

Workshop Manual Audi A6 2005 ➤

General body repairs, exterior

Edition 05.2016



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List of Workshop Manual Repair Groups

Repair Group

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50 - Body - front

55 - Bonnet, rear lid

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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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00 – Technical data

1 Contact corrosion

(ARL004565; Edition 05.2016)

Contact corrosion can occur if unsuitable fasteners (bolts, nuts, washers etc.) are used on the vehicle.

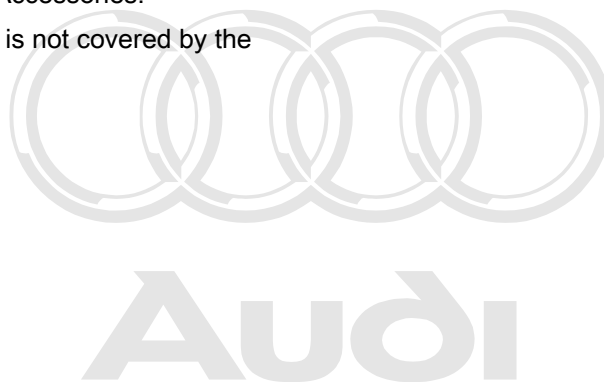
For this reason, only fasteners with a special surface coating are fitted.

In addition, all rubber and plastic parts and all adhesives are made of non-conductive materials.

Should you have any doubts whether certain parts can be re-used, use new parts ⇒ Electronic parts catalogue .

Please note:

- ◆ We recommend using genuine replacement parts only, as these have been checked and are compatible with aluminium.
- ◆ We recommend using Audi Genuine Accessories.
- ◆ Damage caused by contact corrosion is not covered by the warranty.



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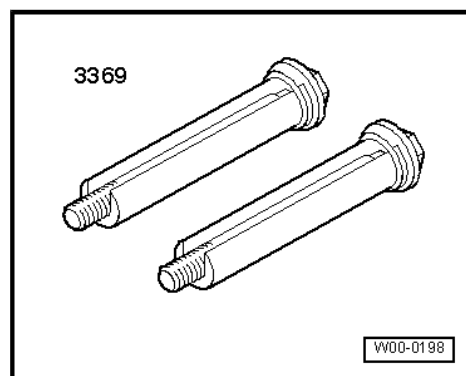
50 – Body - front

1 Body - front

1.1 Lock carrier service position

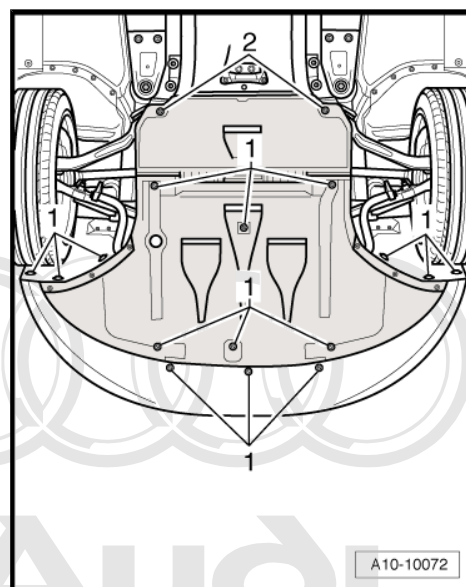
Special tools and workshop equipment required

- ♦ Front-end service sleeves - 3369-

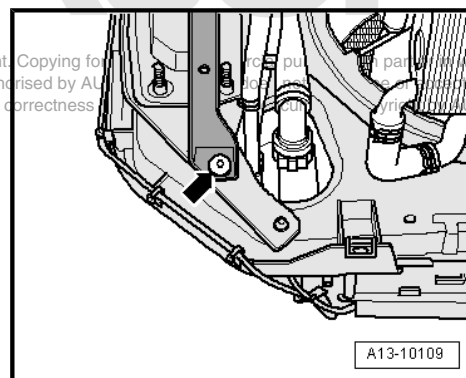


Removing

- Release quick-release fasteners -1- and -2- and remove noise insulation panels.
- Remove front left and right wheel housing liners ⇒ Rep. gr. 66 .
- Remove front bumper ⇒ Rep. gr. 63 .
- Remove headlights (left and right) ⇒ Rep. gr. 94 .

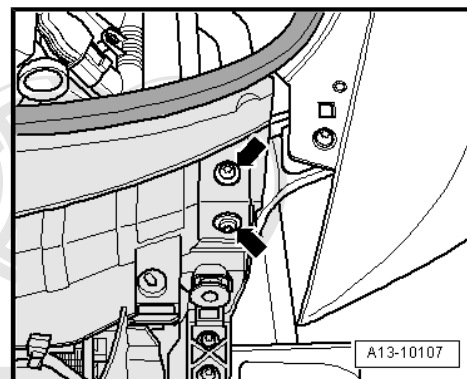


- Remove one bolt from each side of lock carrier at bottom left and right.



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- Detach bonnet seal from both wings.
- Remove two bolts -arrows- from each side of lock carrier at top left and right.
- Screw front-end service sleeves - 3369- into left and right holes for lock carrier bolts (the lock carrier bolts have to be removed beforehand).



- Remove remaining bolts -arrows- on left and right.



Note

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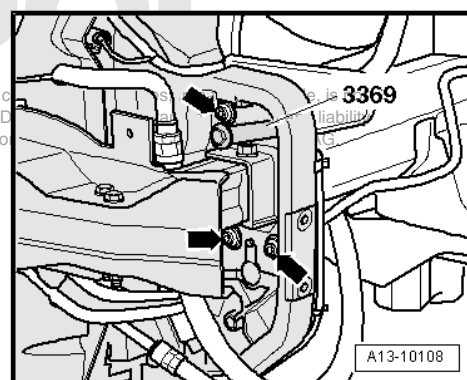
On vehicles with turbocharged engines you must also disconnect the charge air hoses.

- Carefully pull lock carrier forwards.

Installing

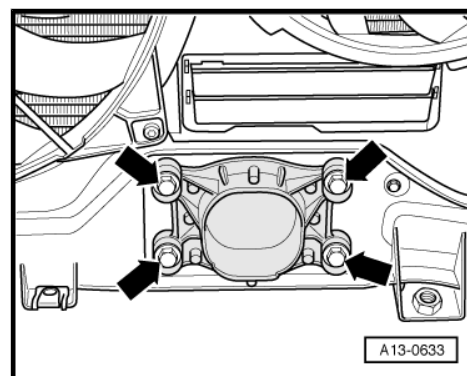
Installation is carried out in reverse order; note the following:

- Install lock carrier with attachments.
- Allow stop for torque reaction support to rest on rubber buffer for torque reaction support under its own weight, and tighten bolts -arrows-.
- Install headlights ⇒ Rep. gr. 94 .
- Install front bumper ⇒ Rep. gr. 63 .
- Check headlight adjustment ⇒ Maintenance ; Booklet 4 F .



Tightening torque

Component	Nm
Stop for torque reaction support to lock carrier	40



1.2 Removing and installing lock carrier with attachments



Caution

For vehicles equipped with adaptive cruise control (ACC) please observe the following:

If the cross member is removed and re-installed, or if changes are made to the retainer for the »ACC« the adaptive cruise control system will have to be adjusted ⇒ Wheels, tyres, vehicle geometry; Rep. gr. 44 .

Exploded view

1 - Bolt with washer

- ☐ Only accessible after removing noise insulation panel (front)
⇒ [page 5](#).

- ☐ 10 Nm

2 - Bolt with washer

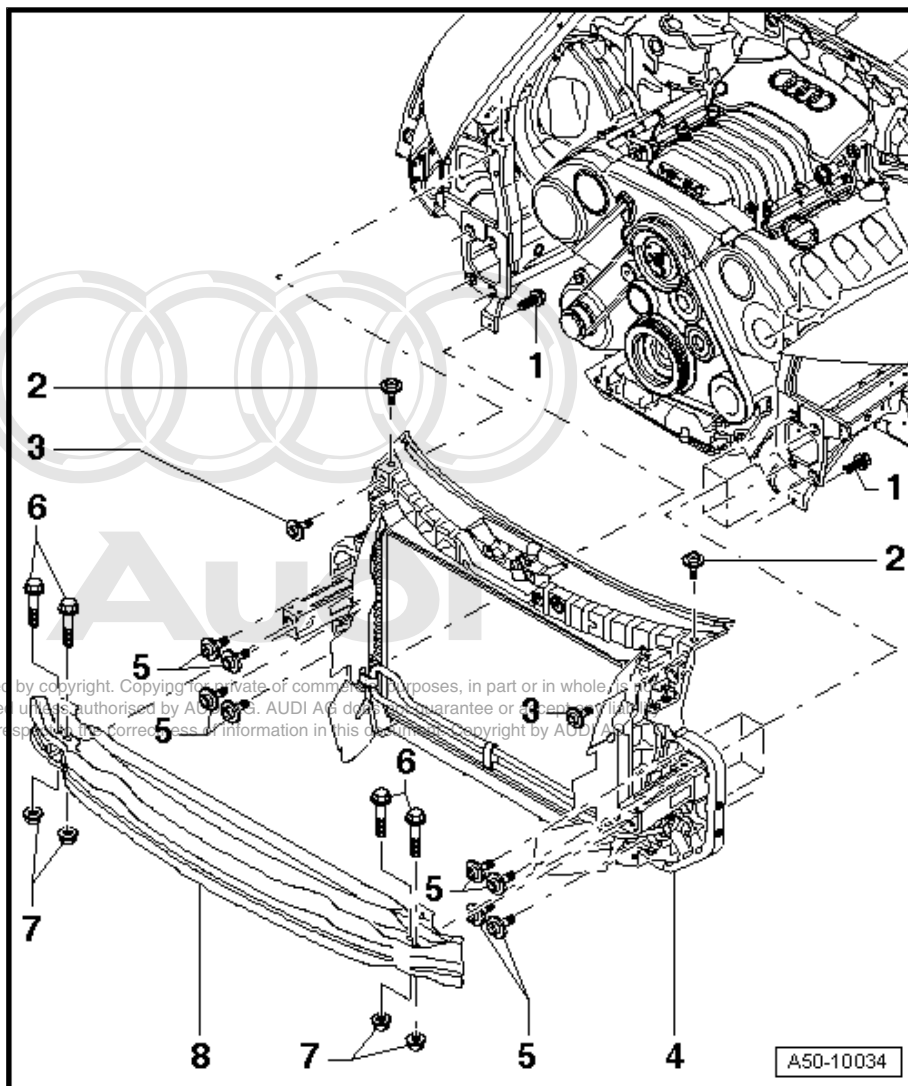
- ☐ 10 Nm

3 - Bolt with washer

- ☐ 10 Nm

4 - Lock carrier

- ☐ Removing:
- ☐ Remove bumper
⇒ [page 142](#).
- ☐ Remove noise insulation ⇒ [page 10](#).
- ☐ Disengage Bowden cable for bonnet lock.
- ☐ Detach engine cover panels -2- and -3-.
- ☐ Unscrew air duct between lock carrier and air cleaner at lock carrier.
- ☐ Unplug electrical connectors.
- ☐ Drain coolant and disconnect coolant pipes/hoses ⇒ [page 6](#) and ⇒ [page 6](#).
- ☐ Only detach condenser from radiator (do not disconnect any pipes/ho-



ses).

- ☐ Secure air conditioner condenser to front wheel using wire or similar. ⇒ Rep. gr. 87



Note

The condenser must not be suspended by its pipes/hoses. The condenser pipes/hoses must NOT be bent or kinked.

- ☐ Disconnect hoses to hydraulic fluid cooler.
- ☐ Remove hydraulic fluid cooler ⇒ [page 6](#) ⇒ Rep. gr. 48 .



Note

The hydraulic fluid cooler pipes must NOT be bent or kinked.

- ☐ Vehicles with automatic gearbox: Disconnect lines to ATF cooler. ⇒ Rep. gr. 37
- ☐ Vehicles with charge air cooler: Detach air hose.
- ☐ Detach bonnet seals (left and right) at joint between wing and lock carrier -1-.
- ☐ Remove bolts -5-.
- ☐ A second mechanic is required to hold lock carrier -1-.
- ☐ Remove bolts -4-.
- ☐ Detach lock carrier towards front.
- ☐ Installing:
- ☐ Install in reverse order.
- ☐ Headlights must be re-adjusted.
- ☐ Adjusting:
- ☐ Lock carrier -1- must be positioned centrally between wings.
- ☐ If wings and bonnet are also being renewed, these must first be centrally aligned with one another.

5 - Bolt with washer

- ☐ 50 Nm

6 - Hexagon bolt

- ☐ 20 Nm

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7 - Hexagon nut

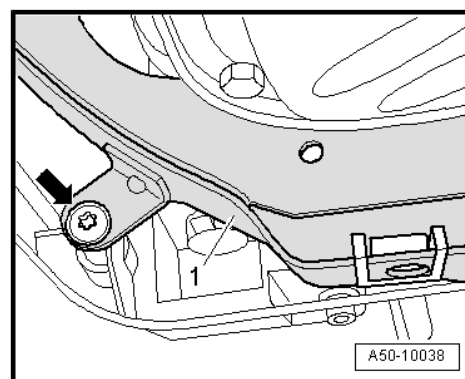


8 - Cross member

- ☐ Bumper cover must be removed before removing cross member.
- ☐ To remove, first unscrew hexagon bolts and detach cross member from impact dampers.

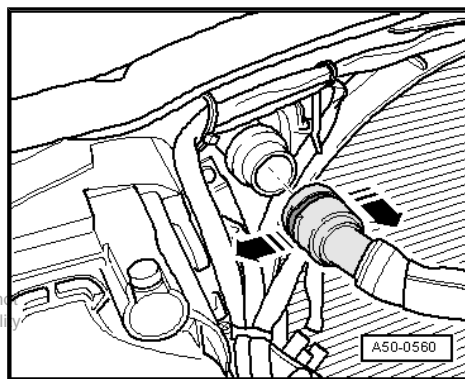
Separate bolted connection on reinforcement plate

- Detach noise insulation.
- Remove Torx bolt -arrow-.
- When installing lock carrier, tighten bolt to 10 Nm.



Disconnecting coolant hose (top)

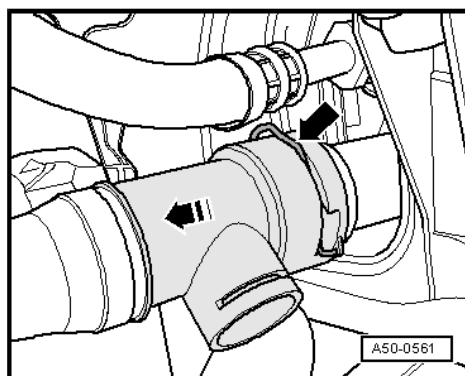
- Pull out retainer for coolant hose connecting flange at top of radiator. Then detach connecting flange.



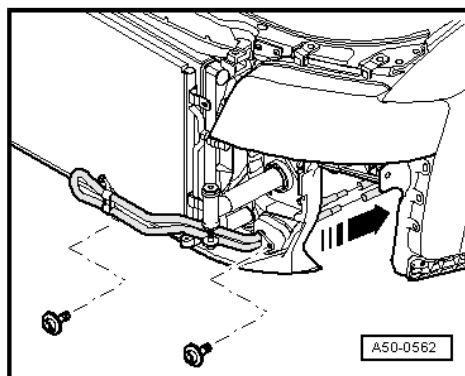
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Disconnecting coolant hose (bottom)

- Pull out retainer for coolant hose connecting flange at bottom of radiator. Then detach connecting flange.
- Bleed cooling system ⇒ Rep. gr. 19 .



Disconnecting hydraulic fluid cooler



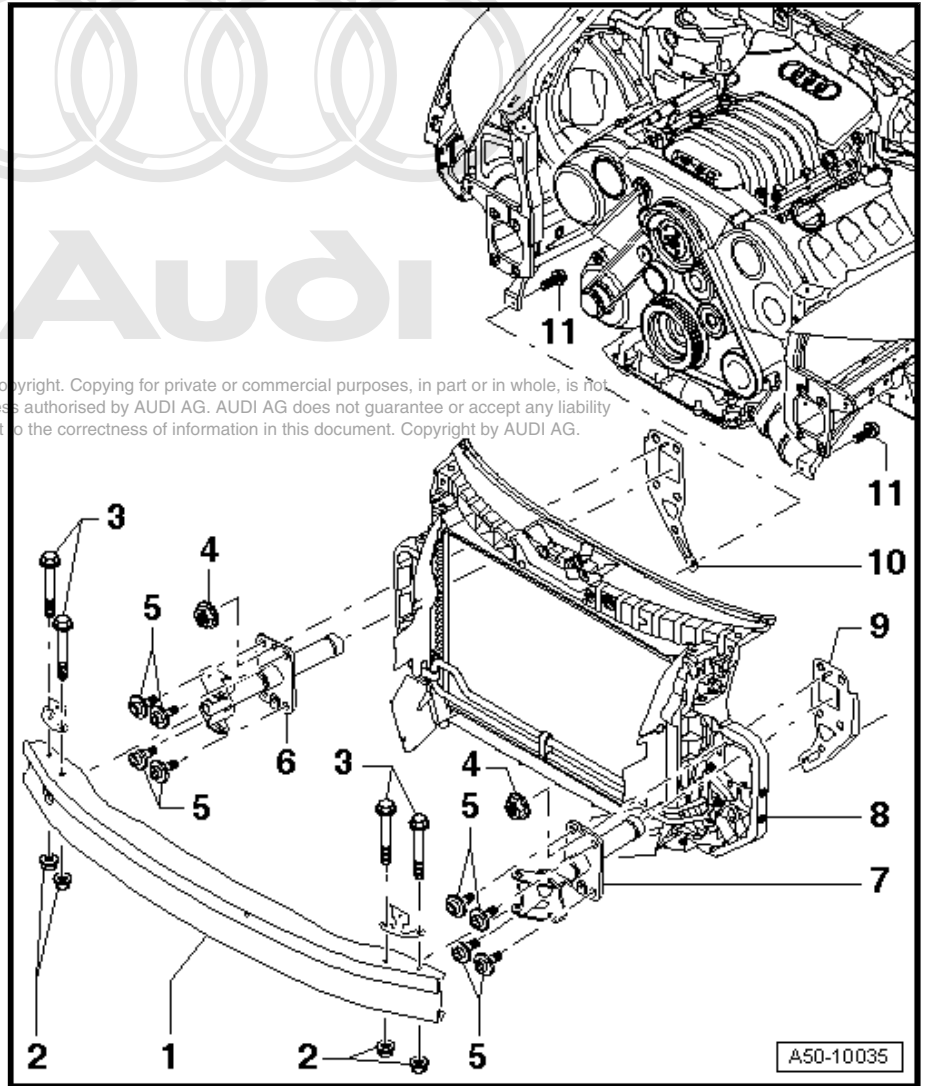
Exploded view for vehicles with impact dampers



Note

Exploded view shows only components which differ from those fitted on vehicles without impact dampers; removing and installing is performed as described above.

- 1 - Cross member
- 2 - Hexagon nut
- 3 - Hexagon bolt
 - ☐ 20 Nm
- 4 - Flange nut
 - ☐ For securing impact dampers in lock carrier
 - ☐ 10 Nm
- 5 - Bolts with washers
 - ☐ 50 Nm
- 6 - Impact damper (right-side)
 - ☐ Only fitted on USA vehicles
- 7 - Impact damper (left-side)
- 8 - Lock carrier
 - ☐ Removing
⇒ [Item 4 \(page 4\)](#)
- 9 - Reinforcement plate (left-side)
- 10 - Reinforcement plate (right-side)
- 11 - Bolt with washer
 - ☐ 10 Nm



1.3 Removing and installing cowl panel trim

1 - Panel bolt

- 1.5 Nm

2 - Cowl panel trim

- Windscreen wiper arms removed
- Plenum chamber cover removed
- Detach locking pins from plenum chamber cover -4-.
- Carefully pull trim upwards out of fastening strip at bottom of windscreen.
- Lift out trim.
- Press trim into fastening strip at bottom of windscreen.
- Make sure that trim engages correctly in fastening strip.

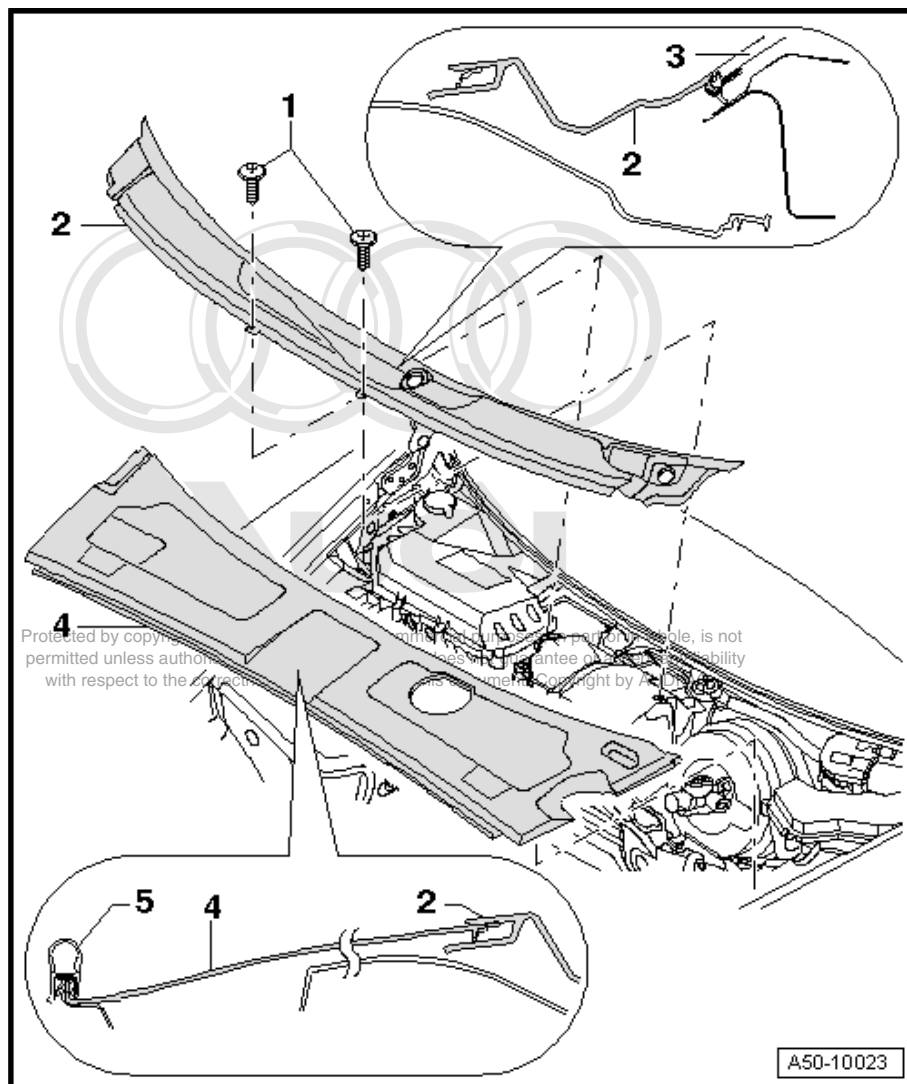
3 - Windscreen

4 - Plenum chamber cover

- Detach seal -5- and pull cover forwards out of cowl panel trim.

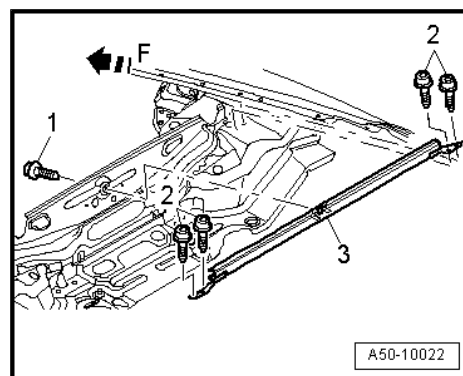
5 - Seal

- Detach by pulling forwards at side.



1.4 Removing and installing cross brace (body brace)

- Unscrew bolts -1- and -2-.
- Remove cross brace -3-.
- When installing, tighten bolts -1- and -2- to 25 Nm.



1.5 Exploded view - wing

Note

- ◆ *The bolts are micro-encapsulated and must be renewed after loosening or removing the wing.*
- ◆ *Before inserting new bolts, clean tapped hole using a suitable tap.*

1 - Bolt with washer

- ☐ 15 Nm

2 - Wing

- ☐ Before removing, remove bolts on wind-screen washer reservoir.
- ☐ Remove bumper
⇒ [page 142](#).
- ☐ Remove wheel housing liner
⇒ [page 230](#).
- ☐ Remove end plate
⇒ [page 10](#).
- ☐ Remove headlight ⇒ Rep. gr. 94.
- ☐ Unplug electrical connectors for side-mounted turn signal.
- ☐ Remove bolts -1- from wing mounting flange.
- ☐ Remove bolts -3- and -4- and detach wing.

3 - Bolt with washer

- ☐ 15 Nm

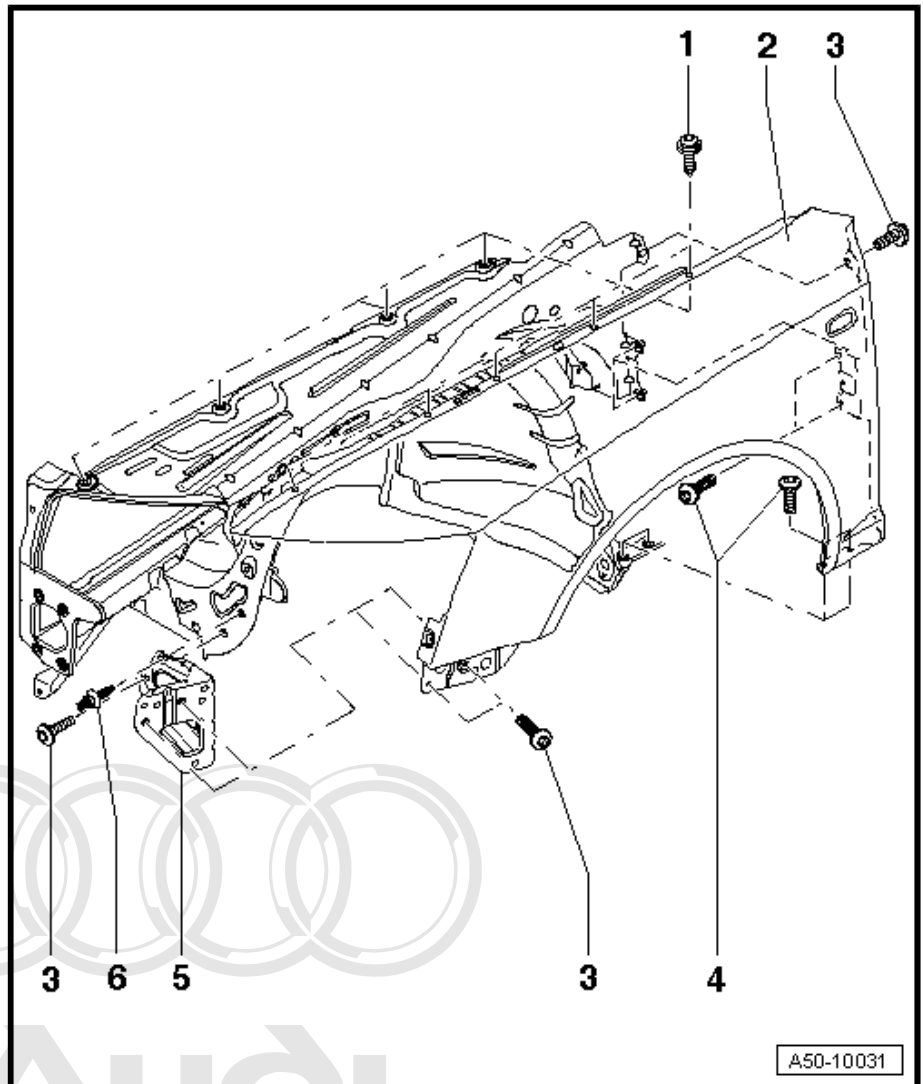
4 - Bolt with washer

- ☐ 15 Nm

5 - Wing panel brace

6 - Double flange bolt

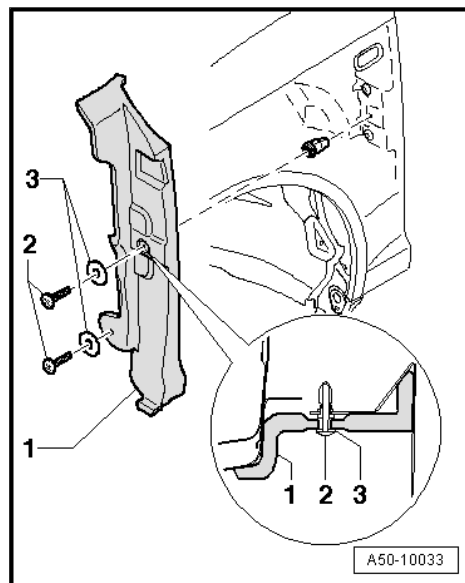
- ☐ 15 Nm
- ☐ Only fitted on left side



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Removing and installing end plate

- Front wheel removed
- Wheel housing liner removed
- Unscrew bolts -2- and take end plate -1- out of wing.
- Tightening torque: 1.5 Nm.



Seal for wing



Note

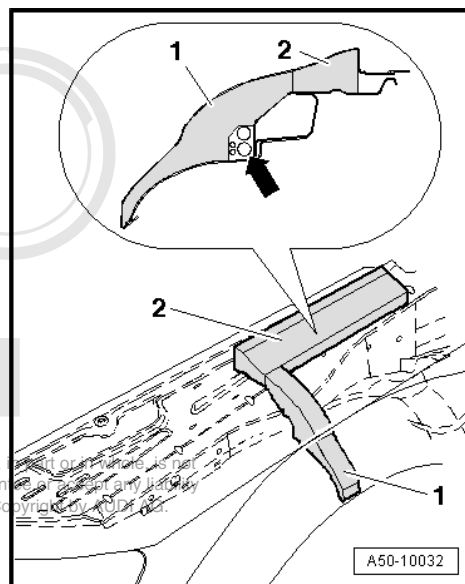
The area onto which the seal is bonded must be free of dust and grease; if necessary clean beforehand.

- Before installing seal -2-, detach protective paper and press seal onto wing mounting flange as shown.
- Proceed in same way with seal -2- for wheel housing liner.



Note

Only make the opening for the Bowden cable for the bonnet -arrow- on the driver's side.



1.6 Exploded view - noise insulation

1 - Noise insulation (front)

- ☐ Release the two striker pins on both wheel housing liners.
- ☐ To remove, release quick-release fasteners at front and rear.
- ☐ First pull out noise insulation panel slightly towards rear from below bumper cover.
- ☐ Pull out noise insulation panel with wheel spoilers towards front.

2 - Wheel spoiler

- ☐ To remove, release fastener by pressing in locking pins.

