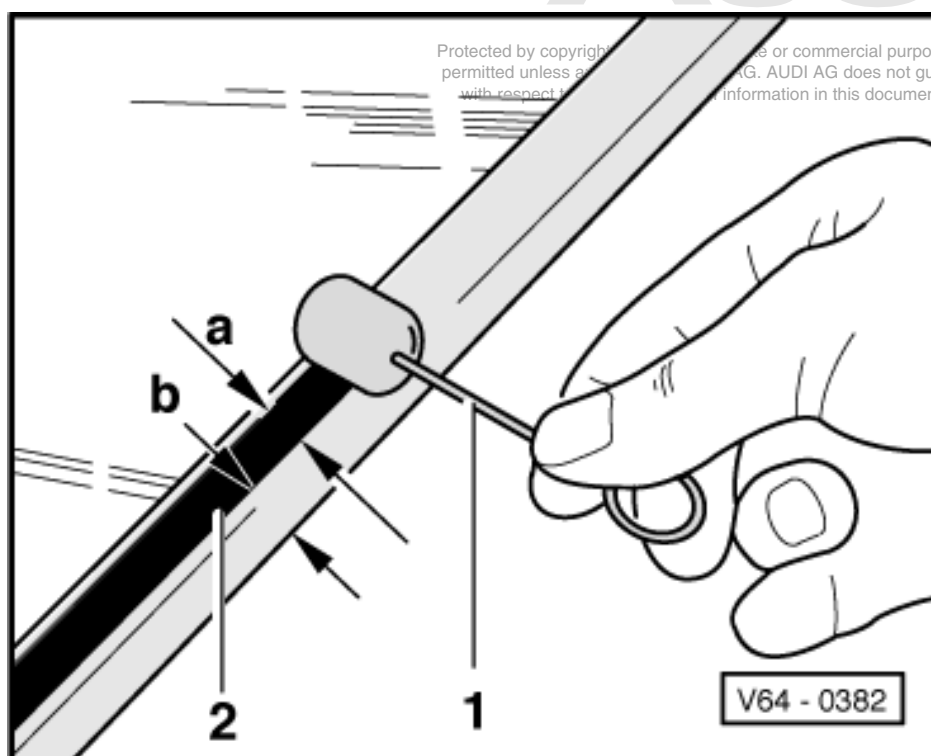


Fig.1 Applying primer

- -> Apply primer -2- evenly in one operation with applicator -1-.
- Start application with fully soaked felt.
- Drying time approx. 10 minutes.
- Primer width dimension -a- ca. 20 mm.

- Apply primer centrally in relation to adhesive bead.

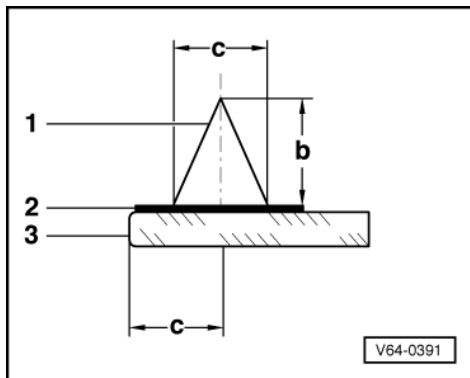
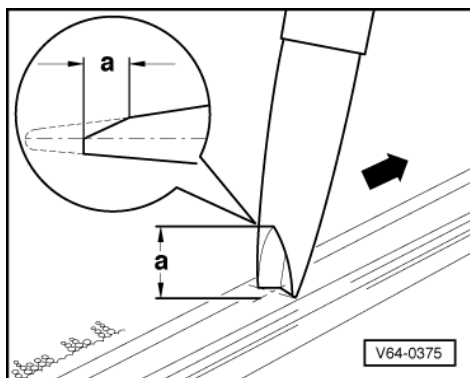


Fig.2 -> Dimensions for applying adhesive

- Adhesive bead -1-.
- Primer -2-
- Windscreen -3-.
- Dimension -a- = 8 mm
- Dimension -b- = 12 mm.
- Dimension -c- = 8 mm from edge of windscreen on all sides.

Repaired windscreen flange

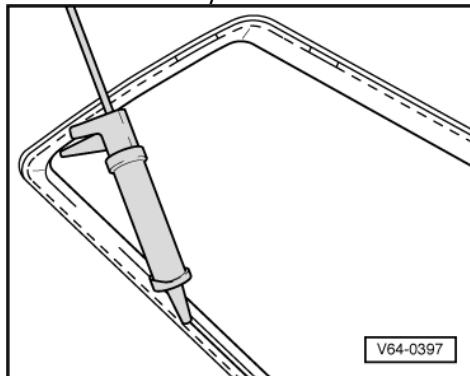
- If the windscreen flange has been repaired or replaced, the paintwork must be restored according to specifications in the "Vehicle Painting" manual and corrosion protection applied if necessary according to the "Surface Treatment/Chemical Materials" Workshop Manual.
- Clean the repaired area with D 009 401 04, then prime with D 009 200 02.



- -> After performing the preparatory work, cut the tip of the nozzle to shape as shown in illustration.
- Dimension -a- = 12 mm.
- Width of adhesive bead 8 mm.
- Application direction -arrow-.

Note:

The size and shape of the adhesive bead is determined by the nozzle opening and the rate of application.



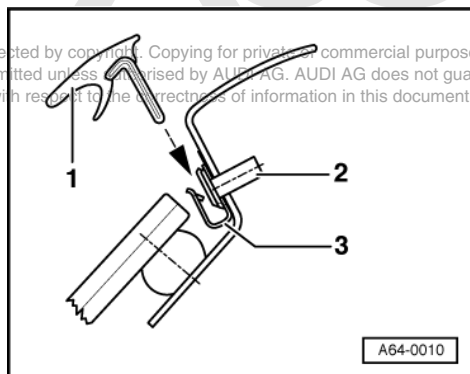
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- -> Apply adhesive sealant to perimeter of windscreen as shown in illustration.
- Spacing between centre of adhesive bead and edge of windscreen is 8 mm.
- Using two double suction cups, install windscreen glass in windscreen opening.

Important

Windscreen must be inserted within 15 minutes, otherwise the adhesive properties of the adhesive sealant will be impaired.

- Laterally align window.
- Distance between windscreen trim cover and roof frame must be 4 mm.



- -> Once adhesive -1- has set press home rain gutter in retainers -3-.
- When pressing in, ensure sealing lip of rain gutter is positioned on windscreen and does not slip behind edge of windscreen.
- Hollow rivet -2-.
- Secure window glass in position in window opening with adhesive tape.

2.7 - Minimum setting times.

Important For safety reasons, when installing windscreen and rear windows, use only non-conductive 2-component adhesive with the designations listed below. The vehicle is only safe to operate after the minimum setting times have elapsed, and must not be operated until then.

Type of window	Vehicle	Adhesive sealant	Curing time in hours.
Windscreen	With/without Airbag	DA 004 600 A2	3
Rear window		DA 004 600 A2	3
Side windows		DH 009 100 03	3

Cleaning off adhesive sealant

Adhesive remover D 002 000 10 is the recommended cleaning agent. Always follow the safety instructions.

Important

When cleaning from inside the vehicle passenger compartment, the window just fitted must not be pressed outwards.



Paint areas:

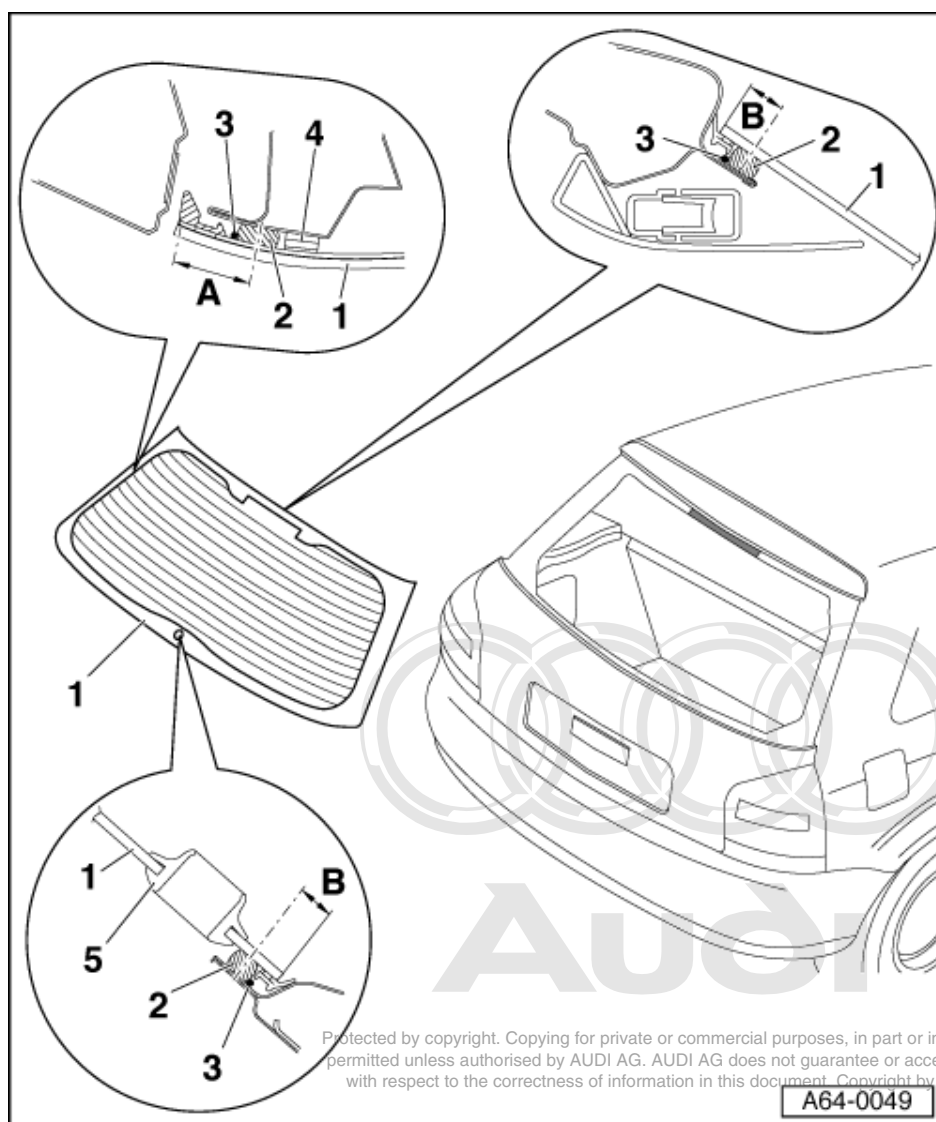
- Clean painted surface with a dry cloth. Remove residual dirt with adhesive remover D 002 000 10.

Plastic trim:

- Allow adhesive sealant to set (approx. 1 hour) and then detach.

3 - Removing and installing rear window

3.1 - Removing and installing rear window



3.2 - Assembly overview

Note:

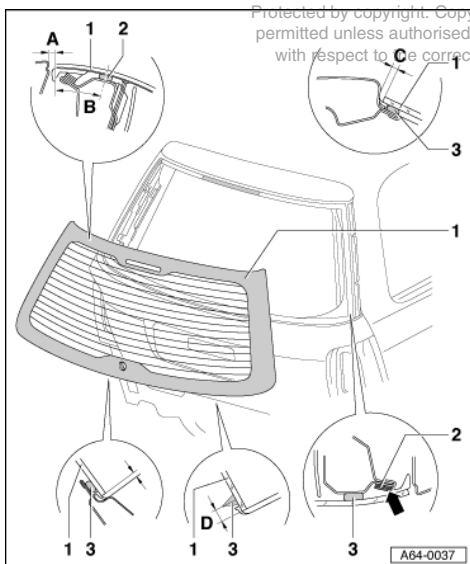
Cut out rear window using cutting cord 357 845 955 and special tool V.A.G 1655

1 Rear window

- ♦ Removing intact window =>Page 150 .
- ♦ Removing broken window =>Page 152 .

2 Adhesive bead

- ♦ Note different distances from edge of windscreen.
- ♦ Distance from side edge of window, dimension -B- = 38 mm.
- ♦ Distance from top and bottom edge of window, dimension -D- = 12 mm.
- ♦ Dimensions for application of adhesive and cross section of adhesive bead =>Page 153



3 Cutting cord

- ♦ Place around entire window from outside and pull both ends through into interior of vehicle using piercing awl.

Important

When drawing in cutting cord and performing subsequent cutting operations, visible sprayed surrounds must under no circumstances be damaged.

4 Velcro fastening strip

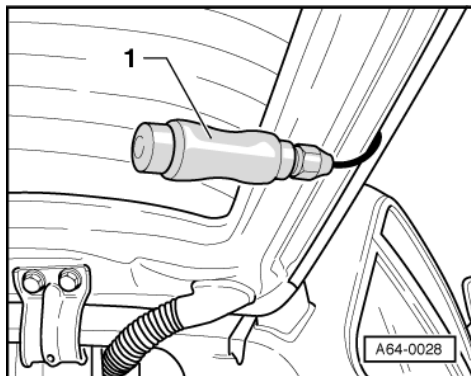
- ♦ Only required in the factory; can be removed.

5 Sleeve for rear window-wiper

Important

When installing the window, the wiper motor axle must be centred in the sleeve to prevent leakage.

3.3 - Removing an intact rear window



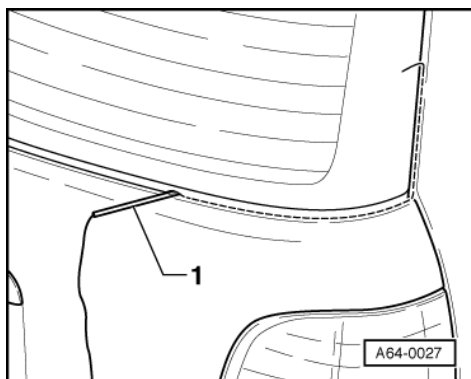
- Removing tailgate interior trims

=> General Body Assembly, Interior; Repair group 70; Trims Trims

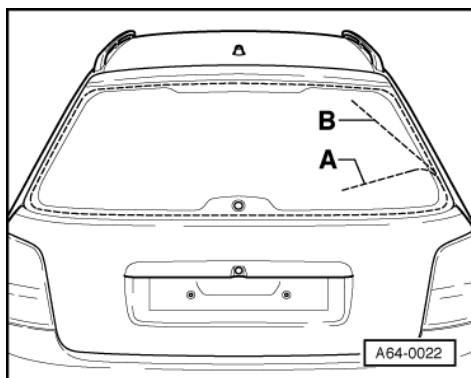
- Remove rear window wiper

=> Electrical System; Repair group 92

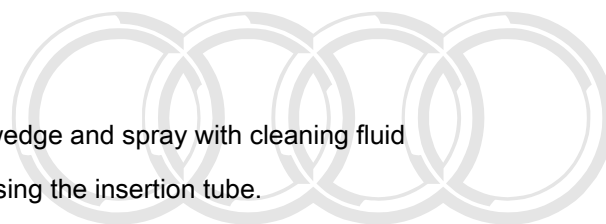
- -> Open tailgate and use handle -1- to guide trimming needle beneath sealing lip and pierce adhesive bead.
- Unscrew handle and insert cutting cord in eye of needle.
- Pull one end of cutting cord into interior of vehicle; use pliers and wear gloves.



- Detach sealing lip from window flange with plastic wedge and spray with cleaning fluid D009 401 04 (lubricant substitute).
- -> Place other end of cutting cord around window using the insertion tube.

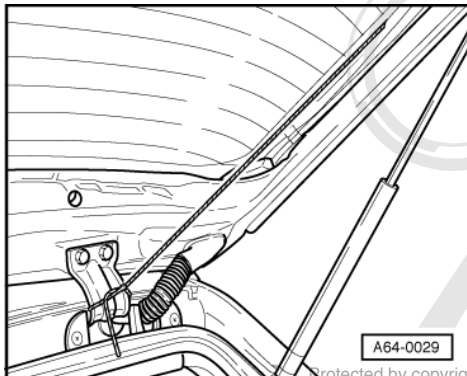


- -> Pull second end of cutting cord -B- into interior of vehicle as shown using trimming needle and handle.
- Enter end of cutting cord -A- in winding device V.A.G 1654 and secure.

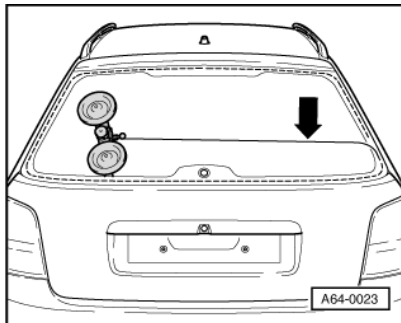


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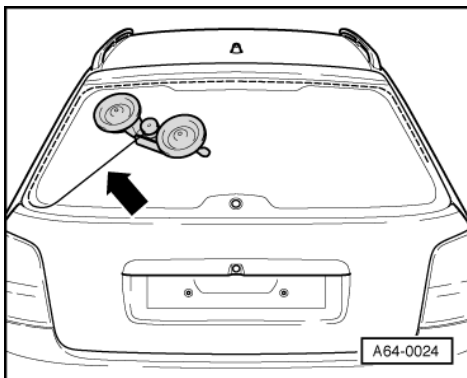
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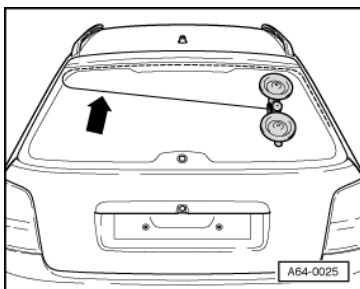
- -> Attach end of cutting cord **B** to tailgate hinge.



- -> Fasten winding device V.A.G 1654 to rear window as shown.
- Press cutting cord in direction of arrow while cutting along side of window.
- Cut out window at the bottom.



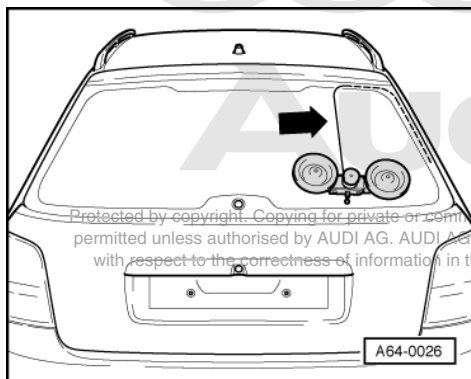
- -> Move winding device and cut out window.
- Press cutting cord in direction of arrow while cutting along -bottom of window-.
- Cut out window at the side.



- Move reel and cut out window.
- -> Press cutting cord in direction of arrow while cutting along side of window.



- Cut out window at the top.



- Move reel and cut out window.
- -> Press cutting cord in direction of arrow while cutting along top of window.
- Completely cut out window and remove from tailgate using double suction cups V.A.G 1344.

3.4 - Removing a broken rear window

- Protect body and passenger compartment against glass splinters.
- Remove pieces of glass up to adhesive sealant.
- Detach connections for rear-window heating.
- Mask flange all round with fabric-reinforced adhesive tape.
- Cut through adhesive sealant (with remaining glass) in window opening using electric cutter and blade V.A.G 1561/10 (with stop roller).

Important
Always wear protective goggles and leather gloves.

3.5 - Preparation for rear window installation

Window removed intact

Note:

If an intact window is to be re-used, trim back adhesive sealant left on window and window flange with electric cutter V.A.G 1510 and scraper V.A.G 1510/8, but do not remove adhesive sealant completely.

The remaining material serves as a bonding surface for new adhesive sealant to be applied.

Keep bonding surfaces clean and free from grease.

Do not prime bonding surfaces and do not treat with cleaning fluid.

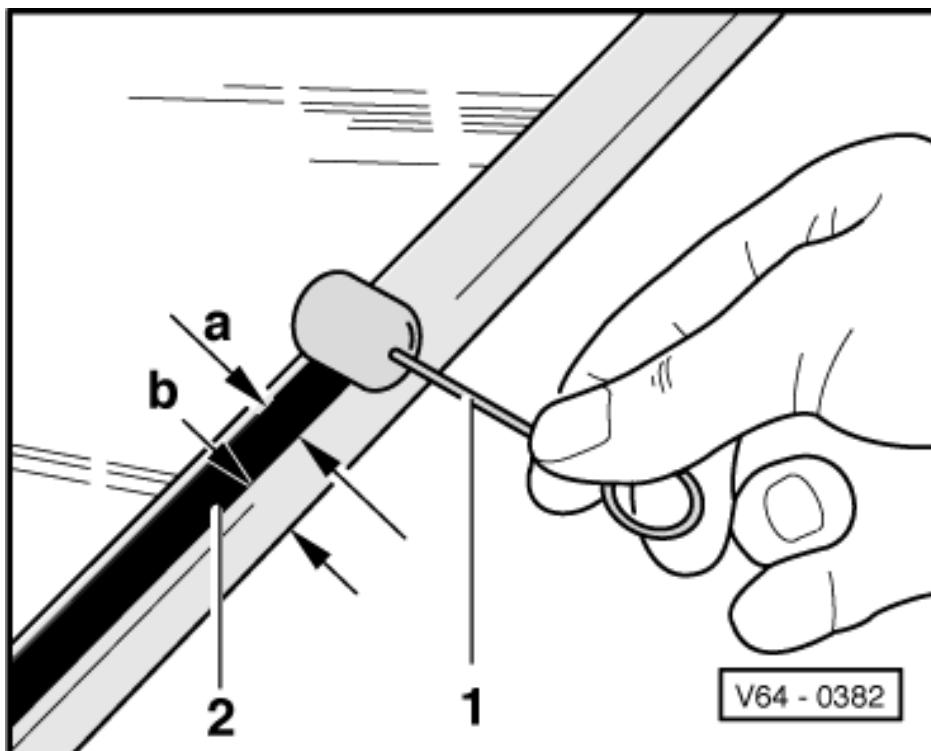
If the window flange is damaged when the window is cut out, make good the paint coating as specified in the vehicle paintwork manual and apply corrosion protection, if necessary as described in the "Surface Treatment/ Chemical Materials" binder.