☐

3 - Locking pin

- ☐ 5x on each wheel spoiler

4 - Noise insulation (rear)

- ☐ Removing ⇒ [page 11](#)

5 - Subframe

6 - Quick-release fastener

- ☐ To move lock carrier to service position, release only quick-release fasteners on lock carrier.
- ☐ 3x

7 - Lock carrier with attachments

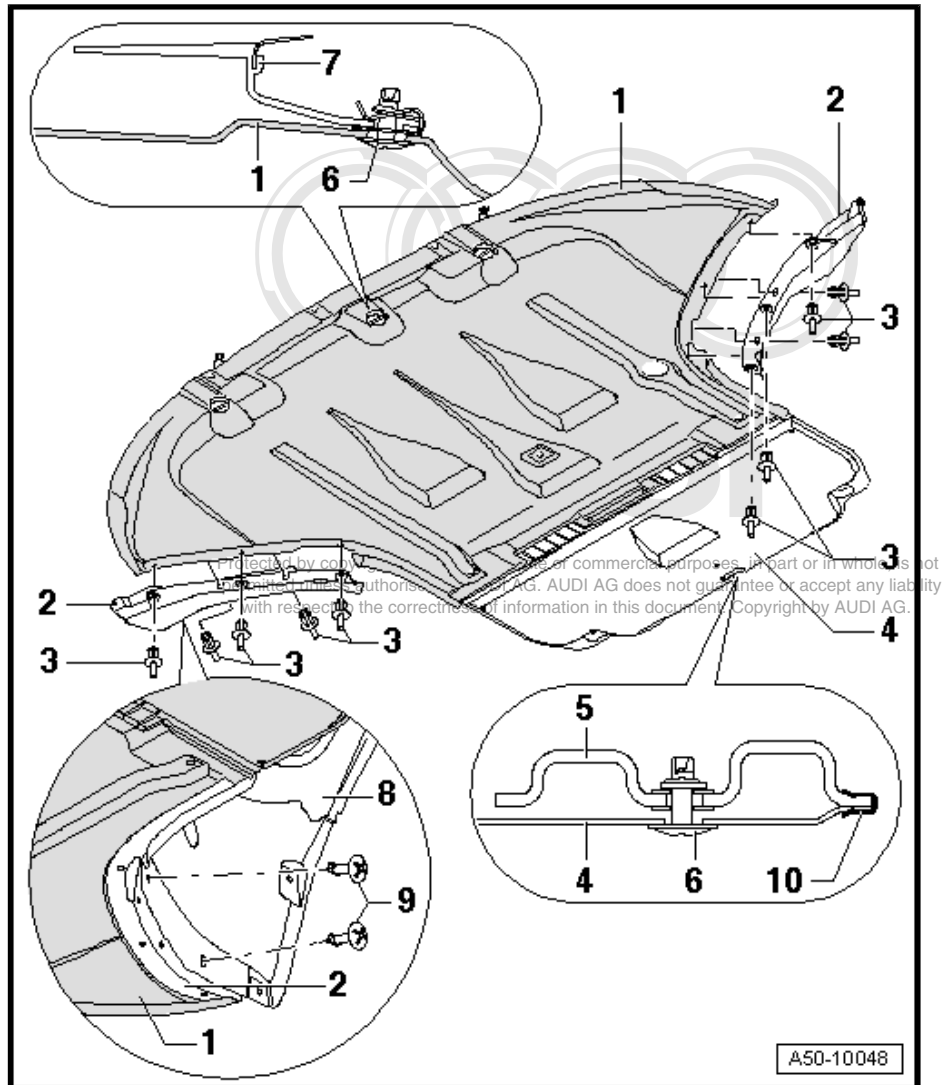
8 - Wheel housing liner

9 - Striker pins

- ☐ Release to remove noise insulation panel (front).
- ☐ 2x, at left and right of each wheel housing liner

10 - Retaining clip

Noise insulation (rear)



1 - Noise insulation (front)

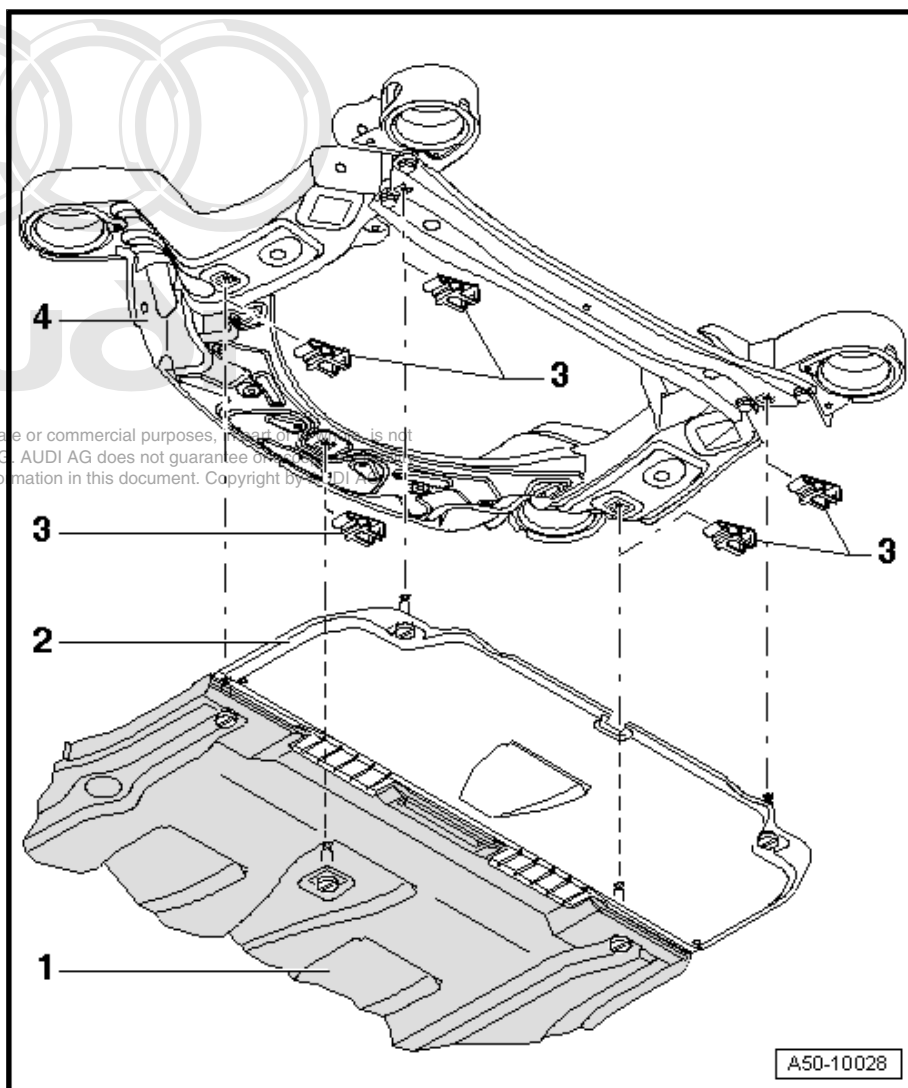
2 - Noise insulation (rear)

- ☐ To remove, release rear quick-release fasteners on noise insulation panel (front).
- ☐ Release rear quick-release fasteners on noise insulation panel (rear) and pull it out towards rear.

3 - Speed nut

- ☐ Pushed into subframe from side.

4 - Subframe



A50-10028

55 – Bonnet, rear lid

1 Bonnet

1.1 Removing and installing bonnet, adjusting bonnet

1 - Bonnet

- ☐ Disconnect hose for windscreen washer system and unclip hose.
- ☐ Second person is required to support and lift off bonnet.
- ☐ Detach gas strut -4- from bonnet -1- [⇒ page 15](#).
- ☐ Remove nuts -6-.
- ☐ Detach bonnet.
- ☐ Installing:
- ☐ Install in reverse order.
- ☐ Adjusting:
- ☐ Align bonnet -1- centrally between the wings.
- ☐ Adjust height of bonnet at bonnet lock [⇒ page 15](#).
- ☐ Bonnet can be adjusted according to wings via stop buffers [⇒ page 14](#).
- ☐ Panel gaps [⇒ page 16](#).

2 - Arrester

3 - Cap nut

- ☐ 11 Nm

4 - Gas strut

- ☐ Removing and installing [⇒ page 15](#)

5 - Ball-head pin

- ☐ 14 Nm

6 - Hexagon nut

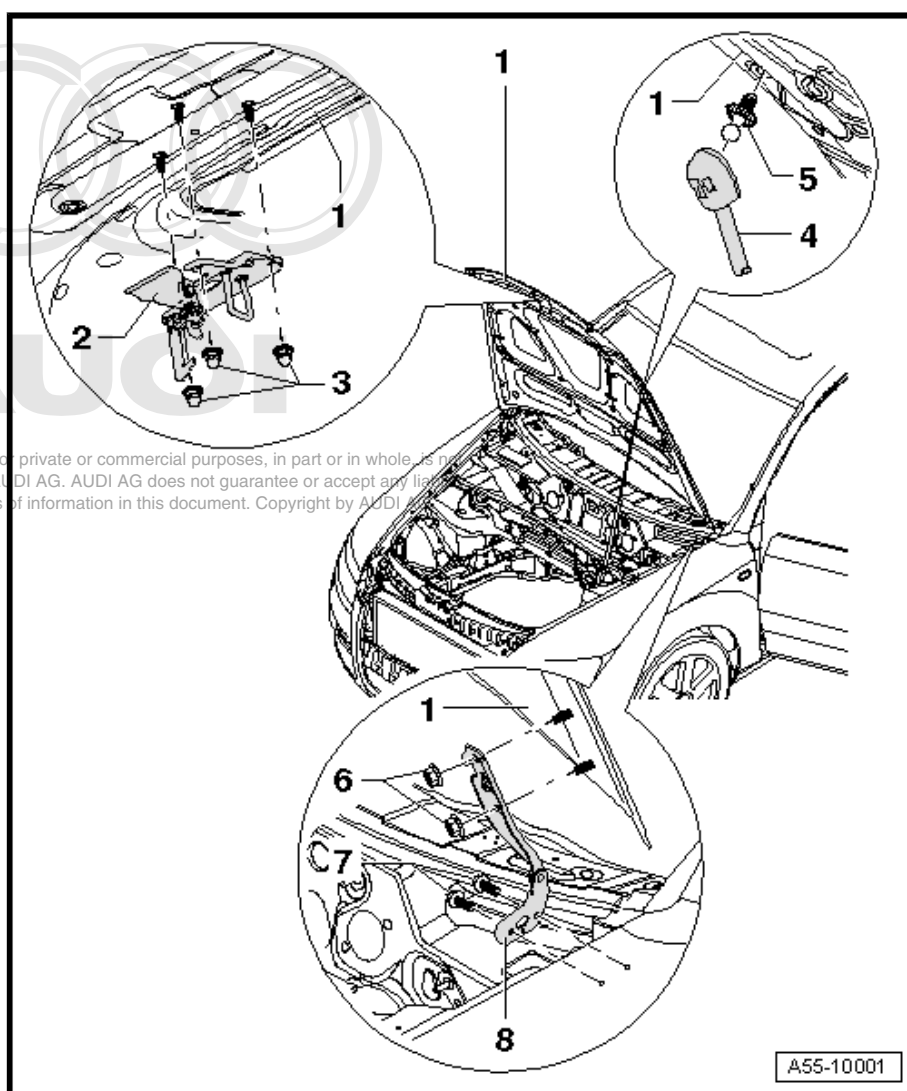
- ☐ 21 Nm

7 - Bolt with washer

- ☐ 21 Nm

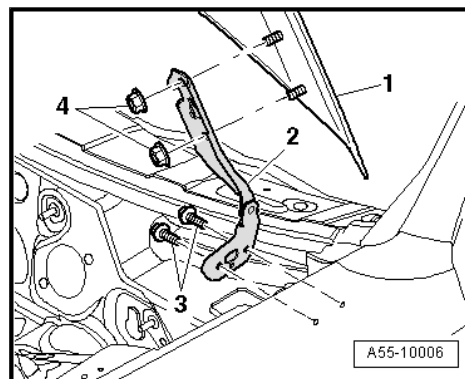
8 - Bonnet hinge

- ☐ Bonnet -1- must be removed or securely supported during removal operations.



Bonnet hinge

- To remove hinge -2-, bonnet -1- must be removed or securely supported.
- To remove, unscrew bolts -3- and nuts -4-.



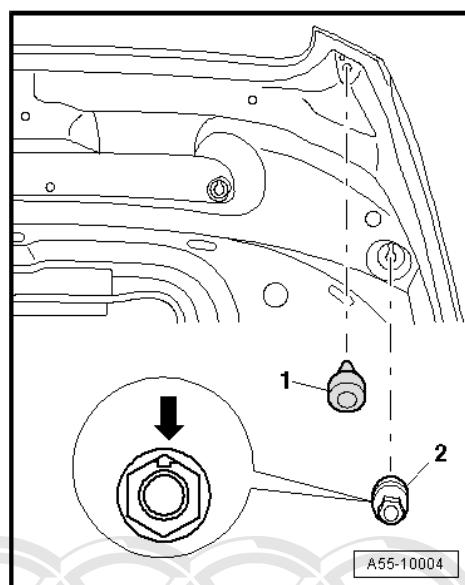
Stop buffers for height adjustment

- With bonnet closed, stop buffers -1- and -2- must rest lightly on lock carrier.



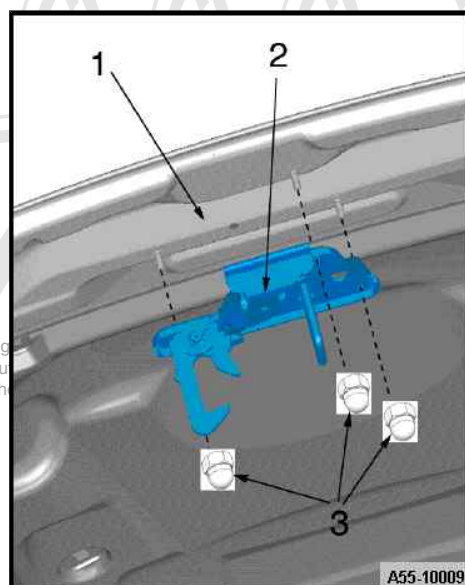
Note

Stop buffers can be used to adjust height of bonnet.



Removing and installing arrester

- To remove, unscrew cap nuts -3- and detach arrester -2-.
- When installing, tighten cap nuts -3- on bonnet -1- to 11 Nm.

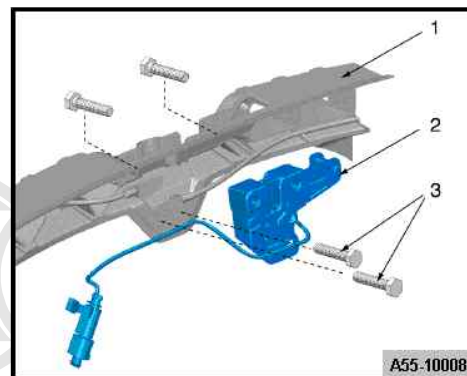


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Removing and installing bonnet lock (bottom section)

- Disengage Bowden cable for bonnet ➤ [page 19](#) .
- Remove bolts -3- (4x).
- When installing, tighten to 14 Nm.
- Remove lower section of bonnet lock -2- from lock carrier -1-.
- To adjust height of bonnet, move lock (bottom section) up or down as required.



Removing and installing gas strut

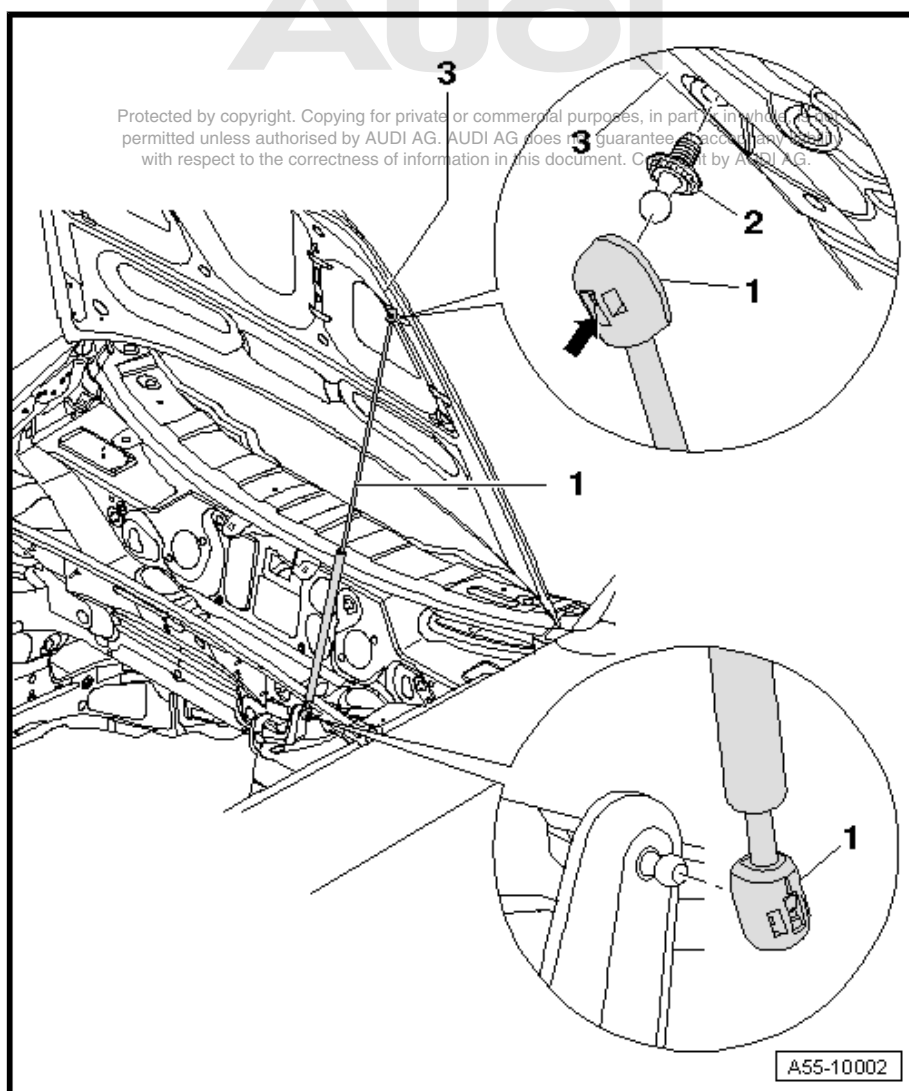
1 - Gas strut

- Prop up and secure bonnet in open position.
- Use screwdriver to slightly raise retaining springs -arrow- at both ends of gas strut and unclip gas strut.
- To install, press gas strut onto ball-head pin and engage.
- Cylinder end of gas strut is installed on body side.

2 - Ball-head pin

- 14 Nm

3 - Bonnet



Releasing gas from gas strut

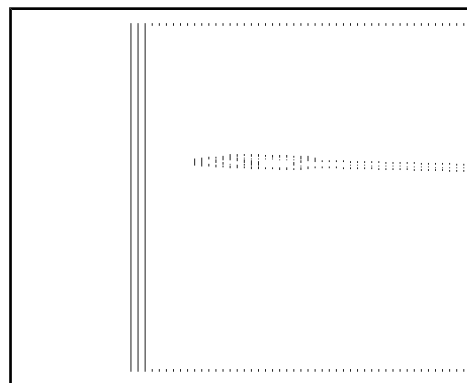


WARNING

Only the section indicated may be clamped in the vice (accident risk!).

Protective goggles must be worn during sawing process.

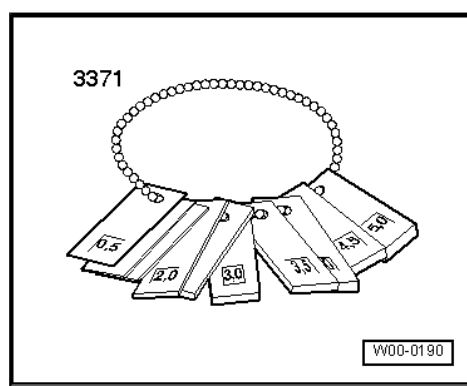
- Clamp gas strut in vice in area x = 50 mm.
- Saw open the first third of the cylinder part of the gas strut (measured from the piston rod end of the cylinder).



1.2 Panel gaps for bonnet

Special tools and workshop equipment required

- ◆ Setting gauge - 3371-



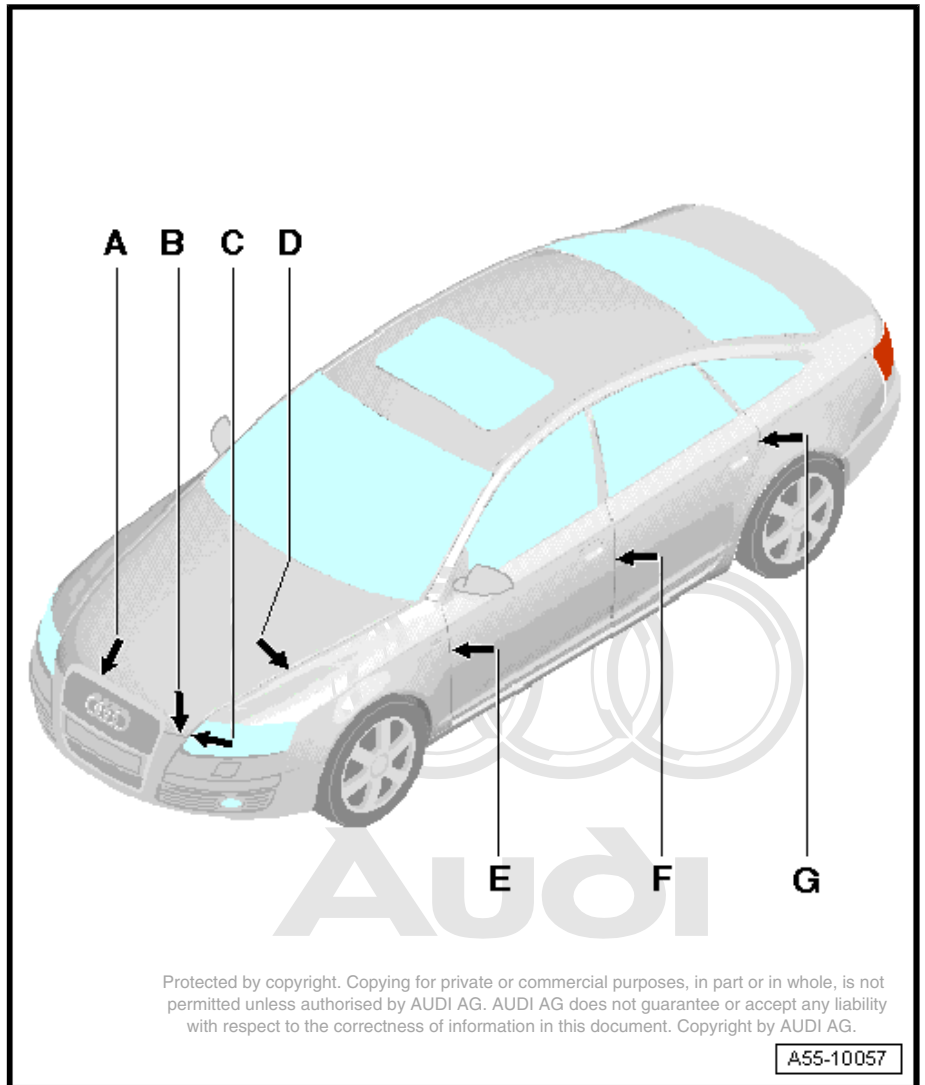
Panel gaps



Note

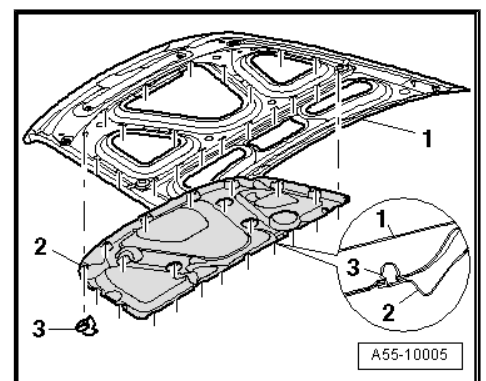
Panel gaps can be checked using setting gauge - 3371-.

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1.3 Lining for bonnet

- Detach clips -3- from bonnet -1-.
- Remove cover -2-.



1.4 Bonnet seal

1 - Seal for lock carrier

- ☐ Position seals (left and right) at foam section.
- ☐ Ensure that there are no gaps.
- ☐ Seal must be compressed along length of lock carrier to take up excess length.

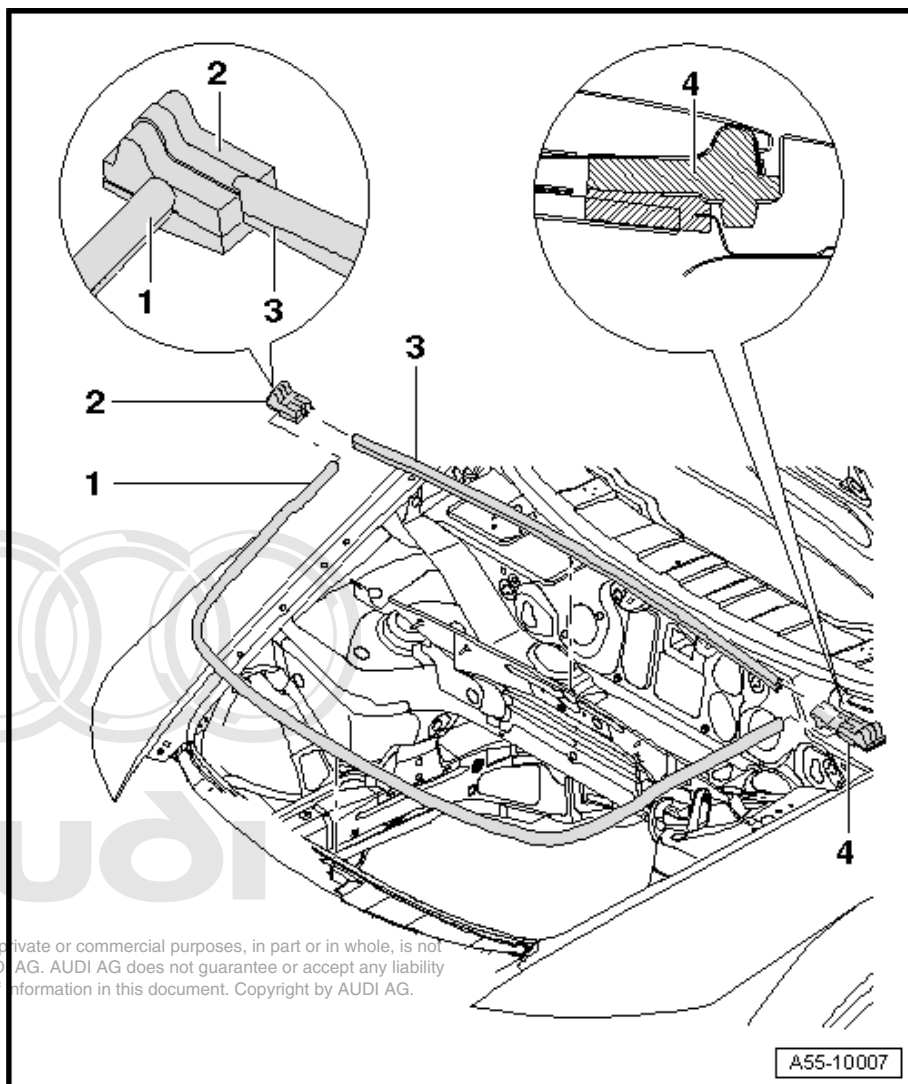
2 - Profiled seal (left-side)

- ☐ Self-adhesive bonding surface must be free of dust and grease.

3 - Seal for plenum chamber

- ☐ Position seals (left and right) at foam section.
- ☐ Ensure that there are no gaps.
- ☐ Excess length of seal must be compressed along length of plenum chamber front panel.

4 - Profiled seal (right-side)



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1.5 Removing and installing bonnet release cable

1 - Bonnet release cable

- ☐ Removing:
- ☐ Removing storage compartment (driver's side)
⇒ Rep. gr. 68
- ☐ Unclip cable from bonnet lock (bottom section) and disengage eyelet.
- ☐ Installing:
- ☐ Install in reverse order.
- ☐ Move ball on Bowden cable at bonnet lock (bottom section) into installation position.

2 - Operating lever

3 - Grommet

- ☐ When installing, ensure correct seating of grommet.

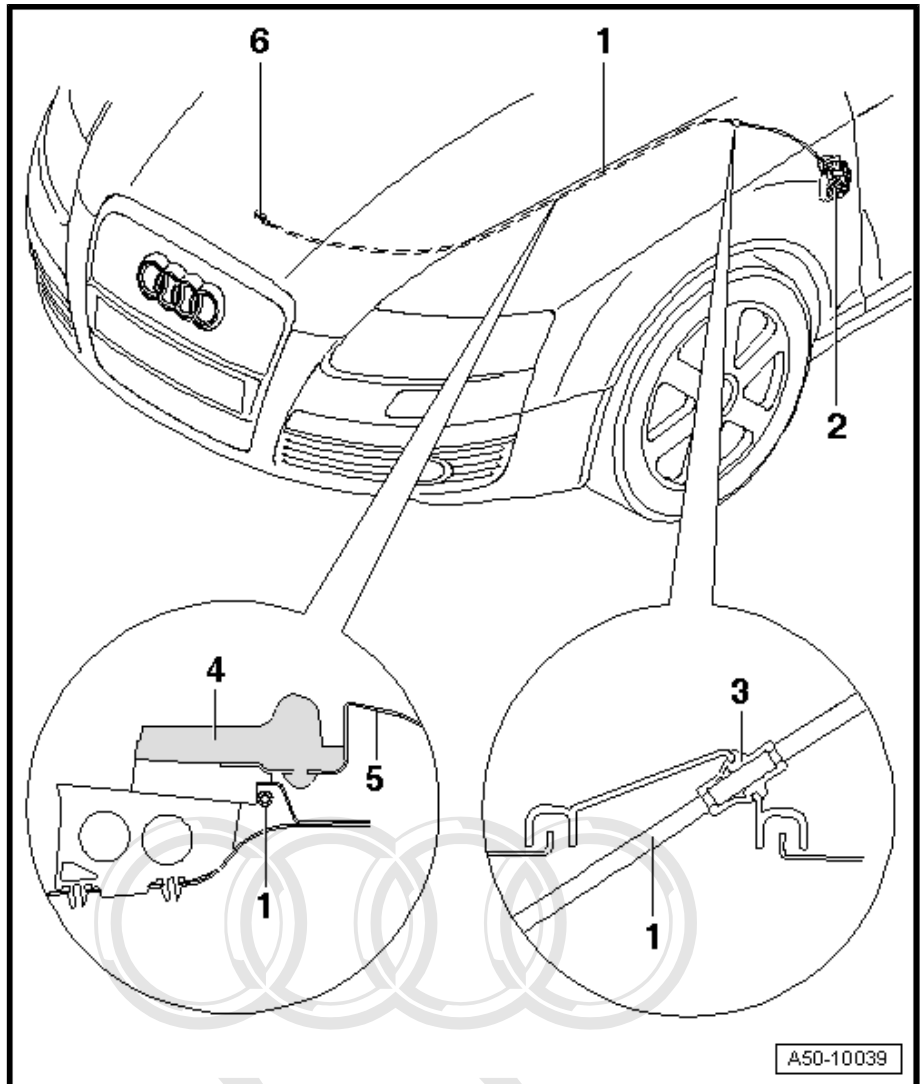
4 - Seal

- ☐ Pressed into hole in wing mounting flange

5 - Wing

6 - Bonnet lock (bottom section)

- ☐ Removing and installing ⇒ [page 15](#)
- ☐ Can be adjusted to set height of bonnet



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2 Rear lid - saloon

2.1 Removing and installing rear lid

1 - Rear lid

- ☐ Removing:
- ☐ Remove warning triangle with bracket.
- ☐ Remove rear lid lining.
- ☐ Unplug electrical connectors and pull them out of rear lid.
- ☐ Unscrew nuts for connecting both hinges to rear lid ⇒ [page 28](#).
- ☐ A second person is required to support and lift off the rear lid.
- ☐ Installing:
- ☐ Install in reverse order.
- ☐ Reversing camera must be re-calibrated (if fitted).

2 - Rear lid hinge

- ☐ Note different versions
- ☐ Standard hinge ⇒ [page 26](#)
- ☐ Convenience hinge ⇒ [page 28](#)

3 - Stop buffer

4 - Bolt with washer

- ☐ 21 Nm

5 - Hexagon nut

- ☐ 21 Nm

6 - Bowden cable for rear lid release

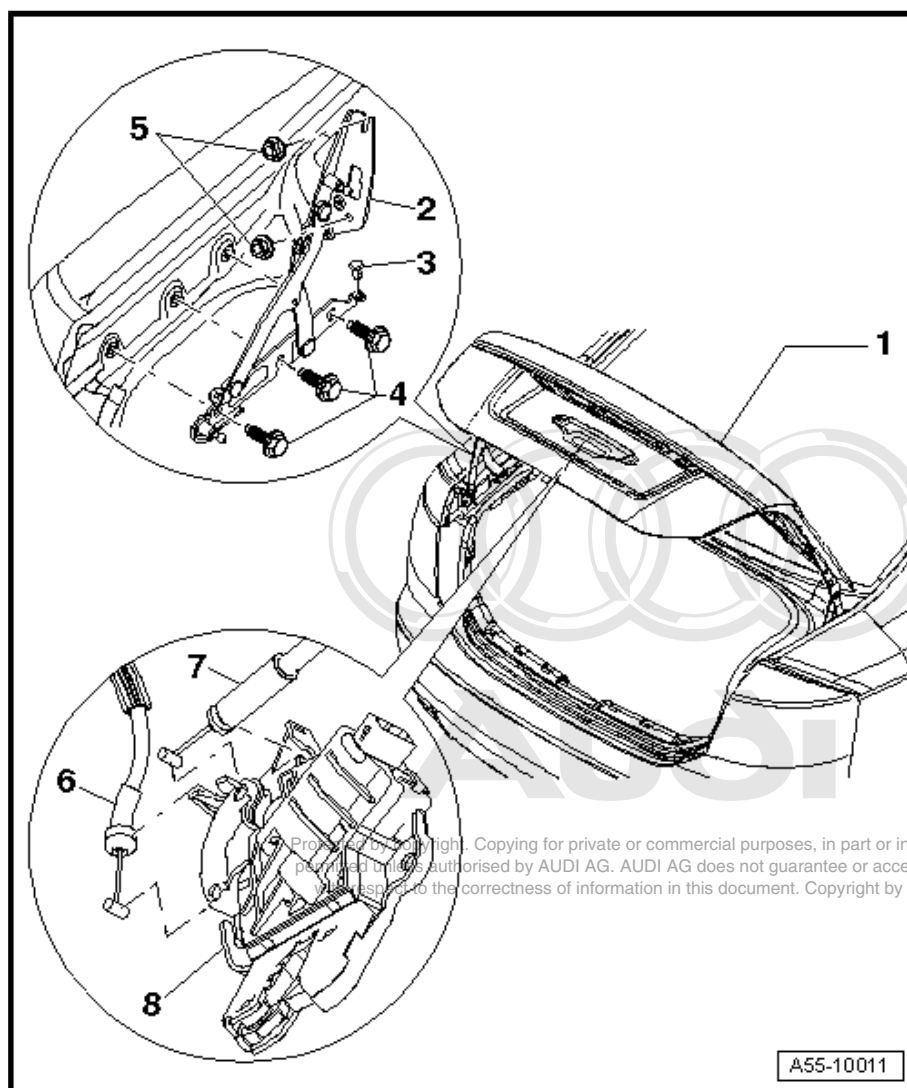
- ☐ Attached to rear lid lock and lock cylinder.

7 - Bowden cable for manual release

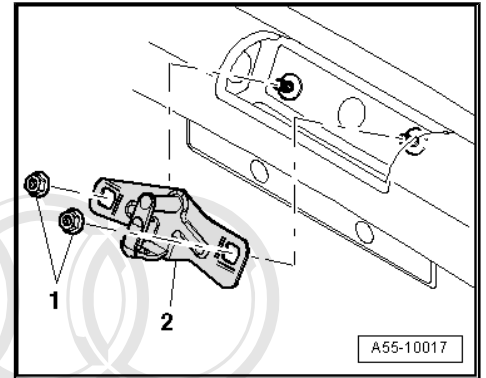
- ☐ Country-specific version - not fitted to all vehicles

Removing and installing striker

- Remove rear cross panel trim. ⇒ Rep. gr. 70



- Unscrew nuts -1-.
- Install in reverse order of removal.
- Tighten nuts -1- to 8 Nm.