New window

- Clean window all around bonding area with cleaning fluid Part-No. D 009 401 04.
- Primer window all around bonding area with D 009 200 02.

Important

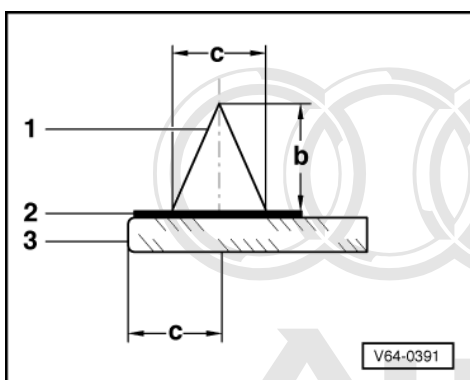
Ceramic layer on windcreens is not a primer. Priming must always be performed before applying adhesive sealant.



- -> Apply primer -2- D 009 200 02 evenly all around the window using applicator -1- Part-No. D 009 500 25 (felt pad with wire).
- Distance from edge of window at top and bottom 12 mm $\pm$ 2 mm.
- Distance from side edges of window 38 mm -1.5 mm.
- Drying time approx. 10 minutes.
- Primer width = 22 mm.

Note:

Allow primer to dry before touching-up primer strip.



-> Cross-section of adhesive bead.

- Adhesive bead- 1-
- Primer- 2-
- Windscreen- 3-
- Dimension -a- = 8 mm
- Dimension -b- = 12 mm.
- Distance from edge of window at top and bottom 12 mm $\pm$ 2 mm.

- Distance from side edge of window 38 mm -1.5 mm.

3.6 - Installation instructions

- Apply adhesive all round cleaned and primed window.
- Note different distances from edge of window =>Page 153 .

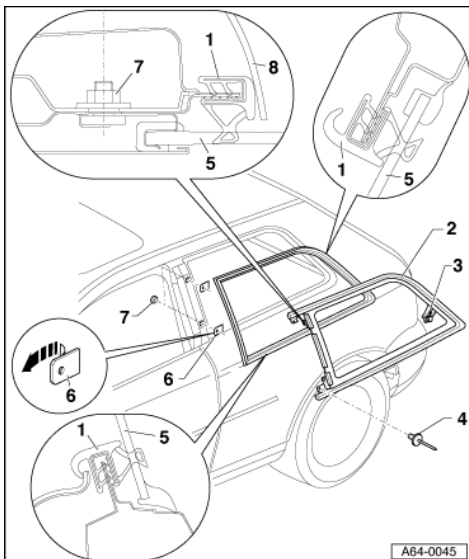
Important

Windscreen must be inserted within 15 minutes, otherwise the adhesive properties of the adhesive sealant will be impaired.

- Use double suction cups to enter window in opening, align and press in as far as spacer of trim strip.
- Secure window glass in position in window opening with adhesive tape.
- Setting time 3 hours.

4 - Removing and installing side window - 3-door vehicles

4.1 - Removing and installing side window - 3-door vehicles



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4.2 - Assembly overview

1 Seal

- ◆ Before removing:
 - Take out rear seat bench and backrest.

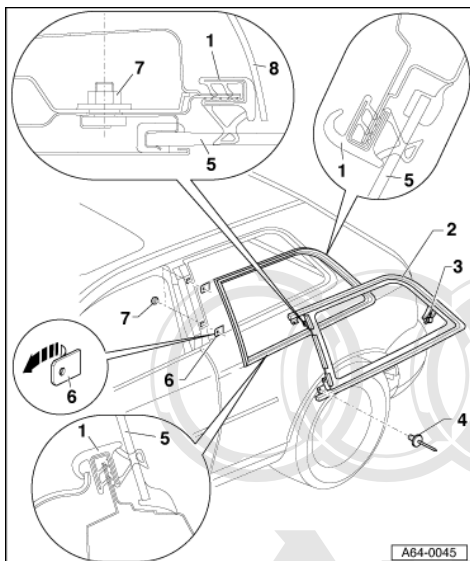
=> General Body Assembly; Repair group 72

- Also remove side trim and -B- pillar trim.

=> General Body Assembly; Repair group 70

- Unbolt tilt mechanism from side window on body side.
- Pull seal out of window opening.

- Press new seal onto window flange.



2 Side window

- ◆ Before removing:
 - Take out rear seat bench and backrest.

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=> General Body Assembly; Repair group 72

- Also remove side trim and -B- pillar trim.

=> General Body Assembly; Repair group 70

- ◆ To remove:
 - Unscrew tilt mechanism -3- on body end => Page 156
 - To remove, drill head off hollow rivet -4-, and knock out shank.
 - Unscrew hexagon bolt -7-.
 - Remove side window from opening.

3 Tilt mechanism

- ◆ Removing => Page 156

4 Hollow rivet

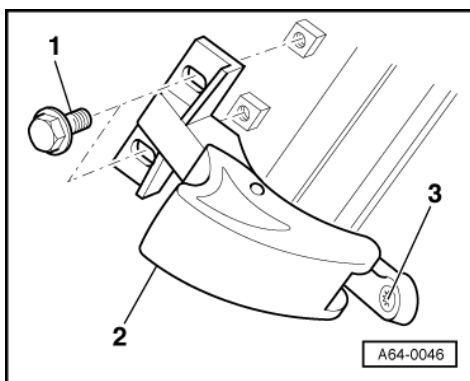
5 Shim plate

- ◆ Pull off protective film.

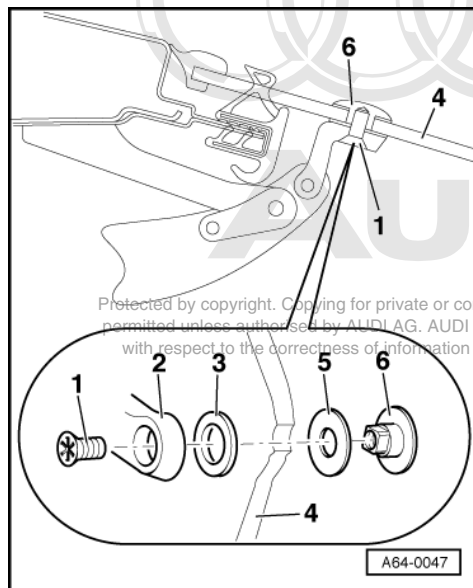
6 Hexagon nut

- ◆ 8 Nm

4.3 - Removing and installing tilt mechanism.



- Unscrew hexagon bolts -1-.
- Tightening torque 8 Nm.
- Unscrew Torx bolt -3-.
- Tightening torque 5 Nm.

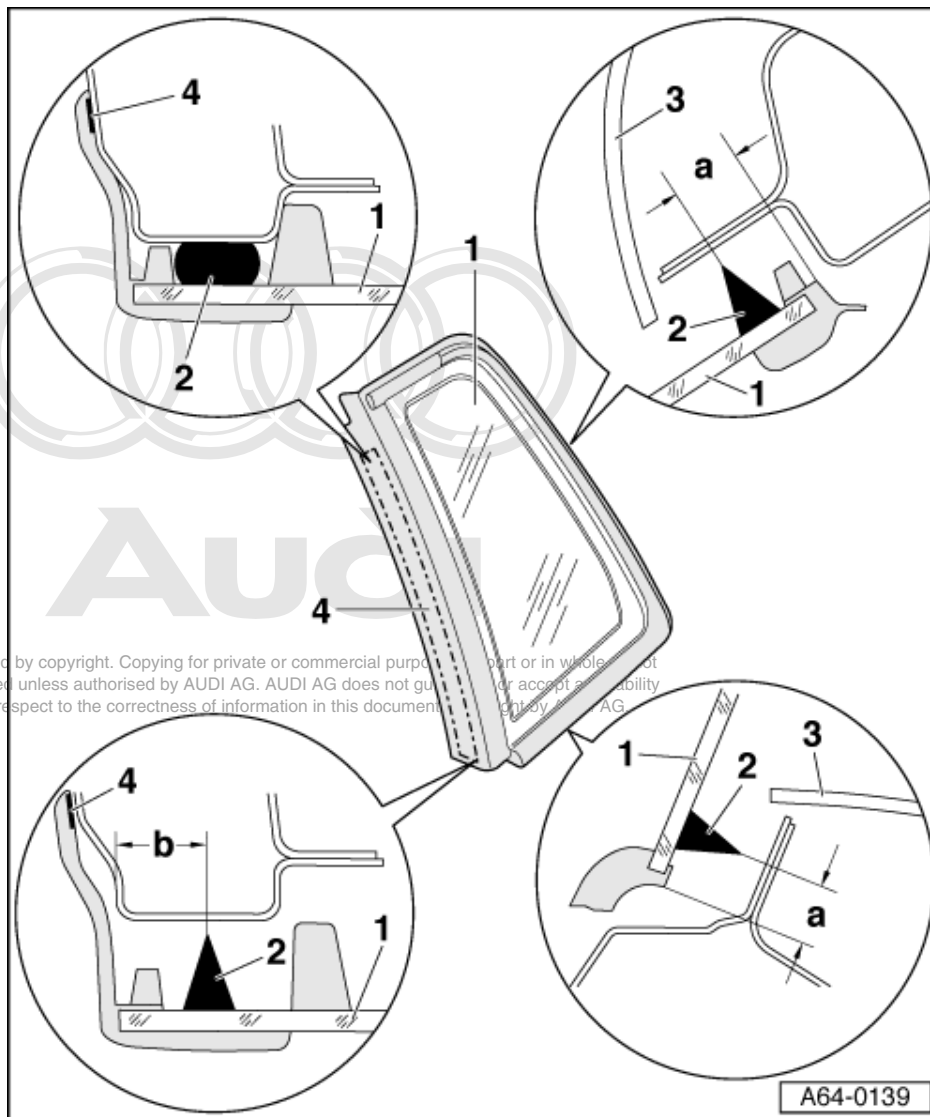


-> Position of individual components

- Secure Torx bolt -1- on installation with D 000 600 A2 and tighten to 5 Nm.
- Tilt mechanism -2-
- Sleeve -3-
- Side window -4-
- Windscreen -5-
- Nut -6-.

5 - Removing and installing side window - 5-door vehicles

5.1 - Removing and installing side window - 5-door vehicles



5.2 - Assembly overview

1 Side window

- ♦ Removal => Page 158 .

2 Adhesive bead

- ♦ Distance from edge of window:
 - a = 12mm
 - b = 14mm

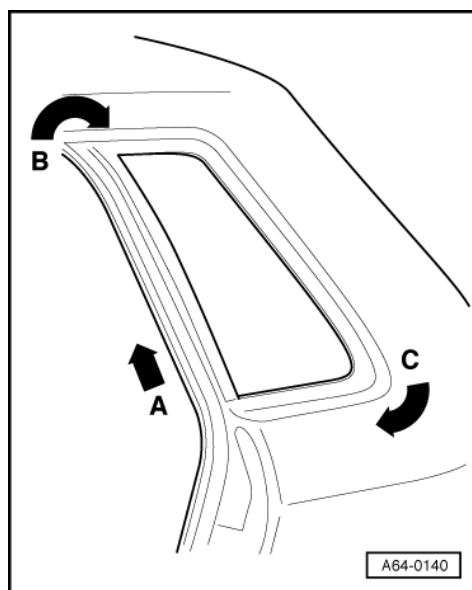
3 C/D-pillar trim

- ♦ Removed:

4 Adhesive tape

- ♦ Do not remove protective film and attach to C-pillar until side window has been installed.

5.3 - Removing an intact window

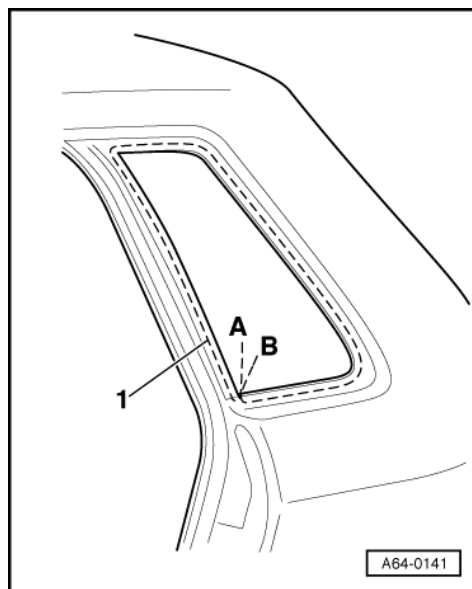


- Pierce through from the inside to the outside in area of C-pillar bottom/side panel using an awl.
- Insert cutting cord into piercing awl and draw cord from outside into vehicle interior.

Important

To avoid paintwork damage, mask over transition between PVC coating and D-pillar and side panel with adhesive tape.

- -> Lay cutting cord on C-pillar from bottom to top -arrow A- under PVC coating.
- Press cutting cord onto D-pillar from top to bottom -arrow B- under the PVC coating, then press between side panel and window in direction shown -arrow C-.



- Pierce through from the inside to the outside in area of C-pillar bottom/side panel using an awl.
- Insert end of cutting cord into piercing awl and again pull into vehicle interior.
- Routing cord -1-.
- -> Secure cutting cord with ends -A- and -B- in two pull handles.
- Pull cutting wire through adhesive sealant towards the interior, thus completely cutting free the window.

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Important Under no circumstances must the PVC coating be damaged in the visible area. Window is considered destroyed if coating is damaged in visible area.

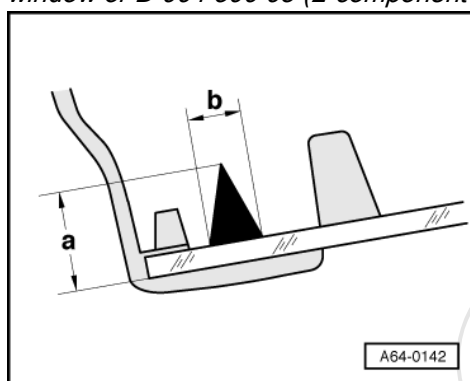
5.4 - Installing an intact window

- When re-using an undamaged window, shortly before installing, smooth down adhesive sealant residue on the window pane and window flange with a carpet knife. Under no circumstances remove completely.
- Remaining material serves as a bonding surface for the new adhesive sealant when it is applied.
- Keep bonding surfaces clean and free from grease.

Important

Note:

It is recommended to use adhesive sealing material D 009 100 03 (small cartridge) for bonding on a single window or D 004 300 05 (2-component adhesive) for more than one window.



- -> Apply adhesive sealant centrally all round residual material on window.
- Dimension -a- = 12 mm
- Dimension -b- = 8 mm.

Note:

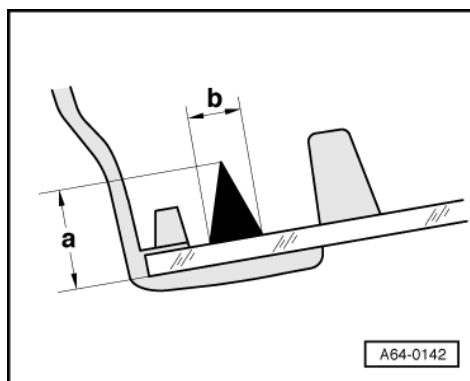
The height of the adhesive bead should be reduced by the height of the remaining residue on the window and the flange.

- Insert window in window opening, align all the way around, press home and fix in position with adhesive tape.

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5.5 - Installing new side window

- Clean new window all around bonding area with cleaning fluid Part-No. D 009 401 01.
- Prime window in bonding area with D 009 200 02.
- Apply adhesive sealant centrally all round residual material on window.





- -> Dimensions for applying adhesive bead.
- Dimension -a- = 12 mm.
- Dimension -b- = 8 mm

Important

Note:

It is recommended to use adhesive sealing material D 009 100 03 (small cartridge) for bonding on a single window or D 004 300 05 (2-component adhesive) for more than one window.

Important

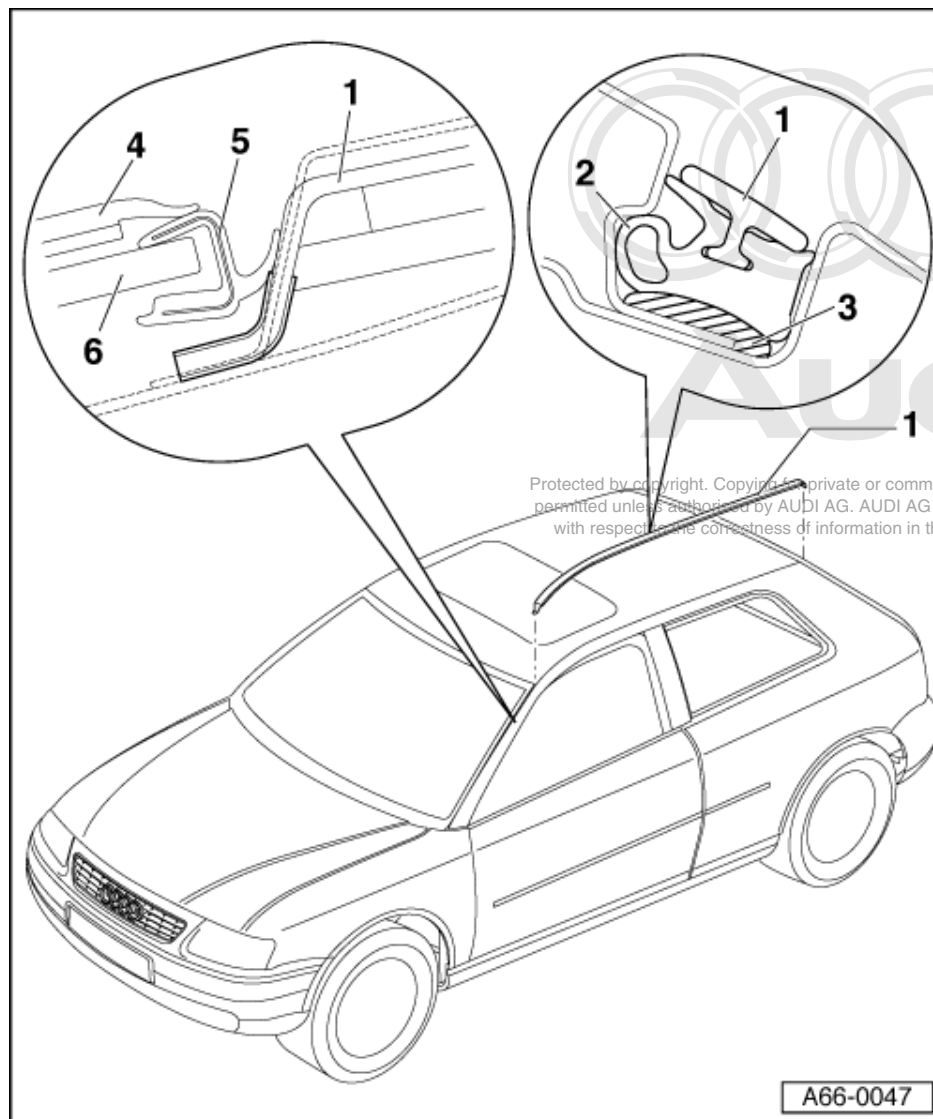
Windscreen must be inserted within 10 minutes, otherwise the adhesive properties of the adhesive sealant will be impaired.

- Insert window in window opening, align all the way around, press home and fix in position with adhesive tape.
- Setting time for DH 009 100 is 3 hours.

66 - Exterior equipment

1 - Roof strips

1.1 - Roof strips



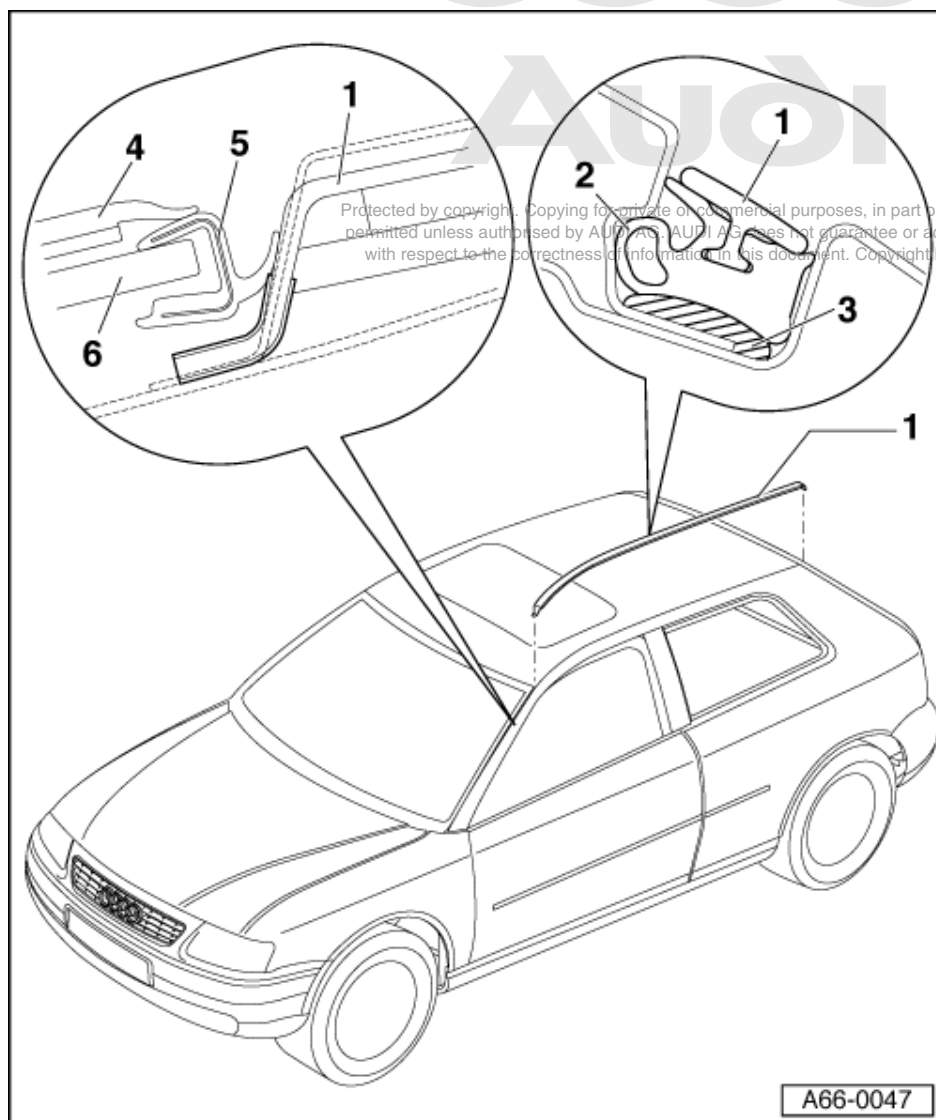
1.2 - Removing and installing roof joint strip

1 Roof joint strip

- ◆ Removal:
 - With tailgate open, carefully lever out of roof seam together with roof seal, starting from the rear.
- ◆ Installation:
 - Fit roof seal onto roof seam moulding.



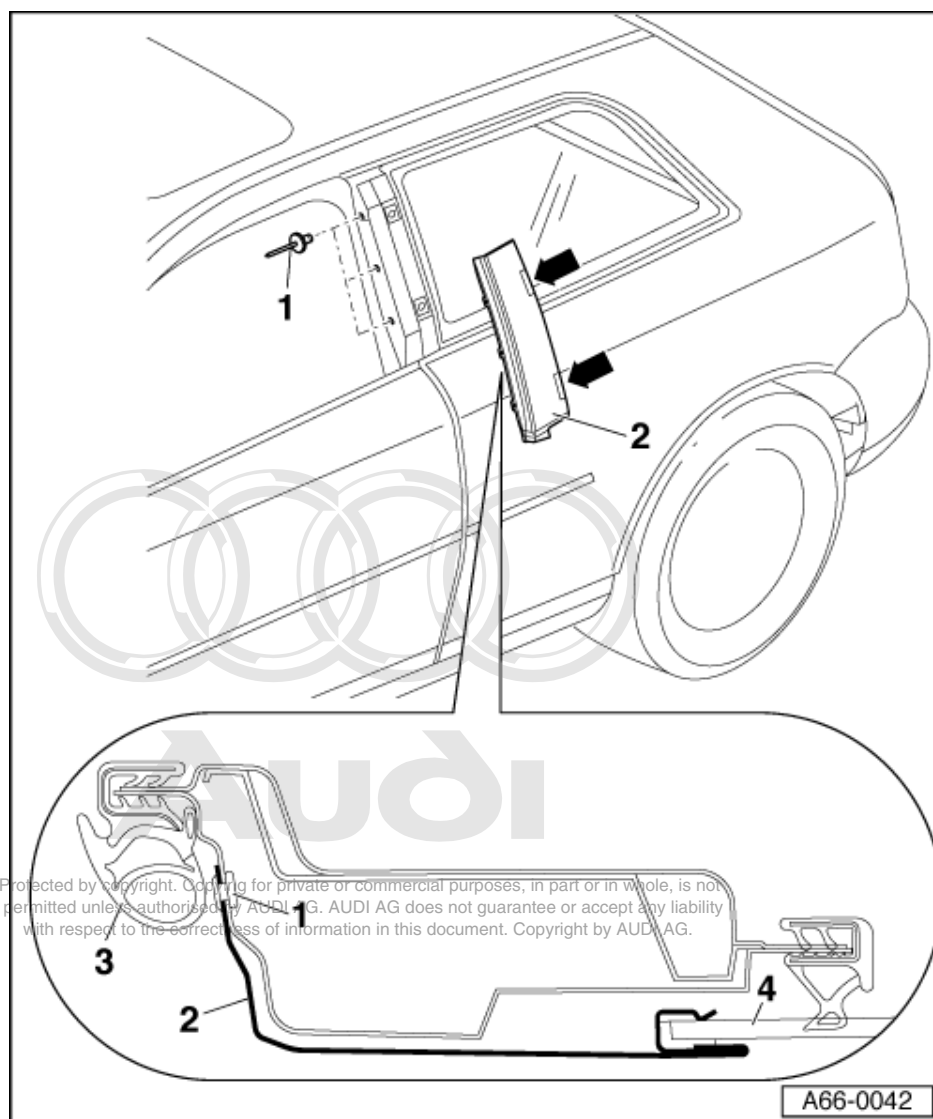
- Insert roof seam moulding under trim cover -5- at windscreen -6- and then press into roof seam section by section, working towards the rear.



- 2 Roof seal
 - ♦ Press into roof seam together with roof seam moulding.
- 3 Sealing compound
- 4 Rain gutter
- 5 Trim cover
 - ♦ Supplied together with windscreen.
- 6 Windscreen

2 - Trims

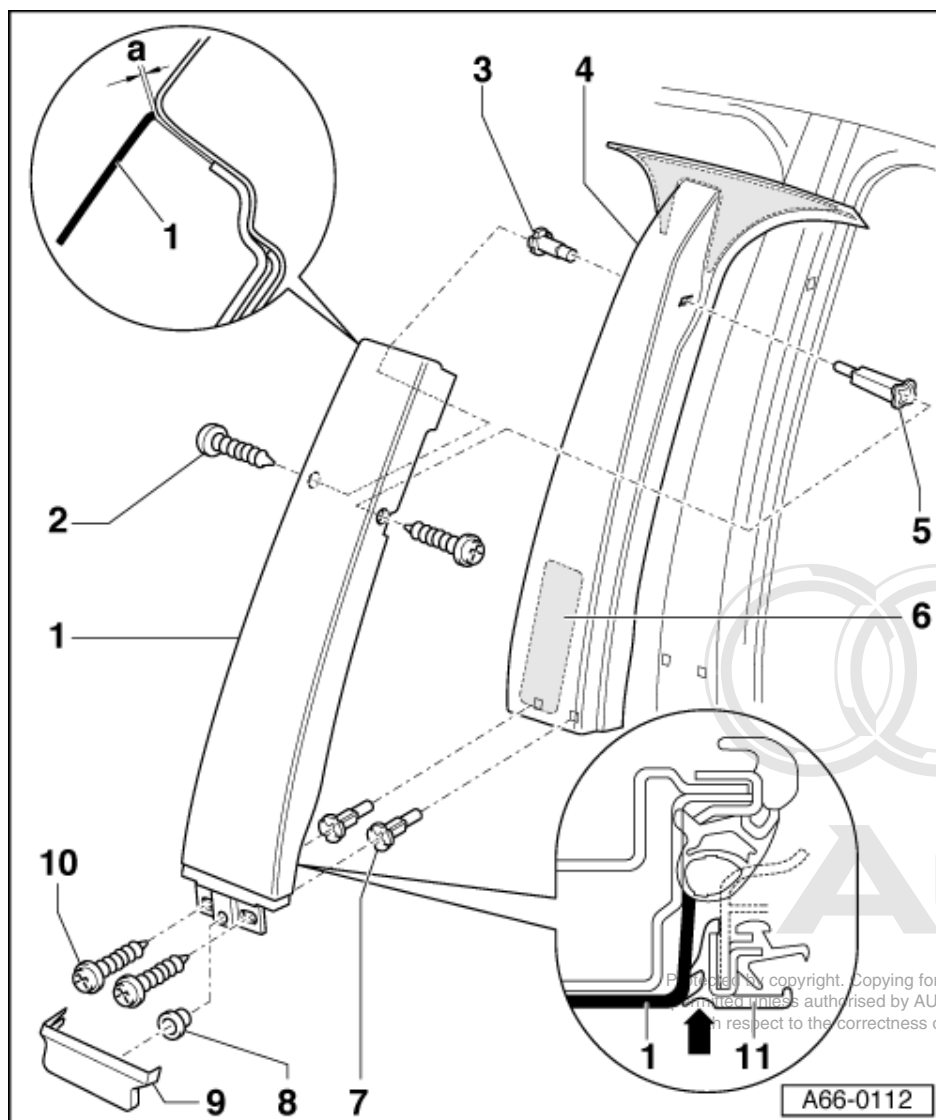
2.1 - Trims



2.2 - Removing and installing -B- pillar trim, 3-door vehicles

- 1 Hollow rivet
- 2 -B- pillar trim
 - ♦ To remove, drill out rivet heads and drive out rivet stems
 - ♦ When installing, fit trim onto vent window with clips as shown.
- 3 Door seal
 - ♦ Pull off seal near trim before drilling out rivet heads.
- 4 Vent window

2.3 - Removing and installing -B- pillar trim, 5-door vehicles



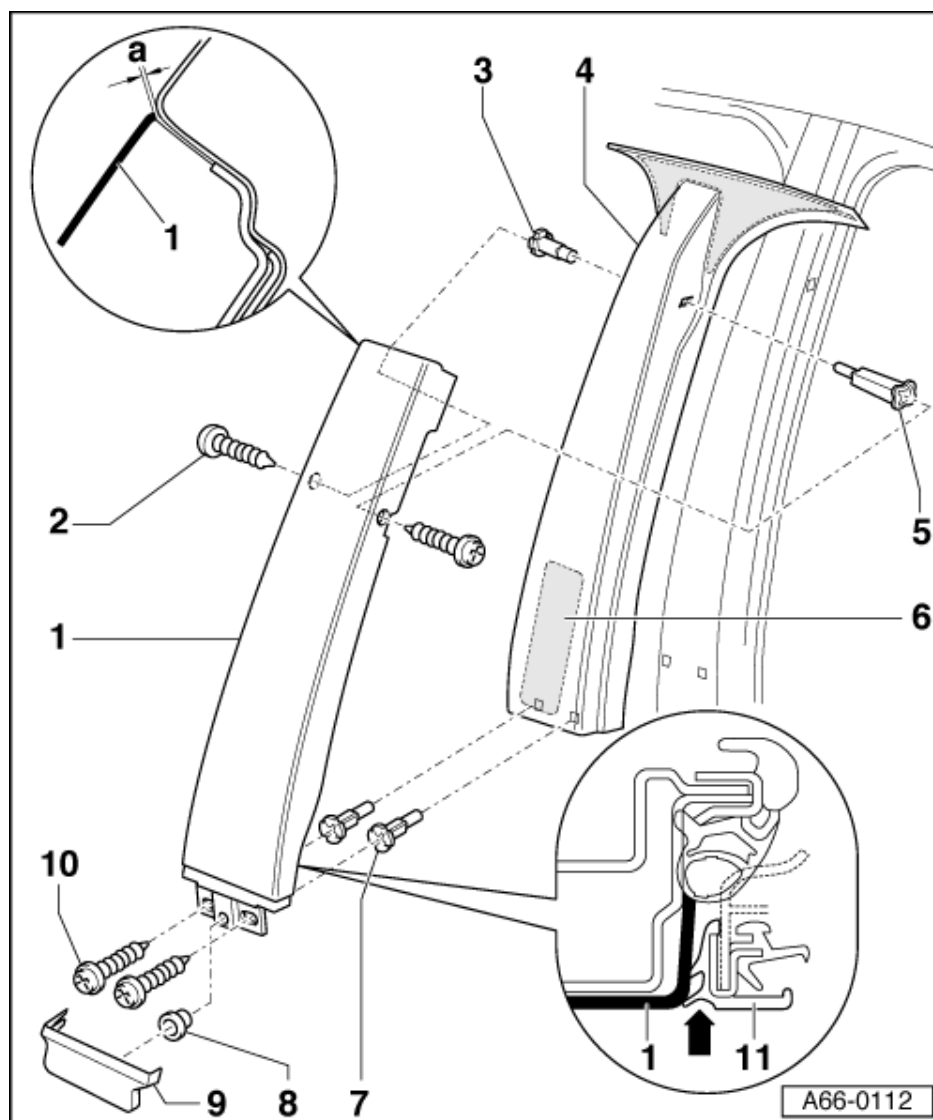
1 B-pillar trim

Removal:

- ◆ Pull off cover strip -9- downwards.
- ◆ Unscrew bolts -1-, -6- and -10- and pull off trim panel outwards.

Installation:

- ◆ Position trim panel with rear door closed as shown in top and bottom detail drawings.
- ◆ Tighten front combi bolt -1- to 1.5 Nm.
- ◆ Gap of between 0.3 to 0.6 mm results from pushing up trim panel until it makes contact with cover strip.



- ♦ The outer lip of rear side window seal must make full contact over entire trim panel area.

Note:

Avoid excessive compression of seal at trim panel -arrow- as otherwise projecting lip could cause wind noise.

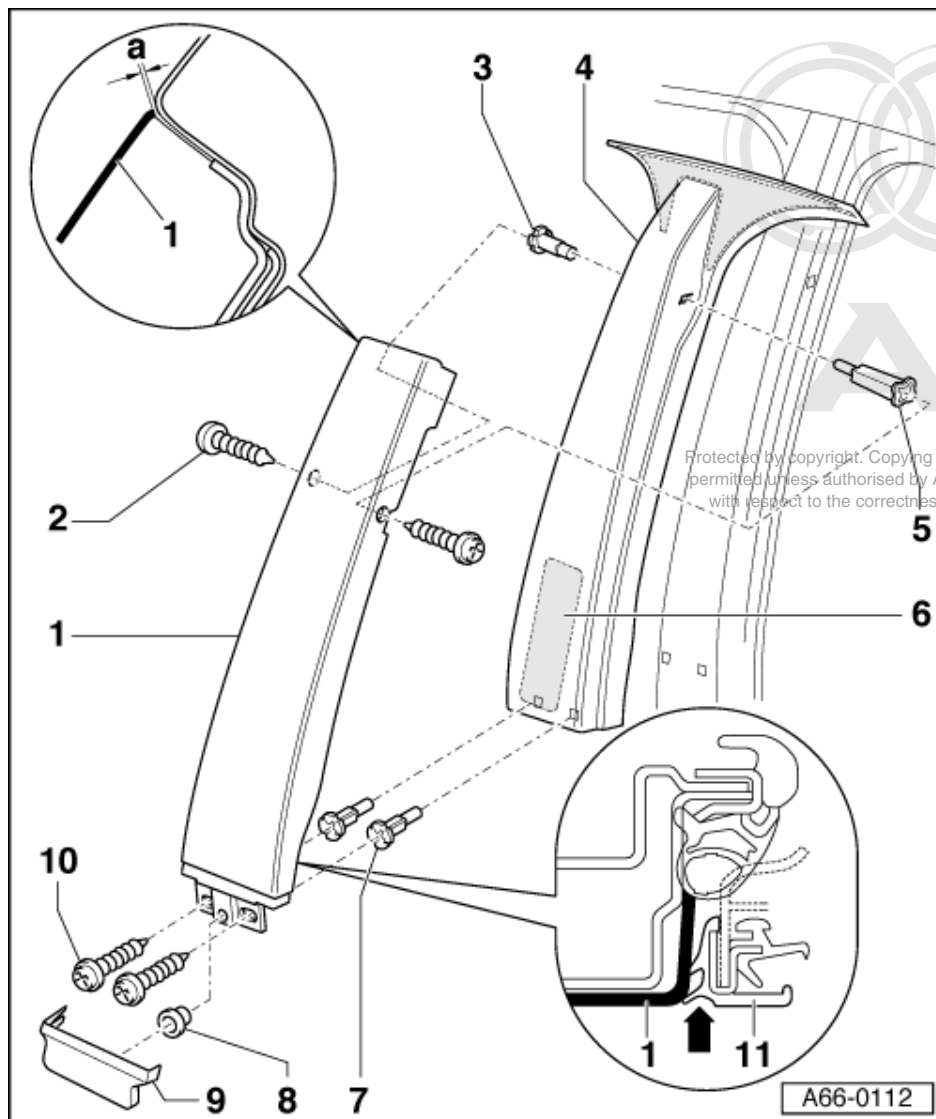
- ♦ Bolt in combi bolt -1- with rear door open.
- ♦ Press grommet -8- into trim panel.
- ♦ Push on cover strip -9- from underneath.

2 Combi bolt

- ♦ 1.5 Nm

3 Front expanding nut

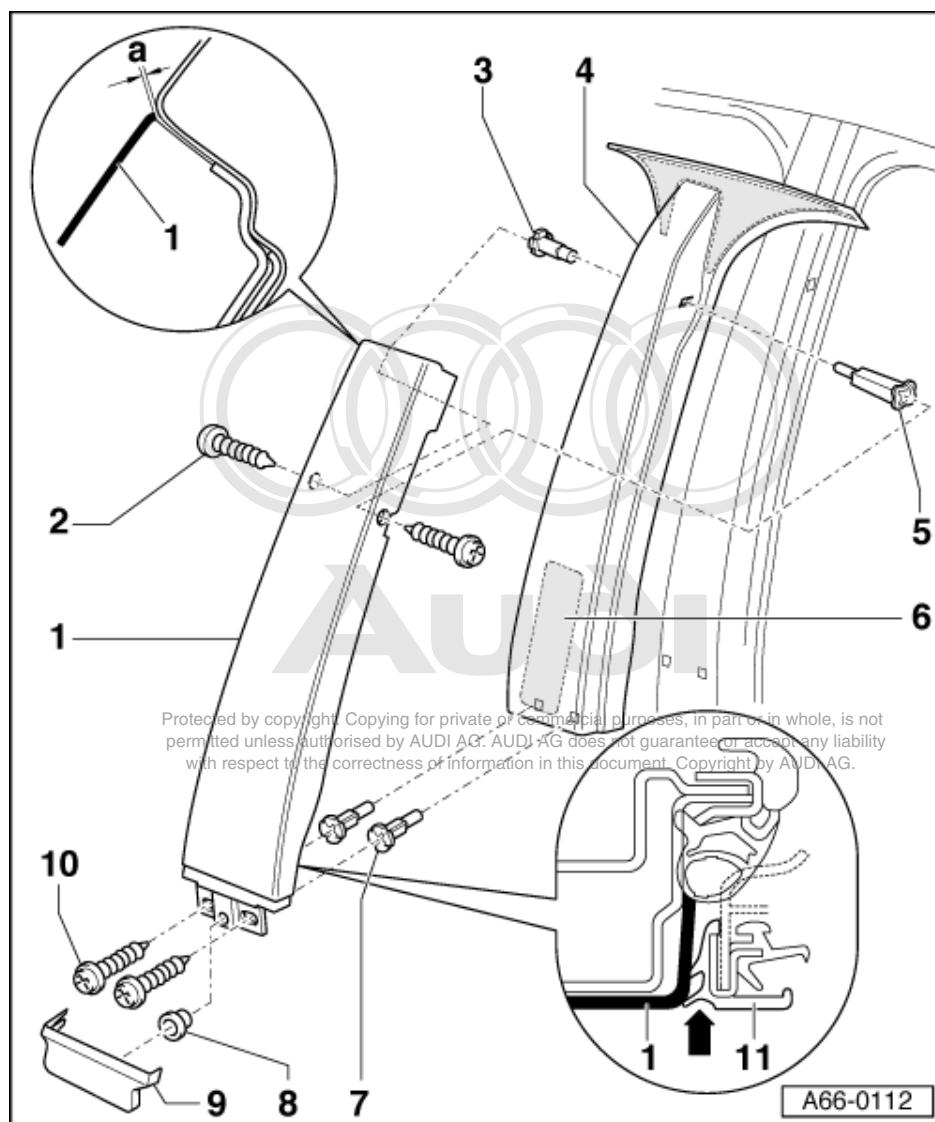
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4 Cover

- ◆ Secured to B-pillar with double-sided adhesive tape -6-.
- Detach from B-pillar to remove.
- Clean B-pillar with cleaning petrol before installing cover.
- Remove protective paper from bonding surfaces.
- Position the cover in the corner of the roof frame and press on the top or bottom of the B-pillar.

5 Rear expanding nut



6 Double-sided adhesive tape

- ◆ Detach backing paper before installing

7 Expanding nut

8 Grommet

9 Cover strip for -B- pillar

- ◆ Pull off downwards to remove.