Adjusting rear lid

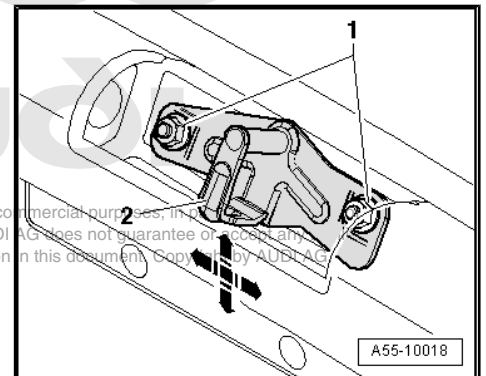
- Remove rear cross panel trim. ⇒ Rep. gr. 70



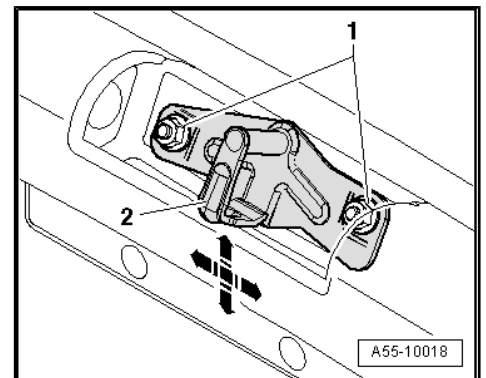
Note

Gas struts must be fitted before adjusting new rear lid.

- Unfasten nuts -1-; it should be possible to move striker -2-.



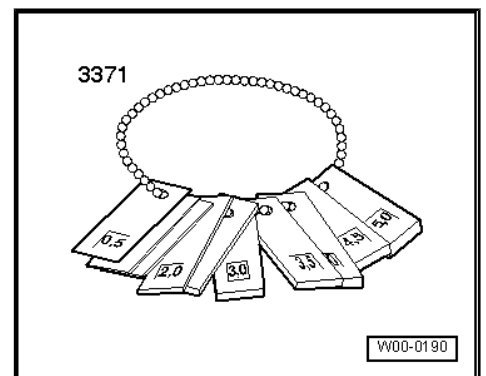
- Carefully close rear lid until it is flush with side panel.
- Carefully open rear lid and tighten nuts -1- to 8 Nm.



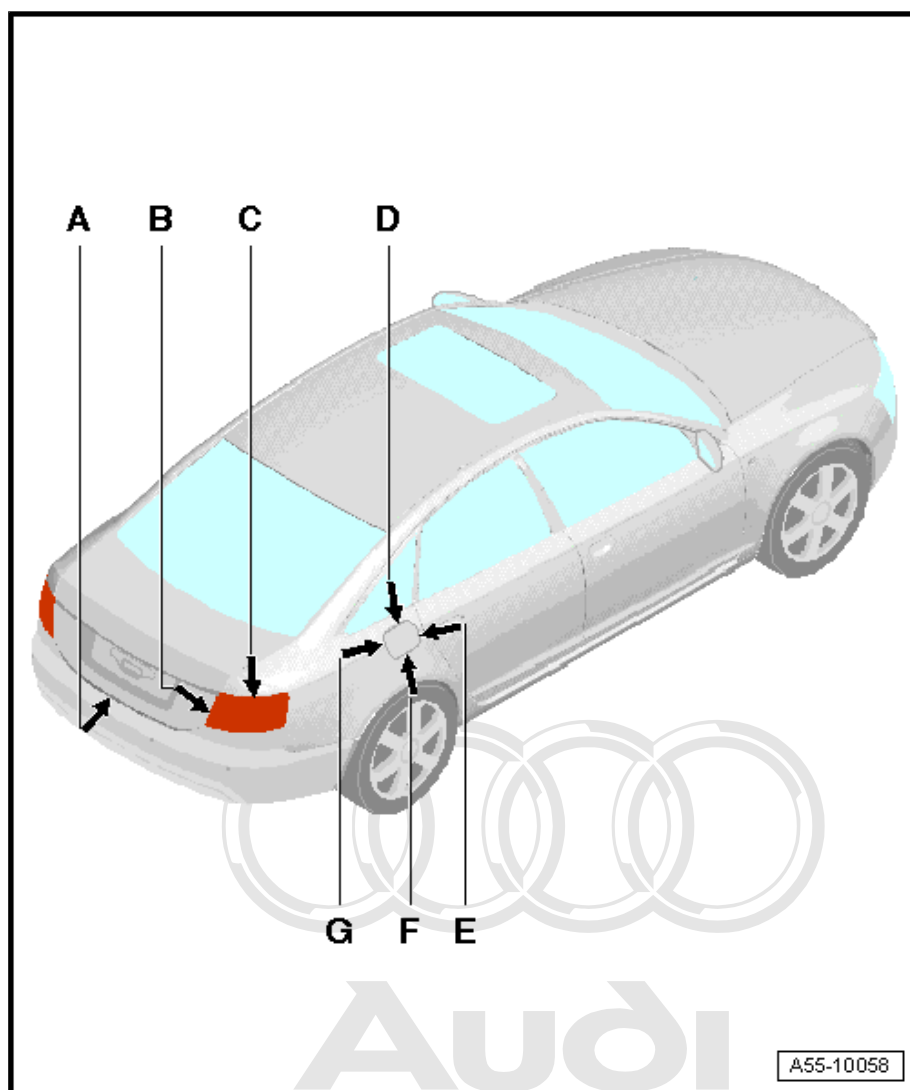
2.2 Adjusting rear lid

Special tools and workshop equipment required

- ◆ Setting gauge - 3371-



Panel gaps



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2.3 Rear lid lock and handle trim

Overview

1 - Rear lid lock

- ☐ To remove, disengage Bowden cable.
- ☐ Unscrew hexagon nuts -2- and remove rear lid lock.

2 - Nut

- ☐ 8 Nm

3 - Bowden cable

4 - Lock cylinder

- ☐ Removing:
- ☐ Unplug electrical connectors.
- ☐ Disengage Bowden cable -3- from lock cylinder.
- ☐ Unscrew bolt with washer -5-.
- ☐ Turn lock cylinder through 90°.
- ☐ Take lock cylinder out of handle mechanism.

5 - Bolt with washer

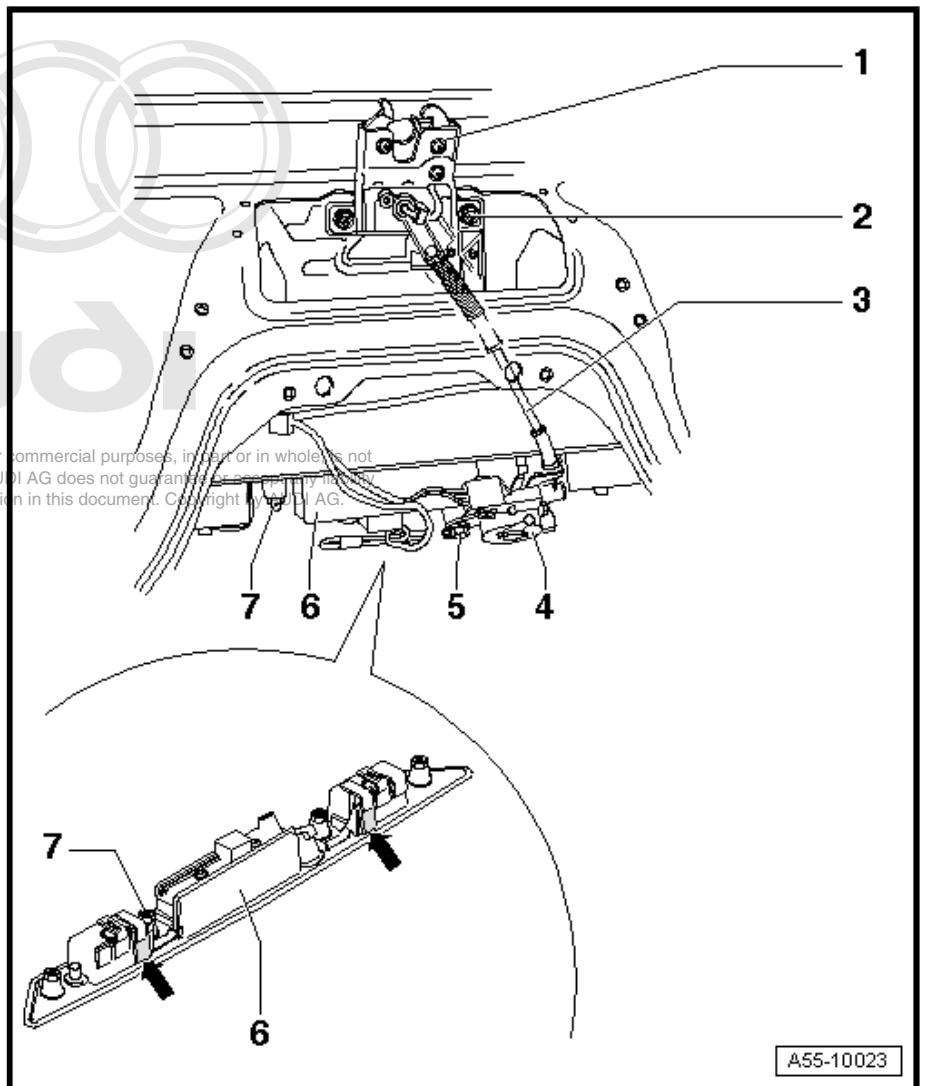
- ☐ 8 Nm

6 - Handle trim

- ☐ Removing:
- ☐ Rear lid trim removed
- ☐ Lock cylinder removed
- ☐ Remove hexagon flange nut -7-.
- ☐ Press in retaining hooks -arrows-.
- ☐ Remove handle trim.

7 - Hexagon flange nut

- ☐ 8 Nm



A55-10023

2.4 Removing and installing rear lid lock

1 - Cover for rear lid lock

2 - Nut with washer

- 8 Nm

3 - Bowden cable to lock cylinder

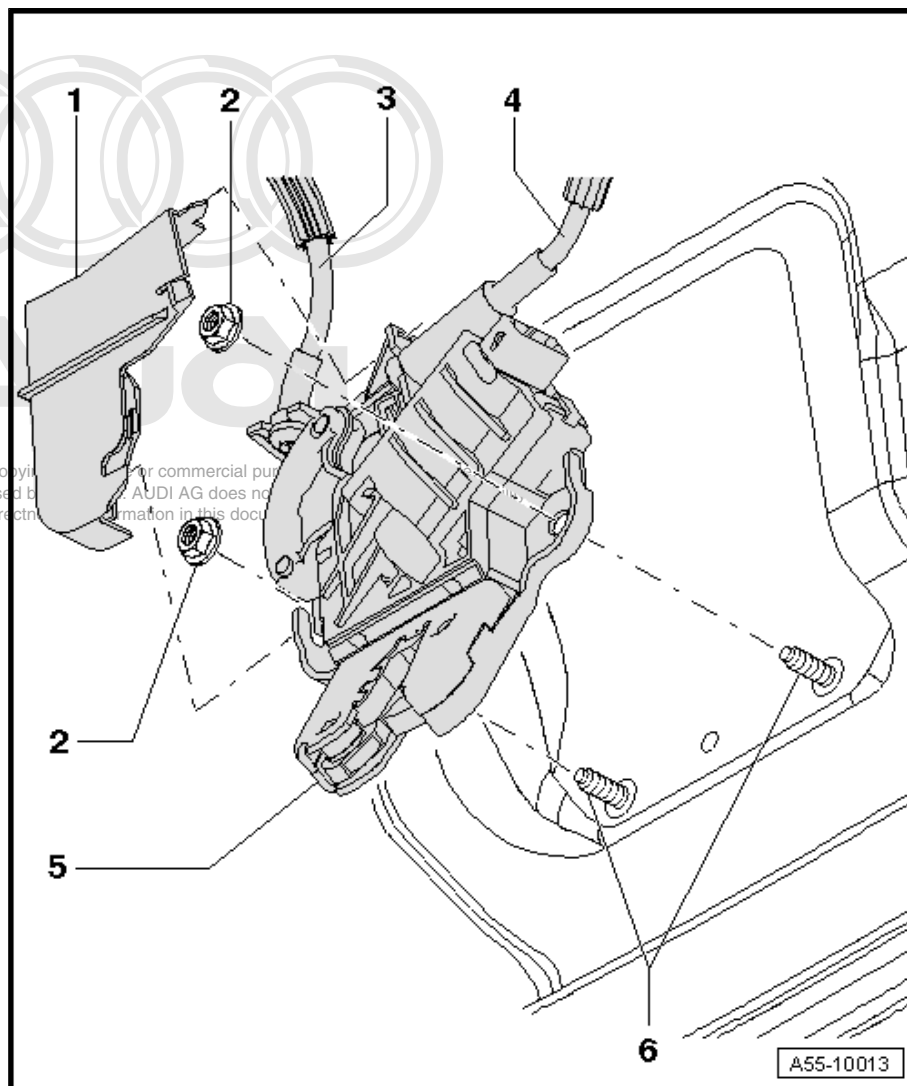
- Disengaged at rear lid lock

4 - Bowden cable for manual release

- Country-specific version - not fitted to all vehicles.

5 - Rear lid lock

- Unclip cover 1- from rear lid lock.
- Unscrew nuts with washers -2-.



2.5 Removing and installing handle trim

- Rear lid trim removed
- Rear lid trim and lock cylinder removed

- Remove nuts with washers -2- and detach Bowden cable.

1 - Cover plate

2 - Nuts with washers

□ 5 Nm

3 - Rear lid

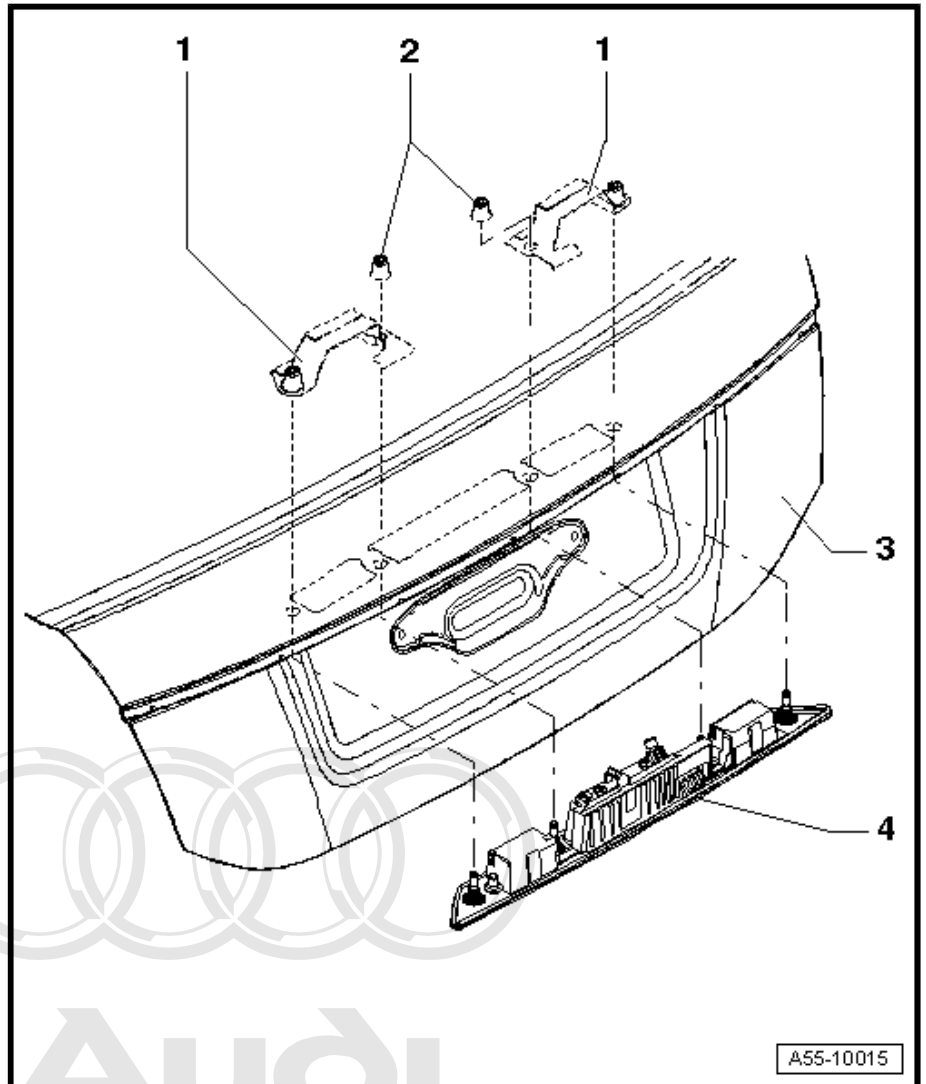
4 - Handle trim

Removing:

- Unscrew nuts with washers -2- and remove cover plate -1-.
- Press in retaining hooks on handle trim and pull handle trim out of rear lid.

Installing:

- Push handle trim into rear lid until catches engage.
- Fit cover plates and tighten outer nuts with washers first.
- Then tighten both inner nuts with washers.



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2.6 Removing and installing rear lid lock cylinder

1 - Rear lid

2 - Cover

3 - Bolt with washer

□ 5 Nm

4 - Lock cylinder

Removing:

- Remove rear lid trim prior to removal.
- Unscrew bolt -3-.
- Remove pin from fastener -7- and detach fastener from rear lid.
- Release cover from catch and remove.
- Release Bowden cable from catch on lock cylinder.

Installing:

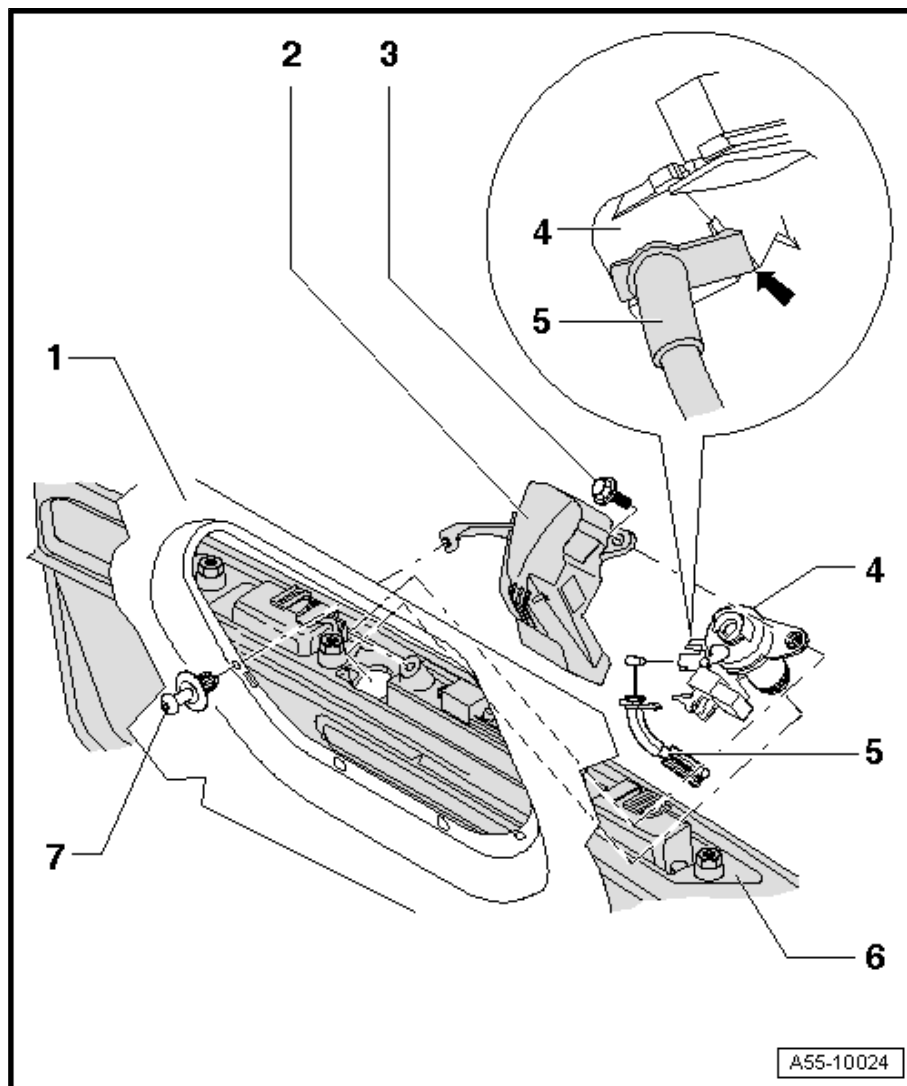
- Insert lock cylinder into handle trim and turn to stop using key.
- Attach Bowden cable to lock cylinder and engage it in housing.
- Attach cover and allow to engage.
- Screw in bolt and clip cover to rear lid.
-

5 - Bowden cable to rear lid lock

- To remove, release catch -arrow-, turn Bowden cable through 90° and pull out of lock cylinder housing -4-.

6 - Handle trim

7 - Fastener



2.7 Removing and installing rear lid hinge

Standard version

- Removing and installing gas strut ⇒ [page 28](#)

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1 - Grommet

- ☐ Coat grommet with soap solution or similar to make installation easier.

2 - Gas strut

- Gas strut cylinder must be engaged on rear lid.

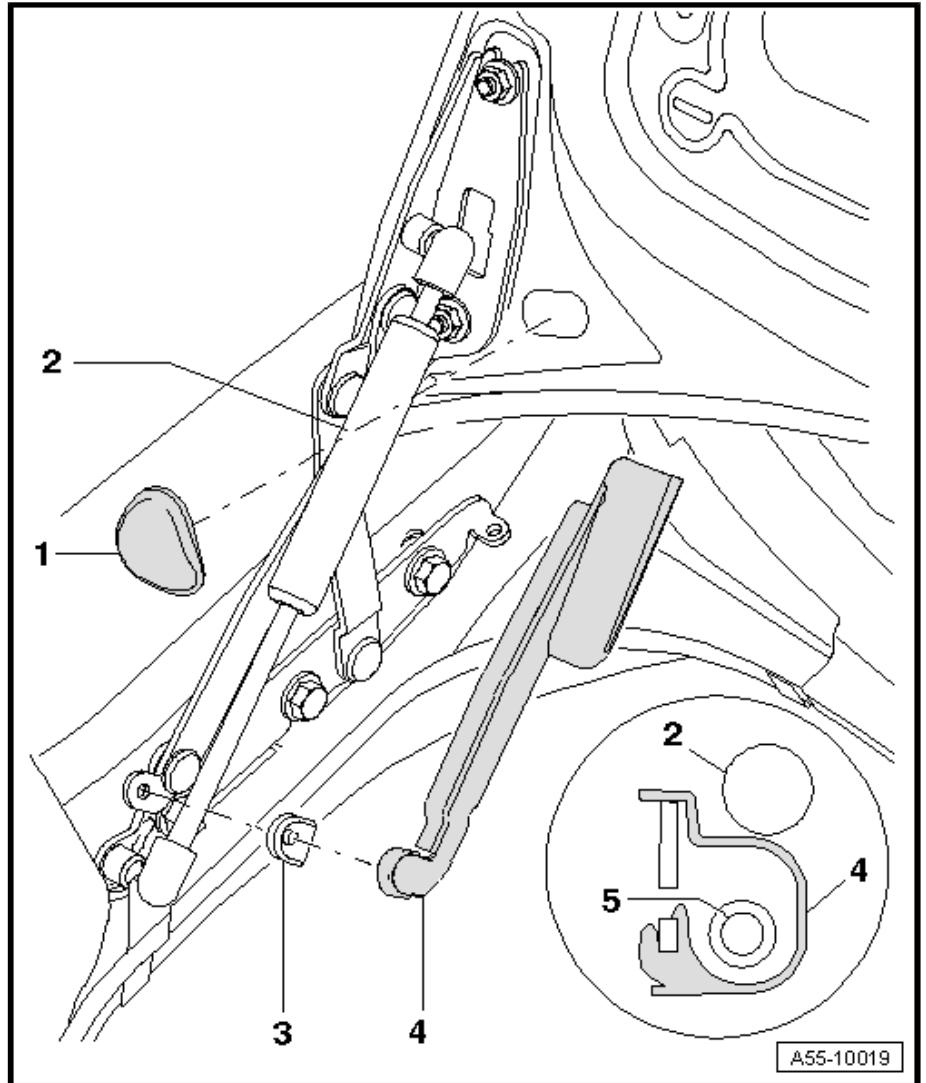
3 - Stop

4 - Cover

- Insert cover in hinge arm.
- Then press top of cover onto hinge arm. Make sure you hear it engage.
- Press stop into hinge eye.

5 - Spring

- ☐ For convenience hinge only



Removing and installing rear lid hinges



Note

When adjusting rear lid, scales provided on hinges facilitate correct setting.

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- Loosen nut -1-. Tightening torque: 21 Nm.
- Remove nut -2-. Tightening torque: 21 Nm
- Lift rear lid off hinge.
- Remove bolts -3- and -4-. Tightening torque: 21 Nm
- Only loosen centre bolt -5-. Tightening torque: 21 Nm
- Detach hinge -6-.
- Install in reverse order of removal.

Removing and installing gas strut



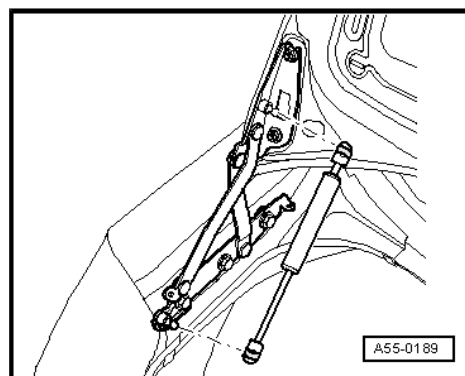
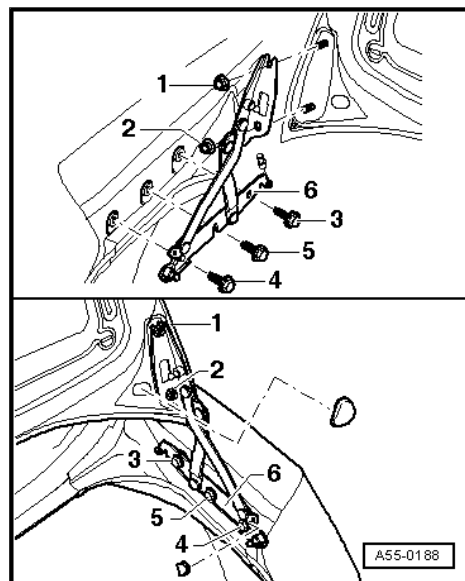
Note

When removing or installing gas strut, push back the opened rear lid slightly without damaging components.

- Raise retaining spring at each end in turn using screwdriver and detach gas strut.

Installing:

- Clip in gas strut at bottom first and then at top.
- The cylinder end of the gas strut must be installed on the rear lid side.



Convenience hinge



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1 - Gas strut

- Gas strut cylinder must be engaged on rear lid.
- Insert cover onto hinge arm.
- Then press top of cover onto hinge arm. Make sure you hear it engage.
- Press stop into hinge eye.

2 - Cover

- Push cover between gas strut and long hinge arm from below.

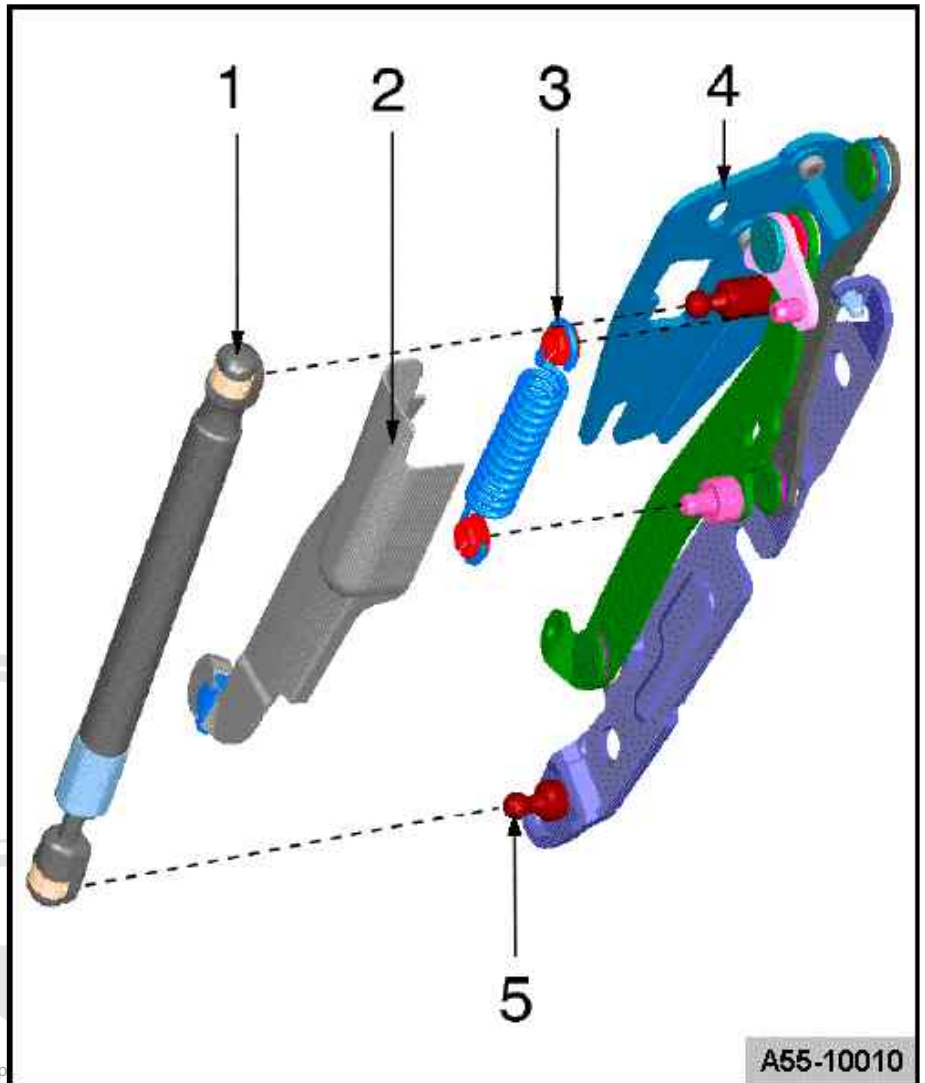
3 - Spring

- Remove gas strut and cover prior to removal.
- To remove, press spring off ball studs.
- When installing, plastic shells of spring must engage properly onto ball studs.

4 - Convenience hinge

5 - Ball stud

- ☐ Supplied with parts kit; not available separately



A55-10010

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Releasing gas from gas strut

- Clamp gas strut in vice in area x = 50 mm.

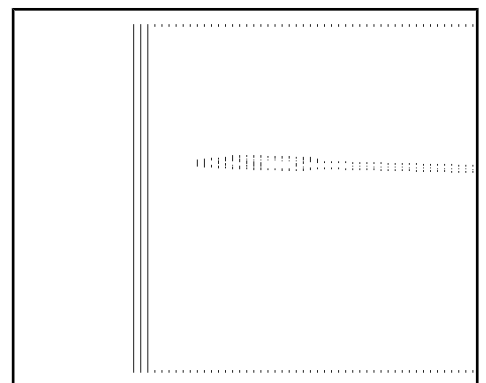


WARNING

Only the section indicated may be clamped in the vice (accident risk!).

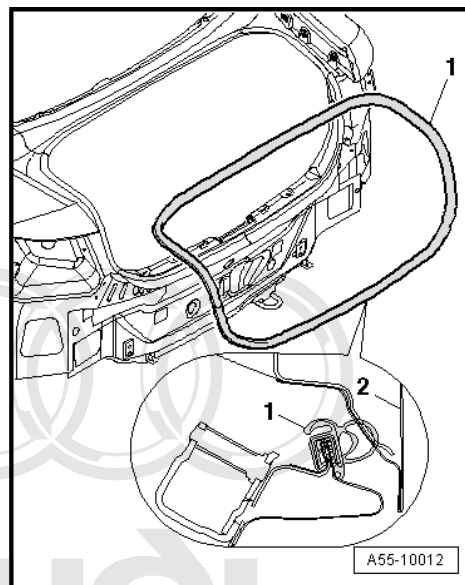
Protective goggles must be worn during sawing process.

- Saw open the first third of the cylinder part of the gas strut (measured from the piston rod end of the cylinder).



2.8 Installing rear lid seal

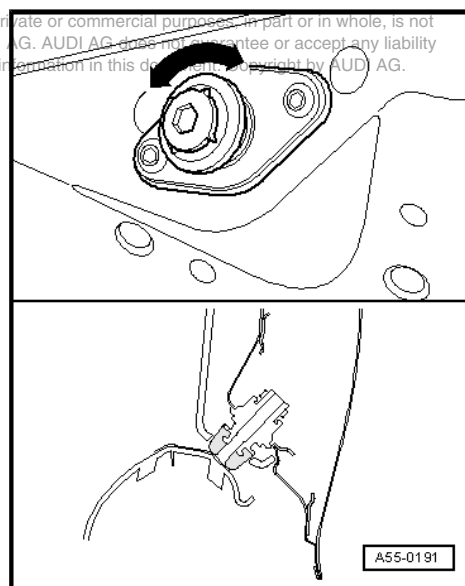
- Butt joint -position A- of seal for rear lid -2- must be aligned with ball socket of hinge (left-side).
- Press seal -1- all around onto flange, as shown.



2.9 Adjusting stop buffers

- Open rear lid.
- Detach rubber cap.
- Screw in stop buffer as far as possible.
- Gradually screw bump stop out again.
- Press on rubber cap.
- When correctly adjusted, stop buffers must rest lightly on sill when rear lid is closed.