10 Cross head screw

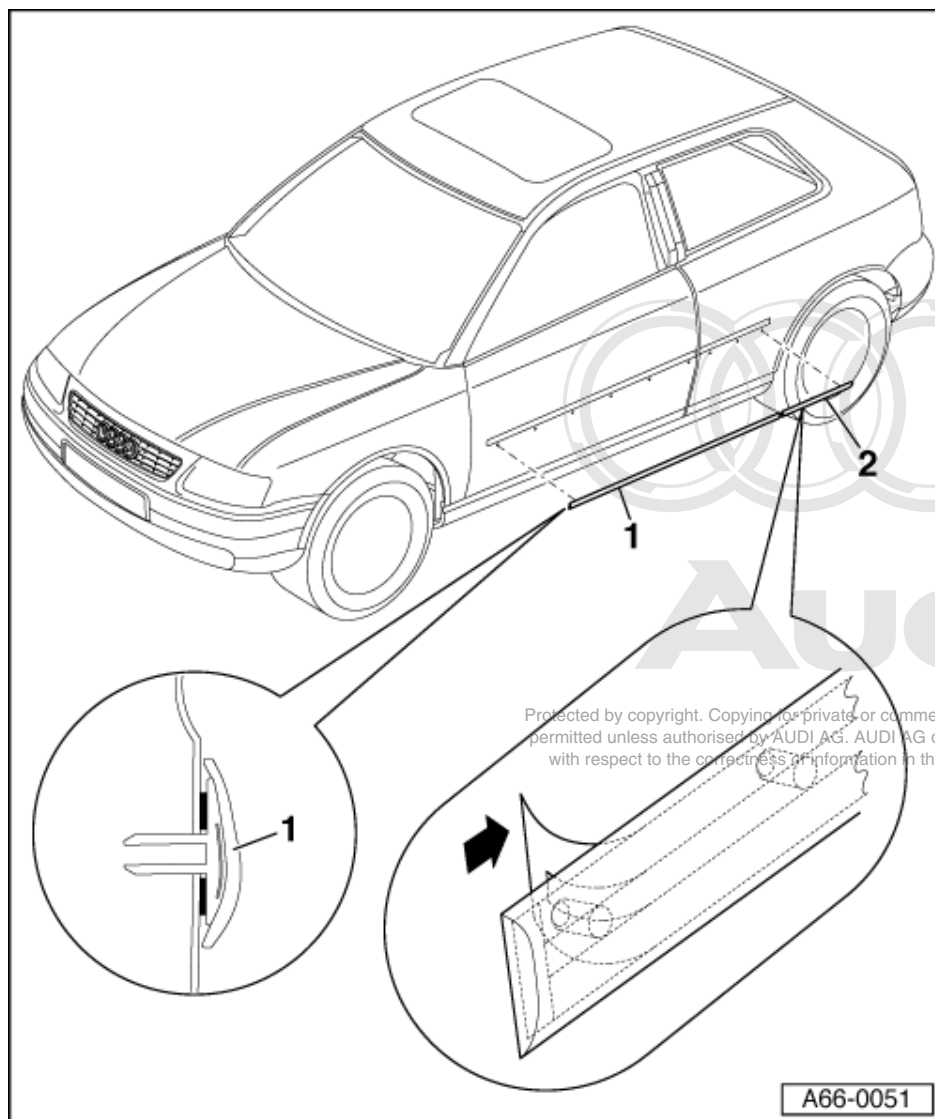
- ◆ 1.5 Nm

11 Door seal

- ◆ The outer lip of rear door window seal must make full contact over entire trim panel area -4-.

3 - Protective strips

3.1 - Protective strips



3.2 - Replacing side protective strips

Note:

- ♦ Heat protective strip with hot-air blower before removing.
- ♦ Clean bonding surface with petrol, treat with silicone remover and rub dry.
- ♦ Before installing, heat protective strip to approx. 40 °C using hot-air blower.
- ♦ Peel off protective film. Locate protective strip in position and then press on firmly.

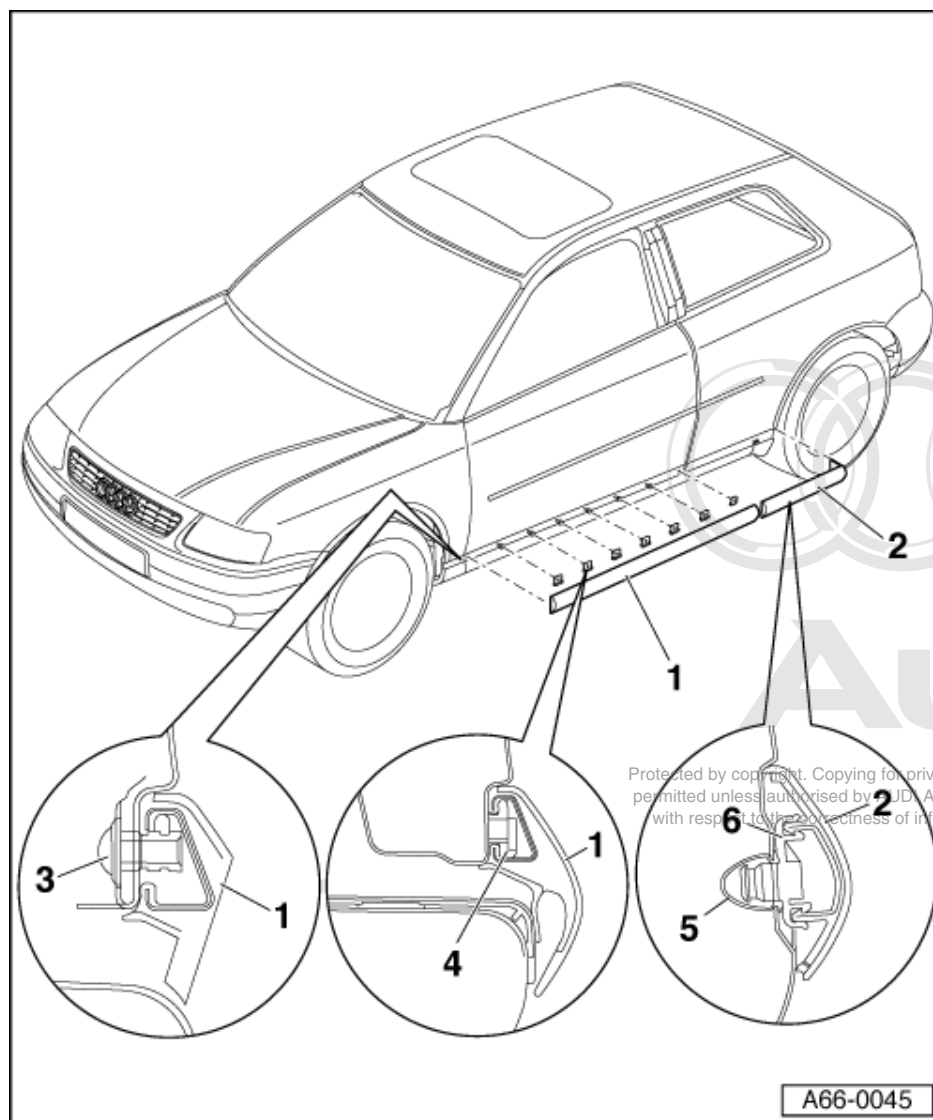
1 Protective strip on front door

- ♦ Self-adhesive

2 Protective strip on rear door

- ♦ Self-adhesive

3.3 - Door and side panel moulding (except S3)



1 Door moulding

- To remove, open door and unscrew cross-head screw -3- at bottom front from inside of door.
- Push moulding off fasteners towards the rear and remove from door.

2 Side panel cover

- ♦ Pull outwards out of locating hook to remove from side panel.

3 Cross-head bolt

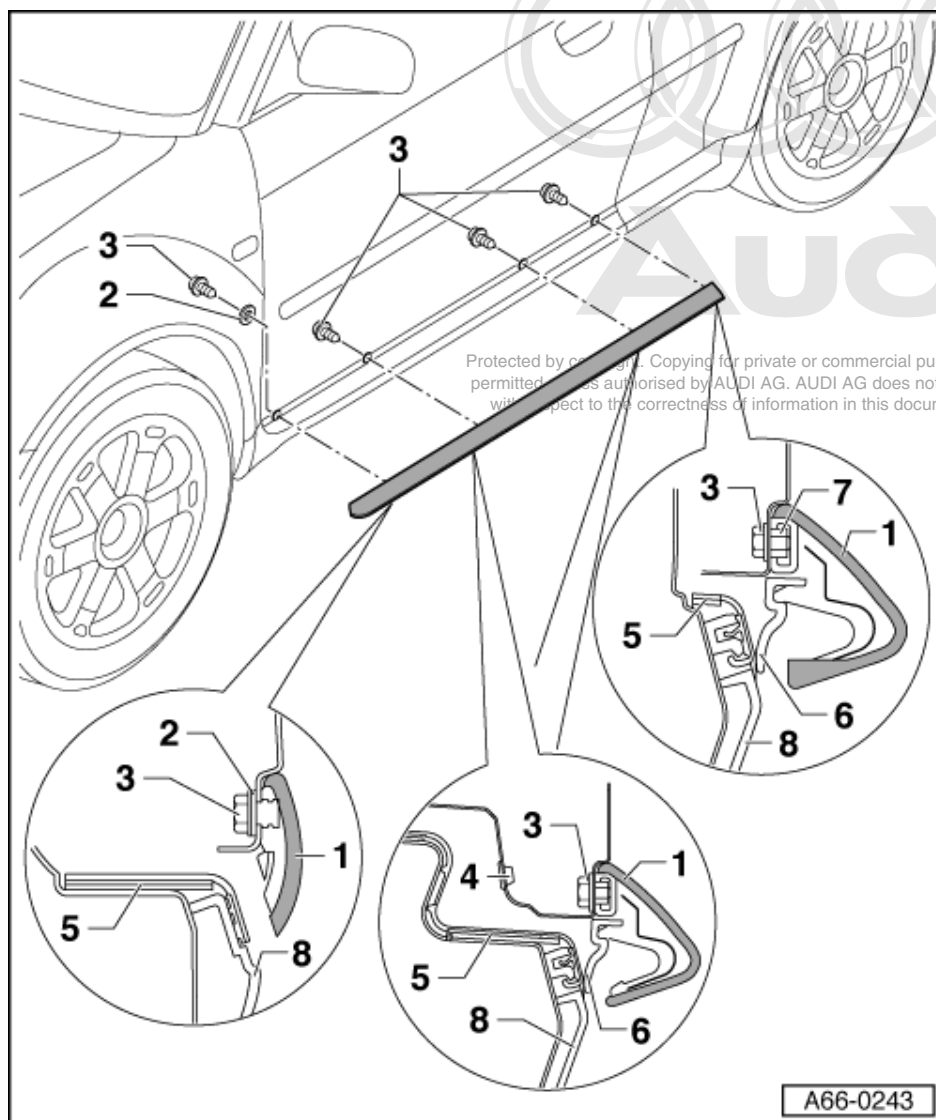
- ♦ 1 Nm

4 Clip

5 Grommet

6 Locking tab

3.4 - Removing and installing door moulding (S3)



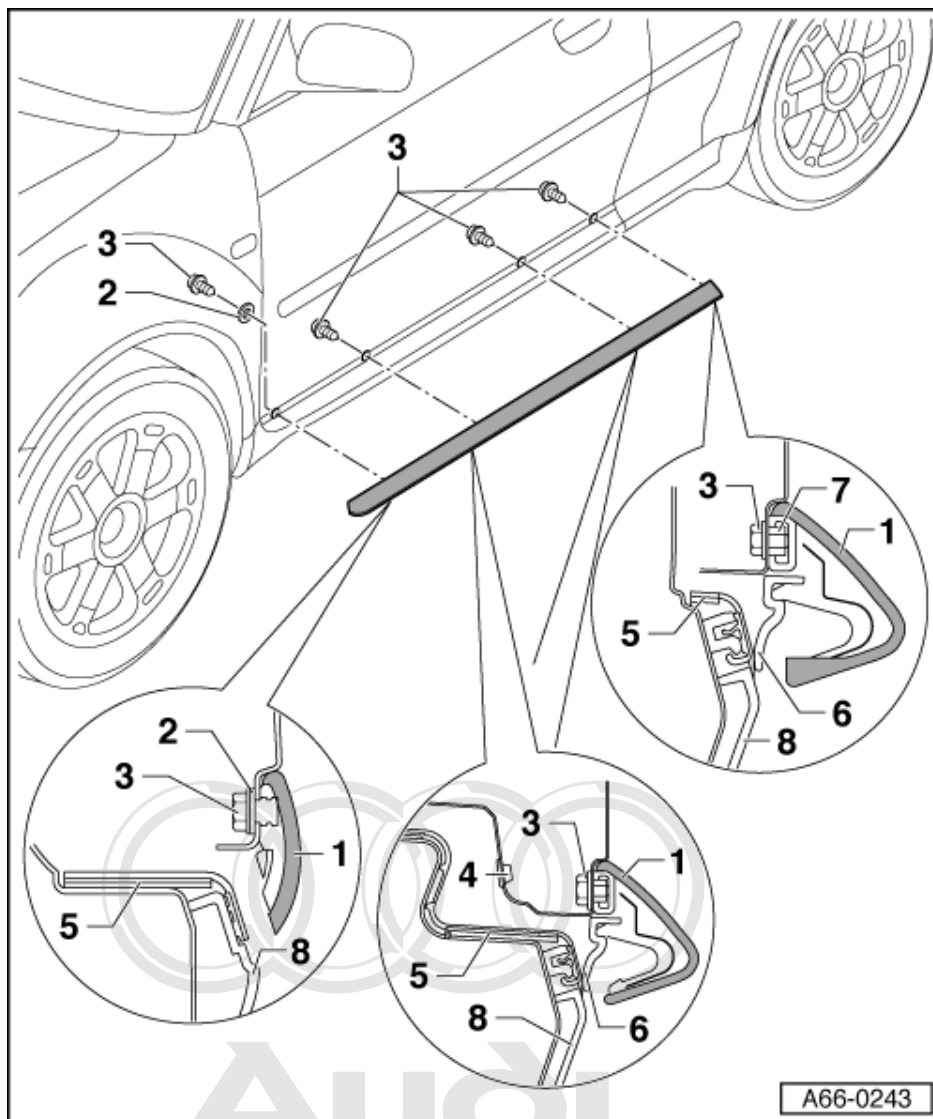
1 Door moulding

- ♦ In scope of delivery:
 - Weather strip =>Item 6
 - Threaded bush =>Item 7
- ♦ Removing
 - Open door.
 - Unclip plugs - 4 - (2x).
 - Unscrew combi bolts - 3 - (4x).
 - Push moulding off fasteners towards the rear and remove from door.
- ♦ Installing

Note:

No PVC residues are permissible in the contact area of the combi bolts.

- Push cover onto the catch from the rear.

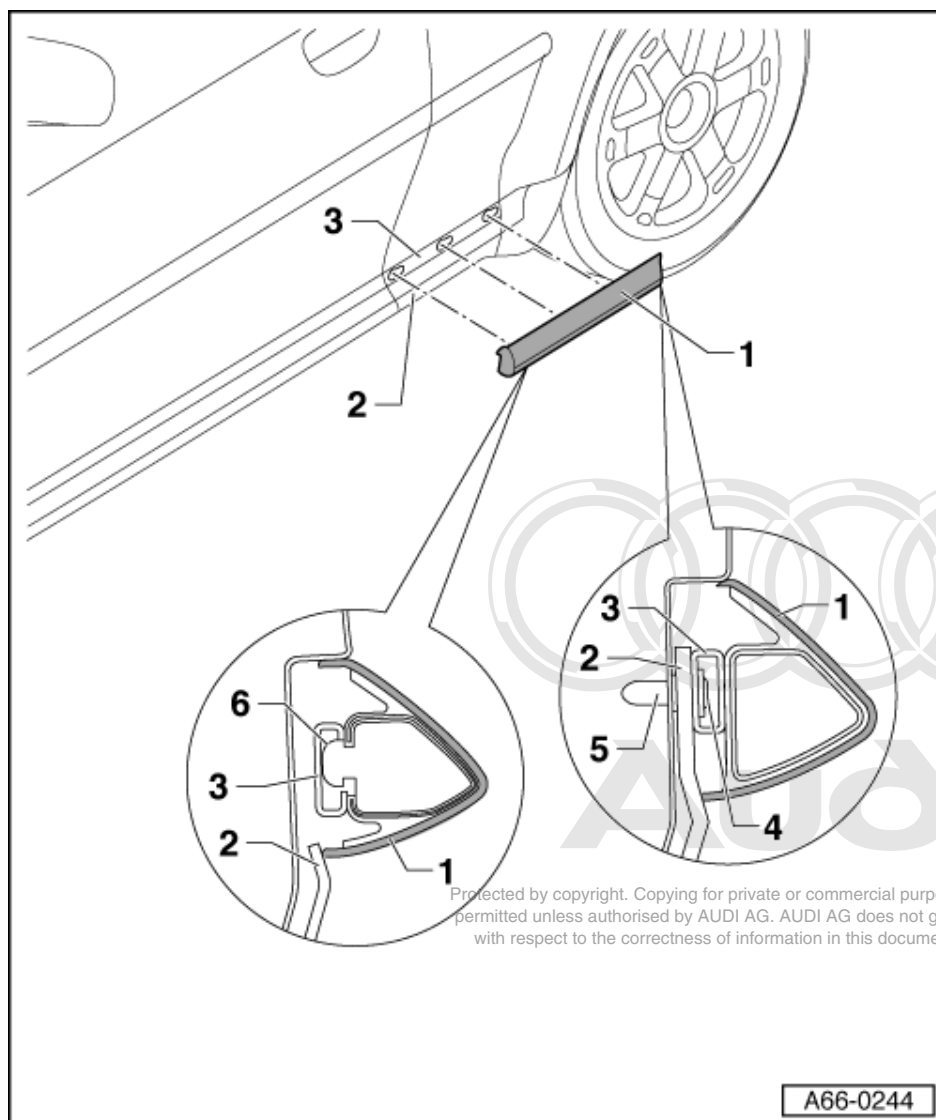


- Screw in combi bolts - **3** - (4x).
- Clip in plugs - **4** - (2x).

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- 2 Washer (1x)**
- 3 Combi bolts (4x)**
 - ♦ 1 Nm
- 4 Plugs (2x)**
- 5 Sill panel**
- 6 Weather strip**
- 7 Threaded bushing**
- 8 Sill cladding**

3.5 - Removing and installing side panel cover (S3)



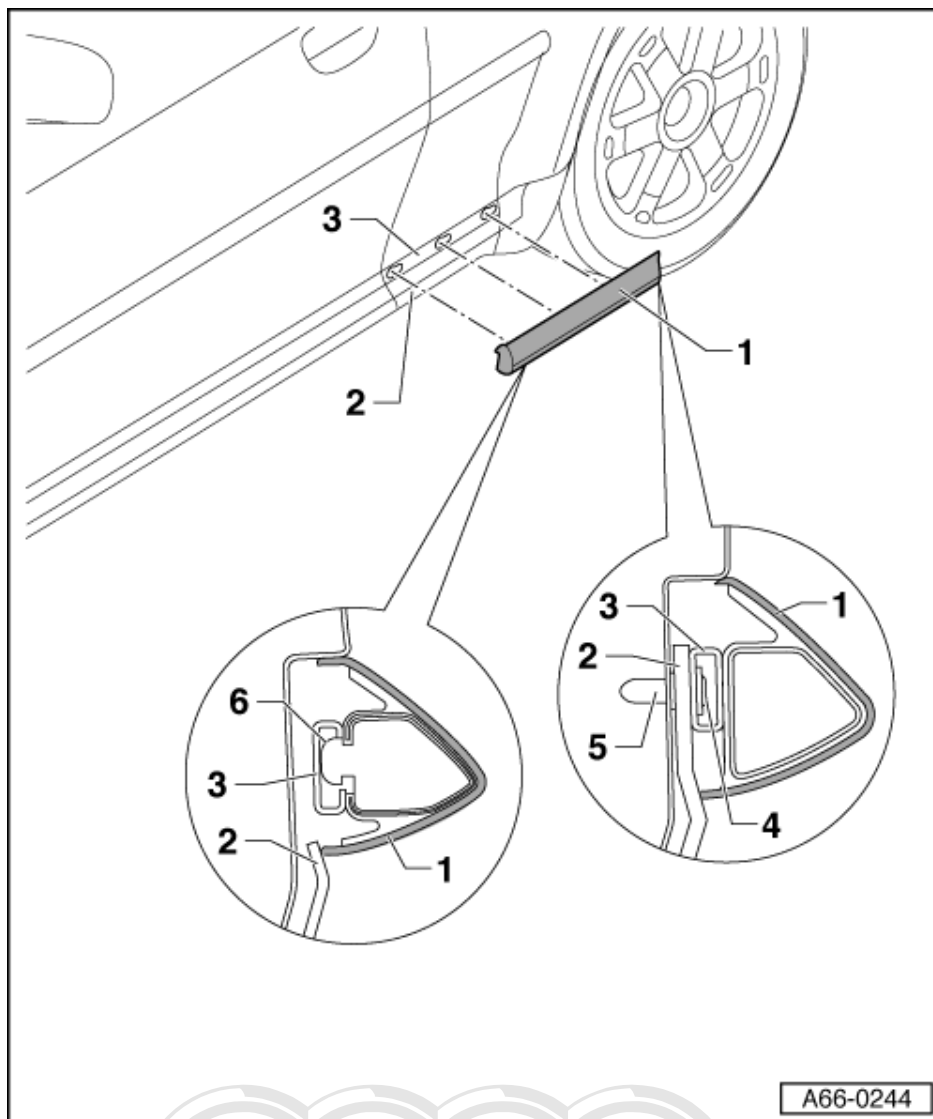
1 Side panel cover

- ♦ In scope of delivery:
 - Clip strip (retaining strip) => Item 3
 - Clip => Item 6
- ♦ Removing
 - Open door.
 - Push side panel cover to stop in the direction of the door aperture.
 - Remove side panel cover.
- ♦ Installing

Note:

The clip - 6 - must be fixed to the side panel cover in the correct position prior to installation.

- Position side panel onto the clip strip - 3 - and push to stop in the direction of the rear axle.