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3 Rear lid - Avant

3.1 Removing and installing rear lid

1 - Gas strut

- ☐ Damping element must be engaged at rear lid end.

2 - Rear lid

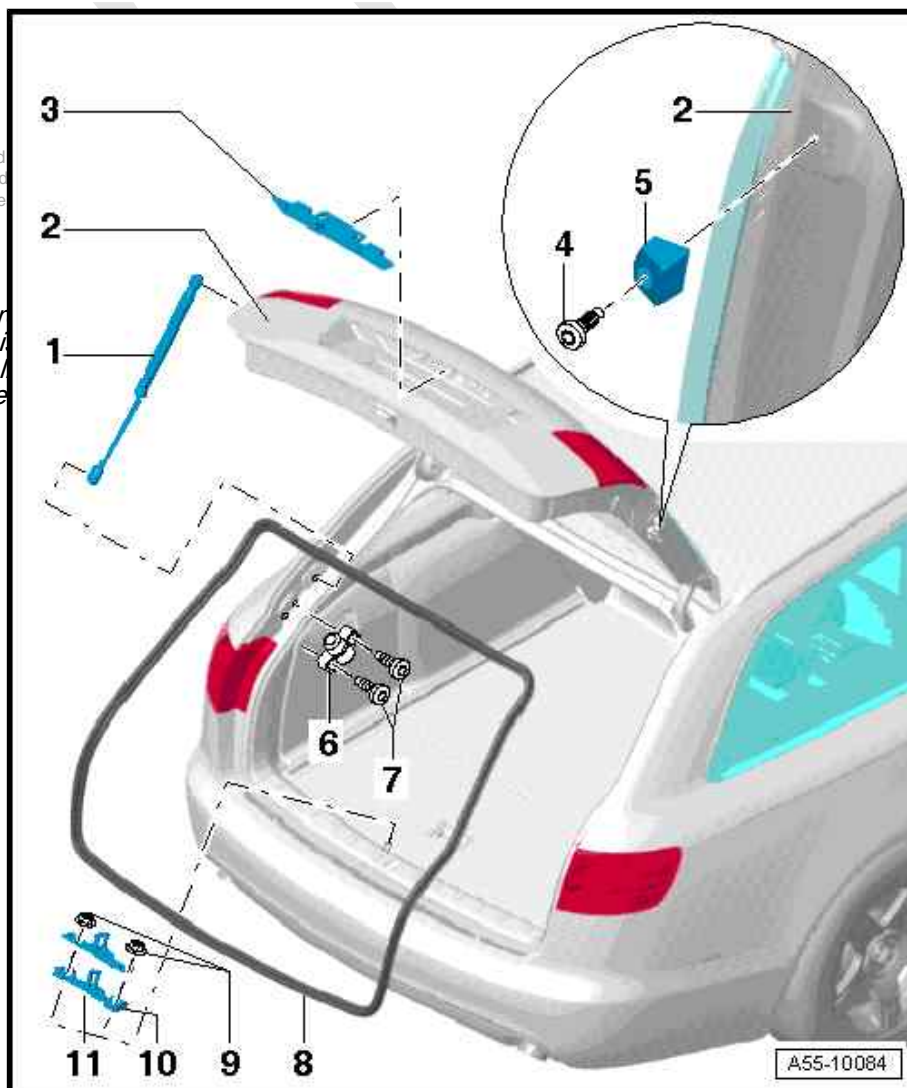
- ☐ Removing:



Note

When re-installing the rear lid after renewing seal, it is necessary re-adjust the rear lid adjuster element between lid and the hinge.

- ☐ Remove rear lid trim. ⇒ Rep. gr. 70
- ☐ Unplug electrical connectors and disconnect/detach hose for rear window washer system.
- ☐ Detach gas struts from rear lid.
- ☐ A second person is required to support and lift off the rear lid.
- ☐ Remove bolts from hinge on rear lid (left and right); do NOT loosen bolt for adjuster element ⇒ [page 37](#)
- ☐ Detach rear lid.
- ☐ Installing:
- ☐ Install in reverse order.
- ☐ Reversing camera must be re-calibrated (if fitted).



3 - Handle trim for rear lid

- ☐ Removing ⇒ [page 46](#)

4 - Bolt with washer

- ☐ 8 Nm

5 - Stop

6 - Adjusting buffer

- ☐ Adjusting ⇒ [page 35](#)

7 - Bolts with washers

- ☐ 8 Nm

8 - Seal

- ☐ Removing and installing ⇒ [page 47](#)
- ☐ Rear lid must be removed before removal of component.

9 - Hexagon nut

- 20 Nm

10 - Striker

- Note different versions.

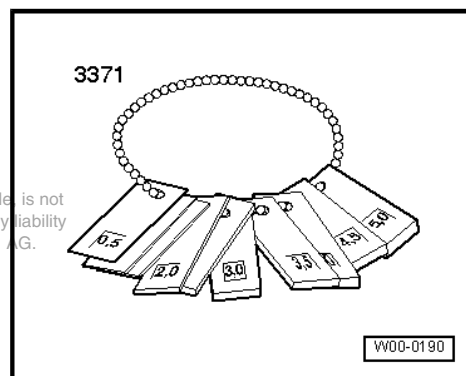
11 - Striker with power latching system

3.2 Adjusting rear lid

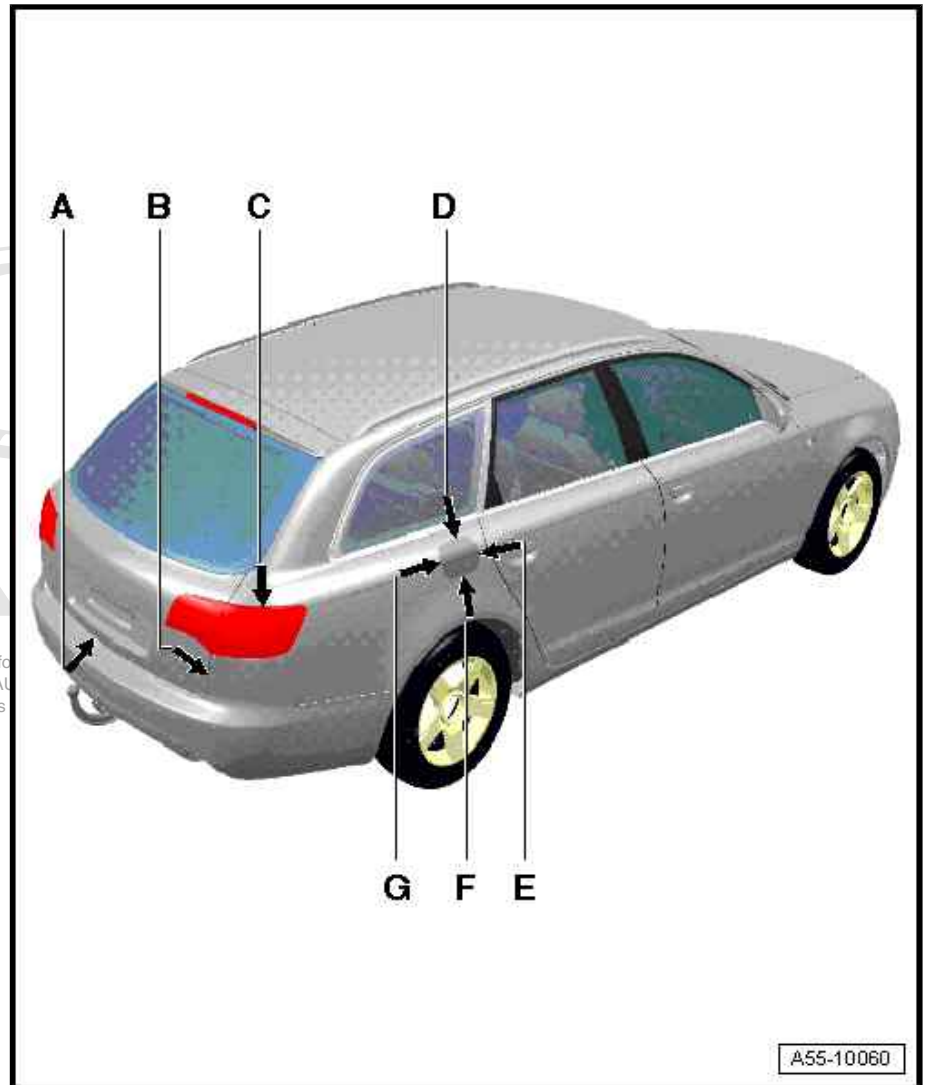
Special tools and workshop equipment required

- ◆ Setting gauge - 3371-

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**Panel gaps**

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- ◆ Dimension -A- = 4.5 mm
- ◆ Dimension -B- = 0.8 mm
- ◆ Dimension -C- = 0.8 mm
- ◆ Dimension -D- = 2 mm $\pm$ 0.5 mm
- ◆ Dimension -E- = 2 mm $\pm$ 0.5 mm
- ◆ Dimension -F- = 2 mm $\pm$ 0.5 mm
- ◆ Dimension -G- = 2.5 mm $\pm$ 0.5 mm
- ◆ Make sure gap runs parallel with body.

 Note

Gas struts must be fitted before adjusting new rear lid.

Adjustment via striker

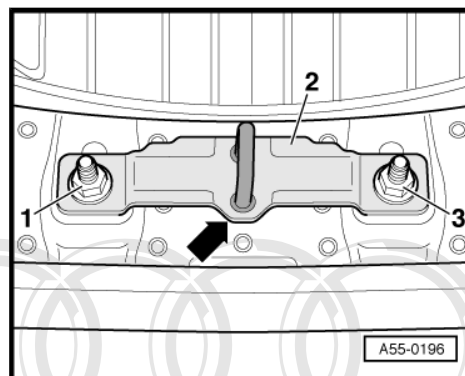


Note

Prior to adjustment, completely screw in adjusting buffers on rear lid ⇒ [page 36](#).

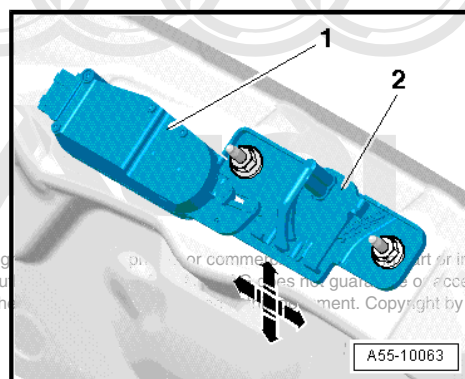
Vehicles with fixed striker

- Remove rear cross panel trim. ⇒ Rep. gr. 70
- Unfasten nuts with washers -1- and -3-; it must be possible to move striker -2-.



Rear lid release motor - V139-

- Unfasten nuts with washers; it must be possible to move striker -2- with power latching motor -1-.
- To facilitate adjustment, marks are provided in rear cross panel for aligning striker.



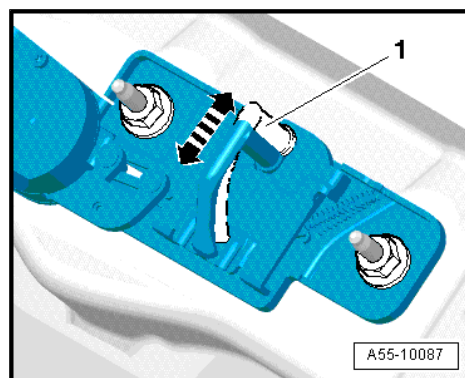
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Top and bottom end positions

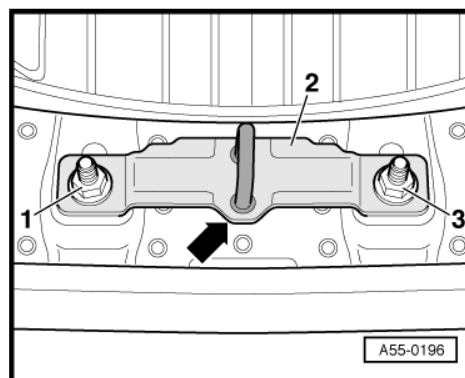


Caution

- ◆ When adjusting the rear lid, the power latching system motor must be in the »rear lid closed« position (bottom end position).
- ◆ The striker must not be fitted in the top end position -1- (marked in white), as otherwise the rear lid could be pulled down too far when it is closed and could become damaged.
- ◆ The motor for the power latching system must not be electrically connected when adjusting the rear lid.



- Before adjusting the rear lid, completely screw in the top parts of the adjusting buffers on the rear lid ⇒ [page 36](#).
- Hand-tighten nuts -1- and -3-.
- Close rear lid and align with body contour.
- Rear lid lock must be engaged in main catch (2nd stop).
- Open rear lid in this position and tighten nuts -1- and -3- to 21 Nm.



Striker with power latching system

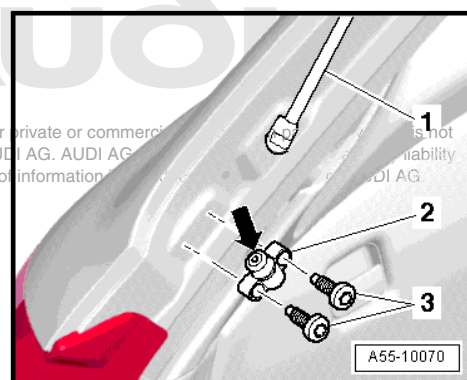
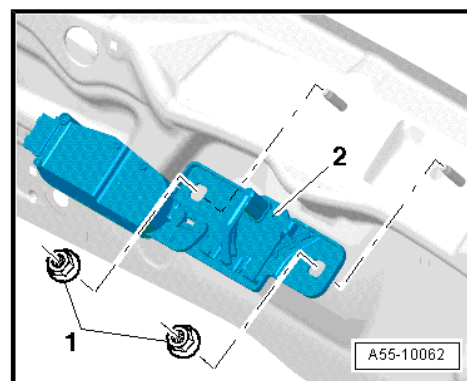
- Mark position prior to removal if the same striker is to be re-installed.



Note

- ◆ *The striker with power latching system must only be installed in the »rear lid closed« position, that is in the same position as a new part would be delivered in.*
- ◆ *If the same striker is re-installed, open the rear lid and block the rear lid lock or latch using a screwdriver or similar tool.*
- ◆ *The power latching system moves to the »rear lid closed« position = basic setting.*
- ◆ *Then unplug the connector from the power latching system. The rear lid lock can be opened again using the handle trim opening mechanism in the rear lid.*

- Only tighten the nuts -1- slightly.
- Close rear lid and align with body contour.
- Rear lid lock must be engaged in main catch (2nd stop).
- Open rear lid in this position and tighten nuts -1- to 21 Nm.
- When installing, tighten bolts -3- to 8 Nm.
- Unscrew adjusting buffer -arrow- until stop buffers of closed rear lid make contact with adjusting buffer.
- Check whether rear lid still closes easily. Repeat adjustment procedure if necessary.
- If rear lid does not close easily, screw in adjusting buffer slightly.



Installation position of adjusting buffer

1 - Rear lid

- ❑ If correctly adjusted, adjusting buffer -3- must be slightly compressed on coming into contact with stop buffer -2- with rear lid closed.

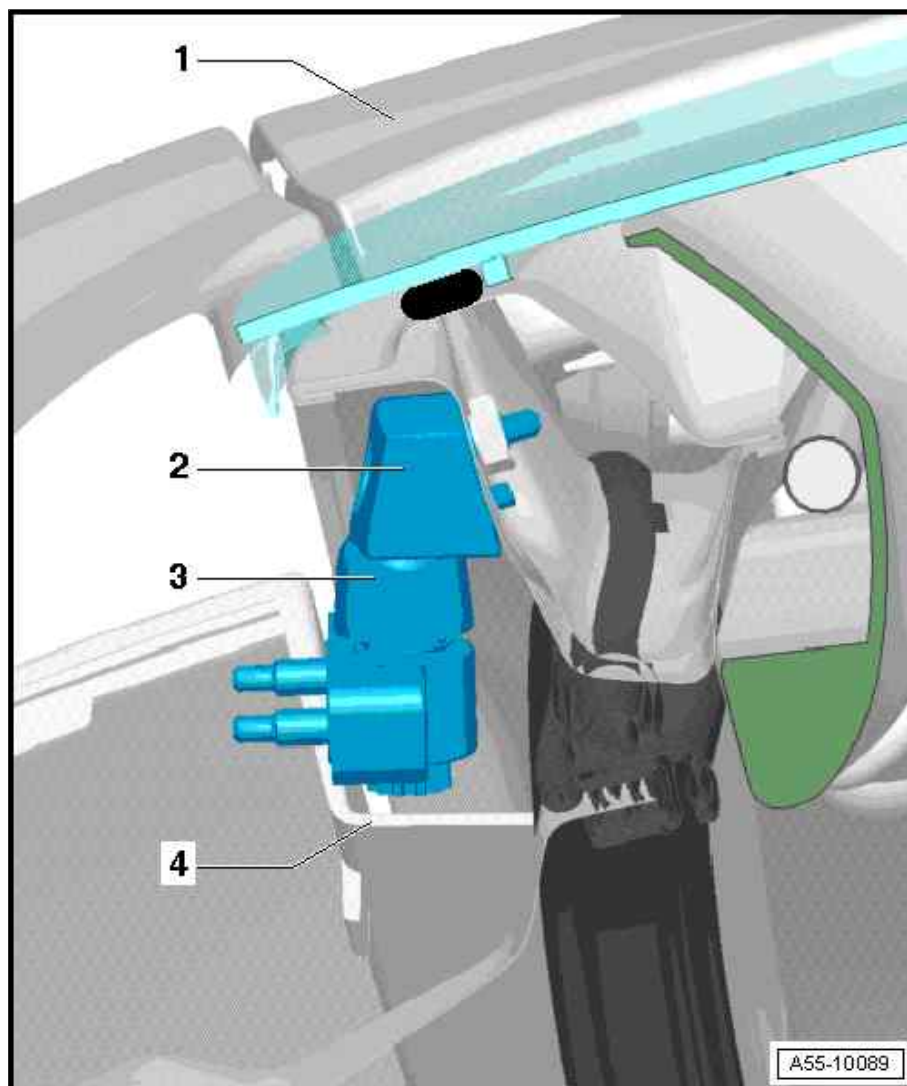
2 - Stop buffer on rear lid end

- ❑ Installing ⇒ [page 37](#)
- ❑ When installing, tighten corresponding bolts to 8 Nm.

3 - Adjusting buffer on body

- ❑ Adjusting buffer is secured with bolts on body.
- ❑ When installing, tighten corresponding bolts to 8 Nm.
- ❑ The height is adjusted via the adjuster screw.
- ❑ If correctly adjusted, adjusting buffer must be slightly compressed on coming into contact with stop buffer (on rear lid) with rear lid closed.

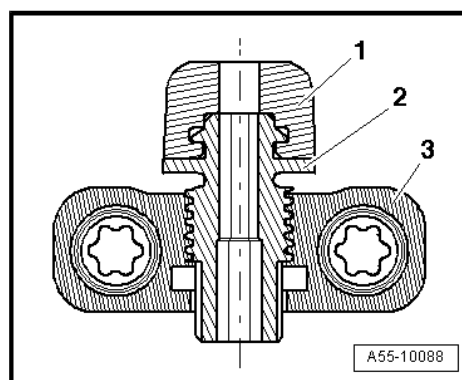
4 - Side panel



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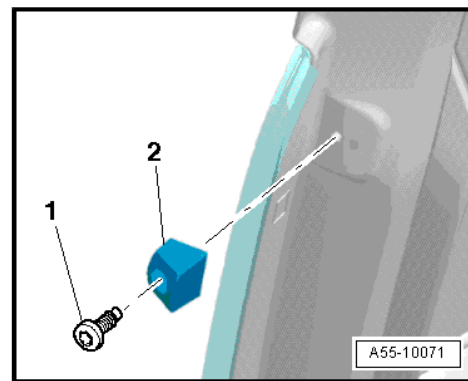
Adjuster screw for adjusting buffer

- Before adjusting rear lid, screw adjuster screw -2- with protective cap -1- completely into adjusting buffer -3-.
- Protective cap -1- pressed on
- Unscrew adjuster screw -2- until protective cap -1- is slightly compressed on coming into contact with stop buffer on rear lid with rear lid closed.
- Make sure that rear lid has no play and closes in line with body contour by pressing or pulling on side edges of rear lid beneath rear window.
- Repeat adjustment if necessary.



Stop on rear lid

- When fitting stop -2-, tighten bolt -1- to 8 Nm.
- Height adjustment is performed via adjusting buffers on body.



3.3 Removing and installing rear lid hinge



Note

- ◆ When renewing both hinges and the rear lid, first secure the hinges to the rear lid and then use the nuts to set the rear lid to align with the body contour of the vehicle.
- ◆ Observe tightening sequence for bolts.

1 - Bolt with washer



Note

- ◆ Observe tightening sequence for bolts with washers.
- ◆ Tighten bolts in following sequence: item -1-, -3- and finally -2- to 21 Nm.

- ☐ 21 Nm

2 - Bolt with washer

- ☐ Do not unscrew when removing rear lid
- ☐ Bolt secures adjuster element -5- to rear lid.
- ☐ 21 Nm

3 - Bolt with washer

- ☐ 21 Nm

4 - Rear lid hinge

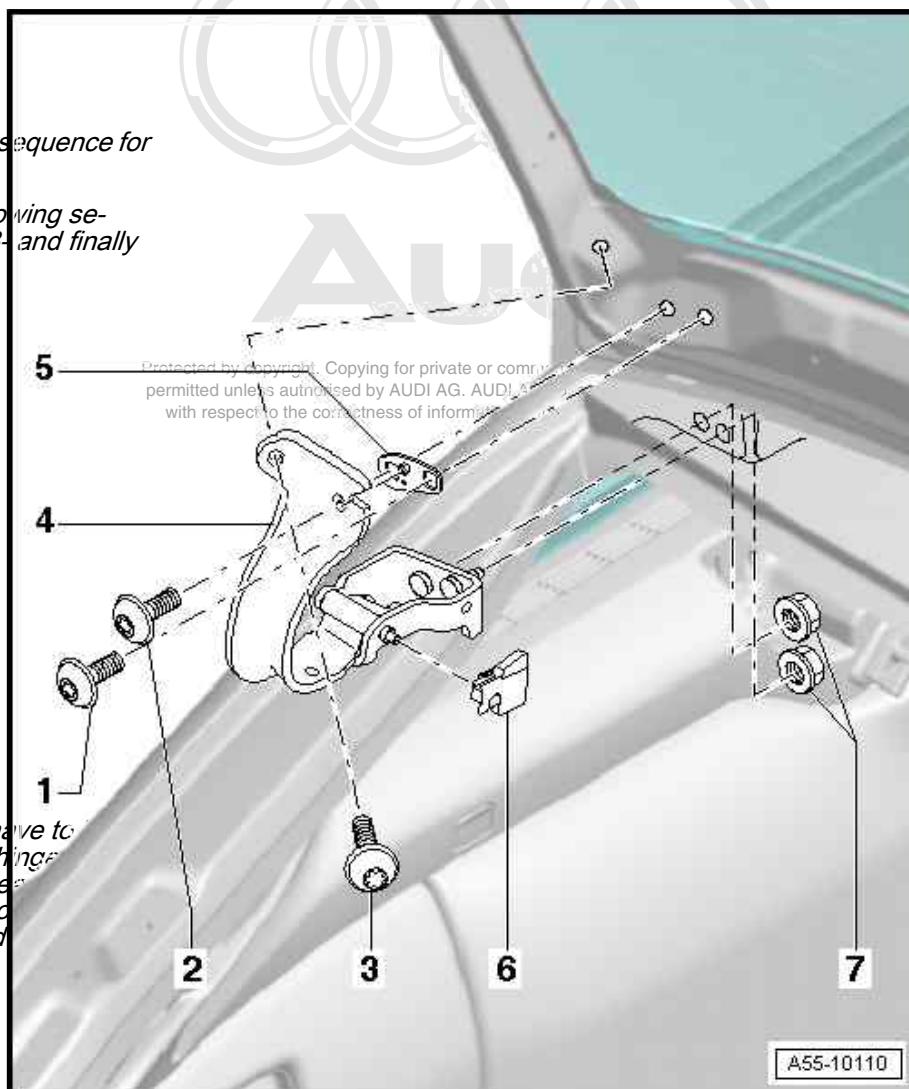
Removing:



Note

If both rear lid hinges have to be renewed, first fit the new hinges to the rear lid; then align the rear lid with the body contour (in the vehicle) and tighten bolts -1-, -2- and -3- to 21 Nm.

- Remove D-pillar trim and rear roof trim ⇒ Rep. gr. 70.



- Detach cover for rear lid hinge.

**Note**

To prevent any damage to the rear lid or body, prop up and secure rear lid.

- Unscrew bolts with washers -1-.
- Unscrew hexagon nuts -5- and detach hinge.

Installing:

- Insert hinge in body and first secure it to rear lid with bolts -1-.
- Tighten bolts -1- to 21 Nm.
- Secure hinge with nuts -5- and tighten to 21 Nm.
- Press on hinge cover.

5 - Adjuster element**Note**

- ◆ *When removing and installing a rear lid (e.g. to change a seal), do not remove the adjuster element from the rear lid.*
- ◆ *The rear lid does not have to be re-adjusted; the position is determined by the adjuster element.*

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6 - Spacer

- ☐ Must always be fitted
- ☐ If spacer is not fitted, rear lid hinge may become distorted and rear lid will no longer be in correct installation position.

7 - Hexagon nut

- ☐ 21 Nm

Installing spacer

1 - Spacer

- ❑ To install, slide spacer onto hinge arm
⇒ [page 39](#) until it engages.
- ❑ Before installing gas strut, slide wedge -3- in direction of -arrow- until it makes contact with roof -4- (with slight pre-tension).

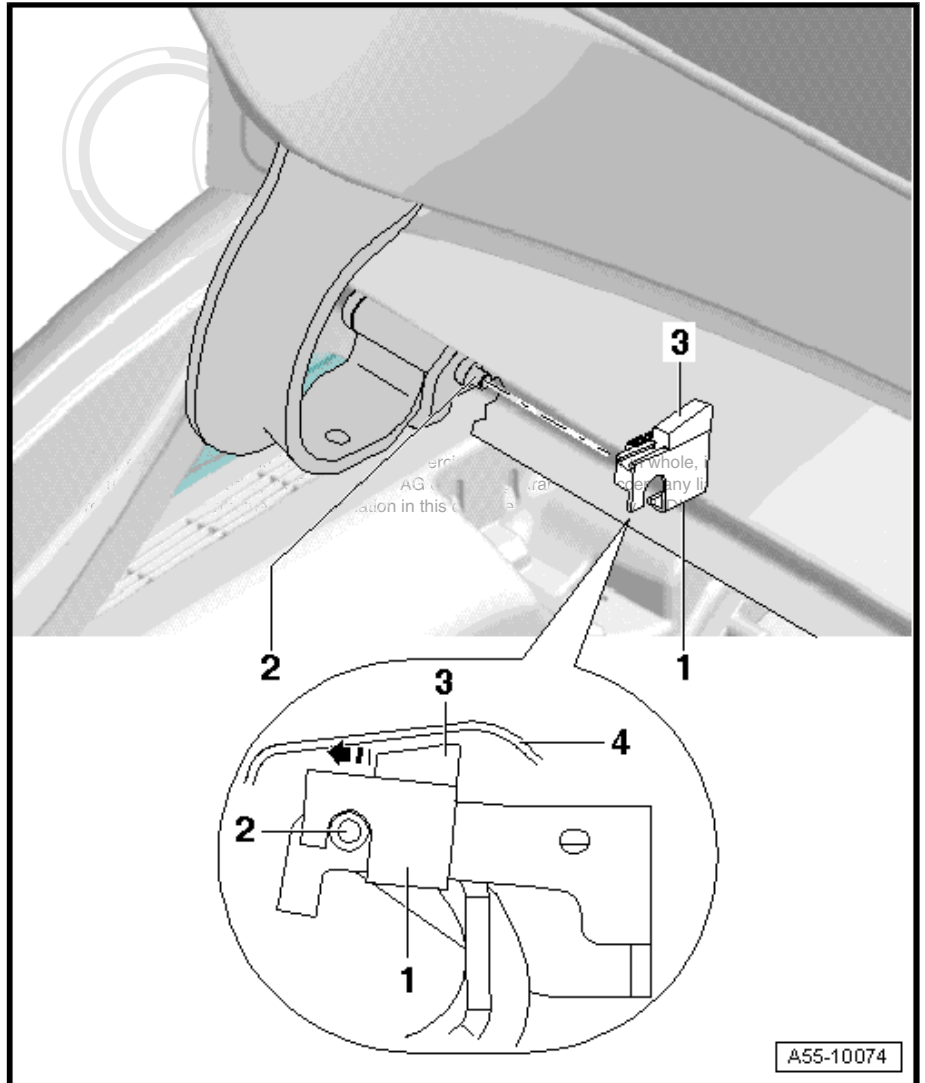
2 - Shaft of rear lid hinge

- ❑ Slide spacer sideways onto shaft.
- ❑ When installed correctly, spacer must engage properly.

3 - Spacer slide

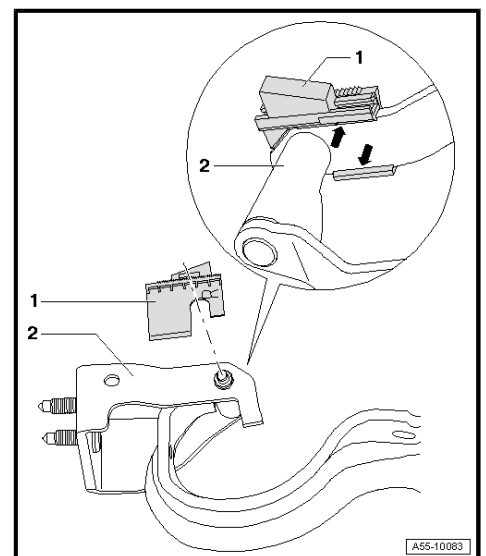
- ❑ Must make contact with roof (with pre-tension).

4 - Roof



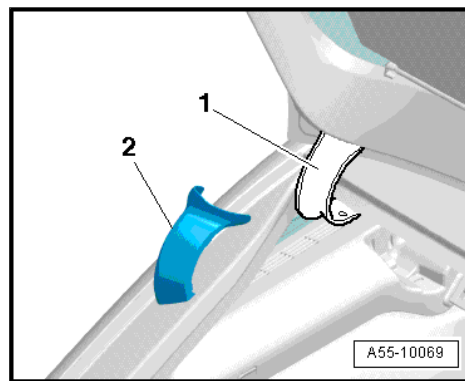
Installation position of spacer

- When installation is correct, the spacer -1- must wrap around the hinge arm -2- at the top and bottom -arrows-.



Cover for rear lid hinge

- Cover is pressed onto rear lid hinge.
- Release side fasteners of cover -2- and detach from rear lid hinge -1-.
- When installing, position the retaining tabs in engaging holes at hinge arm and then fully press on cover on opposite side.
- Cover must engage audibly.



3.4 Removing and installing rear lid drive unit

Exploded view

1 - Rear lid control unit - J605-



Caution

There are different versions of the drive unit; these can be recognised from the drive forks.

On some drive units, the self-tapping bolt -7- is screwed into both halves of the fork; on other drive units, the self-tapping bolt -7- is screwed into only one half of the fork.

Bolt -7- must be tightened to different torques accordingly.

- ☐ Roof end trim removed
⇒ Rep. gr. 70
- ☐ Unfasten D-pillar trim in area of drive unit and, if necessary, push carefully to the side.



Note

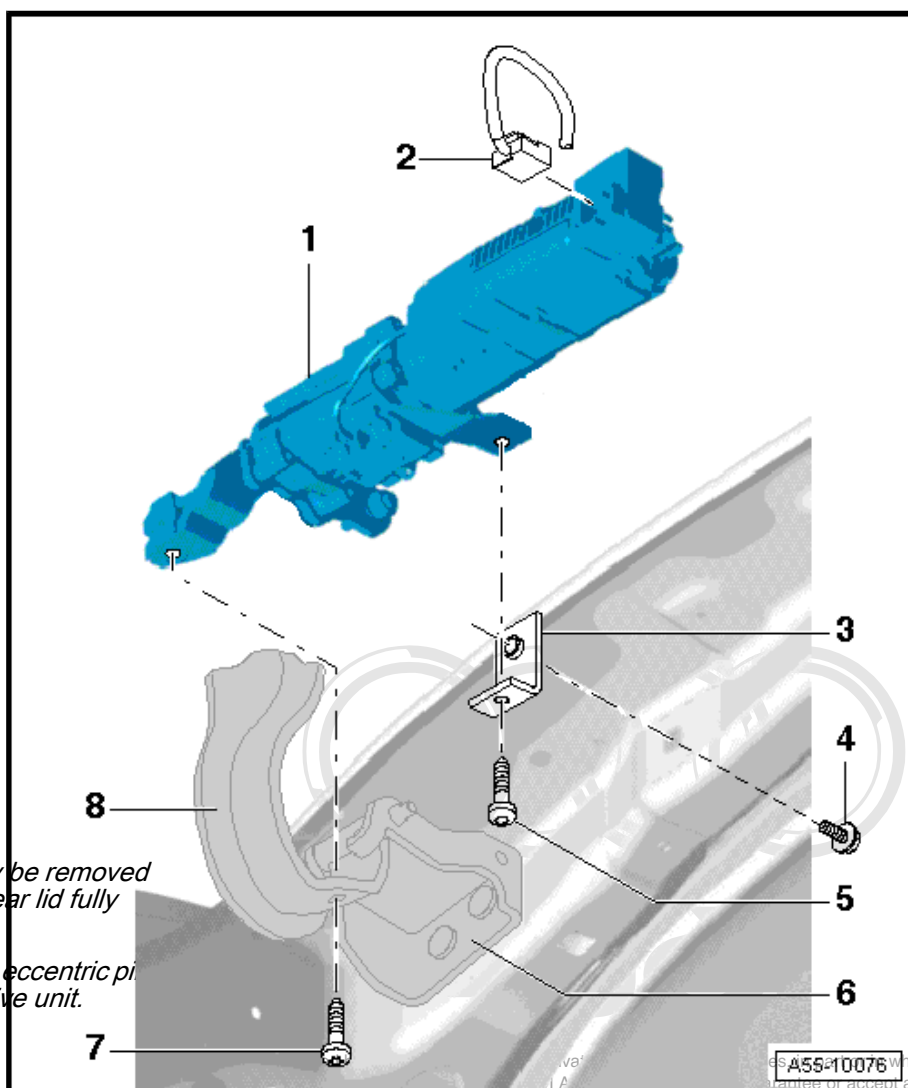
- ◆ Drive unit must only be removed and installed with rear lid fully open.
- ◆ Unfasten lock nut at eccentric pin before removing drive unit.