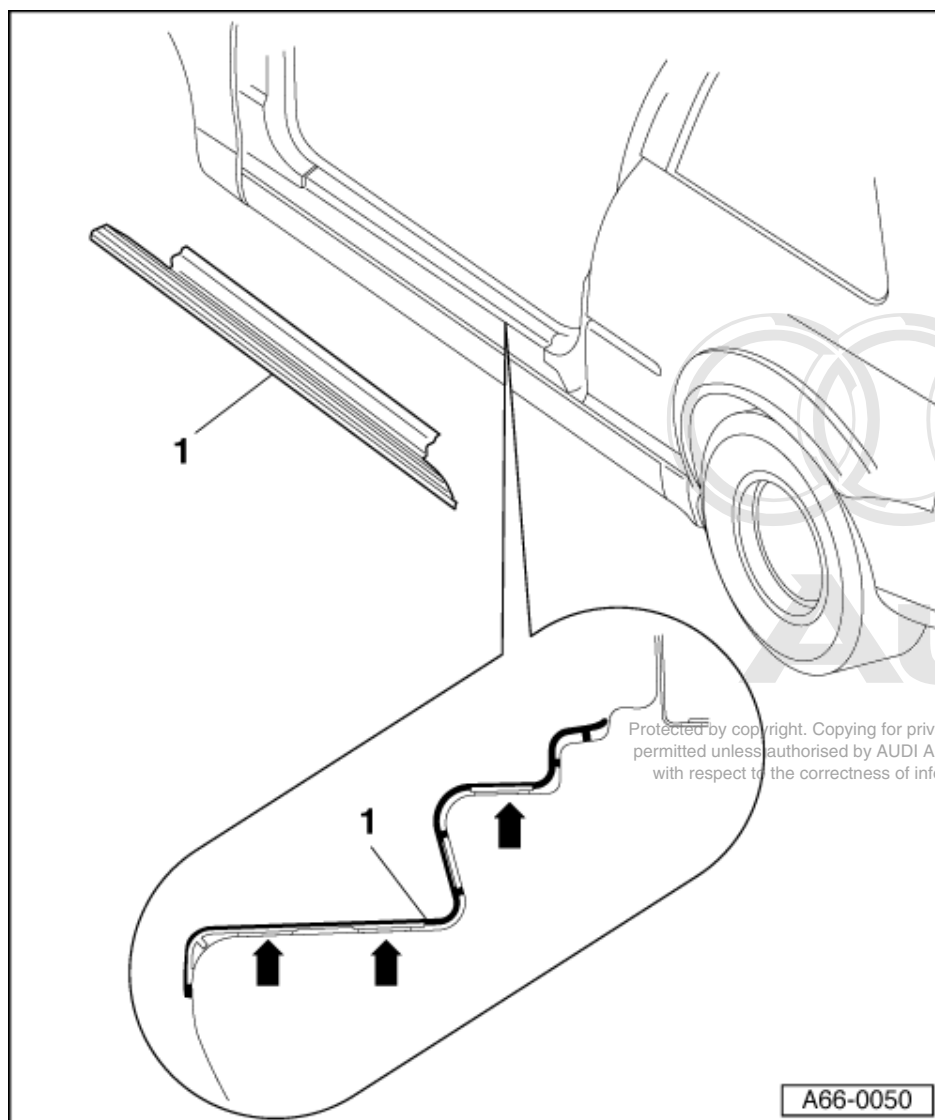


- 2 Sill cladding
- 3 Clip strip (retaining strip)
- 4 Torx bolt (4x)
 - ◆ 1 Nm
- 5 Expanding nut
- 6 Clip



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3.6 - Removing and installing sill panel (except S3)



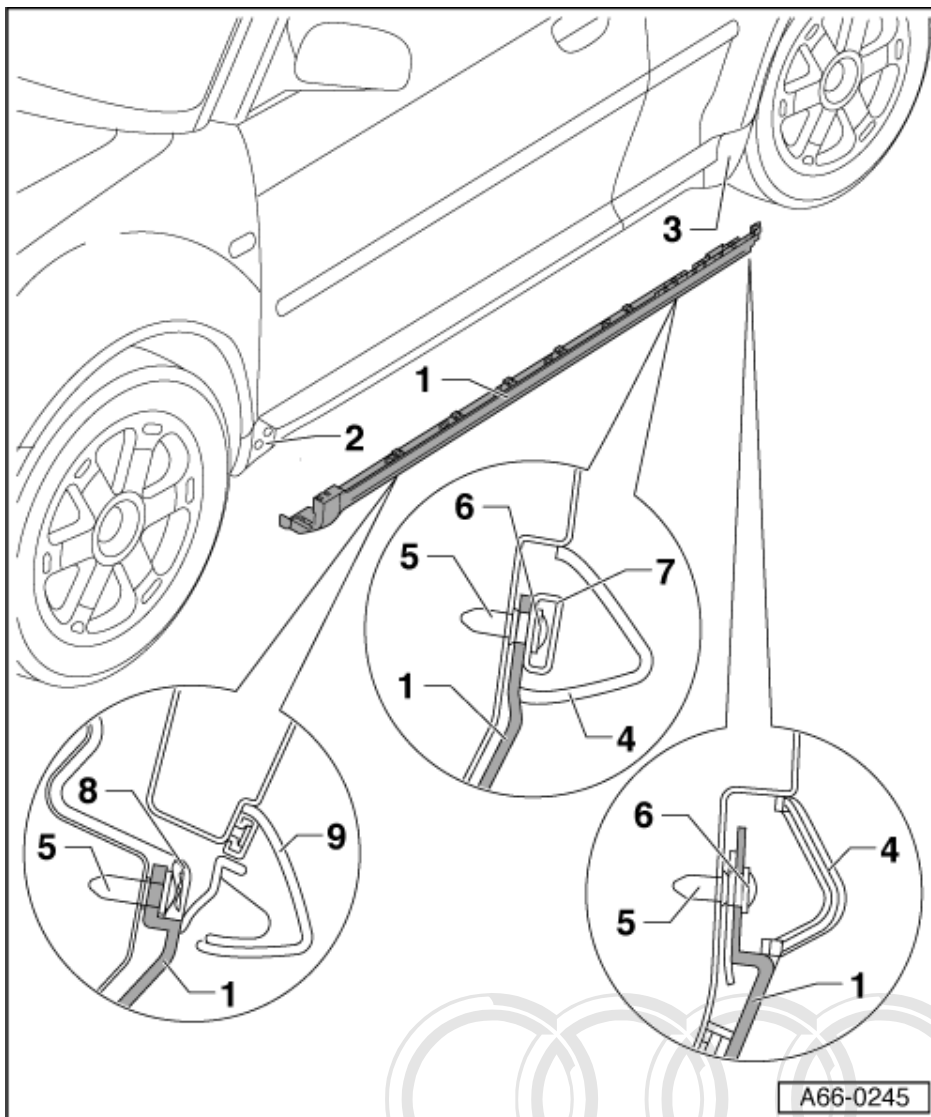
Note:

- ♦ Heat sill panel with hot-air blower before removing.
- ♦ Clean bonding surface with petrol, treat with silicone remover and rub dry.
- ♦ Before installing, heat sill panel to approx. 40 °C using hot-air blower.
- ♦ Peel off protective film and press on sill panel firmly.

1 Sill panel

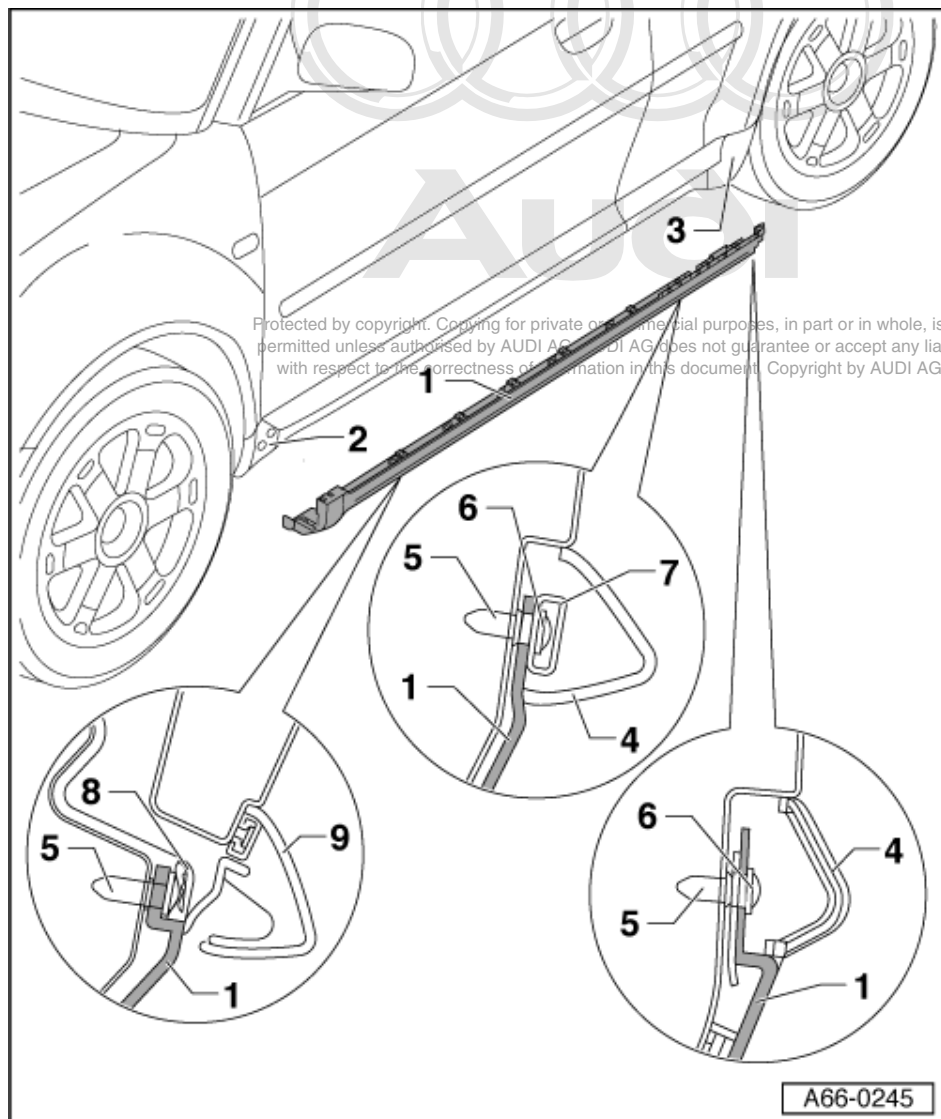
- ♦ Before fitting pull off protective film -arrows-

3.7 - Removing and installing sill cladding (S3)



1 Sill cladding

- ◆ In scope of delivery:
 - End cap =>Page 180
- ◆ Removing
 - Open door.
 - Unclip sill panel - 178 .
 - Remove side panel cover - 172 .
 - Remove clip strip (retaining strip) - 7 -
 - Detach sill cladding from bracket - 178 .
 - Detach sill cladding from end cap - 180 .
 - Unscrew Torx bolts - 6 -
 - Remove sill cladding.



- ♦ Installing
 - Attach sill cladding and secure with Torx bolts - 6 -.
 - Fasten sill cladding to bracket - 178 .
 - Fasten sill cladding to end cap - 180 .
 - Install clip strip (retaining strip) - 7 -
 - Install side panel cover - 172 .
 - Clip in sill panel - 8 -.

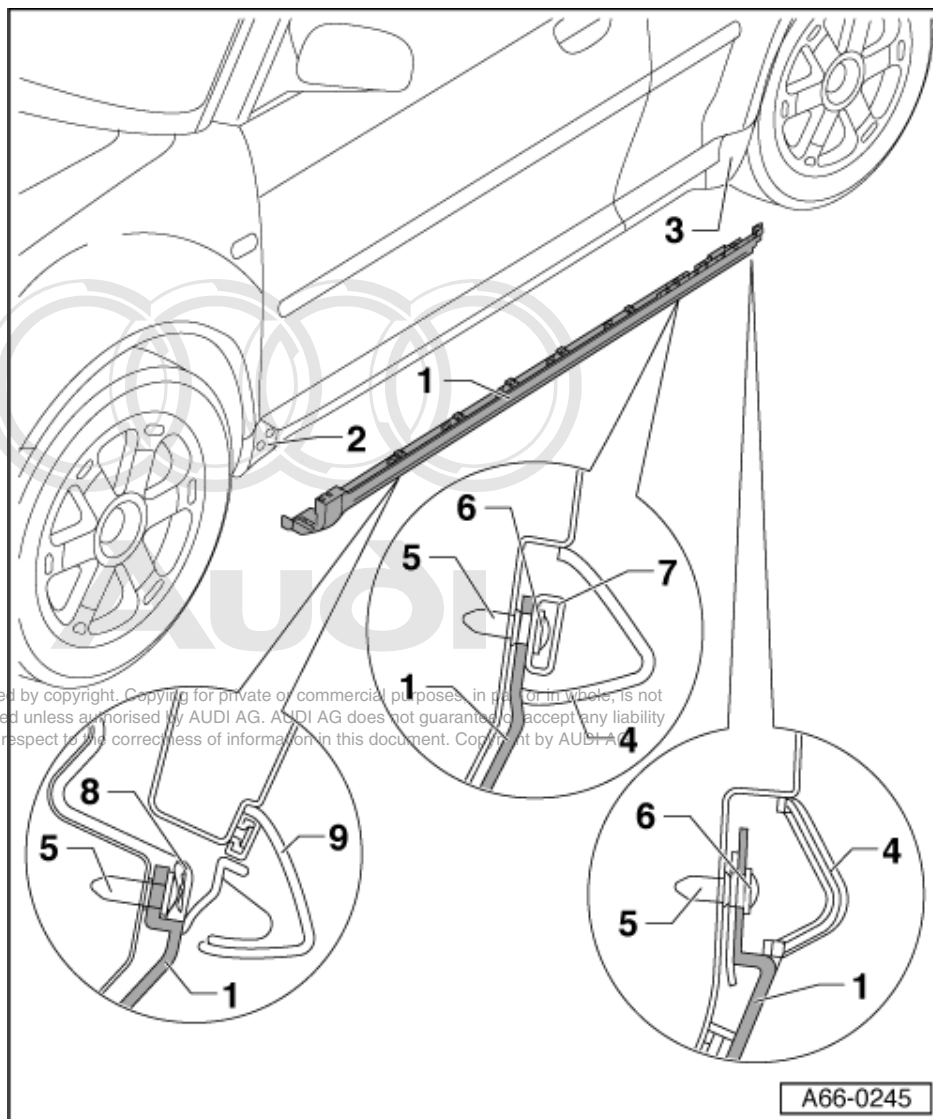
2 Bracket

- ♦ Removing and installing=>Page 178

3 End cap

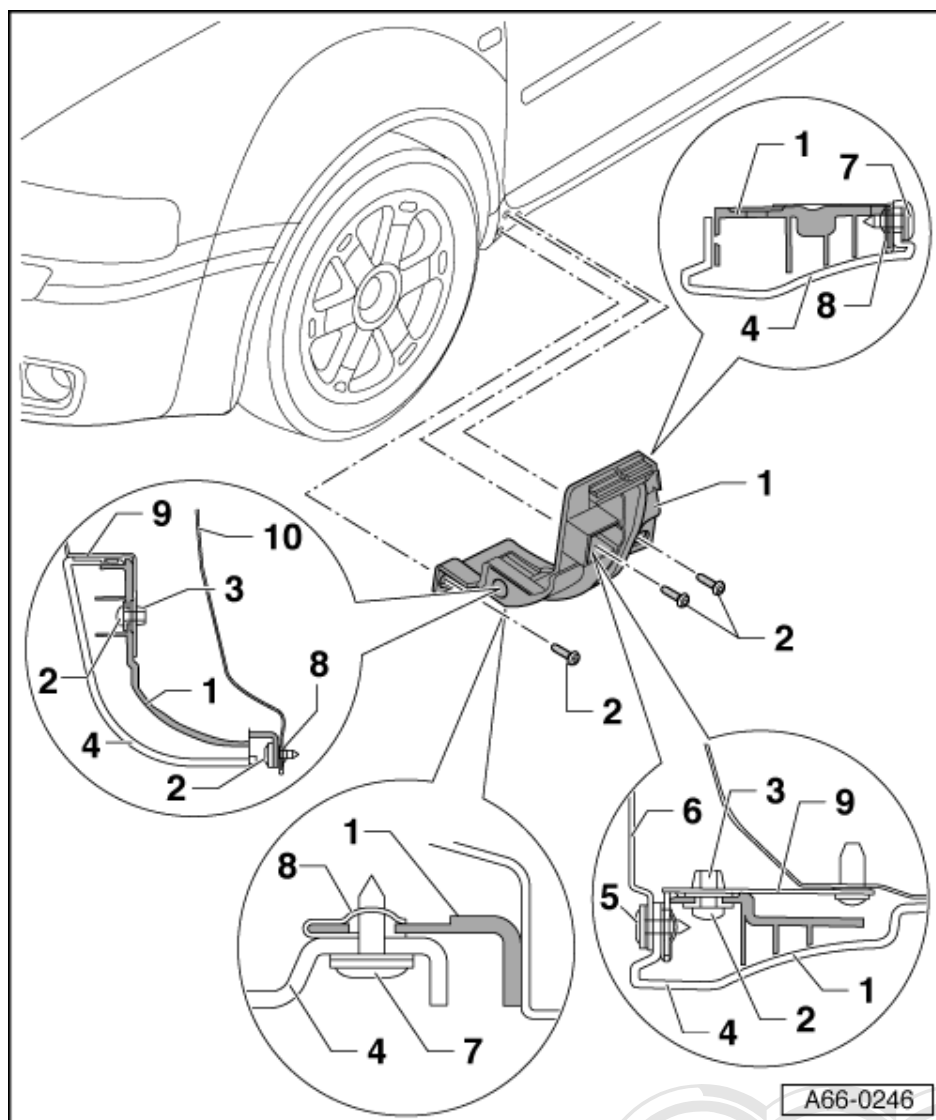
- ♦ Removing and installing=>Page 180

4 Side panel cover



- 5 Expanding nut
- 6 Torx bolt
 - ♦ 1 Nm
- 7 Clip strip (retaining strip)
- 8 Sill panel
- 9 Door moulding

3.8 - Removing and installing bracket (S3)



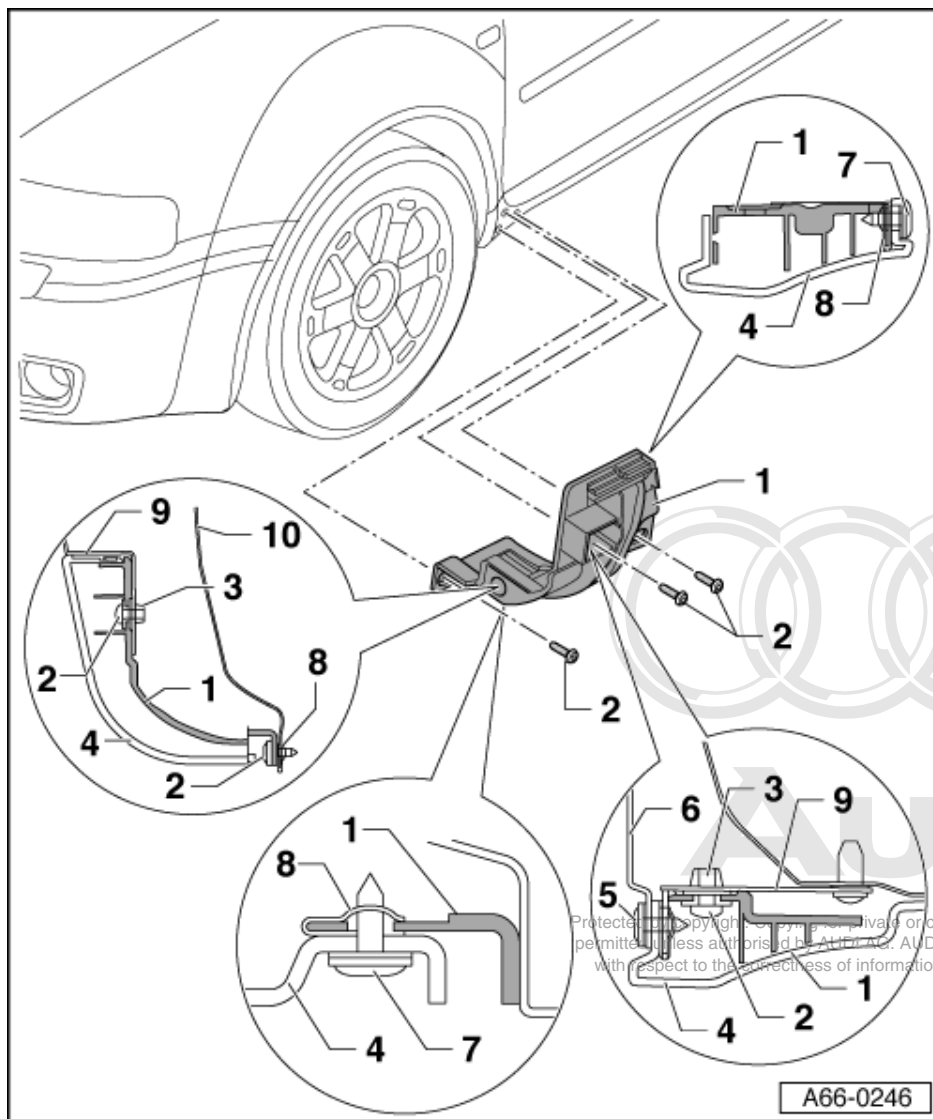
1 Bracket

- ♦ Removing
 - Remove sill cladding => Page 175 .
 - Remove Torx bolts - 5 - and - 7 -.
 - Remove Torx bolts - 2 -.
 - Remove bracket.
- ♦ Installing

Note:

Position the bracket longitudinally above the fixing point on the wing.