- ☐ Unplug electrical connector -2-.
- ☐ Unfasten lock nut at drive unit ⇒ [page 43](#).



Note

The eccentric pin must be seated loosely in the hole in the hinge arm.



- ☐ If necessary, slacken the tension on the eccentric pin by turning it slightly clockwise.
- ☐ Unscrew bolt -5- at bracket -3-.
- ☐ Unscrew bolt -7- at hinge arm and detach drive unit -1- by pulling it to the side.

2 - Electrical connector

- ☐ Unplug before removing drive unit.

3 - Bracket



Note

- ◆ *The bracket has been positioned at the factory using a special device and must not be moved out of this position.*
- ◆ *If the bracket has to be renewed, e.g. in the case of accident repairs, proceed as follows:*

- ☐ Rear lid together with the gas struts must be installed.
- ☐ First attach bracket -3- loosely to drive unit using bolt -5-.
- ☐ It must still be possible to move the bracket.
- ☐ Push the drive unit parallel with the rear lid hinge pin until it makes full contact with the drive unit bush.



Caution

Drive unit bush must make full contact with hinge pin collar.

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- ☐ Use bolt -4- to fasten bracket on body side and tighten bolt to 21 Nm.
- ☐ Tighten bolt -5- to 8 Nm.
- ☐ Secure eccentric pin with lock nut to drive unit (tightening torque: 6 Nm).



Note

- ◆ *When the lock nut is tightened, the eccentric pin in the hinge is tensioned so that it is free of play.*
- ◆ *You must therefore not use an open-ended spanner to counter-hold the hexagon flats of the eccentric pin while you are tightening the lock nut.*
- ◆ *When removing the drive unit, this tension can be slackened by turning the hexagon flats at the eccentric pin slightly clockwise after you have loosened the lock nut.*

- ☐ Tighten bolt -7- at the drive fork to 12 Nm.

4 - Bolt with washer

- ☐ 21 Nm

5 - Bolt with washer

- ☐ 8 Nm

6 - Hinge for rear lid

7 - Bolt

- ☐ Note different torques.

- ☐ Bolt is self-tapping.



Caution

The self-tapping bolt which is screwed into both halves of the fork on the drive unit must be tightened to 12 Nm.

The self-tapping bolt which is only screwed into one half of the fork on the drive unit must be tightened to 8 Nm.

8 - Hinge arm

Installing drive unit in hinge

1 - Rear lid control unit - J605-

- ☐ When installing, slide side of drive with bush -arrow B- and loose eccentric pin -arrow A- on to hinge.



Note

Drive unit bush must make full contact with hinge pin collar.

- ☐ This causes forked arm of drive unit to move into hinge arm -4-.
- ☐ Tighten bolt -2- to 8 Nm to secure drive unit to bracket.
- ☐ Tighten lock nut -6- to 6 Nm.
- ☐ Tighten bolt -3- to torque.

2 - Bolt with washer

- ☐ 8 Nm

3 - Bolt

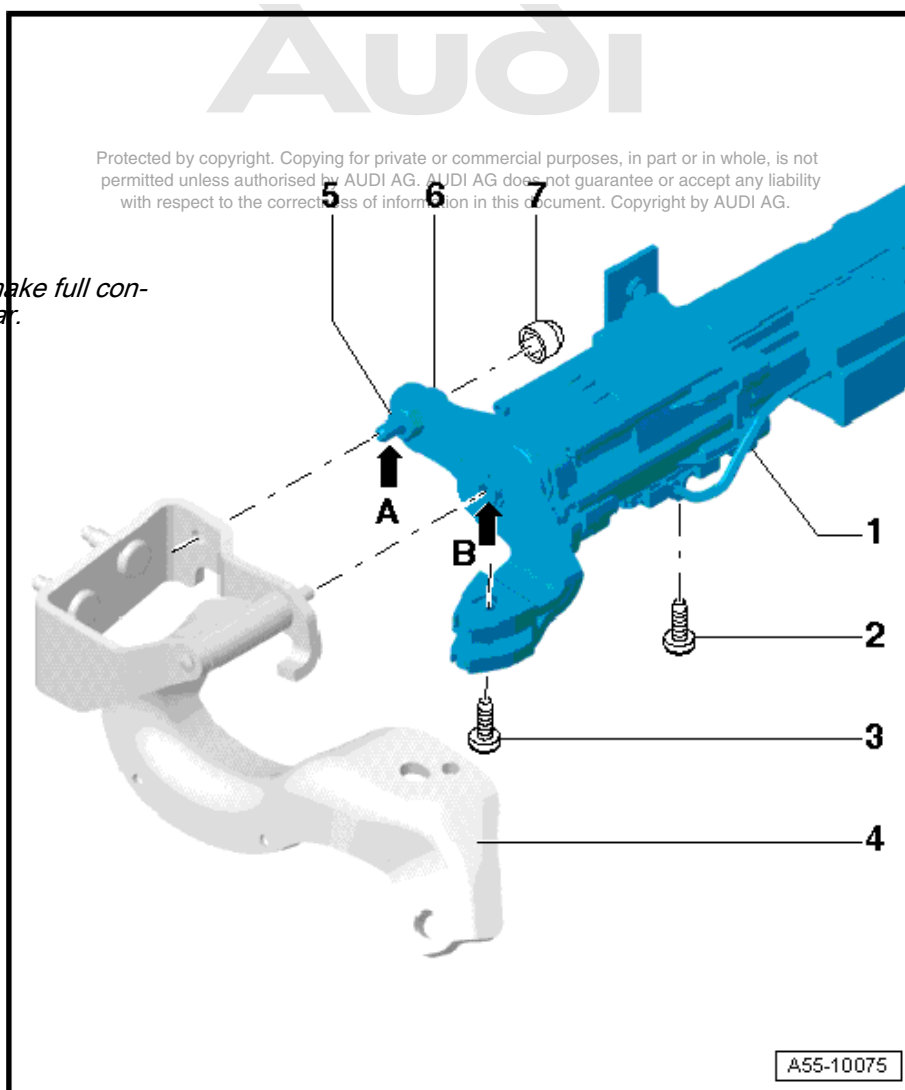
- ☐ Self-tapping



Caution

The self-tapping bolt which is screwed into both halves of the fork on the drive unit must be tightened to 12 Nm.

The self-tapping bolt which is only screwed into one half of the fork on the drive unit must be tightened to 8 Nm.



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4 - Hinge for rear lid

5 - Eccentric pin with hexagon flats



Note

- ◆ *When the lock nut is tightened, the eccentric pin in the hinge is tensioned so that it is free of play.*
- ◆ *You must therefore not use an open-ended spanner to counter-hold the hexagon flats of the eccentric pin while you are tightening the lock nut.*
- ◆ *When removing the drive unit, this tension can be slackened by turning the hexagon flats at the eccentric pin slightly clockwise after you have loosened the lock nut.*

6 - Lock nut

- ☐ Unfasten lock nut at eccentric pin before removing drive unit.
- ☐ If necessary, slacken tension on eccentric pin in the hinge arm by turning hexagon flats slightly clockwise.
- ☐ Self-locking
- ☐ 6 Nm

7 - Cap

- ☐ Attached to lock nut



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3.5 Removing and installing gas strut for rear lid

1 - Gas strut

- ❑ When removing, open and prop up rear lid.
- ❑ Use screwdriver to lift retaining spring -2- as shown and detach gas strut -1- from ball-head pin -3- (top).

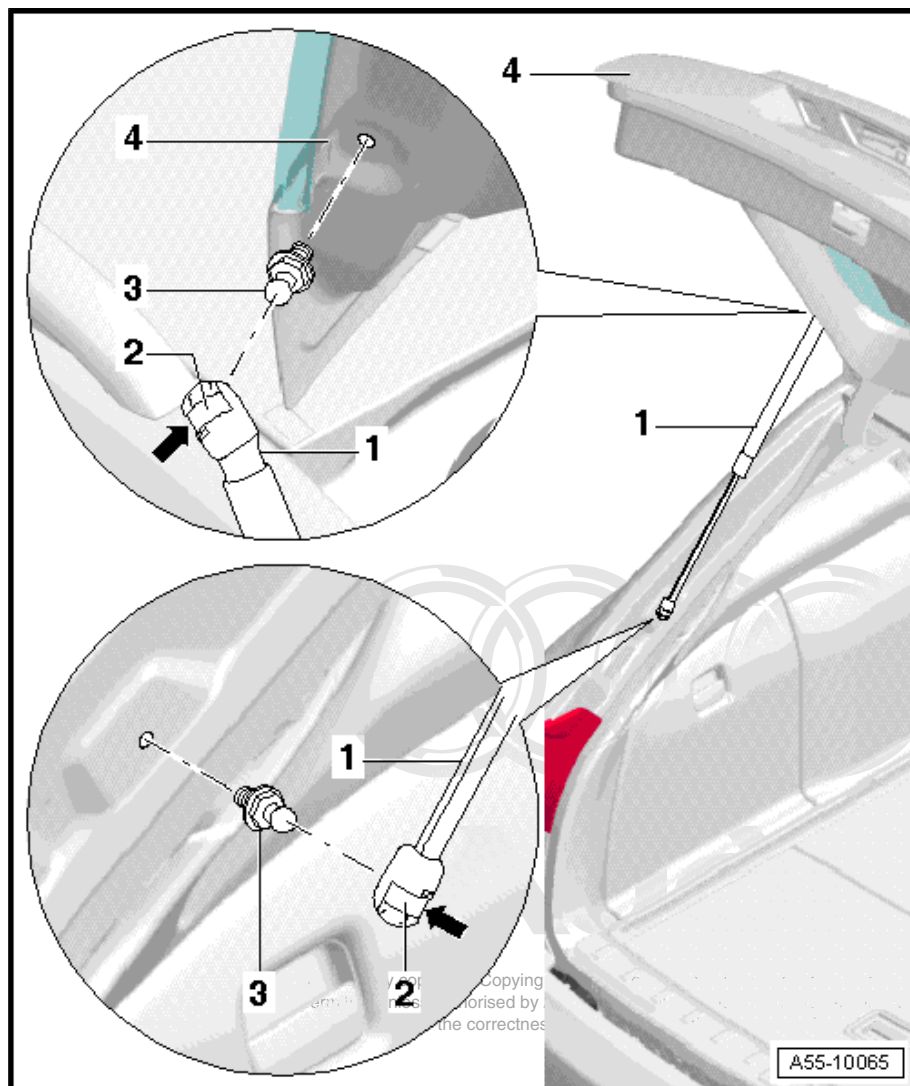
2 - Retaining spring

- ❑ Raise slightly with small screwdriver to remove gas strut ⇒ [page 45](#).

3 - Ball-head pin

- ❑ 20 Nm

4 - Rear lid



Note

- ◆ If gas strut has been completely removed make sure it is re-installed in the correct position.
- ◆ Damping element must be engaged at rear lid end.

Installing

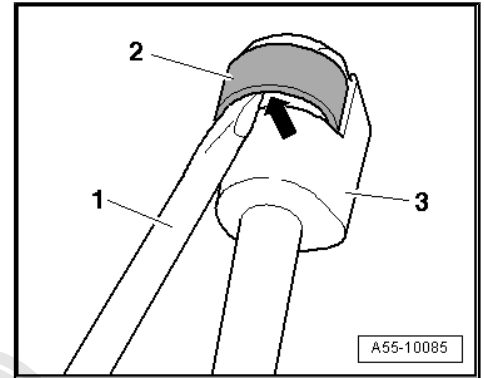
Installation is carried out in reverse order; note the following:

- When installing, gas strut is merely pressed onto ball-head pins.

- Tightening torque for ball-head pin: 20 Nm $\pm$ 2 Nm

Releasing retaining spring

- Lift retaining spring -2- with small screwdriver -1- to release gas strut -3-, which can then be detached from ball-head pin.



3.6 Removing and installing rear lid lock

1 - Rear lid

2 - Rear lid lock

3 - Cover for rear lid lock

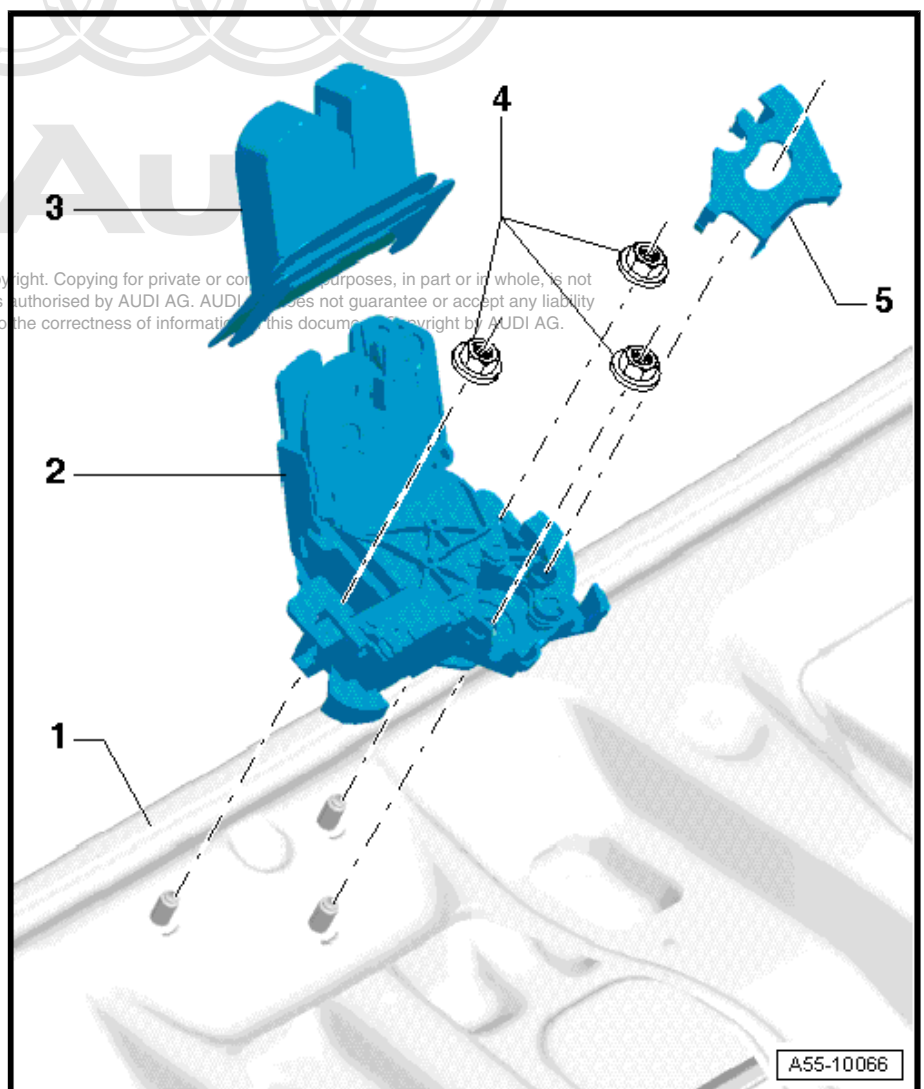
- ☐ When installing, cover must engage audibly in rear lid lock.

4 - Hexagon nuts

- ☐ 21 Nm

5 - Anti-theft cover

- ☐ When installing, cover must engage correctly in rear lid lock.



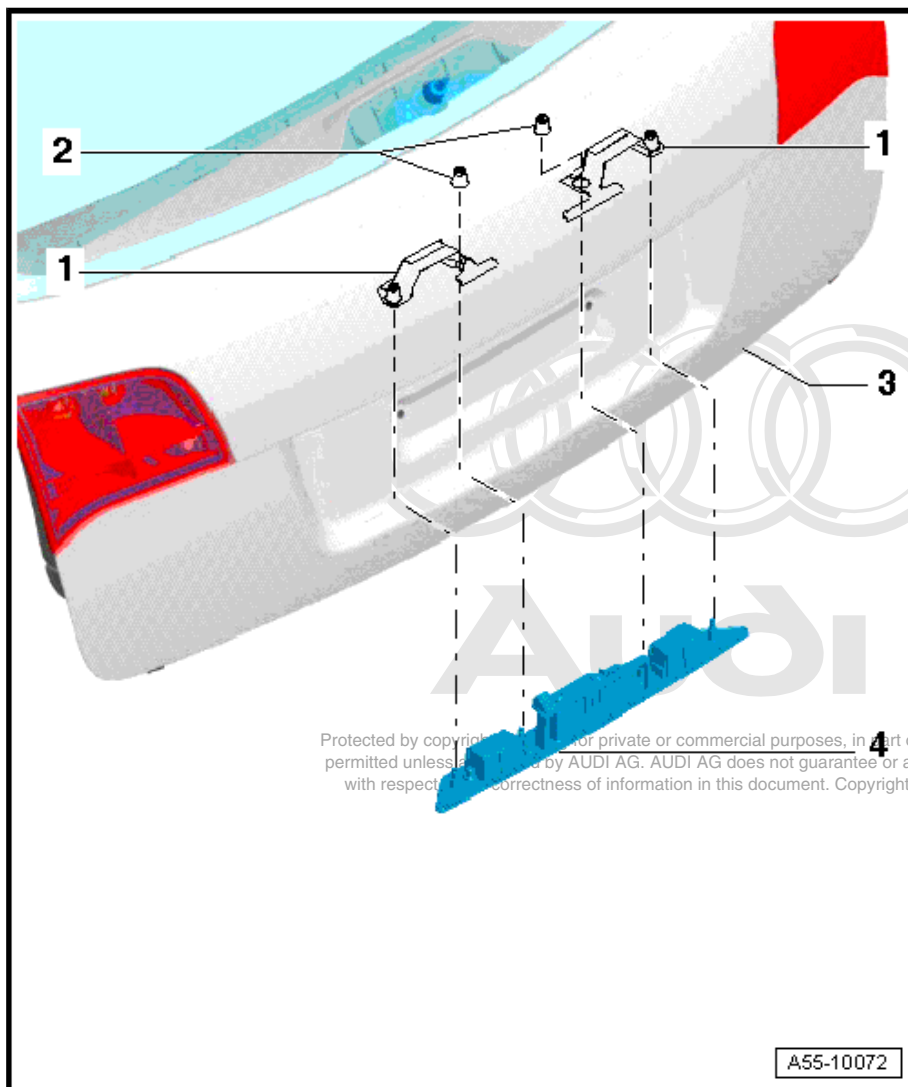
3.7 Removing and installing handle trim

Removing

- Unplug electrical connector on inside of handle trim -4-.

1 - Fastener

- ☐ Unscrew nuts on fasteners -1- (left and right) as well as nuts -2-.
- Take fasteners out of rear lid.
- Tightening torque: 8 Nm
- ☐ Release retaining hooks on handle trim and detach it from rear lid.

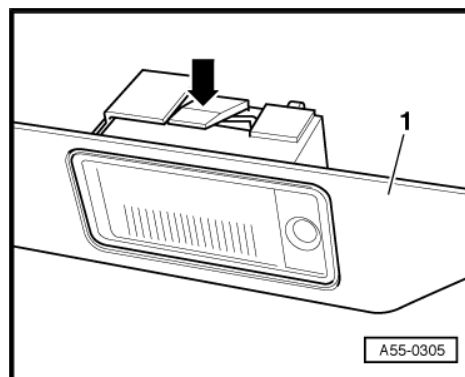


Releasing retaining hooks for handle trim

- Press back both retaining hooks -arrows- above number plate lights and detach handle trim -1-.

Installing

Install in reverse order of removal.



3.8 Removing and installing seal for rear lid



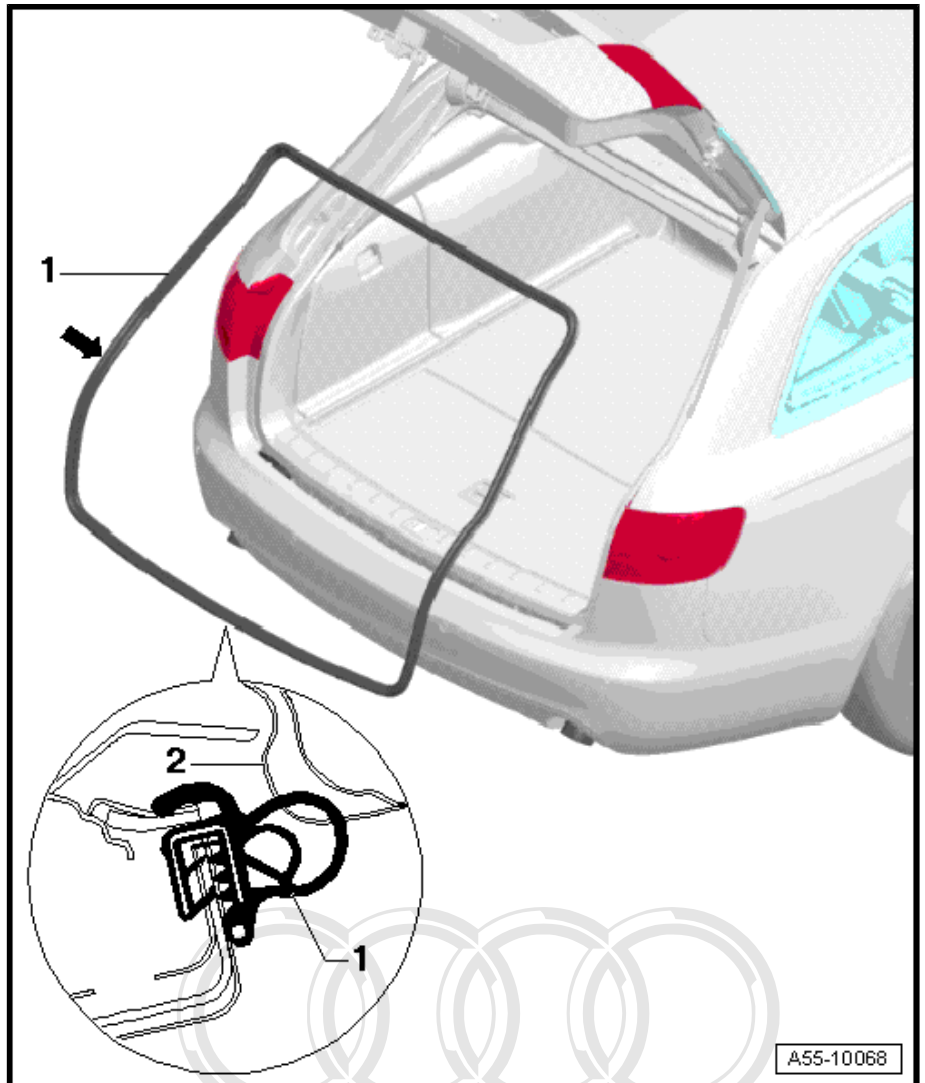
Remove rear lid before fitting seal.

1 - Seal for rear lid

☐ Removing:

- Unclip trim panels at D-pillar and at roof.
- Open rear lid and detach seal at D-pillar to side.
- Detach seal from body flange at roof and rear cross panel (bottom), pulling it in longitudinal direction.
- When installing, vulcanised joint -arrow- of seal must be in line with top edge of rear light.
- Press seal -1- onto body flange as shown.

2 - Rear lid



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4 Tank flap

4.1 Removing and installing tank flap

Exploded view

1 - Tank flap cup

- ☐ When installing, ensure correct seating of tank flap cup in side panel and in tank flap unit
⇒ [page 50](#).
- ☐ Before fitting, insert drain hose in fuel tank cup.

2 - Tank flap unit



Note

Is damaged irreparably moved.

- ☐ Removing:
 - Detach guide sleeve prior to removal.
 - Using the tips of circlip pliers, turn guide sleeve to left out of catch.
 - Pull guide sleeve out of fuel tank flap unit.
 - Release catches -arrows- using a small screwdriver and pull out tank flap unit.
- ☐ Installing:
 - Insert drain hose in tank flap cup.
 - Press tank flap cup into cut-out in side panel.
 - Align markings on tank flap cup and side panel -arrows-.
 - Place tank flap unit in opening and engage in tank flap cup ⇒ [Item 2 \(page 50\)](#).

3 - Fuel filler flap

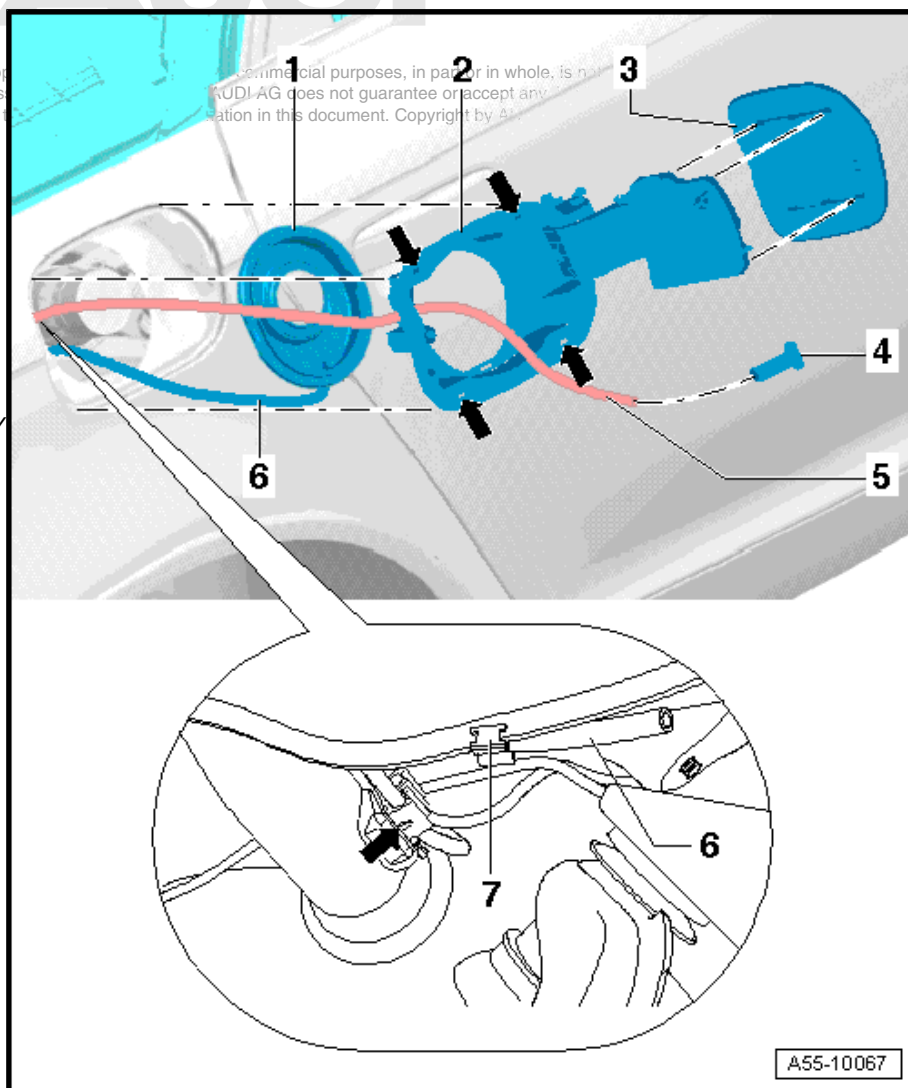
- ☐ Removing ⇒ [page 49](#)
- ☐ Place flap on hinge arm and make sure it engages.

4 - Guide sleeve for tank flap lock

- ☐ For removal, use commercially-available circlip pliers.
- ☐ Insert tips of circlip pliers in both guide sleeve bores and turn approx. 90° to left. This will release the locking mechanism.
- ☐ Pull guide sleeve out of fuel tank flap unit.

5 - Assembly hose

- ☐ This hose is used as an assembly aid to facilitate installation of the locking rod in the guide sleeve.



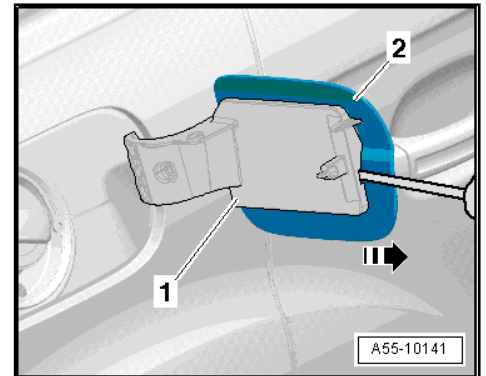
- ☐ Slide hose onto locking rod before fitting tank flap unit.
- ☐ Pull assembly hose sideways as shown through opening for guide sleeve.
- ☐ Place tank flap unit in body opening and make sure you hear it engage.
- ☐ Detach hose from locking rod and insert guide sleeve.
- ☐ Use commercially available long-nose pliers to lock guide sleeve.

6 - Drain hose

- ☐ At bottom, slide drain hose with clip -7- onto flange at side panel.

Releasing tank flap

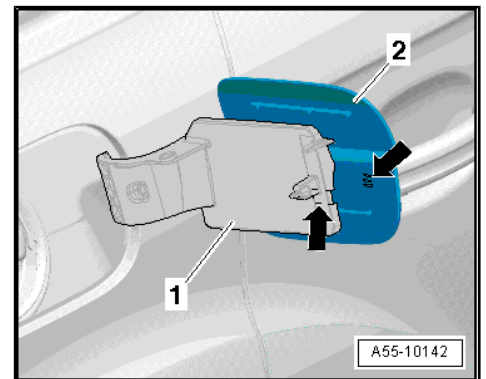
- Insert a screwdriver between flap -2- and flap mounting -1- as shown to release retainer.
- Pull flap slightly towards rear out of retainer.
- Detach flap to the side.



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Installing tank flap

- Insert flap into recesses on mounting.
- Slide flap -2- forwards in direction of arrow until it engages in retainer -arrows- on mounting -1-.



4.2 Tank flap unit

Installation position

1 - Tank flap

- ☐ Can be renewed separately.

2 - Tank flap unit



Note

Is damaged irreparably when removed.

- ☐ When installing, make sure sealing lips are correctly seated on tank flap cup.

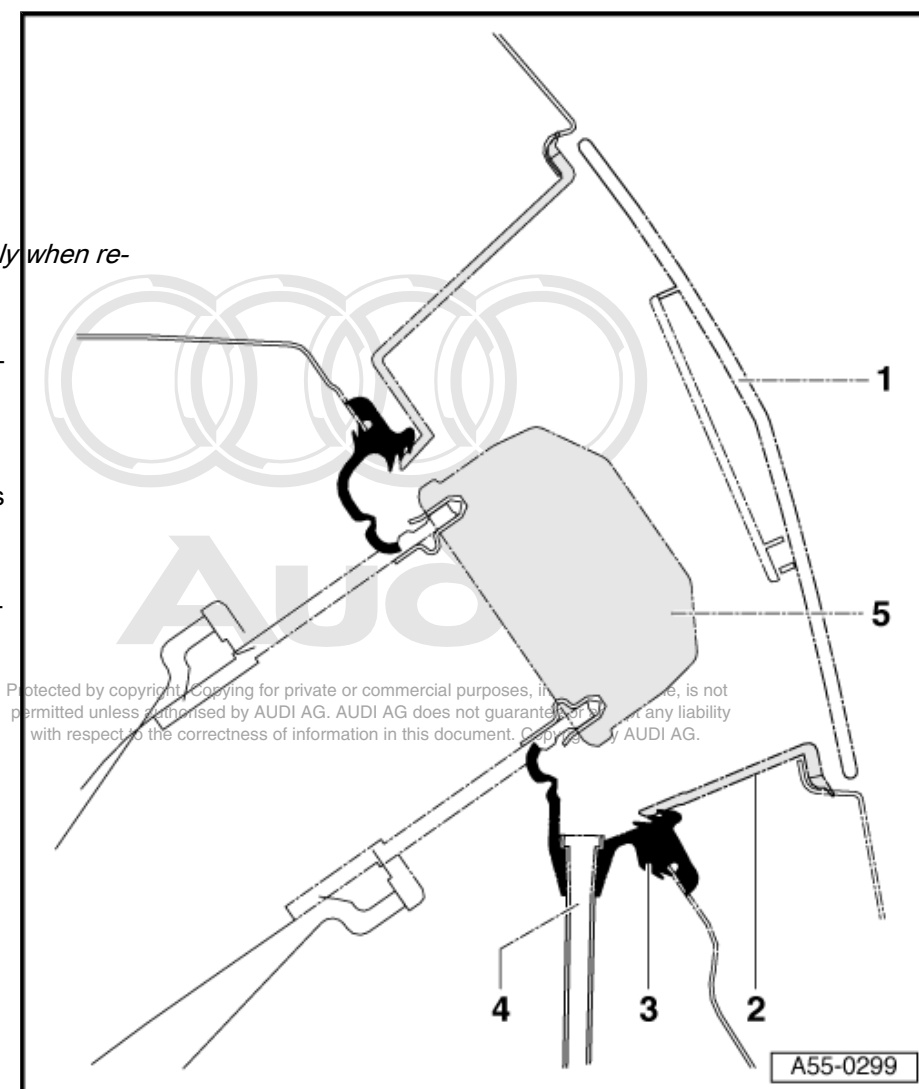
3 - Tank flap cup

- ☐ Insert into side panel as shown.

4 - Drain hose

- ☐ Secured to wheel housing beneath wheel housing liner using retaining clip.

5 - Tank cap



57 – Front doors, door components, central locking

1 Front door

1.1 Removing and installing door



Note

- ◆ For various assembly activities, the entire door can be lifted right out of its hinges after you have unplugged the electrical connections at the bottom of A-pillar / B-pillar.
- ◆ No adjustment work is required after fitting.

1 - Door panel

- Pull bellows out of A-pillar (bottom).
- Unplug electrical connectors at A-pillar (bottom).
- Loosen bolt -4- at door hinge (top).
- Unscrew lower bolt with washer -9- at door hinge (bottom).
- Pull cap off hinge pin.



Caution

Protect the painted surfaces on the door and wing panel from damage.

- Carefully lift the door up and off the hinges.

2 - Upper section of door hinge (top)

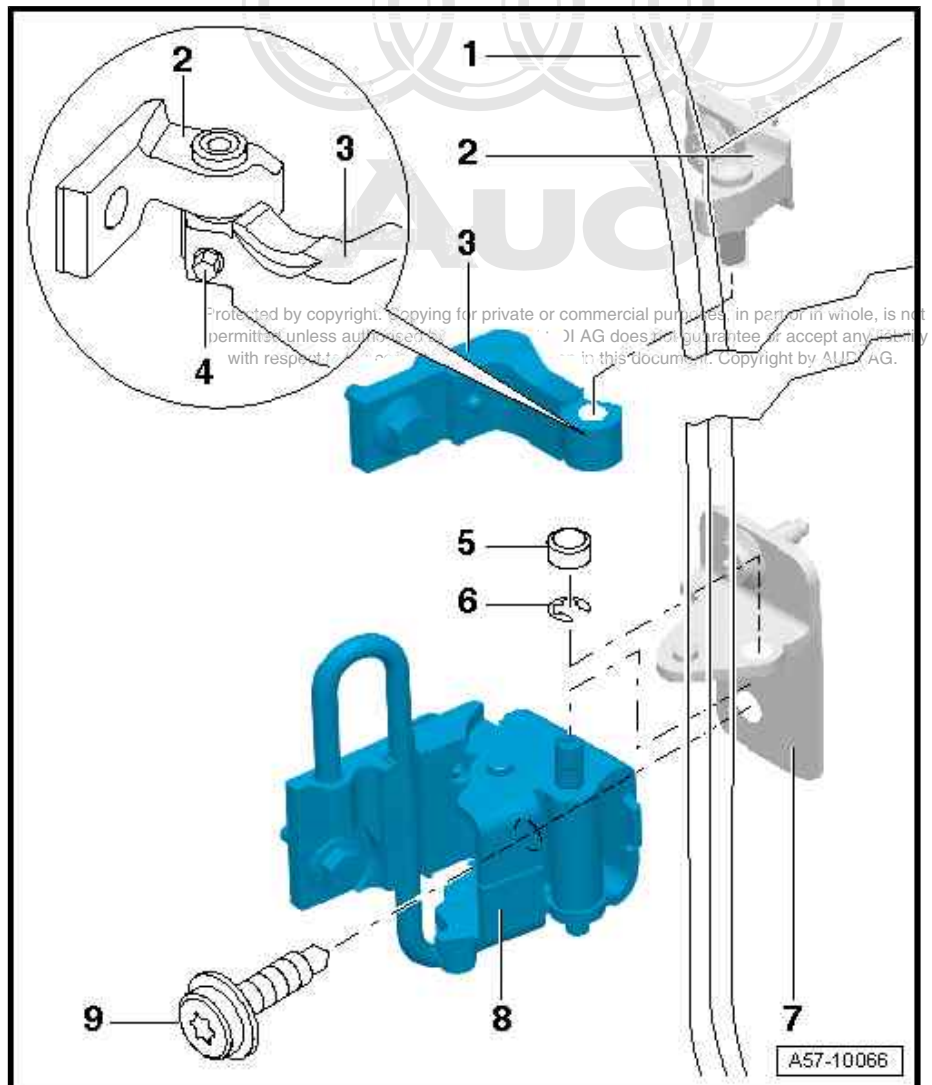
- ☐ Not available as separate part
- ☐ Remains bolted to door

3 - Lower section of door hinge (top)

- ☐ Not available as separate part
- ☐ Remains bolted to A-pillar.

4 - Locking bolt

- ☐ 25 Nm





5 - Cap

- ☐ Fit on pivot pin

6 - Retaining clip

- ☐ Only fitted on replacement part
- ☐ Pull off after fitting a new hinge.

7 - Upper section of door hinge (bottom)

- If necessary, slacken any tension between upper and lower section of door hinge (bottom) using a screwdriver.
- ☐ Not available as separate part
- ☐ Remains bolted to door

8 - Lower section of door hinge (bottom)

- ☐ Not available as separate part
- ☐ Remains bolted to A-pillar.

9 - Bolt with washer

- ☐ 32 Nm

1.2 Removing and installing window frame and window regulator



Note

Disconnect battery before removing window frame or door.



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1 - Window frame

Removing:



Caution

A side airbag sensor is located on the inside of the door -arrow C-. Note the airbag safety regulations ⇒ Rep. gr. 69.

- ☐ Remove door trim. ⇒ Rep. gr. 70
- Remove bass loudspeaker ⇒ Rep. gr. 91.
- ☐ Unplug electrical connectors.
- ☐ Remove window regulator motor ⇒ [page 54](#)
- ☐ Remove bolts -5-, -8-, -9-, -10- and -11-.
- ☐ Remove fitted bolts -7- and lift window frame with window regulator out of door.

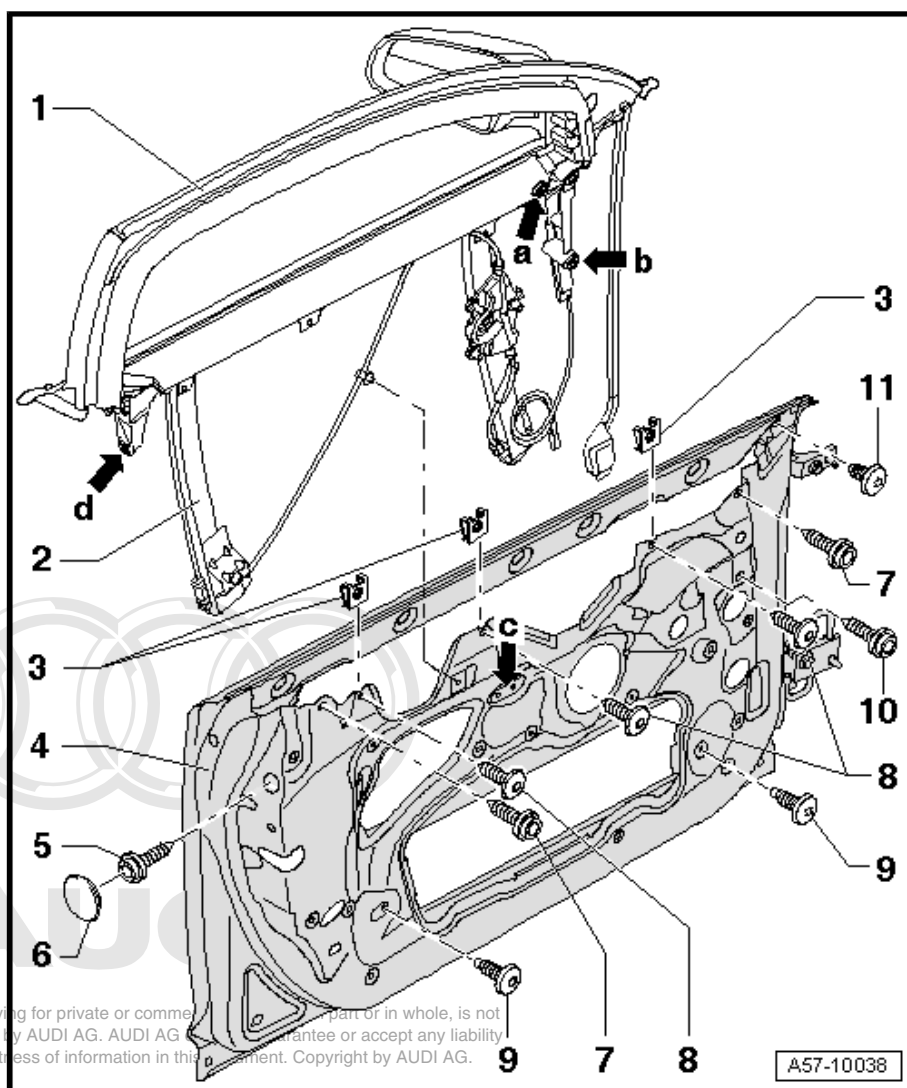
Installing:

- ☐ Before installing, move half of window glass into window frame.
- ☐ Insert window frame and window regulator into door from above.
- ☐ Loosely screw in bolts in the following sequence: -7-; -5-; -10- and -11-.
- ☐ Hand-tighten fitted bolts -7- and flange bolt -11-.
- ☐ Press top of window frame -1- slightly inwards.
- ☐ Use a 9 mm Allen key to move the adjustment bush -arrow B- into contact with the inner door panel.
- ☐ Tighten bolts -5- and -10- to 32 Nm.
- ☐ Tighten fitted bolts -7- to 32 Nm.
- ☐ Tighten bolt -11- to 10 Nm.
- ☐ Tighten locking bolt -arrow A- in longitudinal member at window frame to 32 Nm.
- ☐ Attach upper half of seal (on door side) into window frame (top).



Note

- ◆ When setting the door angle, the adjustment bush -arrow B- must only make contact with the door panel.
- ◆ Do NOT adjust the window frame via the adjustment bush. The window frame must be pressed into the correct position before the adjustment bush makes contact with the inner door panel.
- ◆ Tighten all bolts in the specified sequence.



2 - Window regulator

- ☐ Bolted to window frame for installation in door

3 - Speed nut

- ☐ Fitted to door flange

4 - Front door

5 - Torx bolt

- ☐ 32 Nm

6 - Cap

7 - Fitted bolt

- ☐ 32 Nm

8 - Panel bolt

- ☐ 2.5 Nm

9 - Flange bolt

- ☐ 6 Nm

10 - Torx bolt

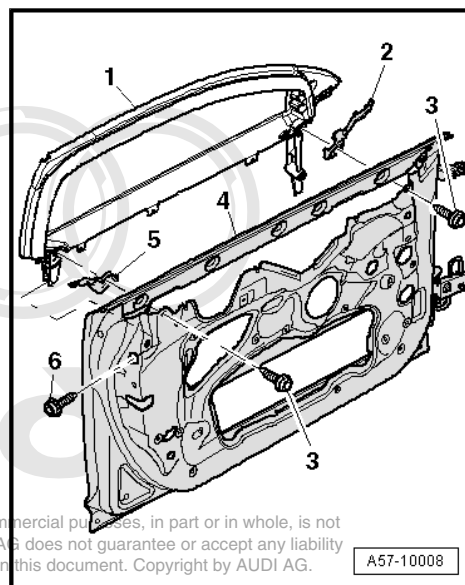
- ☐ 32 Nm

11 - Torx bolt

- ☐ 10 Nm

Seal for window frame

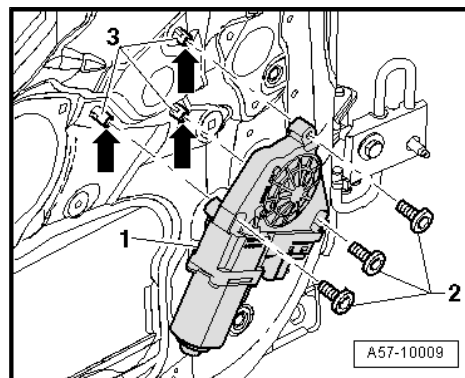
- Before installing window frame -1- in door -4-, check for correct seating of seals -5- and -2-.
- If necessary, renew seals.
- Press seals into window frame as shown.
- Insert window frame into door and screw in fitted bolts -4- and flange bolts -3-.



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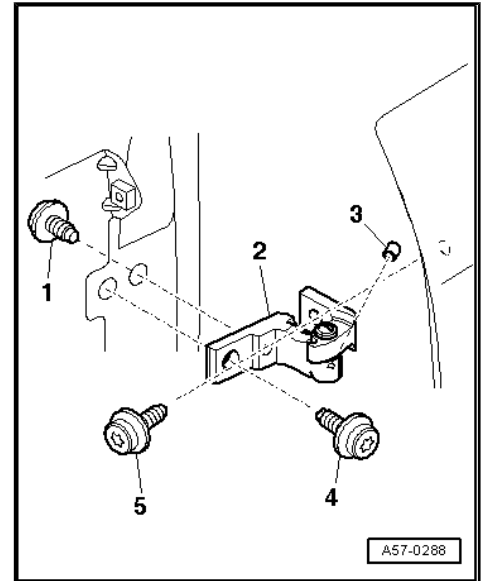
Removing and installing window regulator motor

- To remove, unscrew bolts -2- and detach window regulator motor.
- Installing window regulator motor ⇒ [page 59](#).



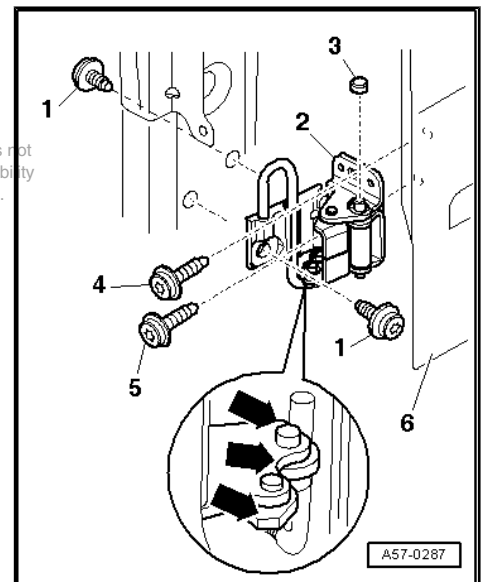
Door hinge (top)

- Torx bolt -T 45- -1- (fitted from inside vehicle): 32 Nm
- Door hinge (top) -2-
- Cap -3-
- Torx bolt -T 45- -4-: 32 Nm
- Fitted bolt -5- -T 45- : 32 Nm.



Door hinge (bottom)

- Torx bolt -T 45- -1- 32 Nm to B-pillar (fitted from inside of vehicle).
- Door hinge (bottom) -2-
- Cap -3-
- Torx bolt -T 45- -4-: 32 Nm
- Fitted bolt -T 45- -5-: 32 Nm
- Re-grease lubrication points -arrows- at prescribed service intervals.
- Front door -6-



1.3 Renewing seal for window frame

1 - Window frame

- ☐ Removed

2 - Seal for window frame

- To install, hook securing parts of seal into window frame in area of A-pillar (top) and at corner of B-pillar.

- ☐ Press seal onto window frame from side.



Note

- ◆ The seal must be pressed into position. Do not tap or hammer on the seal with your fist.
- ◆ Use soap solution to facilitate installation of seal.

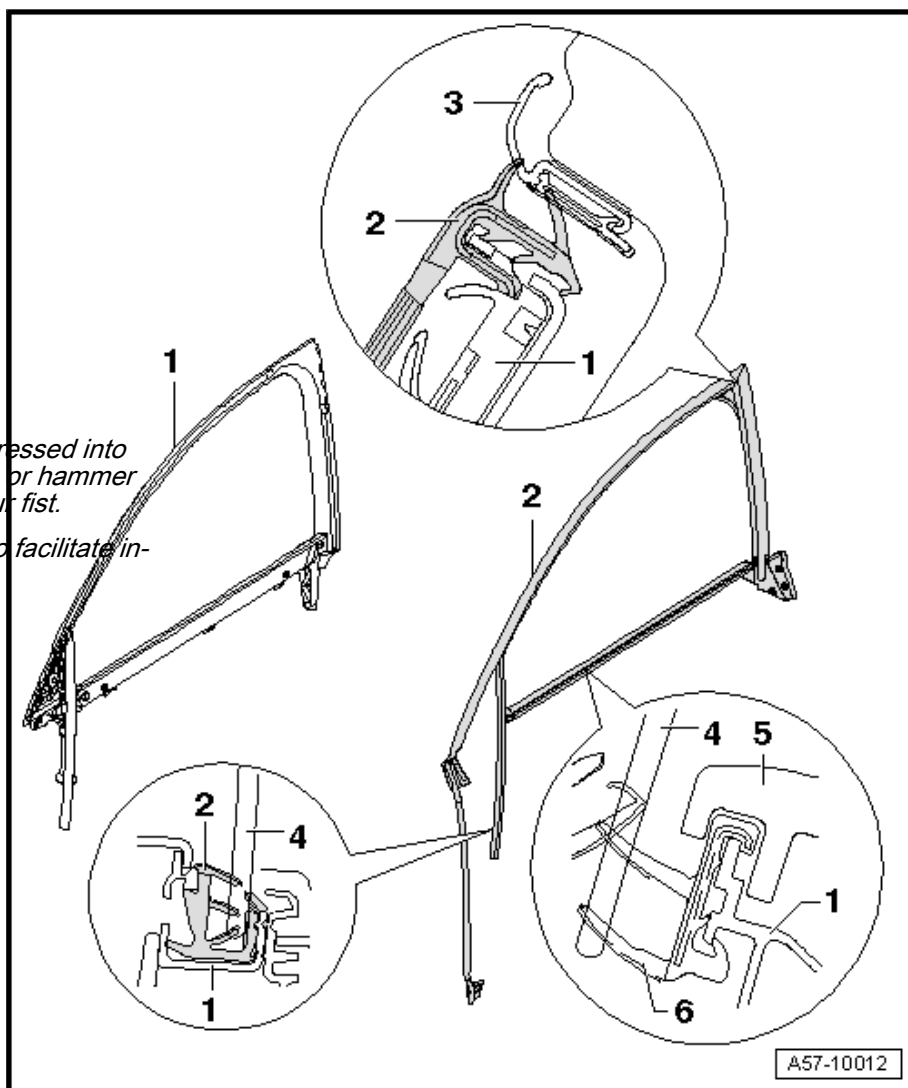
3 - Roof trim strip

4 - Door window

5 - Door trim

6 - Inner window slot trim strip

- ☐ Remove door trim prior to removal
- ☐ Pull off to the side
- ☐ To install, first hook into bottom of window frame, then press on upwards.



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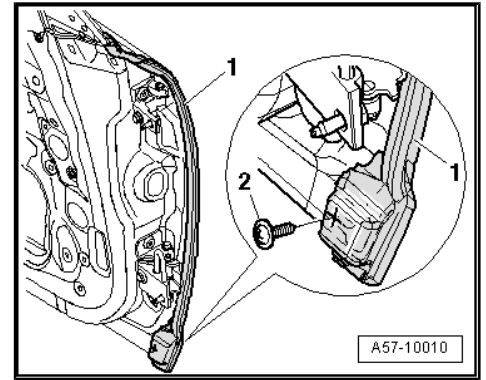
Installing lower joint seal

Note

To facilitate installation of the joint seal, you can remove the entire door from its hinges and refit without any adjustment work
⇒ [page 51](#).

Note

- ◆ Clean bonding surface before installing seal.
- ◆ Bonding surface must be free of dust and grease.
- Clip in seal at top.
- Detach protective foil from seal -1- starting at bottom up to embossed area.
- Bond on seal up to embossed area.
- Fix moulding in position at bottom and fully bond on seal in lower area.
- Detach rest of protective foil and bond on seal in upper area.
- Screw in bolt -1- at bottom of seal and tighten to 1 Nm.
- Insert rubber lip of door cover in moulding on A-pillar (bottom).



1.4 Removing window regulator and door window



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1 - Window frame

- ☐ Removing:
- ☐ Remove door trim. ⇒ Rep. gr. 70
- ☐ Window frame removed from front door together with window regulator ⇒ [page 52](#)
- ☐ Door window -4- removed
- ☐ To remove, unscrew countersunk-head bolts -3- and detach window regulator from window frame.
- ☐ Installing:
- ☐ When installing, ensure that both guide rails, arrows -A-, run parallel to guide, arrow -B-
- ☐ Tighten bolts -3- to 6 Nm.

2 - Window regulator

- ☐ Window frame removed from front door together with window regulator ⇒ [page 52](#)
- ☐ Door window removed
- ☐ To remove, unscrew countersunk-head bolts -3- and detach window regulator from window frame.

3 - Countersunk-head bolt

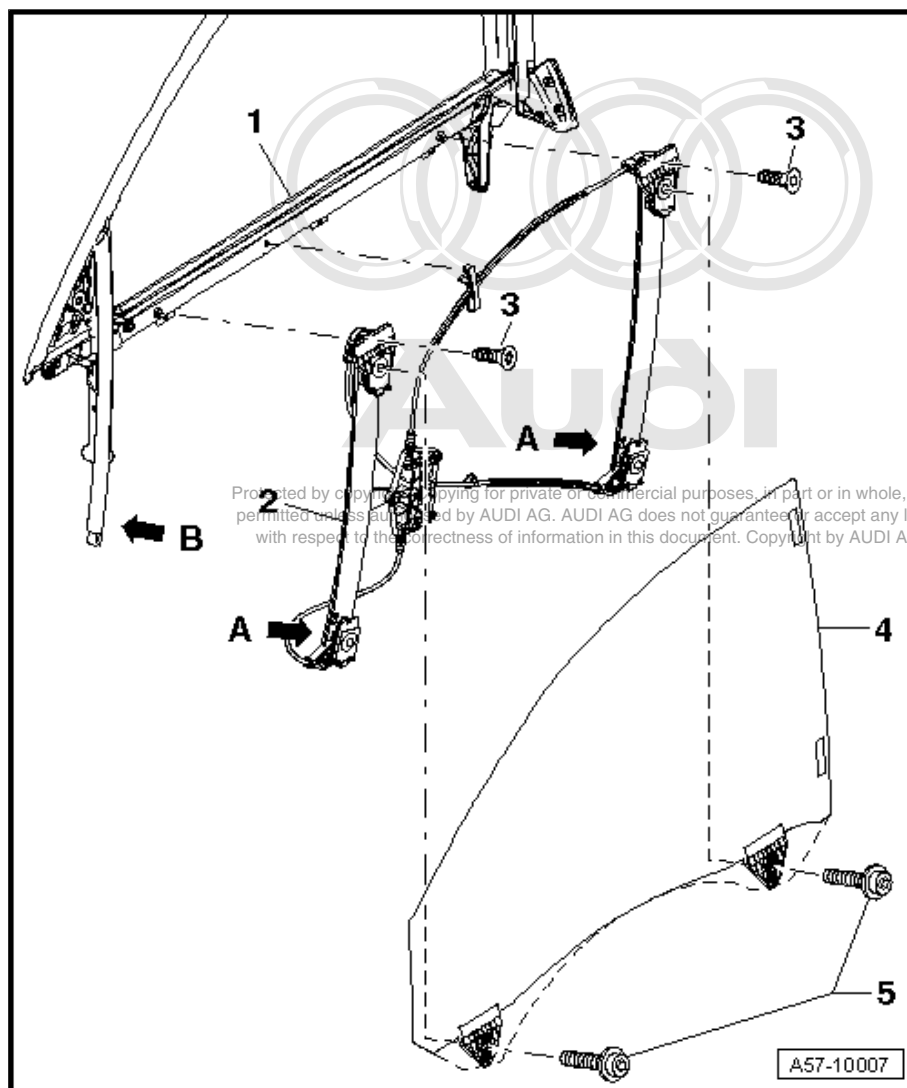
- ☐ 6 Nm

4 - Door window

- ☐ Removing:
- ☐ Lower door window.
- ☐ Unscrew bolts -5- and detach door window from window regulator.
- ☐ Installing:
- ☐ Insert window in window regulator.
- ☐ Screw bolts -5- into window regulator but do not tighten yet.
- ☐ Move door window upwards into window frame.
- ☐ Pull door window to rear into window guide on window frame at B-pillar and tighten bolts -5- to 4 Nm.

5 - Hexagon socket head bolt

- ☐ 4 Nm



1.5 Removing and installing outer door seal

1 - Window frame

- Installed in door

2 - Cover for exterior mirror

3 - Retaining rail

- Retaining rails are clipped in all around door.

4 - Retaining rail

5 - Retaining rail

6 - Retaining rail

7 - Retaining rail

8 - Outer door seal

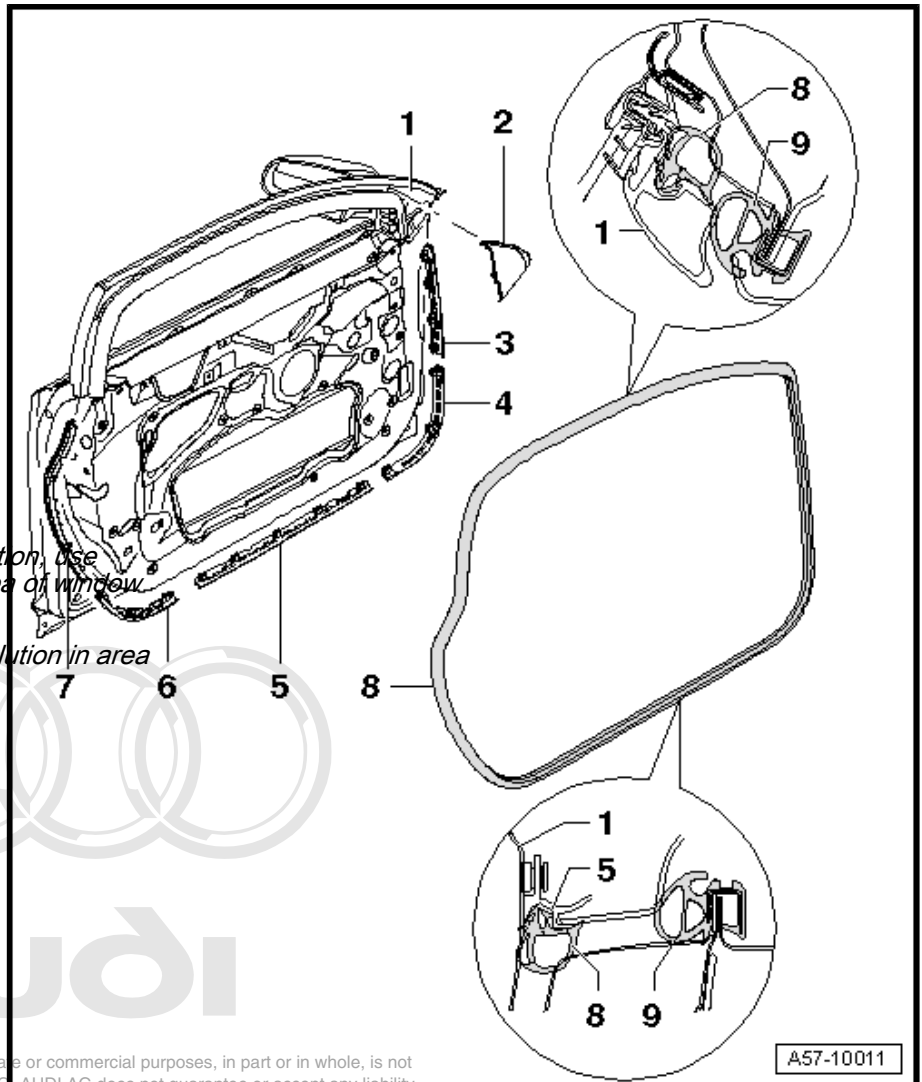


Note

- ◆ To facilitate installation, use soap solution in area of window frame.
- ◆ Do not use soap solution in area of retaining rails.

- Starting at top of window frame, press in seal all around retaining rails.

9 - Inner door seal



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A57-10011

1.6 Removing and installing window regulator motor

Removing

- Door trim removed ⇒ Rep. gr. 70



Note

- ◆ Window regulator motor can be removed or installed with motor or side window in any position.
- ◆ Unplug connectors before removing motor.

- Unscrew Torx bolts -2- -T 30- and remove motor -1-.

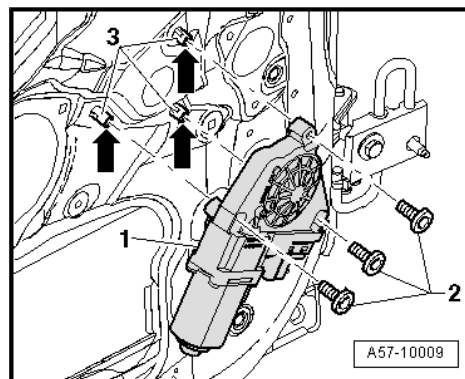
Installing

- When installing, make sure threaded pins -arrows- are engaged in inner door panel.
- Push window regulator motor -1- onto threaded studs -3- and secure with bolts -2-.
- Tightening torque: 3.5 Nm



Note

- ◆ After installing the electric motor and attached wiring, first turn the ignition on and then off again.
- ◆ Then raise door window as far as it will go and keep window regulator switch pulled for approx. 2 seconds.
- ◆ The window regulator is now in the basic setting and the opening/closing function is activated.



1.7 Removing and installing power latching system

1 - Bolt

- 2.5 Nm

2 - Driver door power latching motor - V302-

- Disengaging and engaging ⇒ [page 61](#)
- Unscrew bolts and take motor out of mounting bracket.

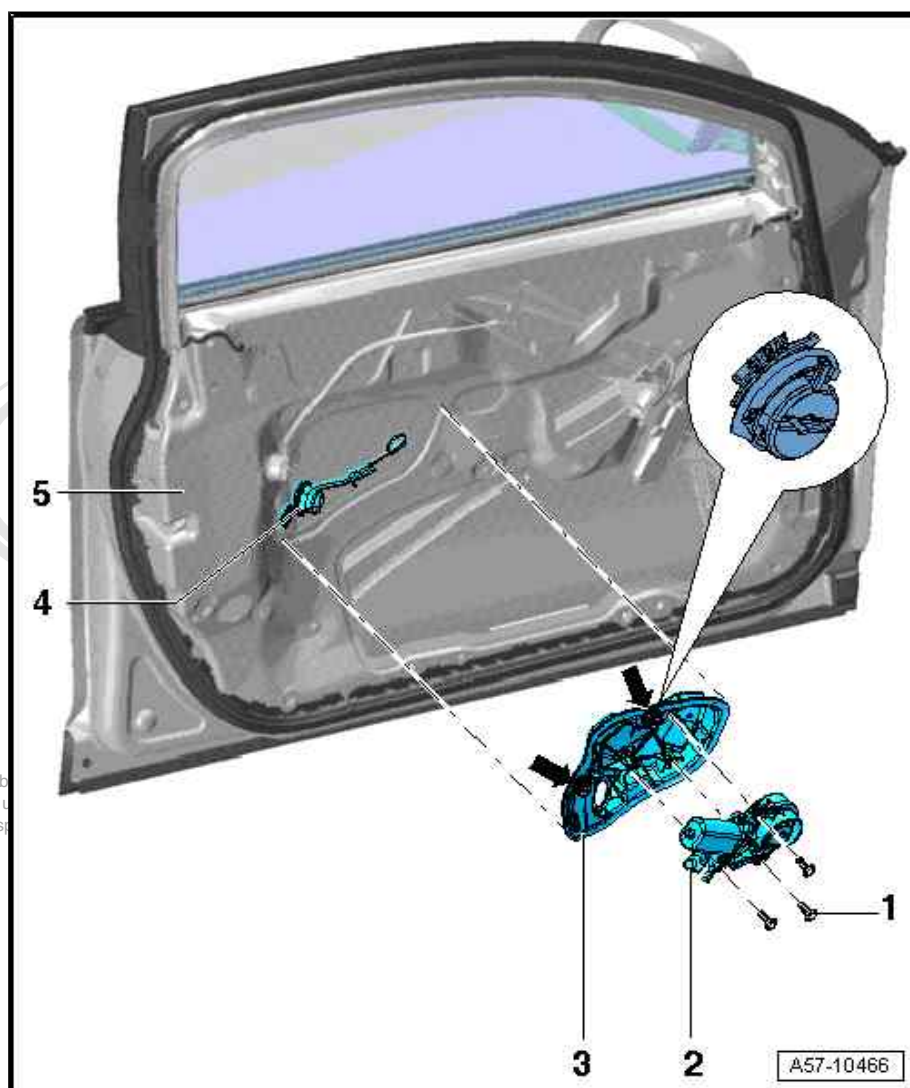
3 - Mounting bracket

- When removing from door lock, disengage cable at motor.
- Release fasteners -arrows- using a screwdriver, and fold out motor together with mounting bracket.
- When installing, fasteners must engage audibly.

4 - Cable

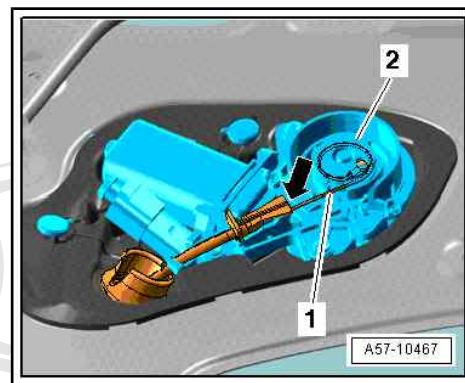
- When installing, grommet for cable must be pressed all the way into mounting bracket.