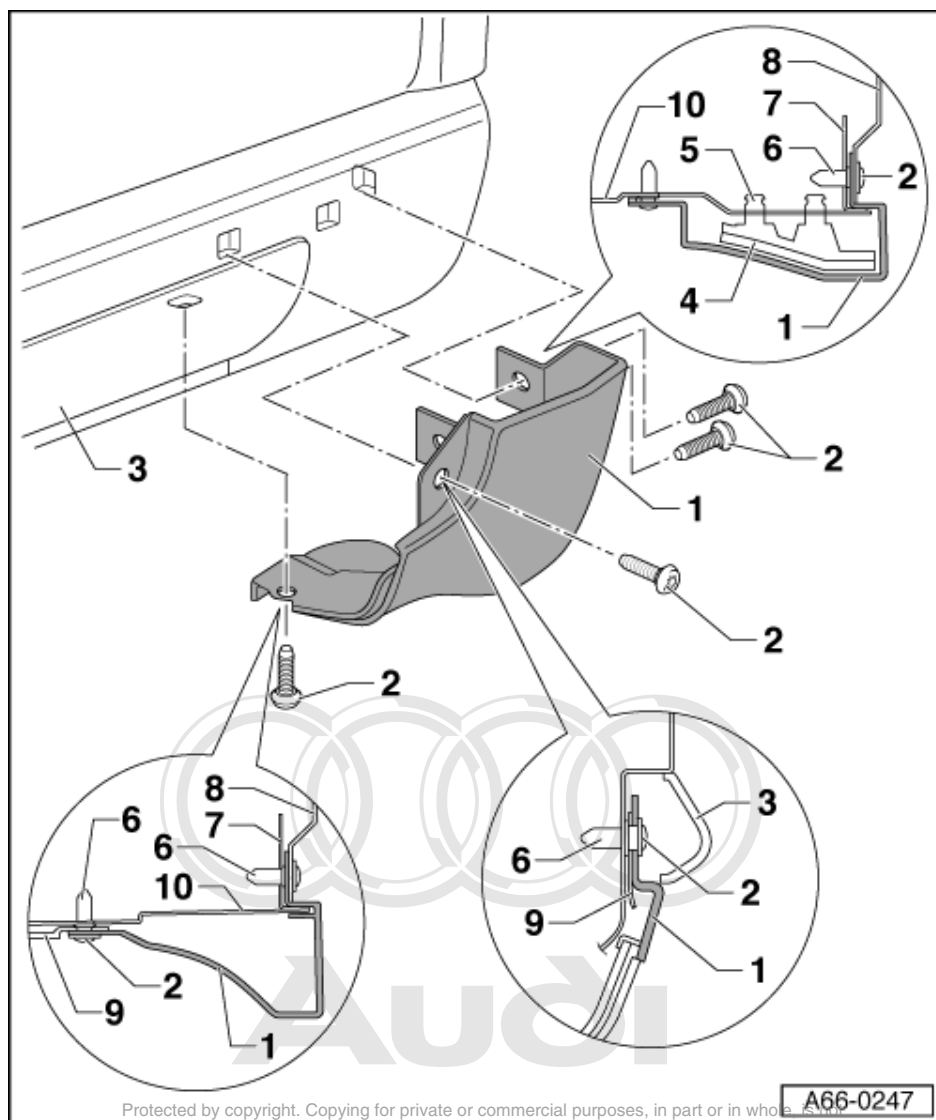
- Position bracket and fit Torx bolts - 5 - and - 7 -.
- Do not tighten Torx bolts, the bracket must remain movable.



- Align bracket and tighten Torx bolts - 5 - and - 7 -.
- Install sill cladding => Page 175 .

- 2 Torx bolt
 - ♦ 1 Nm
- 3 Expanding nut
- 4 Sill cladding
 - ♦ Removing and installing=>Page 175
- 5 Torx bolt
 - ♦ 1 Nm
- 6 Wheel housing liner
- 7 Torx bolt
 - ♦ 1 Nm
- 8 Snap nut
- 9 Wings
- 10 Outer side panel

3.9 - Removing and installing end cap (S3)



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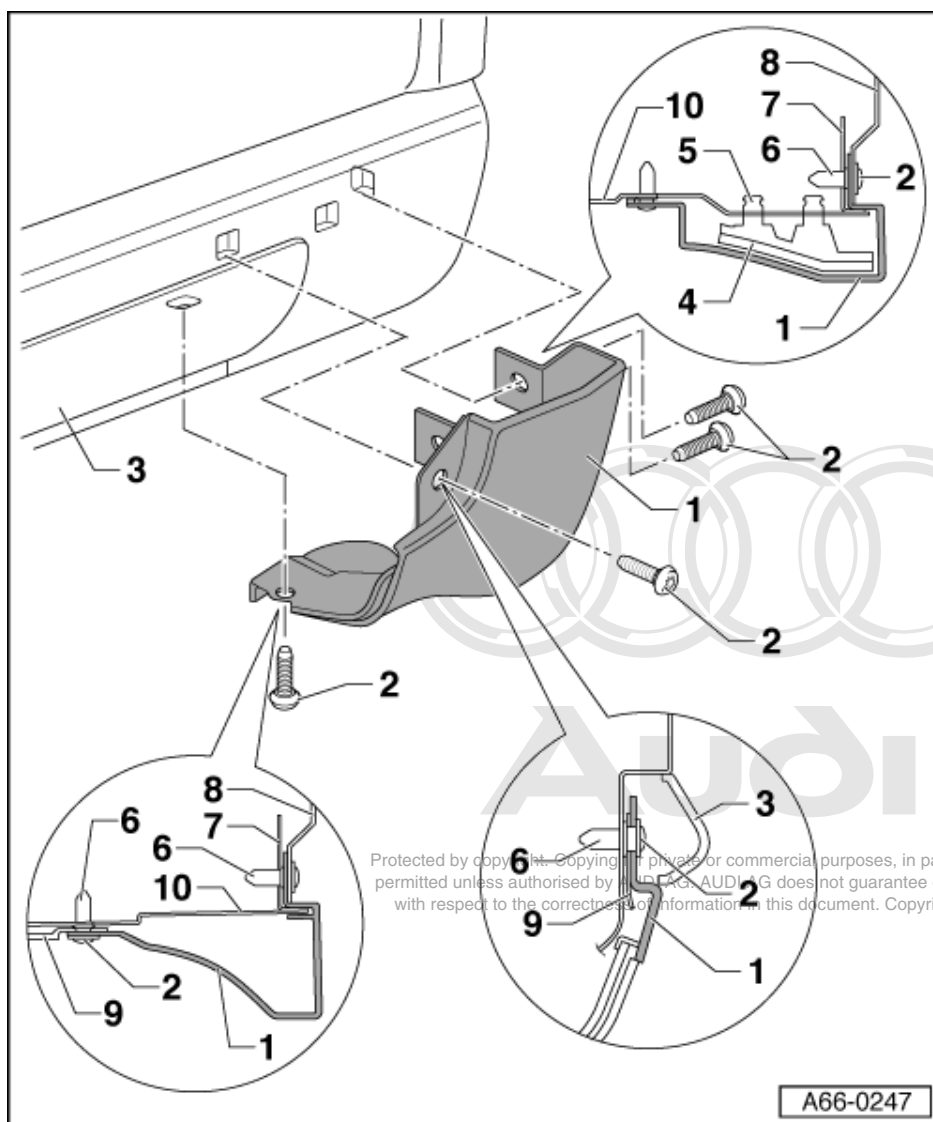
1 End cap

- ♦ In scope of delivery:
 - Retaining clip =>Item **5**
- ♦ Removing
 - Remove side panel cover - **172**.
 - Remove Torx bolts - **2** -.

Note:

A pull-off force of approx. 300 N is required in order to overcome the retaining force of the Velcro fastening - **4** - when removing the end cap from the retaining clip - **5** -.

- Pull off end cap.
- Replace retaining clip - **5** - if necessary.
- ♦ Installing
 - Fit and position end cap.

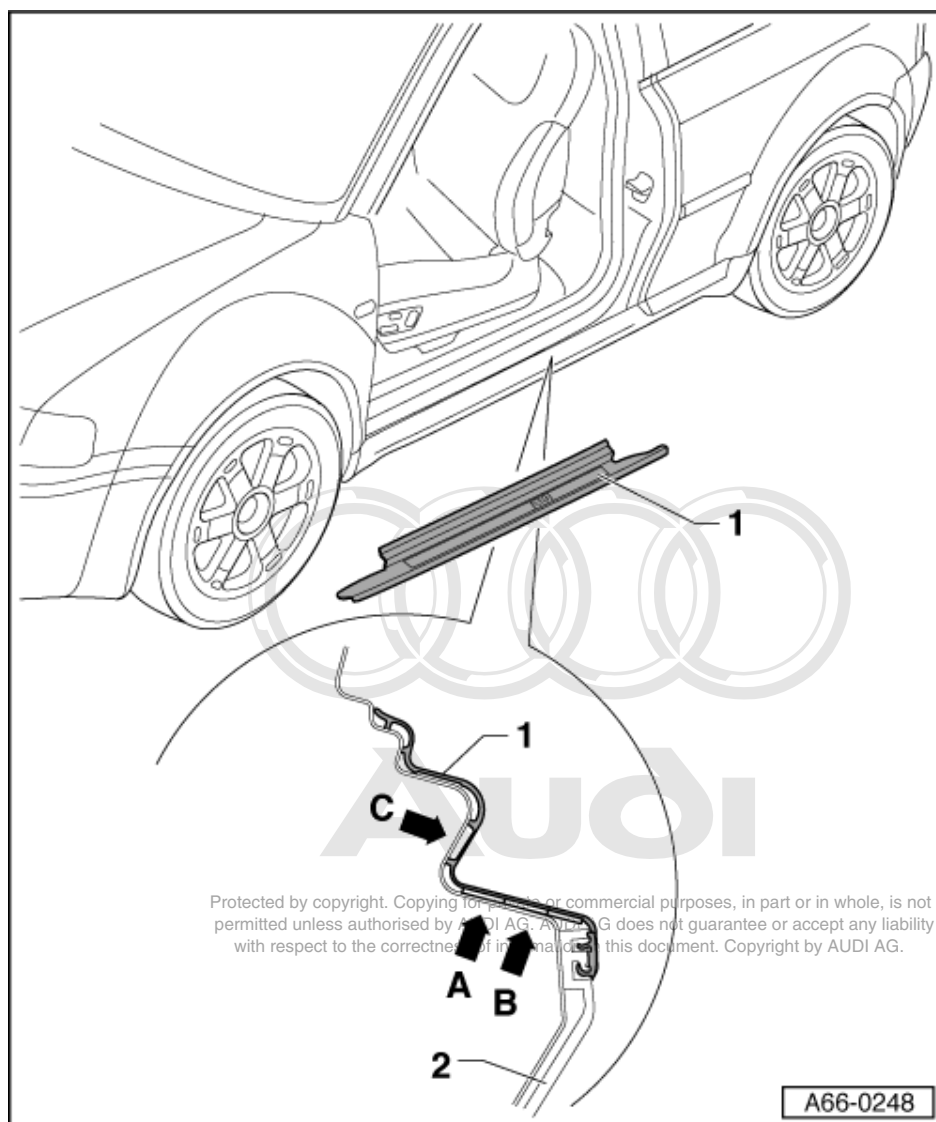


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- Press end cap on firmly in order to ensure firm hold between end cap/Velcro fastener/retaining clip.
- Insert Torx bolts - 2 - and tighten.
- Install side panel cover - 3 -.

- 2 Torx bolt
 - ♦ 1 Nm
- 3 Side panel cover
- 4 Velcro fastening strip
- 5 Retaining clip
- 6 Expanding nut
- 7 Wheel housing
- 8 Wheel housing liner
- 9 Sill cladding
- 10 Outer side panel

3.10 - Removing and installing sill panel (S3)

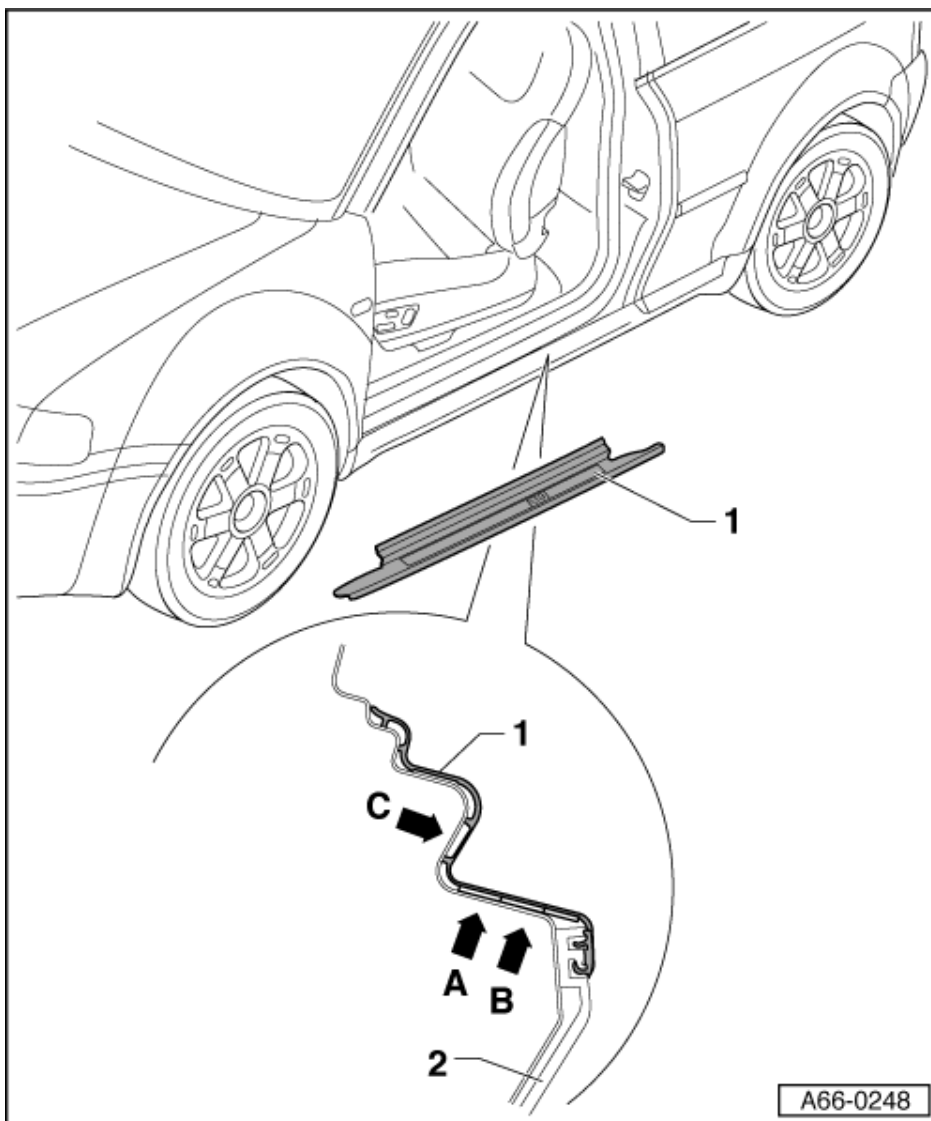


1 Sill panel

- ♦ Removing
 - Unclip sill panel and detach from body.
- ♦ Installing

Notes:

- ♦ Clean bonding surface with petrol, treat with silicone remover and rub dry.
- ♦ Body temperature: Room temperature
- ♦ Before installing, heat sill panel to approx. 40 °C using hot-air blower.
- ♦ Do not remove protective film until just before installing the sill panel.



- Clean the bonding surface on body from adhesive residues, dust and grease.
 - Heat the sill panel to approx. 40 °C.
 - Remove the protective film of lower adhesive strip -arrow A- and -arrow B-.
 - Clip in the sill panel along the row of clips in the sill cladding -2-, use rubber lubricant if necessary.
 - Press down entire surface of sill panel firmly onto lower bodywork.
 - Pull off remaining protective film -arrow C-.
 - Firmly press down entire surface of sill panel.
- After bonding on sill panel, the vehicle must be kept at room temperature for a further 2 hours.

2 Sill cladding



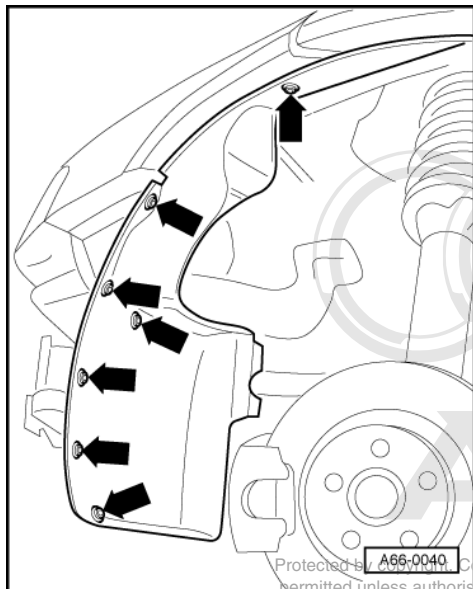
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4 - Wheel housing liners

4.1 - Wheel housing liners

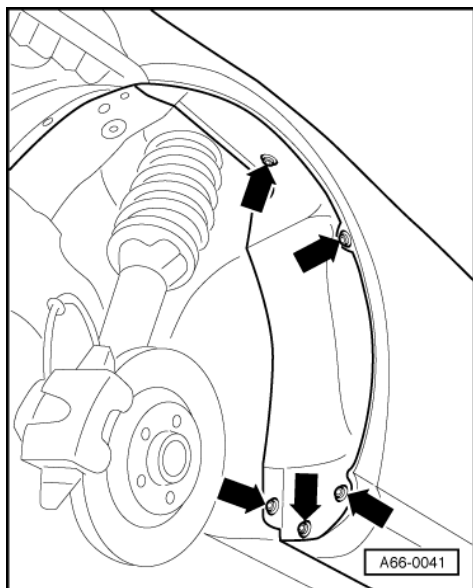
4.2 - Removing and installing front wheel housing liner (except S3)



- Remove front wheel.
- -> Unscrew Torx bolts -arrows- from wheel housing liner (front part).

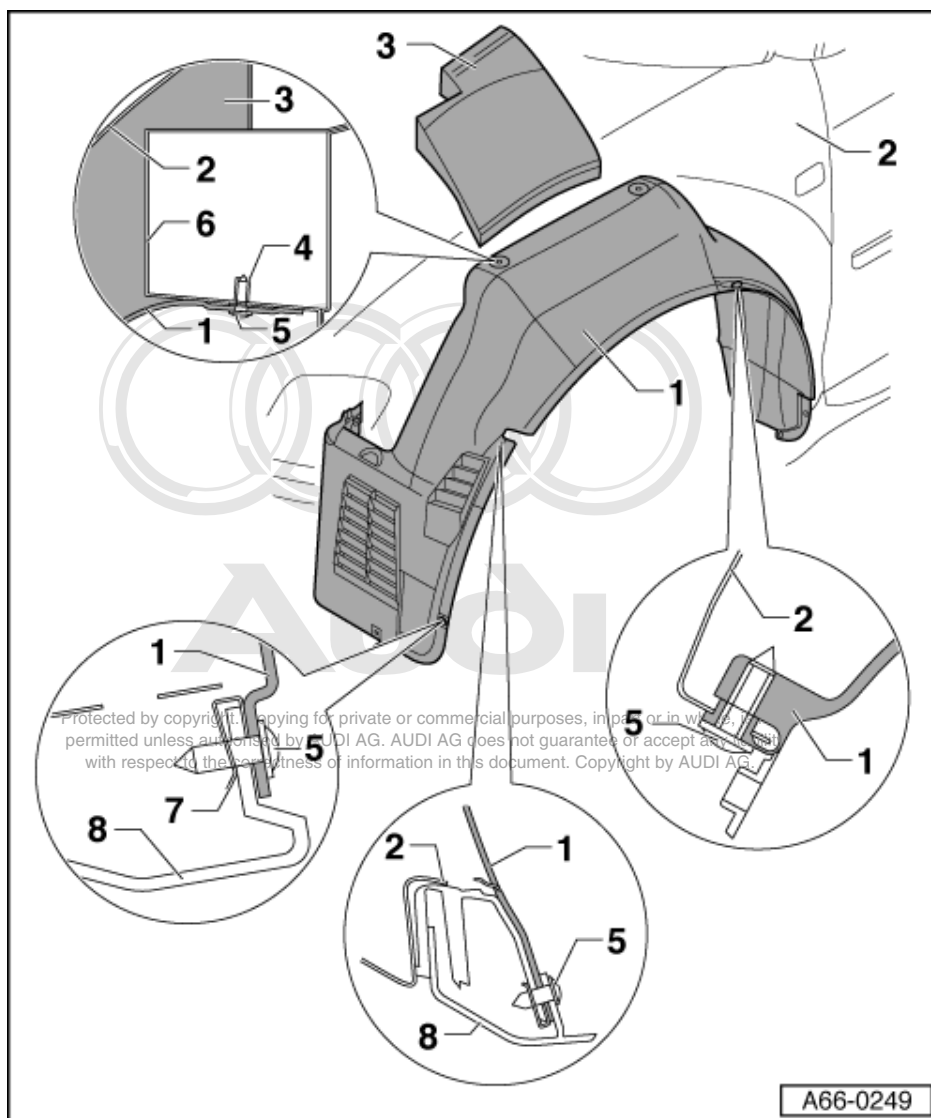
Note:

The wheel housing liner is of one-piece design and is only shown in two illustrations for greater clarity.



- -> Unscrew Torx bolts -arrows-, bend wheel housing liner inwards slightly and take it out of the wheel housing.