5 - Front door



Disengaging and engaging cable

- To remove, unclip cable from retainers -arrow- and pull out of guide towards rear.
- Thread cable -1- out of cable reel -2-.
- To install, first insert nipple of cable into cable reel.
- Insert cable into groove on cable reel through 360° as shown.
- Slide cable into guide and fasten with retaining hooks.
- Press grommet for cable all the way into mounting bracket.



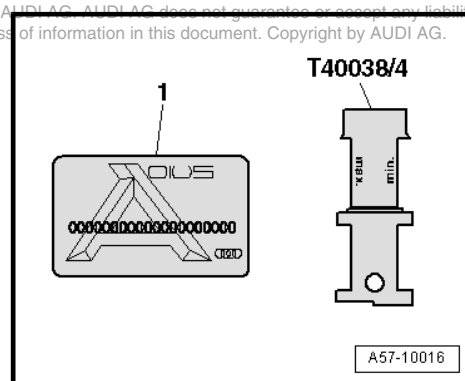
1.8 Checking door adjustment with template - T40038/4-

Special tools and workshop equipment required

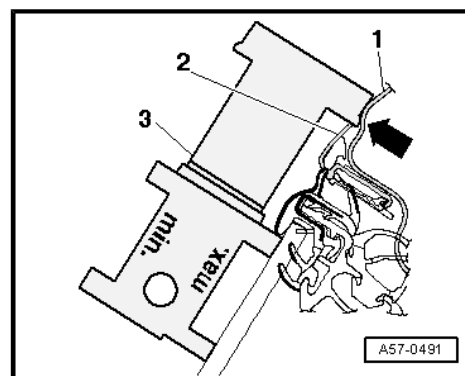
◆ Template - T40038/4-

- Use template - T40038/4- for checking (e.g. for wind noise) and adjusting door as described below:
- Use a regular bank card -1- or similar to check contact pressure of sealing lip on roof trim strip.

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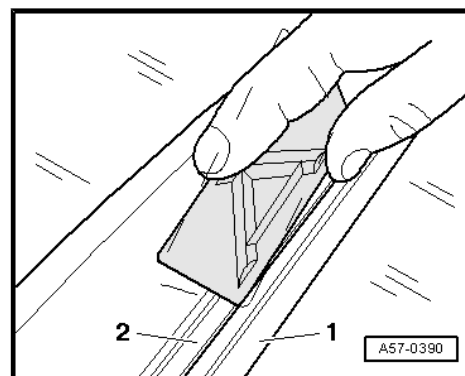
- For correct adjustment, template -3- should make contact with top of roof trim strip -2- and roof -1- -arrow-.



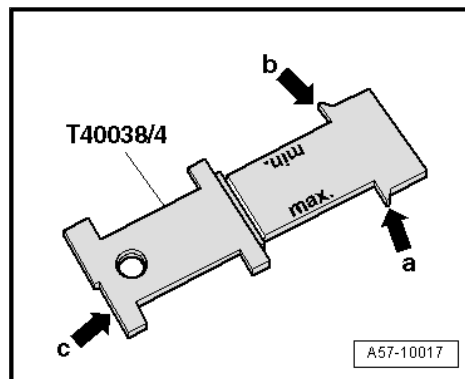
Checking contact of sealing lip on roof trim strip

- Move a regular bank card along the area of contact between the sealing lip and the roof trim strip, applying light pressure.
- Card must not penetrate between sealing lip -1- and roof trim strip -2-.

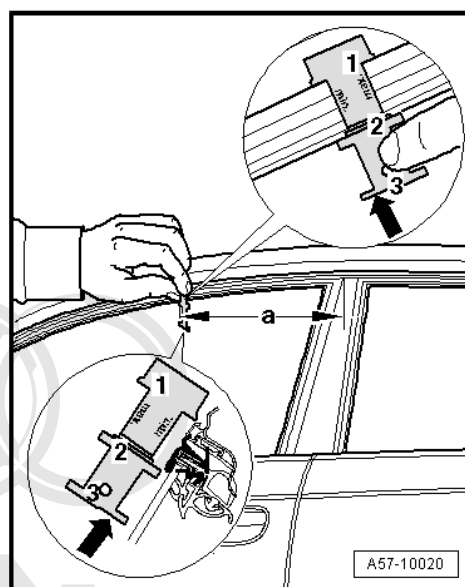
Lateral adjustment of door (setting angle)



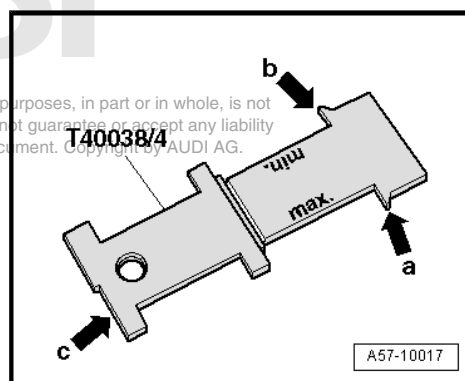
- Template has arms of different length at arrows -a- and -b-.
- These can be used to check lateral adjustment of doors.
- Use side with “max” mark to check whether window frame is positioned too far outwards.
- Use side with “min” mark to check whether window frame is positioned too far inwards.



- Position template at distance -a- = 200 mm and with cut-out -arrow- pointing towards the door window.
- Make sure points -1- and -3- make contact.
- A gap is permissible at point -2- of the template.
- This position (max) represents outermost door setting within tolerance range.
- If there is no gap at point -2- or if there is a gap at point -1-, window frame is positioned too far outwards and must be adjusted.



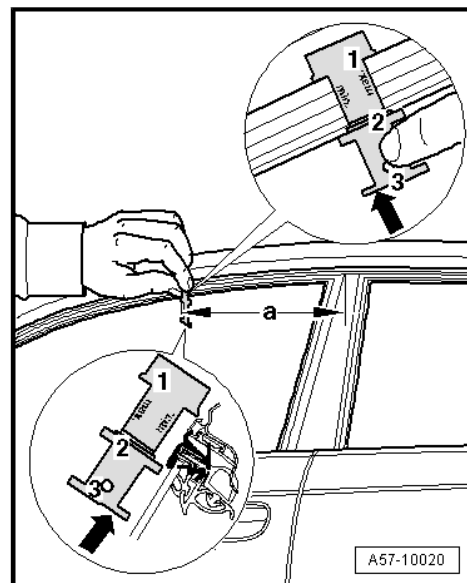
- Use side with arrow -b- (min mark) to check whether window frame is positioned too far inwards towards body.
- Position template at distance -a- = 160 mm and with cut-out -arrow- pointing away from door window as shown.



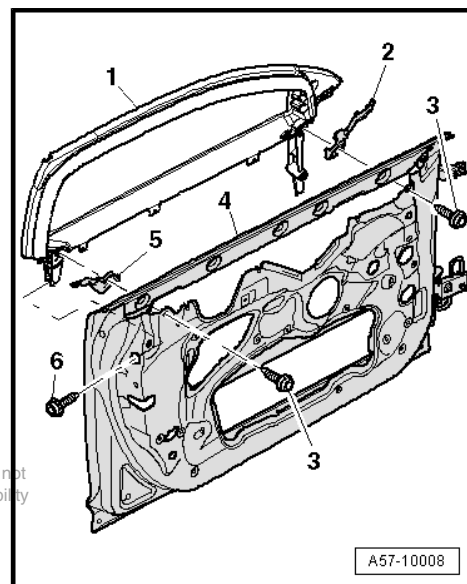
- Make sure points -2- and -3- make contact with door window.
- A gap is permissible at point -1- of the template.
- This position (min) represents innermost door setting within tolerance range.
- If there is no gap at point -1- or if template contact cannot be established at point -2-, window frame is positioned too far towards inside and must be adjusted. ⇒ [page 61](#)

Height adjustment of window frame

- If it is necessary to adjust height of window frame, fitted bolts -2- and -5- must be exchanged for standard bolts of same property class and length.

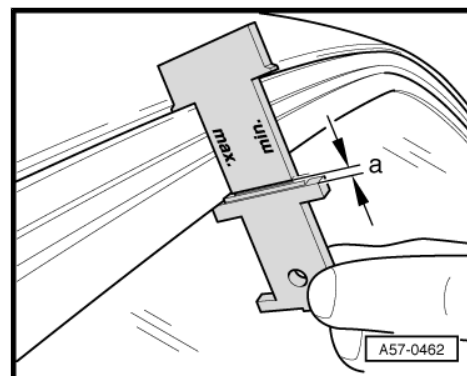


- Height of window frame -1- can now be adjusted in relation to door -4-.
- Seals -5- and -2- are inserted into window frame.
- Place template on roof as shown, or on upper edge of rain channel.



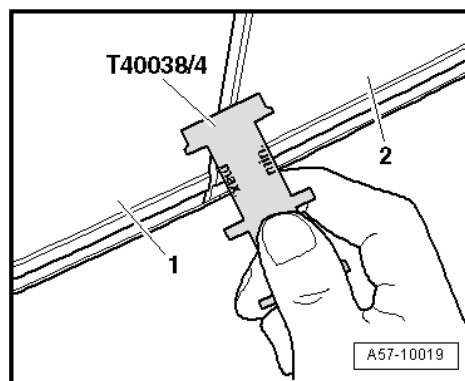
- When correctly adjusted, lower edge of window frame should be inside grooved area -a- on template.
- Check/adjust angle of window frame.

Adjusting front door

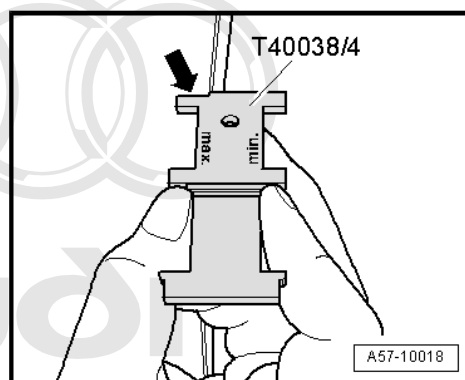


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- Underside of template -T40038/4- (illustration shows different template) can be used to check position of door.
- The door must not be recessed relative to the side panel -2-.
- The front door -1- must not be recessed relative to the side panel -2- (wind noise).



- The front door may protrude (max. 0.8 mm) relative to the side panel in the area of the cut-out in the template -arrow-.

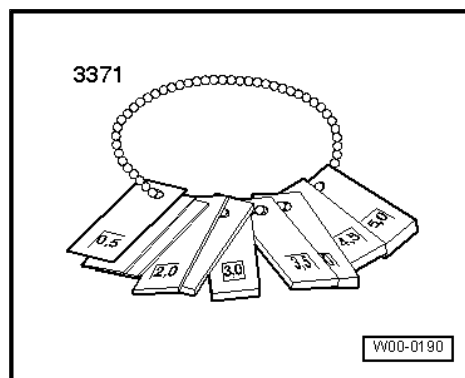


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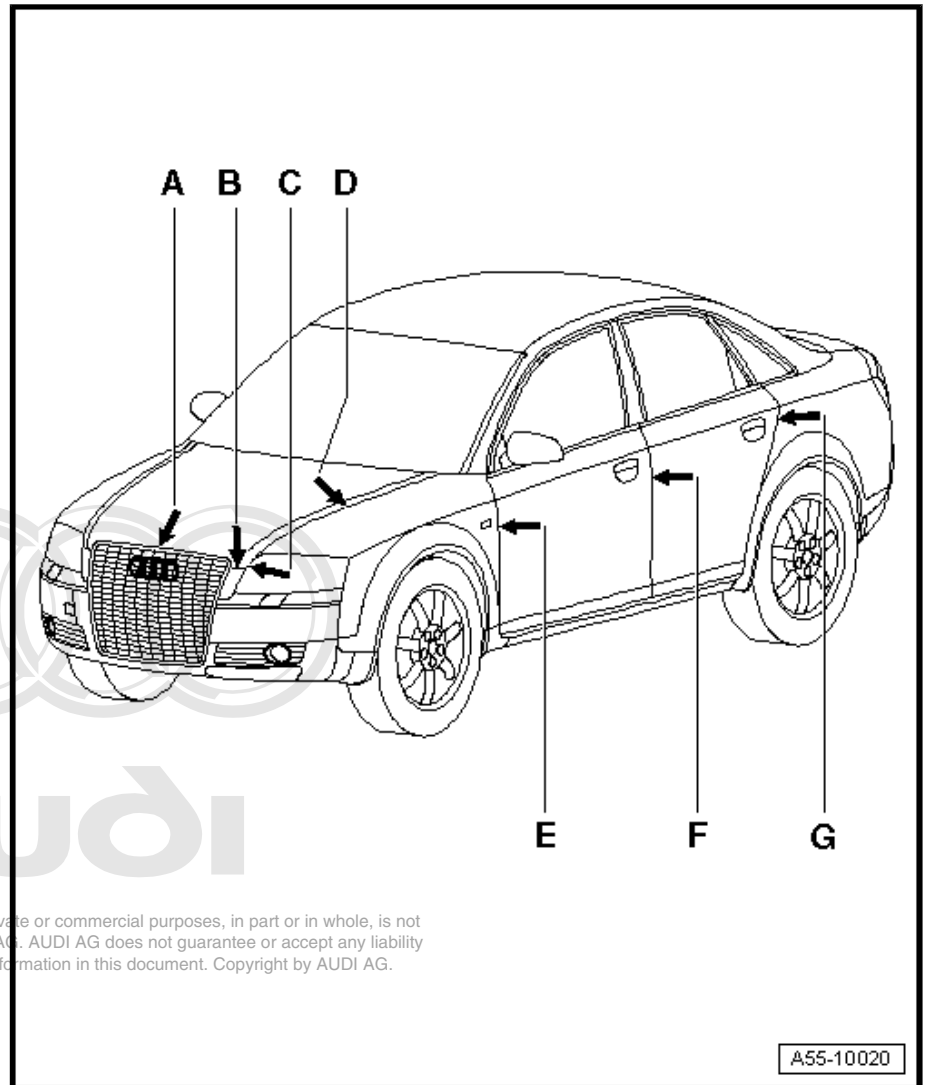
1.9 Adjusting front door

Special tools and workshop equipment required

- ◆ Setting gauge - 3371-



Panel gaps



Note

Panel gaps can be checked using setting gauge - 3371- .

Adjustment dimensions for front door



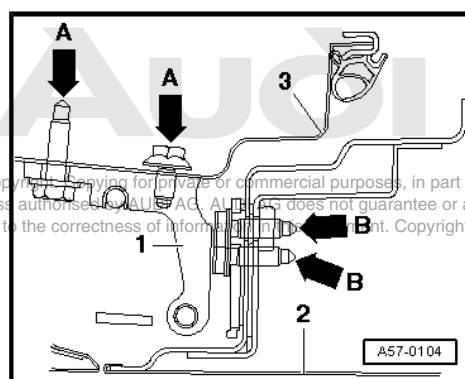
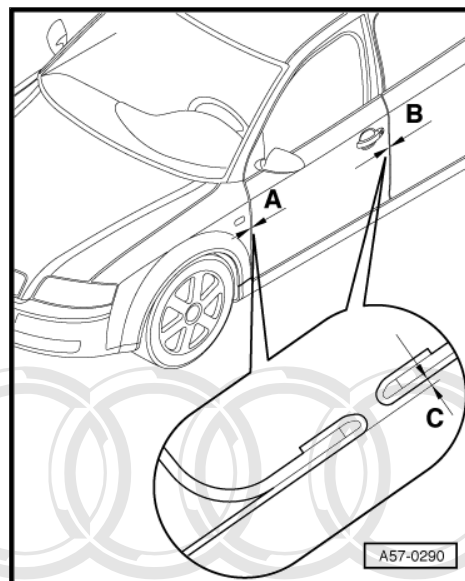
Note

Rear door must already have been adjusted.

- Dimension A = 3.5 mm ± 0.5 mm
- Dimension B = 4.5 mm ± 0.5 mm
- Flush alignment, dimension C = 0 mm -1 mm (parallel to body contour)

Longitudinal adjustment

- For longitudinal adjustment of the door, slacken hinge bolts -arrow A- on A-pillar at door hinge (top and/or bottom) and move door -2- within elongated holes in hinge or A-pillar.
- Tightening torque: 32 Nm
- Door hinge -1-
- A-pillar -3-
- Door -2-



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Note

Illustration shows door hinge (bottom).

Adjusting the door inwards/outwards



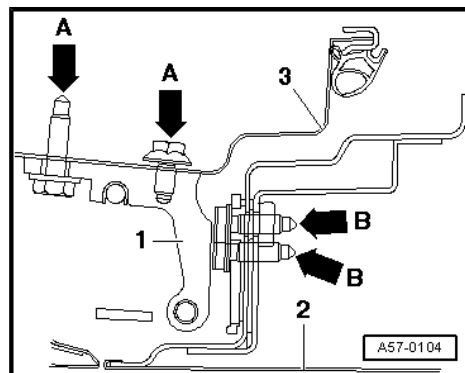
Note

- ♦ A fitted bolt is installed on each of the lower door hinges on the door side.
- ♦ As a result, an adjustment is not usually required during repair work.
- ♦ However, should adjustments be required after all, the fitted bolts can be replaced by bolts of the same size, length and strength, as offered in the Parts catalogue.
- The door can be adjusted relative to the centre of the vehicle by slackening the door hinge bolts (top and/or bottom) -arrow B- and moving the door within the elongated holes in the hinge.
- Tightening torque: 32 Nm



Note

Adjust rear end of door by altering position of striker inwards or outwards.



Adjustment via striker

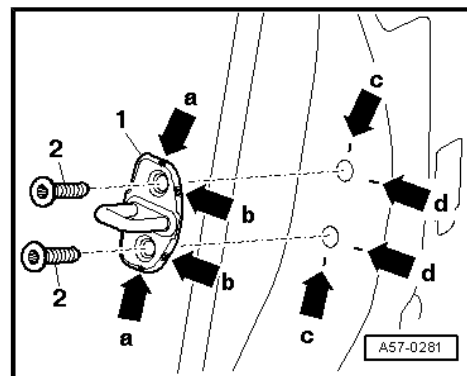
- Loosen bolts -2-.
- Use markings -arrows a- and -arrows c- for lateral adjustment.
- Move striker -1- until door is flush with body contour.



Note

Use this adjustment only to adjust door inwards or outwards, not vertically.

- Use markings -arrows b- and -arrows d- for height adjustment.
- If adjustment is correct, striker should engage centrally in door lock.
- Tighten bolts to 25 Nm.



1.10 Adjustment dimensions for front door window frame

1 - Window frame

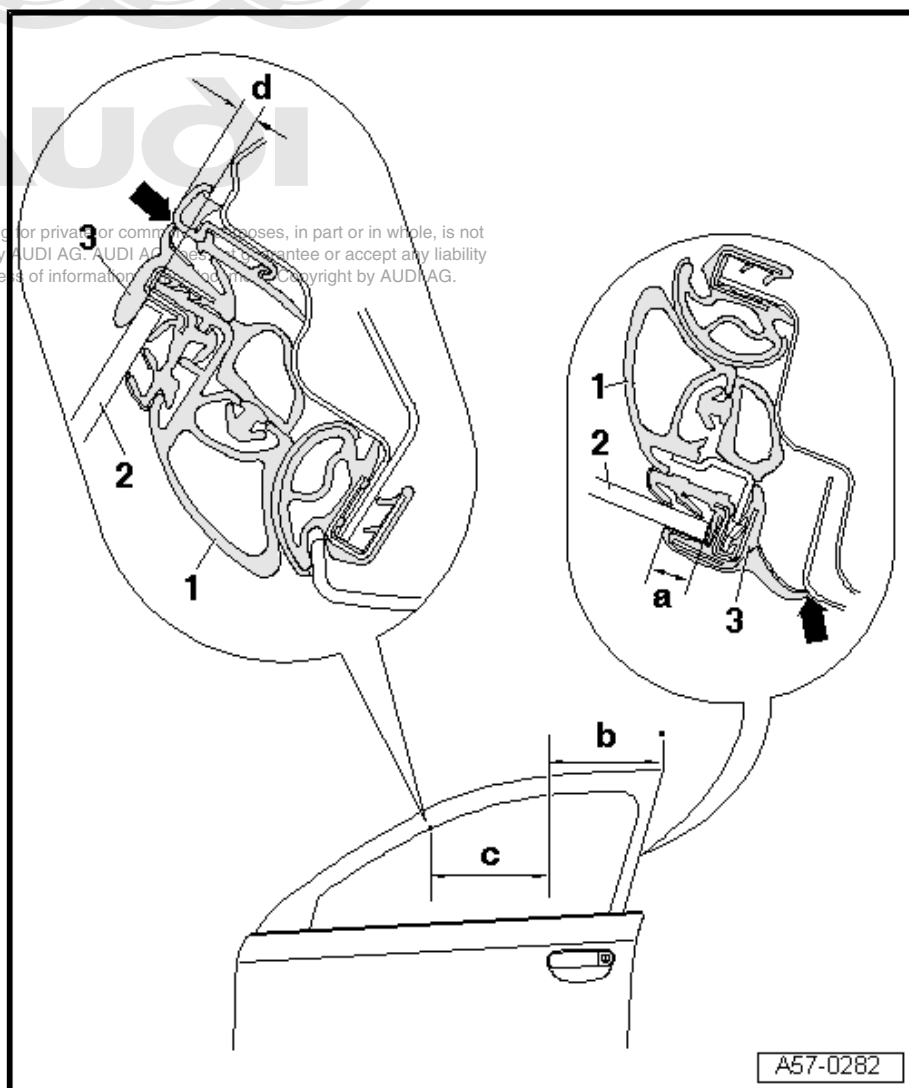
- ❑ If door is adjusted correctly, sealing lip must fit flush with contours of roof frame and B-pillar; see arrows.

2 - Door window

- ❑ Adjust door to achieve dimension -d- = 4 mm in area -c- = 365 mm
- ❑ Dimension -d- can be checked with template -T40038/4-.
- ❑ Dimension -b- measured from rear edge of door at B-pillar = 200 mm

3 - Window frame

- ❑ Door window -2- must fit into window frame at B-pillar (dimension -a- = 7.5 mm - 1 mm).



1.11 Front door handle and door lock

Exploded view

1 - Transmission module

- ☐ Clipped into door handle mounting.
- ☐ Removing ⇒ [page 70](#)

2 - Door handle mounting

- ☐ Releasing ⇒ [page 72](#)

3 - Slide

- ☐ Pull out to detach lock cylinder

4 - Operating rod

- ☐ Clip into door lock
⇒ [page 71](#)

5 - Joint bush

- ☐ Hook operating rod into clip, swivel clip through 90° and engage at operating rod.

6 - Door handle

- ☐ Prior to removal take out window frame and window regulator.
- ☐ Lock cylinder/cover removed
- ☐ Removing ⇒ [page 70](#)

7 - Trim for door handle

- ☐ Removing ⇒ [page 73](#)

8 - Lock cylinder

- ☐ Fitted on driver's side only

9 - Cover

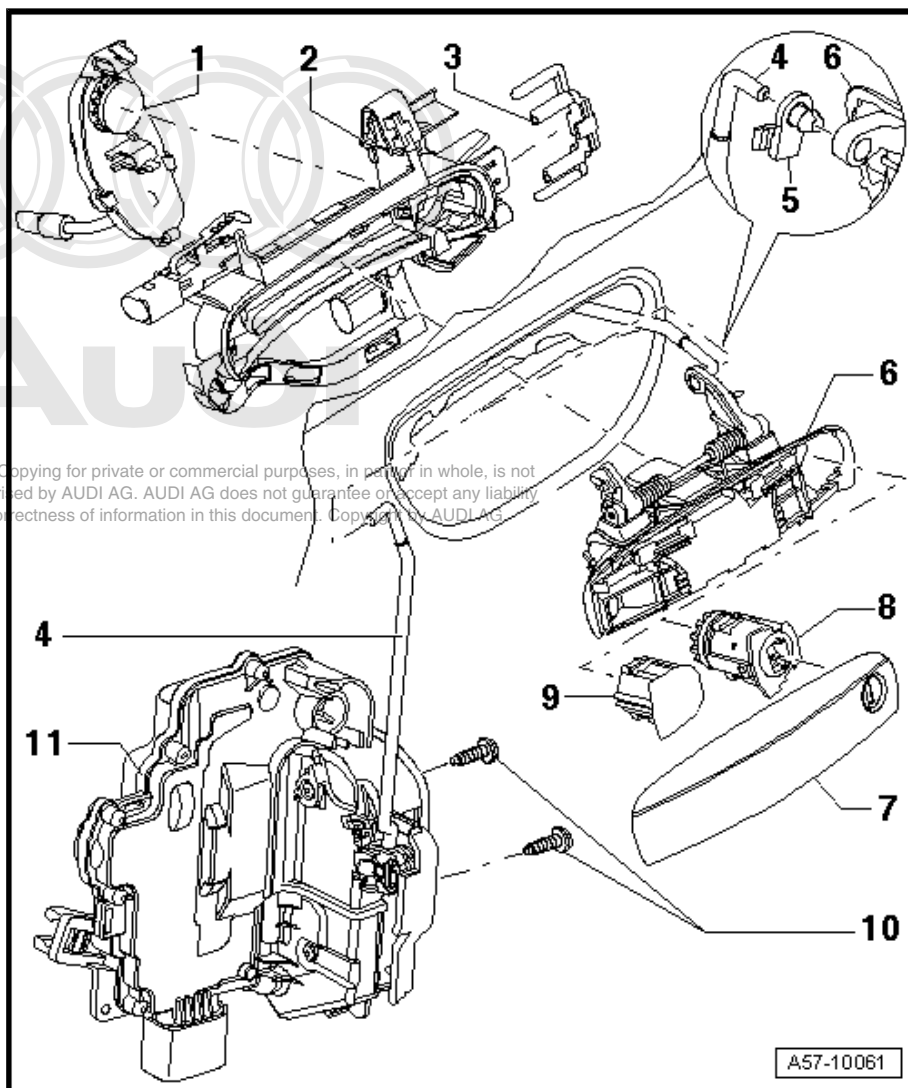
- ☐ Fitted to all door handles without lock cylinder

10 - Multi-point socket head bolt

- ☐ 20 Nm

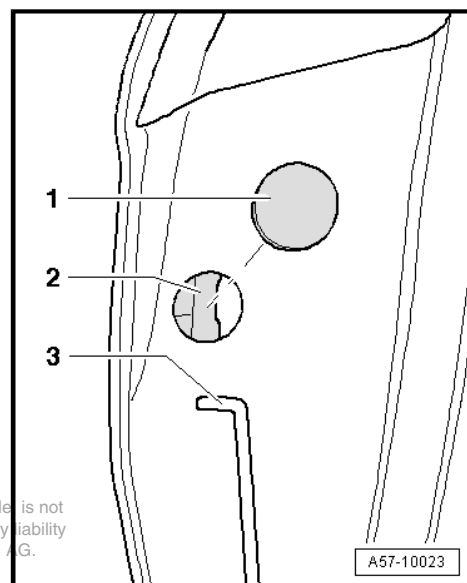
11 - Door lock

- ☐ Removing:
- ☐ Door trim removed
- ☐ Window frame and window regulator removed ⇒ [page 52](#)
- ☐ To remove, unscrew multi-point socket head bolts -10- and take door lock out downwards.

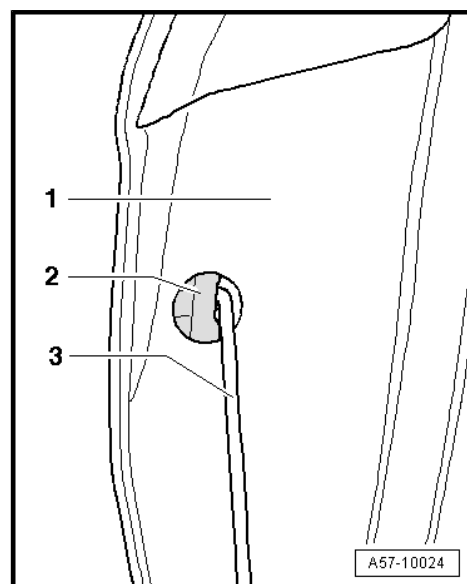


Removing lock cylinder

- Make a small hook -3-, e.g. from welding wire.
- Prise out cap -1-.
- Item -2- shows slide in installation position.
- Using hook -3-, reach through aperture in door -1- behind slide -2-.



- Pull out slide to release lock cylinder.
- Pull lock cylinder out of door handle.



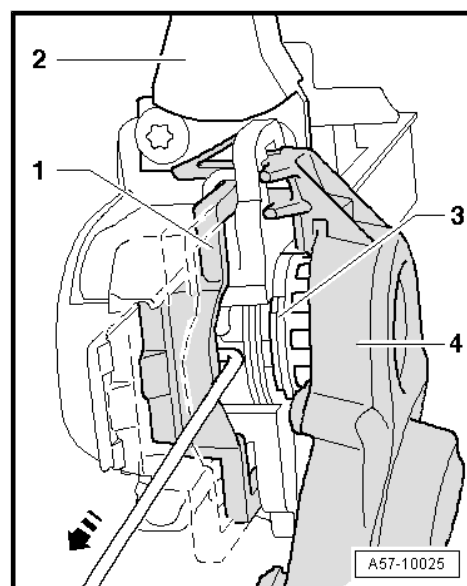
Releasing slide



Note

For greater clarity, illustration shows door handle removed.

- Using hook, reach behind slide -1- and pull it out in -direction of arrow-.
- Dotted line in diagram shows slide when released.
- This will release lock cylinder -3- in door handle.
- Lock cylinder can now be removed from door handle -2-.
- Transmission module -4- is clipped into door handle.



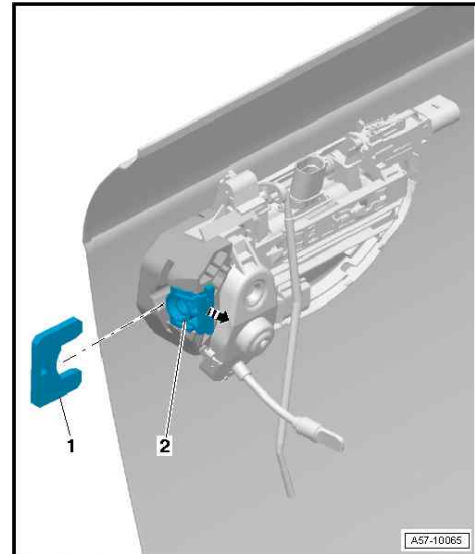
Note

From model year 2005 onwards, an additional cover with a locking mechanism -2- is fitted; this must be loosened first.

Push the locking mechanism -2- in the direction of the arrow towards the centre of the vehicle, e.g. using a screwdriver.

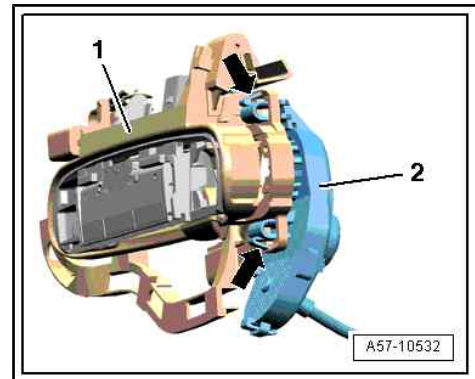
Use hook (see above) to reach into hole on slide -1- and pull slide out as far as stop.

Pull lock cylinder out of door handle.



Removing transmission module

- Door handle and mounting bracket removed
- Compress clips -arrows- and pull transmission module -2- out of mounting bracket -1-.



1.12 Removing door handle



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1 - Door handle

- ❑ Before detaching, remove lock cylinder
⇒ [page 69](#) or cover and trim for door handle
⇒ [page 73](#).

2 - Clip

- ❑ When dismantling door handle -1-, disengage operating rod -3- at clip.

3 - Operating rod

- ❑ Before removing door handle, disengage operating rod at clip -2-.
- ❑ After fitting new door lock, first insert operating rod in slide of release lever -4- and engage in retaining hook -5-.

4 - Release lever

- ❑ To lock operating rod -3-, engage locking element in direction of -arrow- in retaining hook -5- for release lever
⇒ [page 71](#).

5 - Retaining hook

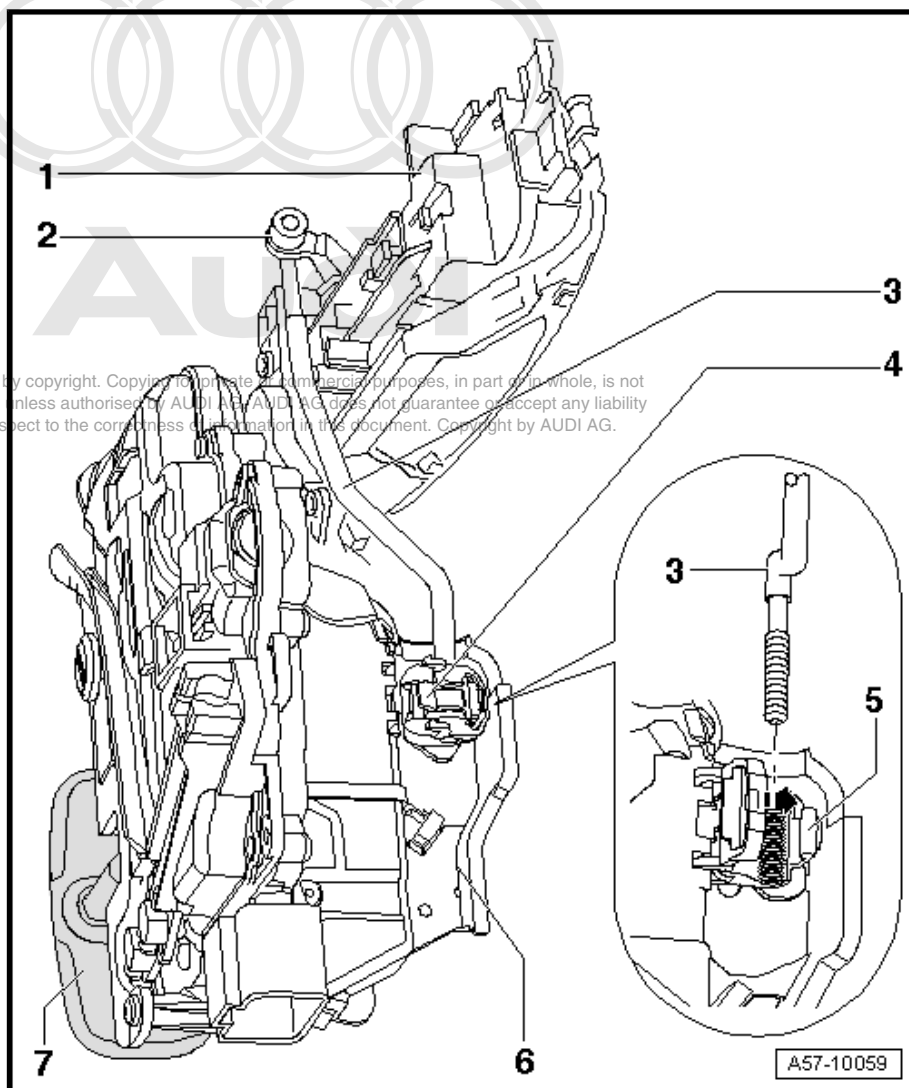
- ❑ Locking element for release lever must engage properly in retaining hook.