4.3 - Removing and installing front wheel housing liner (S3)



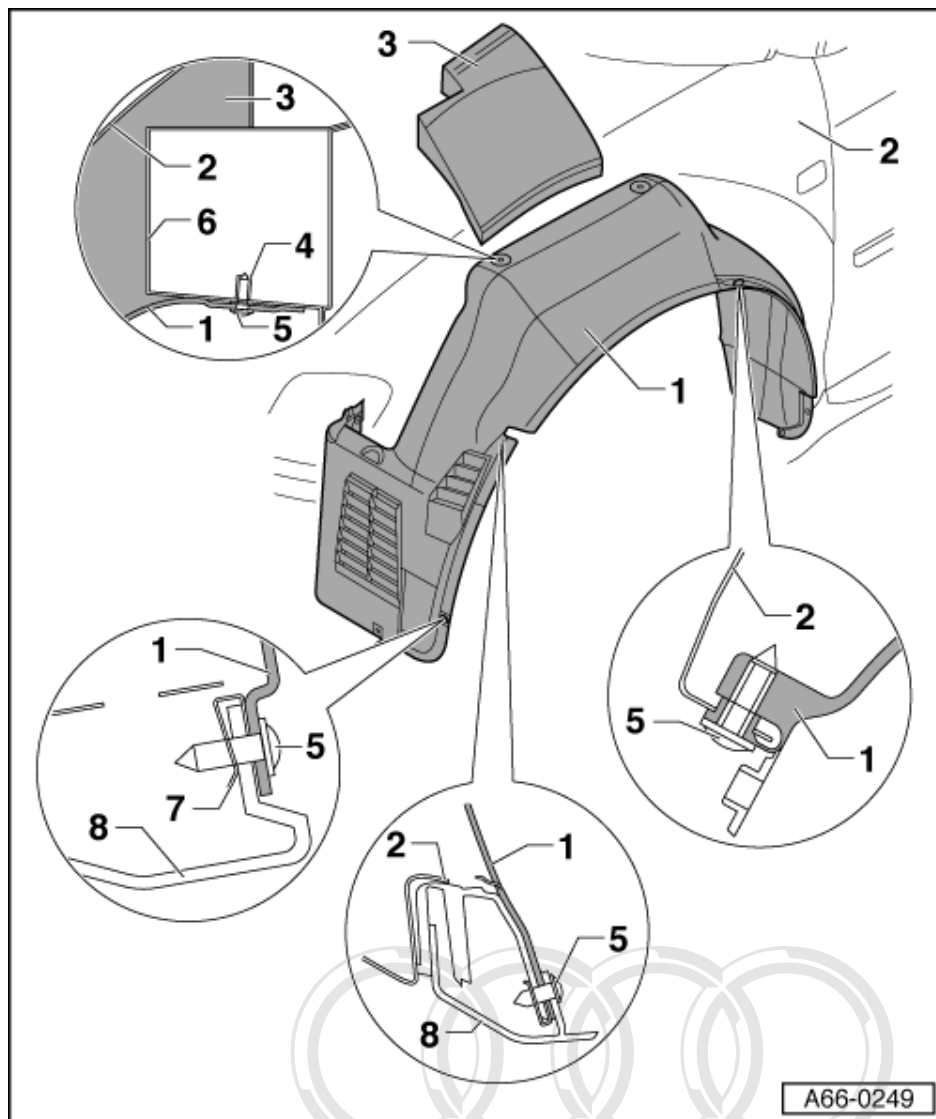
1 Front wheel housing liner

- ◆ Removing
 - Front wheel removed
 - Unscrew Torx bolts - 5 - squeeze liner gently together and remove from wheel housing.
 - Remove seal - 3 -.
- ◆ Installing
 - Position seal - 3 - on wheel housing liner.

Note:

Ensure that the position of the seal is not altered when installing the wheel housing liner.

- Squeeze the liner gently together and insert in the wheel housing.
- Insert Torx bolts - 5 - and tighten.



2 Wings

3 Seal

♦ Inserted between wing - 2 -, longitudinal member - 6 - and wheel housing liner - 1 -

4 Expanding nut

5 Torx bolt

♦ 2.5 Nm

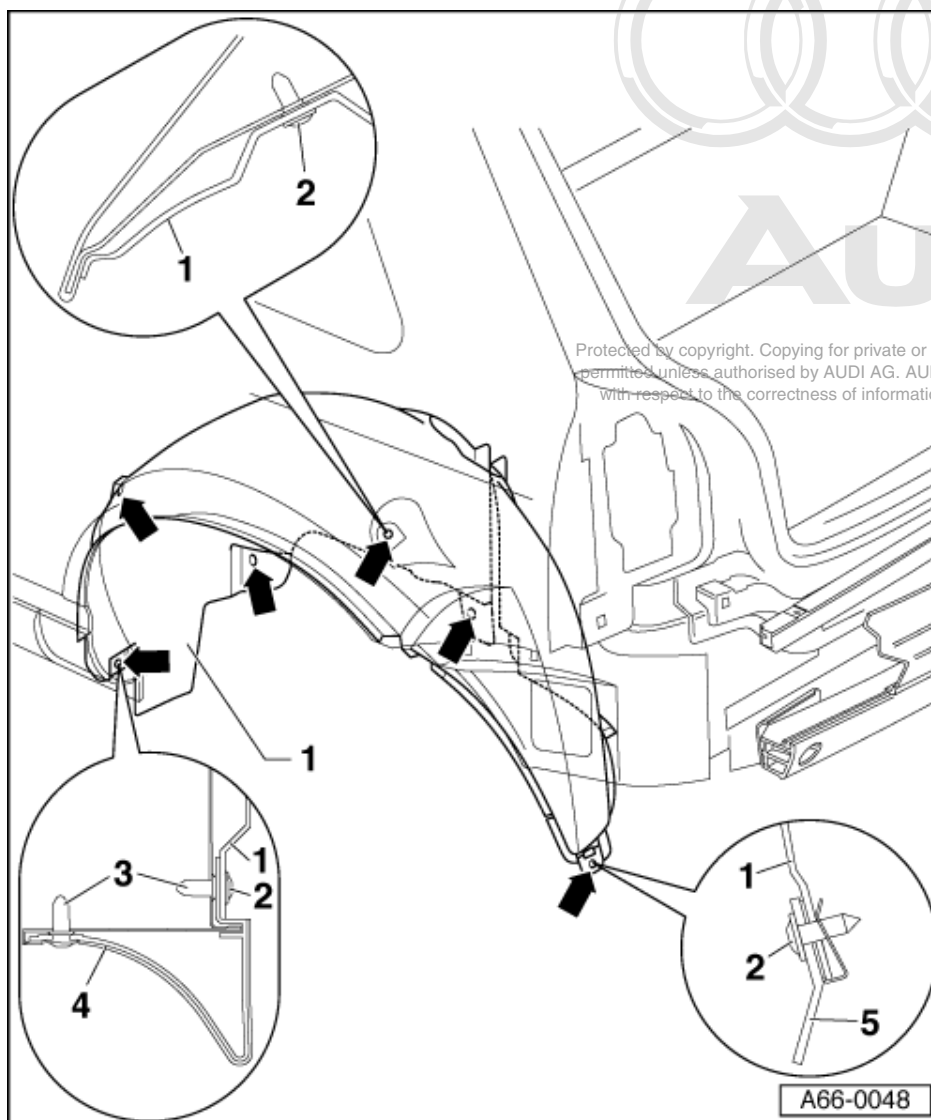
6 Upper longitudinal member

7 Snap nut

8 Bumper

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4.4 - Removing and installing rear wheel housing liner (except S3)



1 Rear wheel housing liner

- Rear wheel removed.
- Unscrew Torx bolts -2- (6*) squeeze liner gently together and remove from wheel housing.

2 Torx bolt

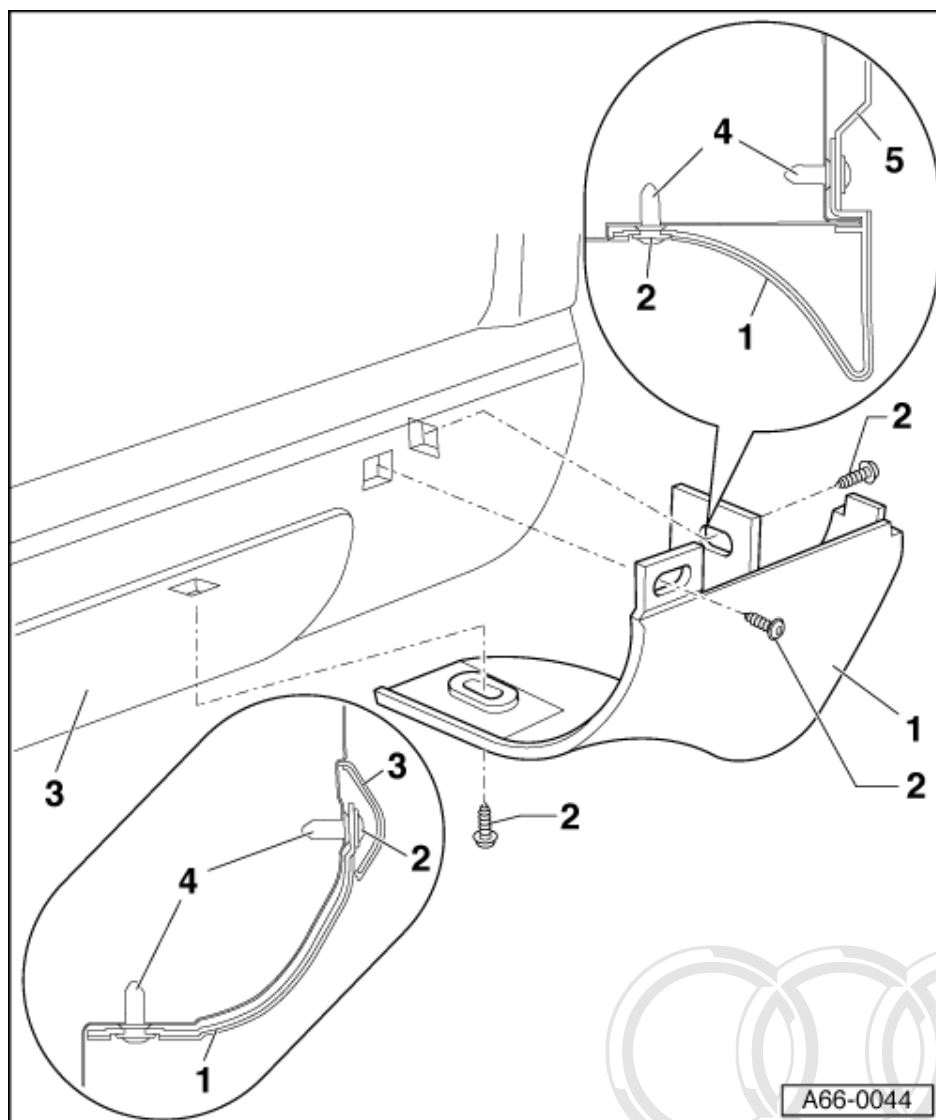
- ♦ 2 Nm

3 Expanding nut

4 Sill panel cover

5 Guide piece

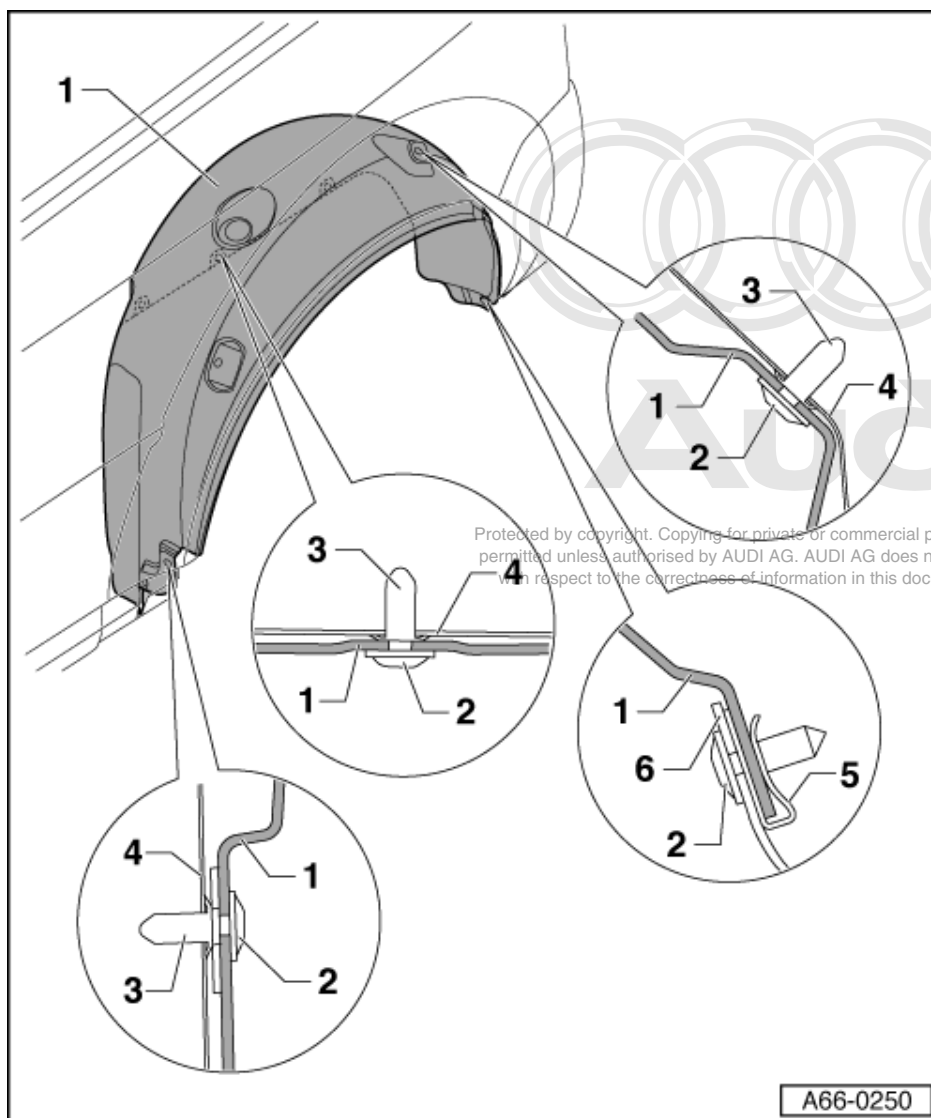
4.5 - Removing and installing sill panel cover (except S3)



- 1 Sill panel cover
 - ♦ To remove, unscrew Torx bolts (T25).
- 2 Torx bolts
 - ♦ 1.5 Nm
- 3 Side panel cover
- 4 Expanding nut
- 5 Rear wheel housing liner

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4.6 - Removing and installing rear wheel housing liner (S3)



1 Rear wheel housing liner

- Rear wheel removed
- Unscrew Torx bolts - 2 - squeeze liner gently together and remove from wheel housing.

2 Torx bolt

- ♦ 2.5 Nm

3 Expanding nut

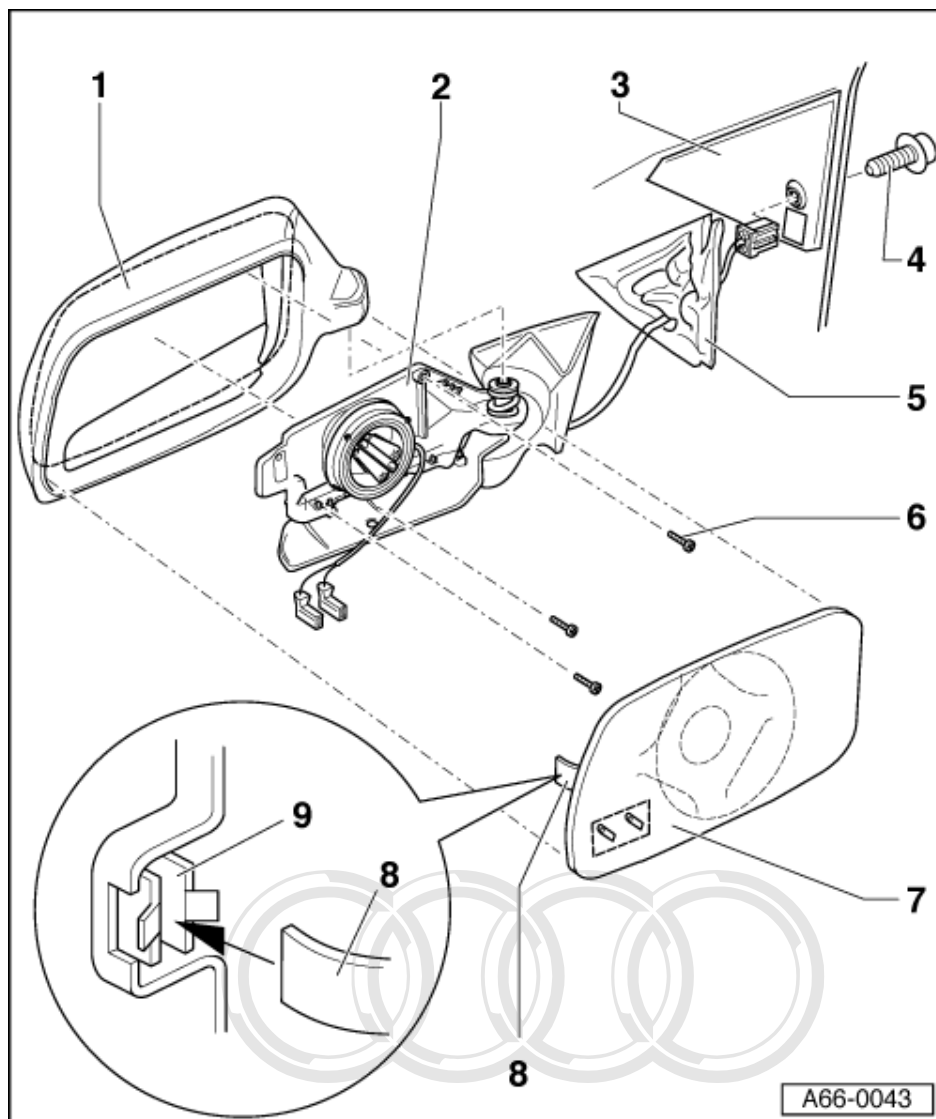
4 Longitudinal member, wheel housing

5 Snap nut

6 Guide strip

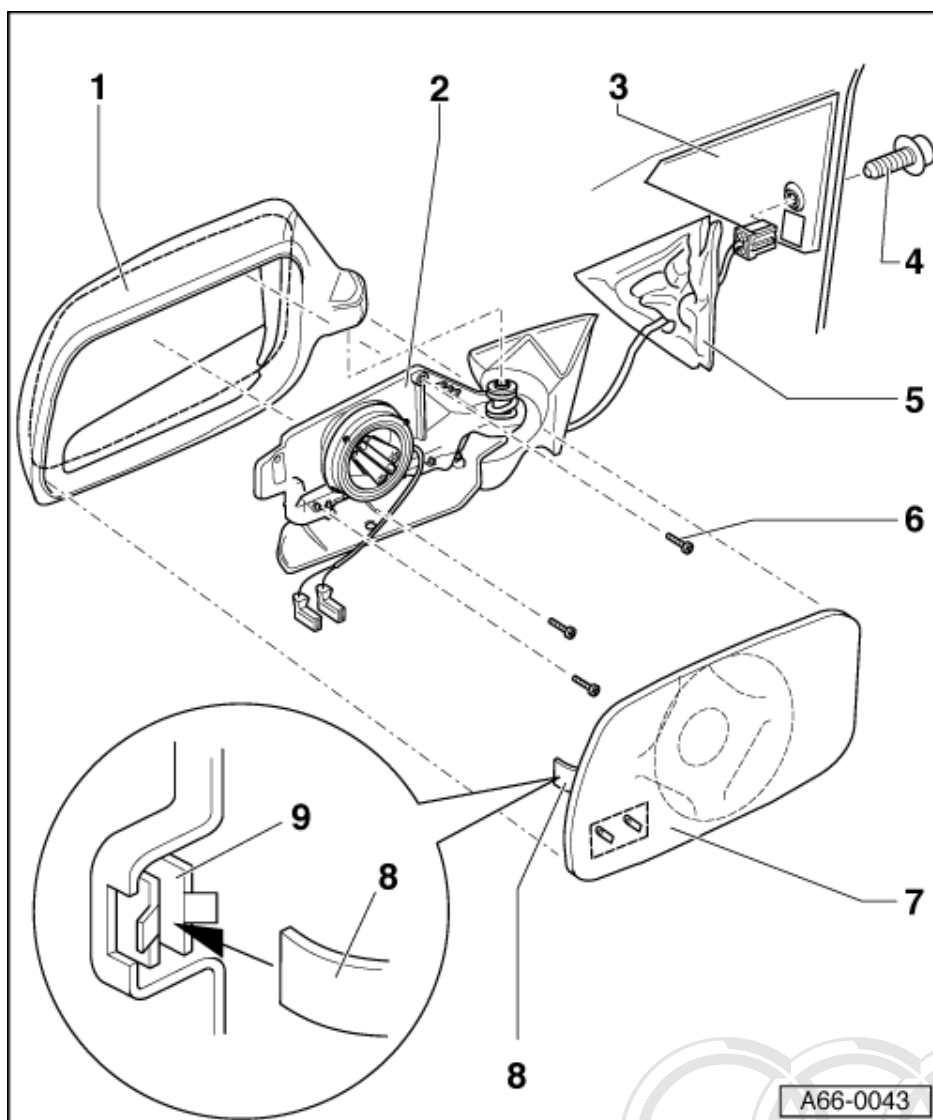
5 - Rear-view mirror

5.1 - Rear-view mirror



5.2 - Removing and installing rear-view mirror

- 1 **Mirror housing**
 - ♦ Can be removed from door without dismantling entire rear-view mirror => Page 193 .
- 2 **Mirror adjuster unit**
 - ♦ Remove mirror from door before removing adjuster unit.
 - To remove, lever off mirror glass, unplug electrical connectors for mirror heater, unscrew cross-head bolts -6- and take mirror adjuster unit out of mirror housing -1-.



3 Door subframe

4 Hexagon socket-head bolt

- ◆ 12 Nm

5 Seal

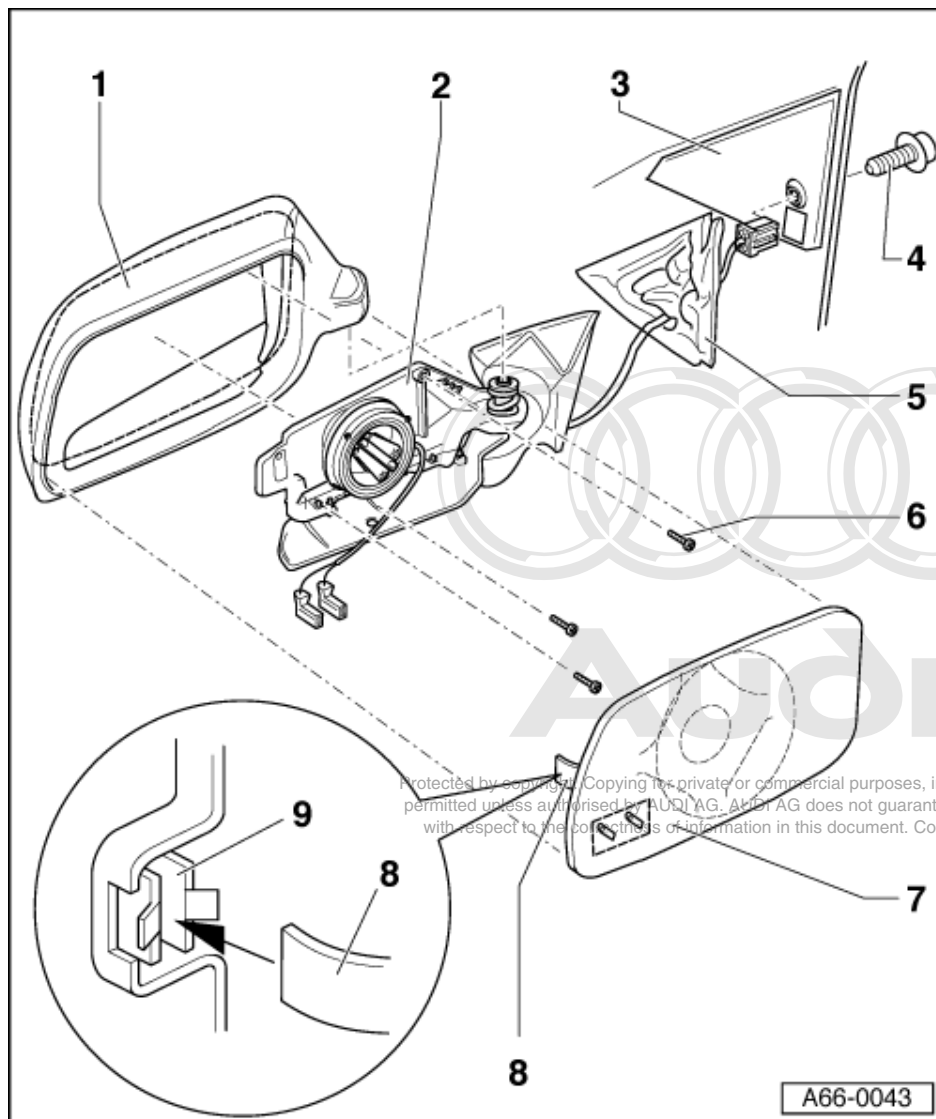
- ◆ When installing, make sure seal is seated correctly.

6 Cross-head screw

- ◆ 1 Nm

7 Mirror glass

- Use special tool 80-200 (assembly lever) to unclip mirror glass.
- Protect top and bottom of mirror housing from damage with fabric-backed adhesive tape.
- Lever off mirror glass at the bottom first, then at the top.



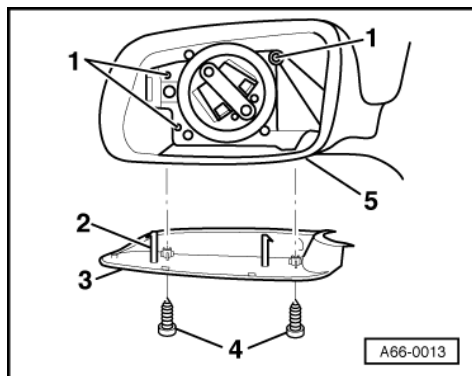
- To install, enter mirror glass into guide stud and friction finger into friction spring, and press on.
- Always use protective gloves, and only exert pressure at centre of glass.

8 Friction finger

- ◆ When fitting mirror glass, press friction finger -8- into friction spring -9- in housing.

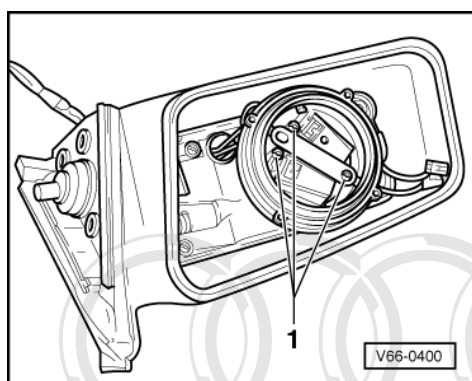
9 Friction spring

5.3 - Replacing exterior mirror housing



- Remove mirror glass.
- -> Unscrew hexagon nut -4- (2x).
- Press back lugs -2- and remove cover -3- downwards.
- Unscrew bolts -1- at mirror adjuster (3x).
- Removing housing -5- upwards.

5.4 - Replacing electrical mirror adjuster unit



- Disconnect battery.
- Remove mirror glass.
- -> Unscrew bolts -1- (3x).
- Tightening torque 1 Nm.
- If the mirror adjuster unit has electrical connectors, disconnect these before dismantling.

Note:

If the mirror adjuster unit has soldered wiring, the electric wires must be disconnected individually directly at the housing.

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- Install electric wires in the connector housing supplied with the replacement part.

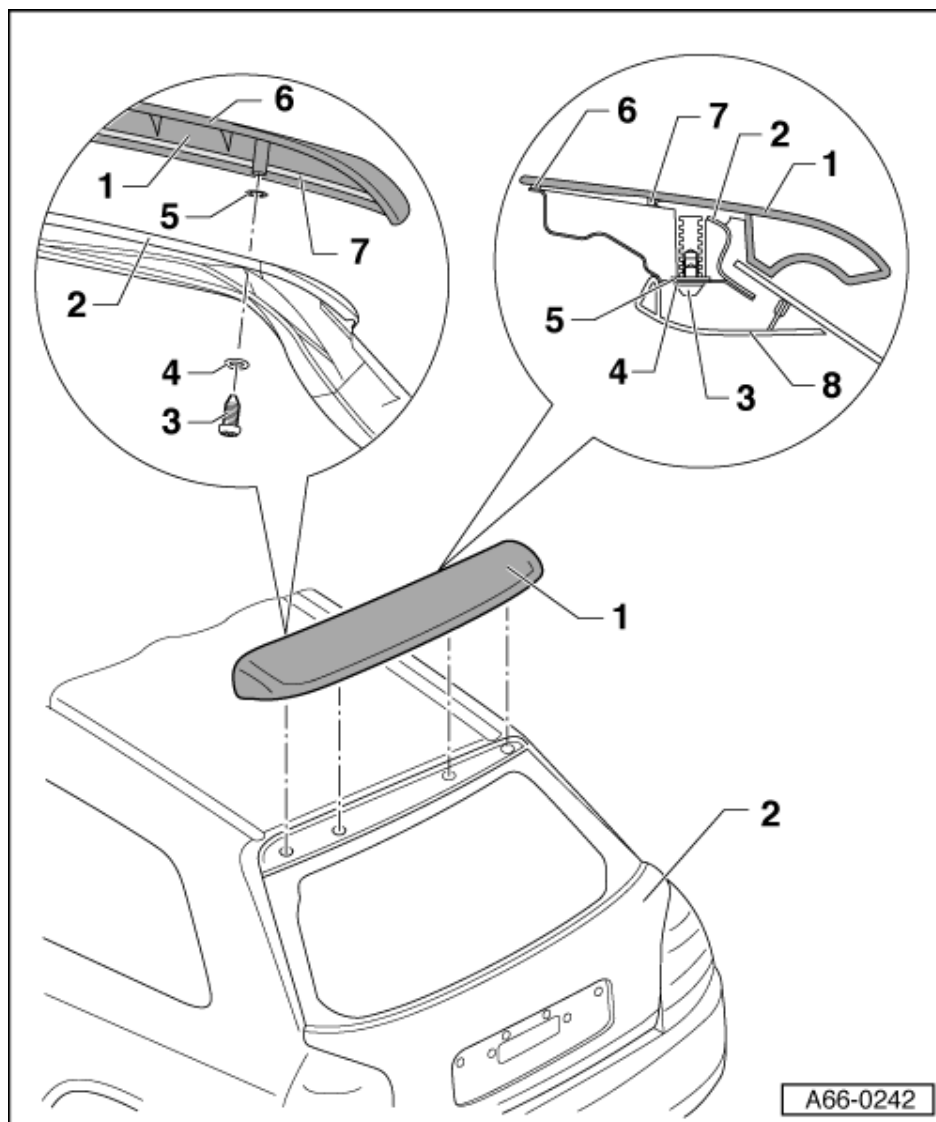
Note:

Note configuration of electric wires on old adjuster unit.

Use appropriate current flow diagram.

6 - Spoiler for tailgate (S3)

6.1 - Spoiler for tailgate (S3)



6.2 - Removing and installing spoiler

1 Spoiler

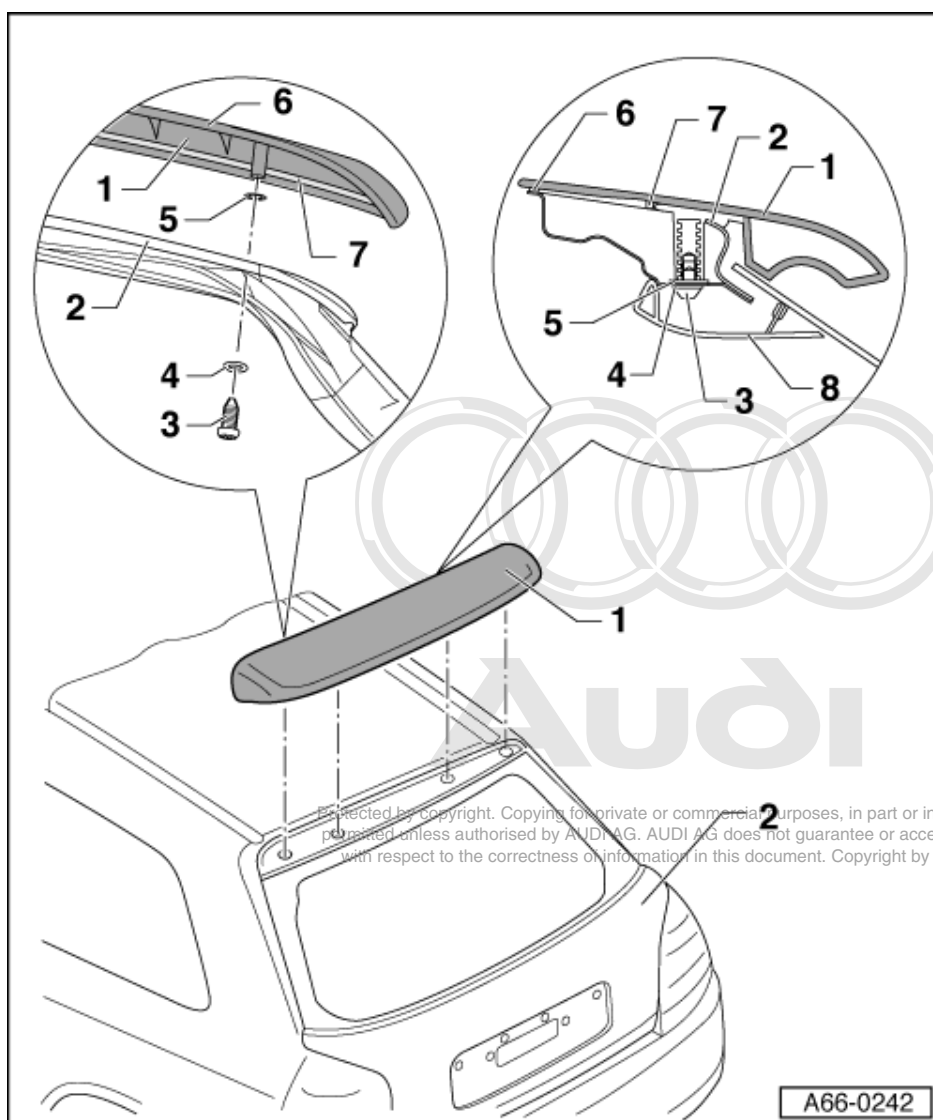
- ♦ In scope of delivery:
 - Weather strip => Item 5
 - Adhesive strip => Item 6
 - Sponge rubber sealing strip => Item 7
- ♦ Removing
 - Detach upper trim -8-

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing tailgate trim Trim panels Removing and installing tailgate trim

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- Remove Torx bolts - 3 - (4x).

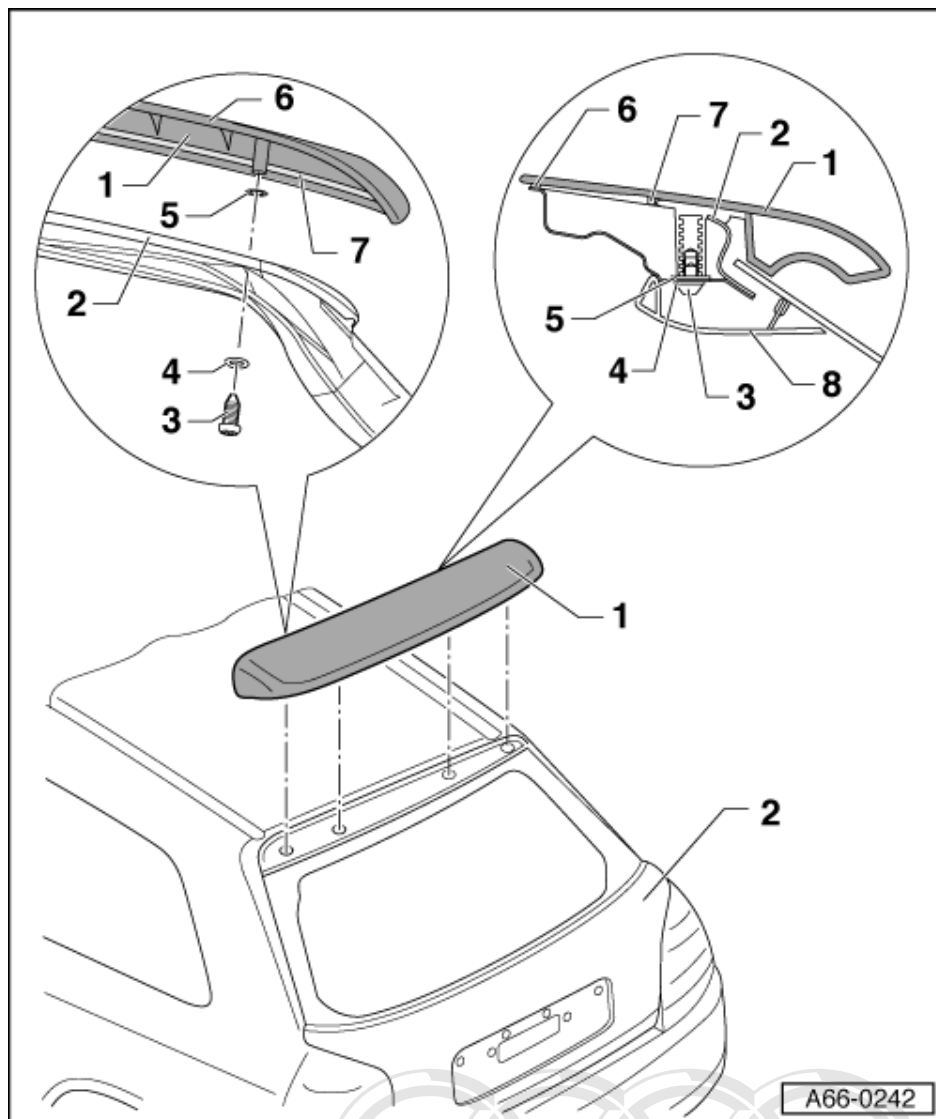
- Detach spoiler from tailgate - 2 -.



♦ Installing

Notes:

- ♦ Clean bonding surface on tailgate with petrol, treat with silicone remover and rub dry.
- ♦ Only remove protective foil of adhesive strip after positioning on tailgate.
 - Clean the bonding surface on tailgate - 2 - from adhesive residues, dust and grease.
 - Check that the sealing washers - 5 -- are fitted on the underside of the spoiler fastening pin.
 - Position spoiler on tailgate - 2 - and align.
 - Remove protective foil of adhesive strip - 6 -. Use the aids provided on the protective film when pulling off.
 - Press spoiler down firmly.



- Insert Torx bolts - 3 - (4x) with washers - 4 - (4x) and tighten.
- Install upper trim -8-.

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing tailgate trim Trim panels Removing and installing tailgate trim

2 Tailgate

3 Torx bolts (4x)

- ♦ 8 Nm

4 Washers (4x)

5 Sealing washer

- ♦ Bonded into spoiler - 1 -

6 Adhesive strip

- ♦ Bonded into spoiler - 1 -

7 Sponge rubber sealing strip

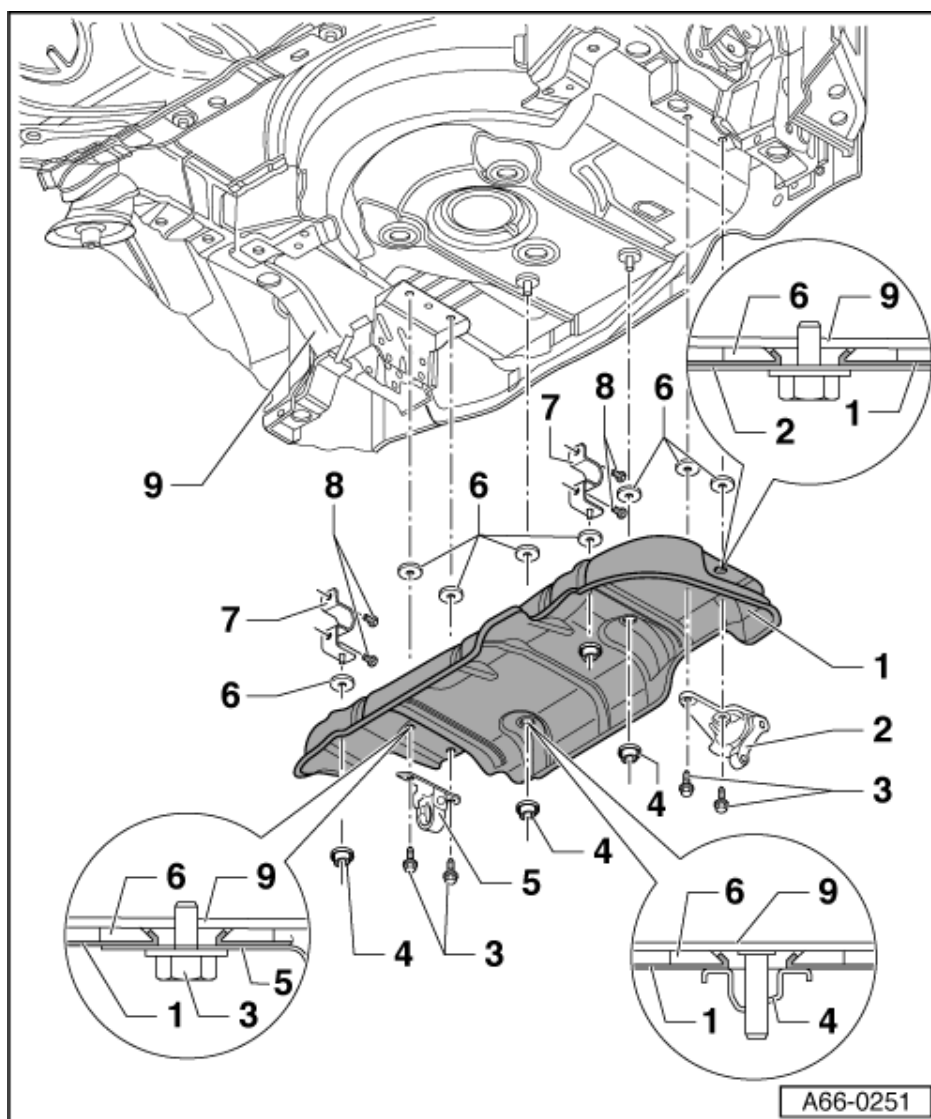
- ♦ Bonded into spoiler - 1 -

8 Upper trim

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7 - Removing and installing rear heat shield for floor (S3)

7.1 - Removing and installing rear heat shield for floor (S3)



- 1 Heat shield
- 2 Mounting
 - ◆ For exhaust system
- 3 Hexagon collar bolt (4x)
 - ◆ 23 Nm
- 4 Speed nut (4x)
 - ◆ 2.5 Nm
- 5 Mounting
 - ◆ For exhaust system
- 6 Spacer
- 7 Clip
 - ◆ For anti-roll bar
- 8 Hexagon bolt (4x)
 - ◆ 20 Nm
- 9 Rear floor

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