6 - Door lock

- ❑ Removing ⇒ [page 73](#)

7 - Striker

- ❑ Adjusting ⇒ [page 67](#)



Engaging operating rod in door lock

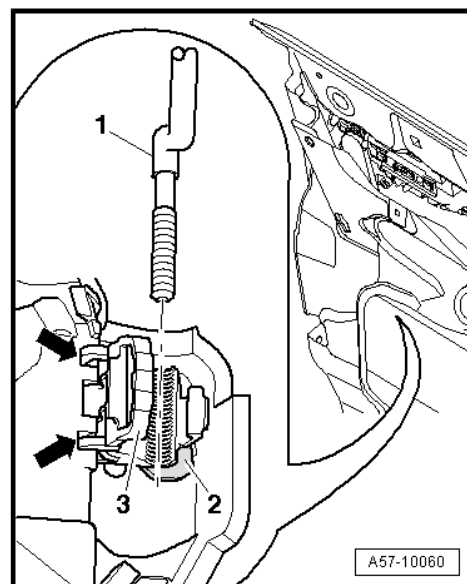
- To install a new door lock, clip operating rod -1- into release lever -2-.
- To lock operating rod, fold over locking element -3- until it engages in release lever mounting.
- To remove door lock, release locking element and engage in recesses at door lock -arrows-.
- Clip in operating rod in this position only.

Removing cover for door lock



Note

Cover is fitted only on side of vehicle with door lock.

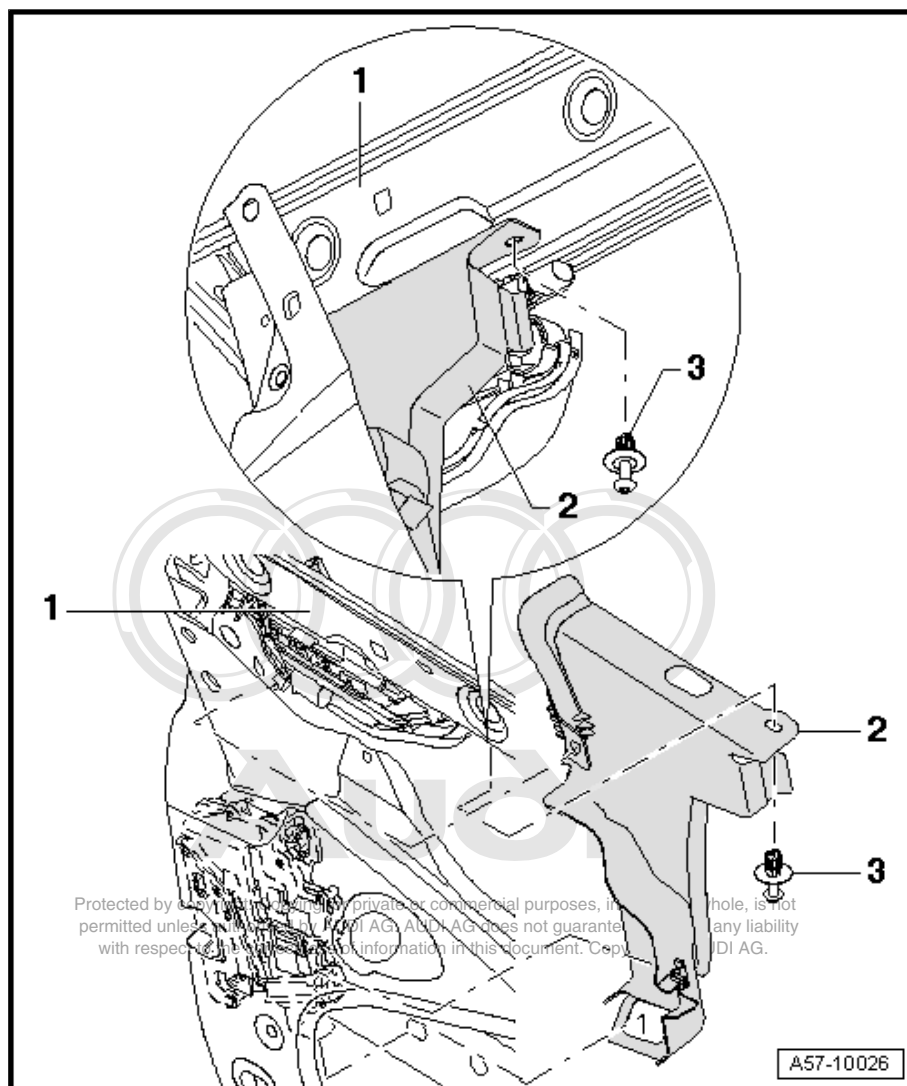


1 - Front door

2 - Cover for door lock

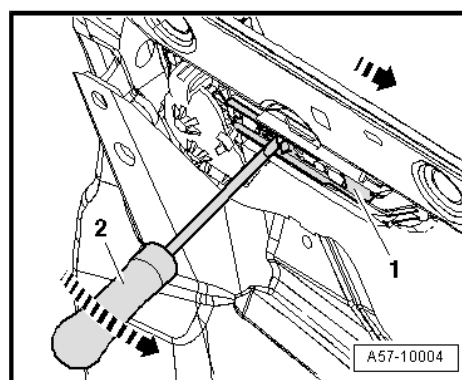
- ☐ Window frame removed
- ☐ Release pin from spreader rivet -3- and pull spreader rivet out of door.
- ☐ Unplug electrical connector to door lock.
- ☐ Unclip cover from door towards side.
- ☐ Pull cover downwards over connector at door lock.

3 - Spreader rivet



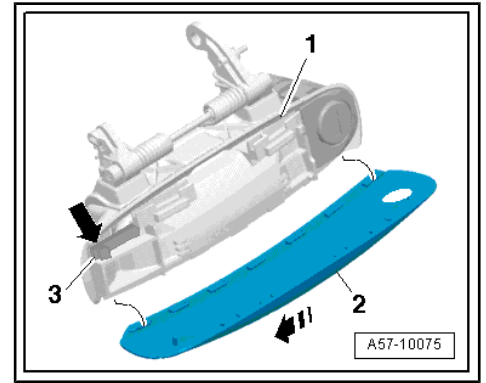
Releasing door handle mounting

- Door trim, window frame and window regulator removed
- Insert screwdriver -2- through door panel and release slide -1- from door handle in direction of arrow.



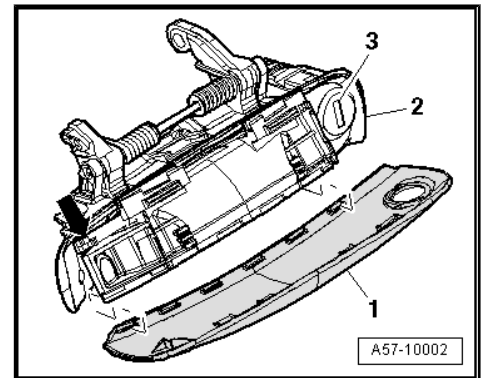
Removing trim panel

- To remove, pull up door handle -1- and use a small screwdriver to release locking element -3-.
- Push trim panel -2- slightly towards front of vehicle, disengage at top to one side and detach from door handle.
- Install in reverse order.



Catch for handle trim

- When installing, locking element -arrow- on door handle -2- must engage in trim panel -1-.



1.13 Removing door lock

Exploded view



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1 - Multi-point socket head bolt M8

- ❑ 20 Nm

2 - Front door

3 - Support

4 - Door lock

- ❑ Door trim removed
- ❑ Window frame and window regulator removed
- ❑ First, remove cover on driver's side ⇒ [page 71](#).
- ❑ Unplug electrical connector at door lock.
- ❑ Release locking element from door lock at release lever and unclip operating rod ⇒ [page 71](#).
- ❑ Unscrew multi-point bolts -1- and take out door lock.

5 - Shaft

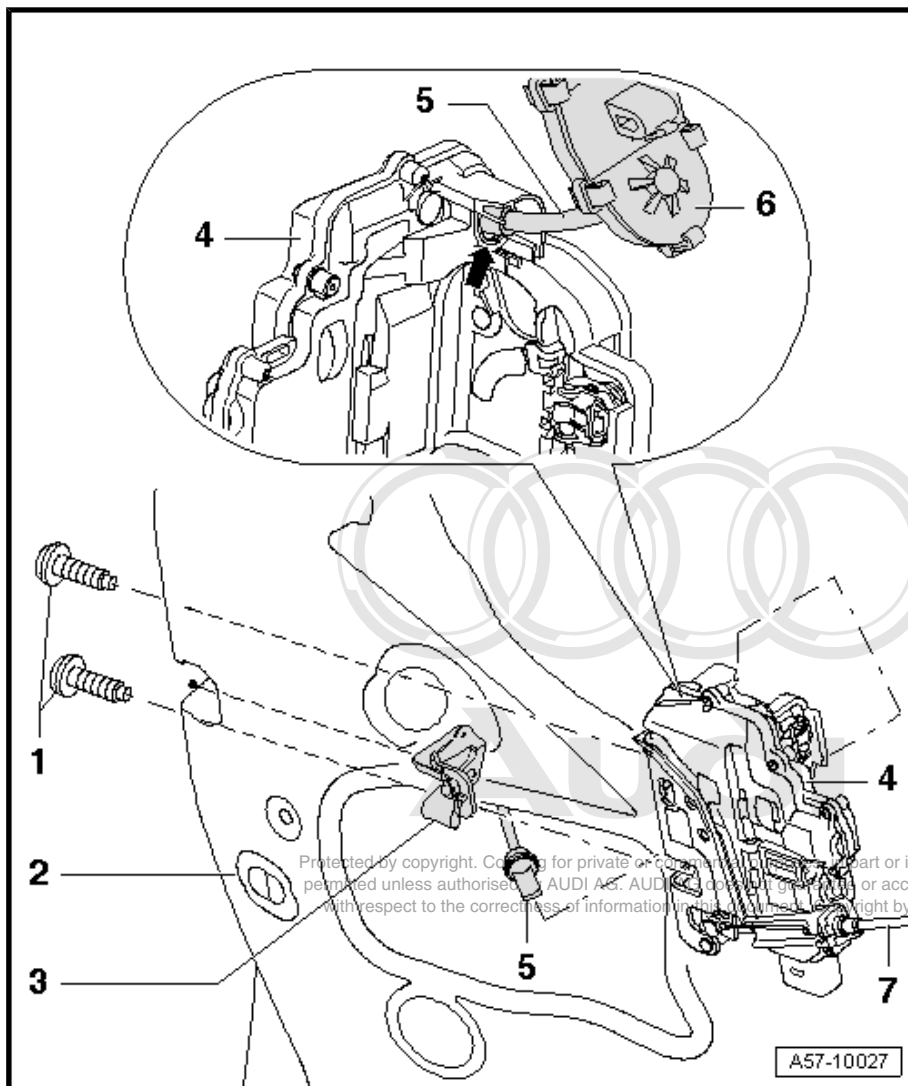
- ❑ To install, insert "paddle" of shaft in groove of door lock -arrow- as shown.

6 - Transmission module

- ❑ Clipped into door handle
- ❑ Fitted on driver's side only.
- ❑ Removing ⇒ [page 70](#)

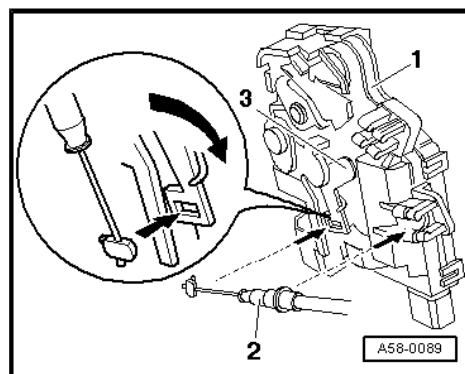
7 - Bowden cable for interior door handle

- ❑ To install, first insert vertically in release lever as illustrated in detail view, then swivel 90° and clip into door lock to secure.



Engaging Bowden cable in door lock

- To install, first insert Bowden cable -2- vertically into release lever -3- as shown in detail view, then swivel 90° and clip into door lock -1- to secure.



2 Security door (front)

2.1 Exploded view - window frame, door window, front door

1 - Bolt

- ☐ 2x
- ☐ 3 Nm

2 - Window regulator

- ☐ Removing and installing
⇒ [page 79](#)
- ☐ Only available together
with window regulator
motor -item 21-

3 - Door shell

4 - Nut

- ☐ 2x
- ☐ 8 Nm

5 - Bolt

- ☐ 3x
- ☐ Hand-tight

6 - Bolt

- ☐ 2x
- ☐ 18 Nm

7 - Bolt

- ☐ 18 Nm

8 - Window frame

- ☐ Removing and installing
⇒ [page 79](#)

9 - Door window

- ☐ Removing and installing
⇒ [page 81](#)

10 - Bolt

- ☐ 2x
- ☐ 8 Nm

11 - Retaining rubber

12 - Window lifter rail

- ☐ For door window
- ☐ Removing and installing ⇒ ["2.4 Removing and installing window regulator", page 79](#)

13 - Door hinge (top)

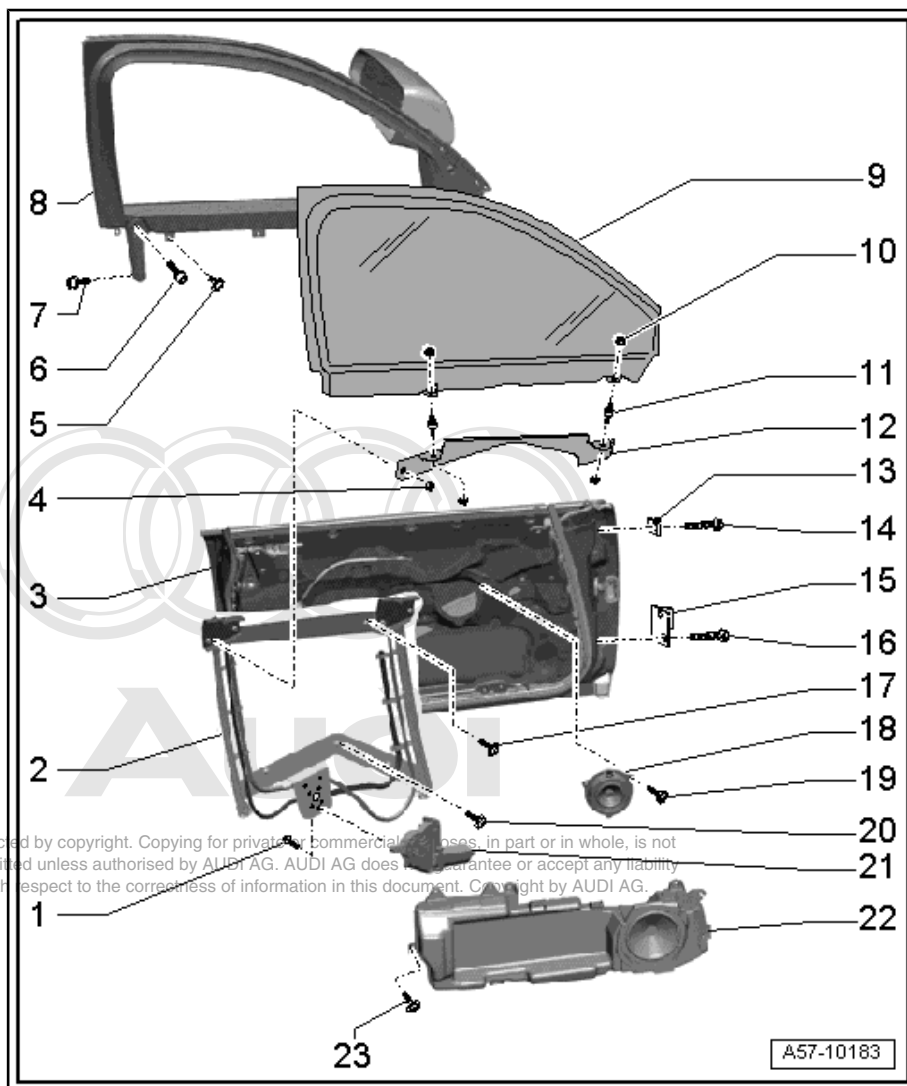
14 - Bolt

- ☐ 48 Nm

15 - Door hinge (bottom)

16 - Bolt

- ☐ 2x
- ☐ 48 Nm





17 - Bolt

- ☐ 3x
- ☐ 12 Nm

18 - Mid-range/treble loudspeaker (front)

19 - Bolt

- ☐ 3x
- ☐ 2 Nm

20 - Bolt

- ☐ 3x
- ☐ 12 Nm

21 - Window regulator motor

- ☐ Removing and installing ⇒ [page 82](#)
- ☐ Only available together with window regulator -item 2-

22 - Bass loudspeaker (front)

23 - Bolt

- ☐ 6x
- ☐ 2 Nm



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2.2 Exploded view - reinforcements for front door

1 - Bolt

- ☐ 12 Nm

2 - Reinforcement for door anchorage (rear)

- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 83](#)

3 - Rear reinforcement for front door

- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 83](#)

4 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid [⇒ Parts catalogue](#)
- ☐ 12 Nm

5 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid [⇒ Parts catalogue](#)
- ☐ 12 Nm

6 - Cover for grip moulding

- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 82](#)

7 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid [⇒ Parts catalogue](#)
- ☐ 12 Nm

8 - Front reinforcement for front door

- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 85](#)

9 - Bolt

- ☐ 12 Nm

10 - Reinforcement for door anchorage

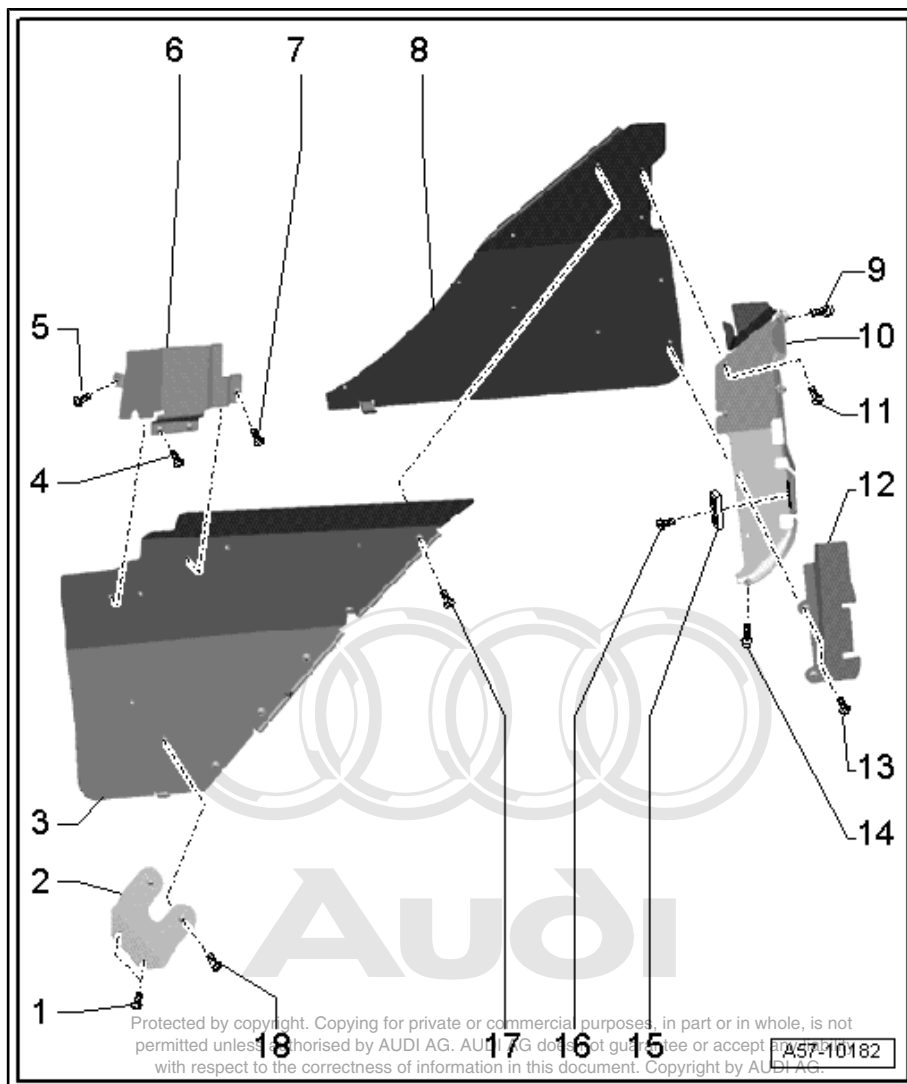
- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 86](#)

11 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid [⇒ Parts catalogue](#)
- ☐ 12 Nm

12 - Reinforcement for hinge cover

- ☐ Order of removal [⇒ page 78](#)
- ☐ Removing and installing [⇒ page 85](#)



13 - Bolt

- ☐ 12 Nm

14 - Bolt

- ☐ 12 Nm

15 - Threaded plate

- ☐ For adjusting bottom door hinge

16 - Bolt

- ☐ 10 Nm

17 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

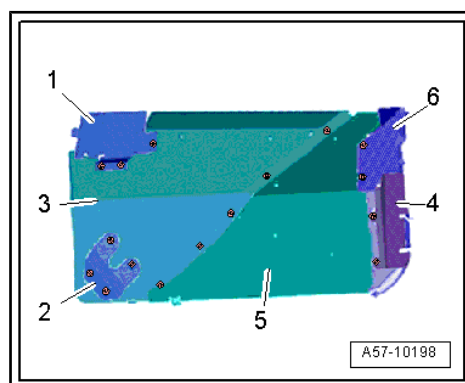
18 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

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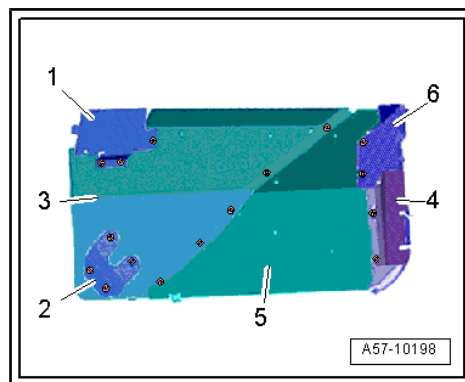
Order of removal of reinforcements

- 1 - Cover for grip moulding
- 2 - Reinforcement for door anchorage (rear)
- 3 - Rear reinforcement for front door
- 4 - Reinforcement for hinge cover
- 5 - Front reinforcement for front door
- 6 - Reinforcement for door anchorage



Tightening sequence for reinforcements

- 6 - Reinforcement for door anchorage
- 1 - Cover for grip moulding
- 2 - Reinforcement for door anchorage (rear)
- 3 - Rear reinforcement for front door
- 5 - Front reinforcement for front door
- 4 - Reinforcement for hinge cover



2.3 Removing and installing window frame

Removing

- Lower door window as far as it will go.
- Remove door trim ⇒ Rep. gr. 70 .
- Detach insulating mat -1- at upper section of door frame.
- Pull door seal -2- out of groove on door frame.
- Release cover -3- for exterior mirror in direction of -arrow-.
- Unplug electrical connector at door control unit -4- and at microphone -6- for exterior mirror.
- Press grommet -5- for wiring harness out of door frame.
- Detach rubber cover -1- on door lock side.



Note

To facilitate removal, you can use a silicone-free lubricant spray.

- Remove bolts -arrows A-.
- Mark bolts -arrows B- for re-installation. Remove bolts.



Caution

Make sure inside of door window is not damaged.

- Carefully pull window frame -2- upwards out of door frame and simultaneously guide out wiring harness for exterior mirror through opening in door frame.

Installing

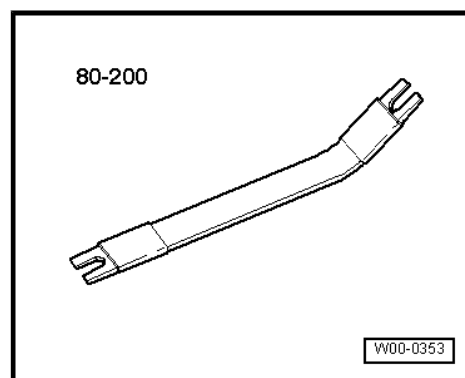
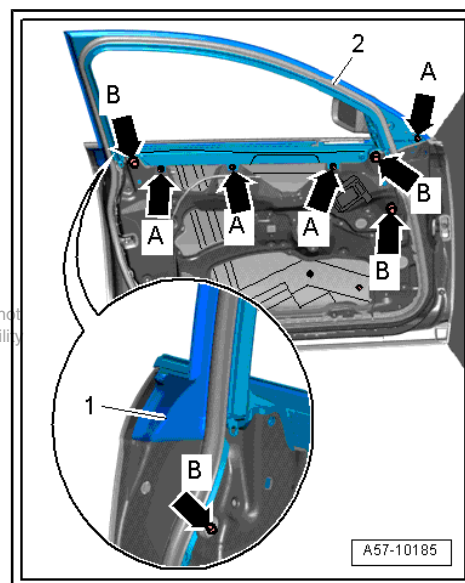
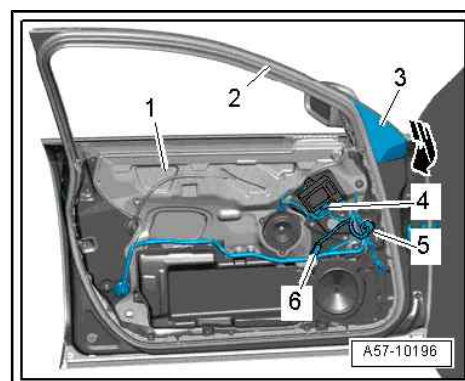
Install in reverse order of removal.

- Tightening torque ⇒ [page 75](#)

2.4 Removing and installing window regulator

Special tools and workshop equipment required

- ◆ Removal lever - 80 - 200-



Removing

- Remove window frame ⇒ [page 79](#) .
- Remove door window ⇒ [page 81](#) .
- Use removal lever - 80 - 200- to move wiring harness -2- clear.



Note

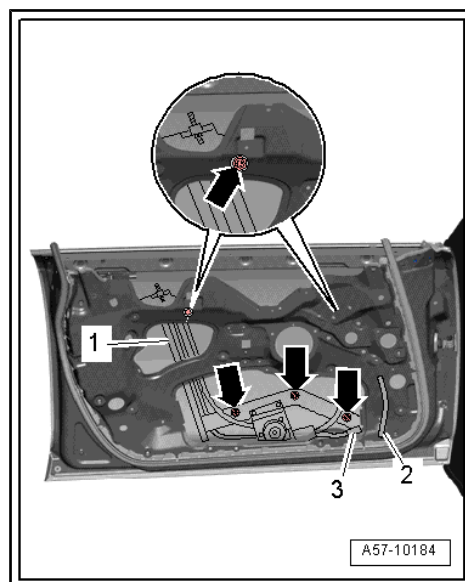
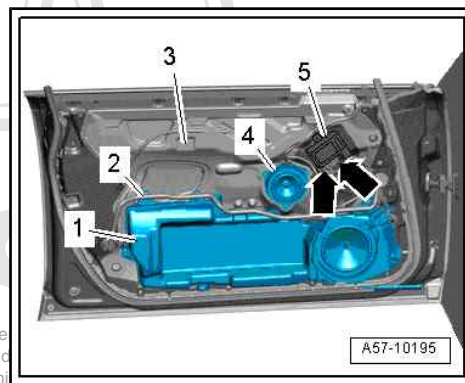
To facilitate removal, you can use a silicone-free lubricant spray.

- Remove front bass loudspeaker -1- ⇒ Rep. gr. 91.
- Remove front mid-range/treble loudspeaker -4- ⇒ Rep. gr. 91 .
- Remove insulating mat -3-.
- Unplug electrical connectors -arrows- and remove door control unit -5-.
- Press grommet -2- for wiring harness out of door frame.
- Disengage wiring harness from retaining clip -3-.
- Remove bolts -arrows-.
- Guide wiring harness for window regulator motor through opening in door frame.
- Lift out window regulator -1-.

Installing

Install in reverse order of removal.

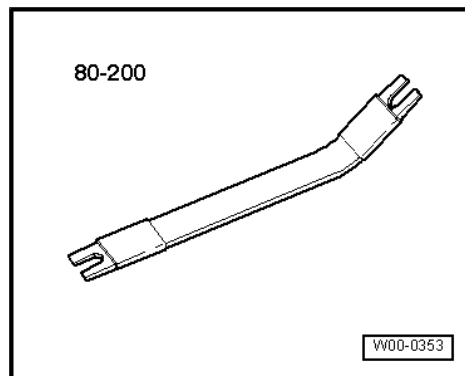
- Tightening torque ⇒ [page 75](#)



2.5 Removing and installing exterior mirror

Special tools and workshop equipment required

- ◆ Removal lever - 80 - 200-



Removing

- Remove window frame ➔ [page 79](#) .
- Use removal lever - 80 - 200- to release wiring harness -3- at window frame.



Note

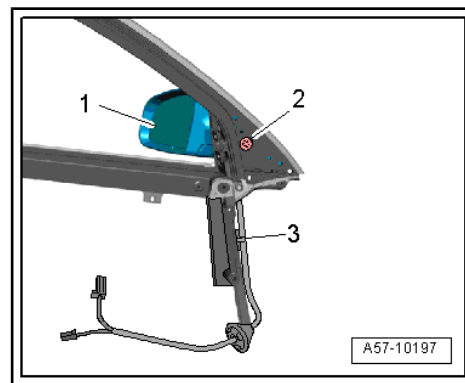
To facilitate removal, you can use a silicone-free lubricant spray.

- Remove bolt -2-.
- Detach exterior mirror -1- from window frame.

Installing

Install in reverse order of removal.

- Tightening torque ➔ [page 75](#)



2.6 Removing and installing door window

Removing

- Remove window frame ➔ [page 79](#) .
- Plug electrical connectors of door wiring harness and door trim into door control unit.



Caution

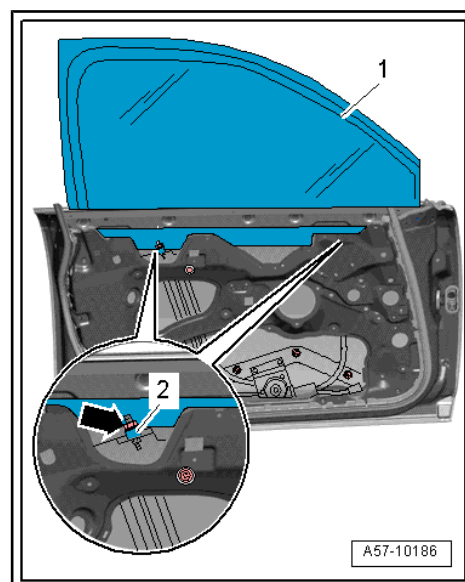
A second mechanic is required to guide and hold the door window.

- Raise door window as far as it will go.
- Remove nuts -arrow- at damping elements -2-.
- Set down door window -1- with outside resting on a soft surface.



Caution

Make sure inside of door window is not damaged.



Installing

Install in reverse order of removal.

- Tightening torque ➔ [page 75](#)

2.7 Removing and installing window regulator motor

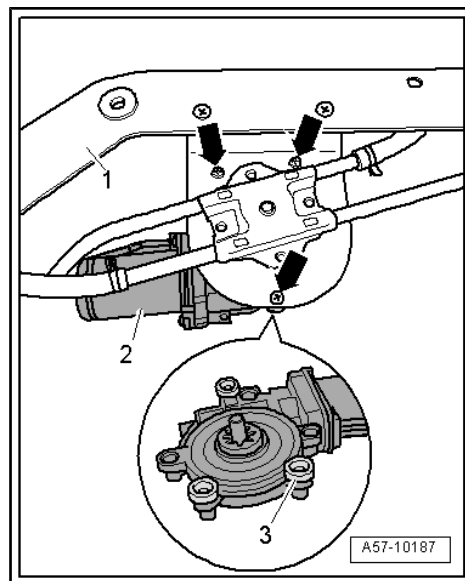
Removing

- Remove window regulator ⇒ [page 79](#) .
- Remove bolts -arrows-.
- Detach motor -2- for window regulator from window regulator -1-.

Installing

Installation is carried out in reverse order; note the following

- Make sure that spacer sleeves -3- are attached to window regulator motor.
- Tightening torque ⇒ [page 75](#)



2.8 Removing and installing cover for grip moulding

Removing

- Remove window regulator ⇒ [page 79](#) .
- Remove bolts -arrows-.
- Lift out cover for grip moulding -2-.



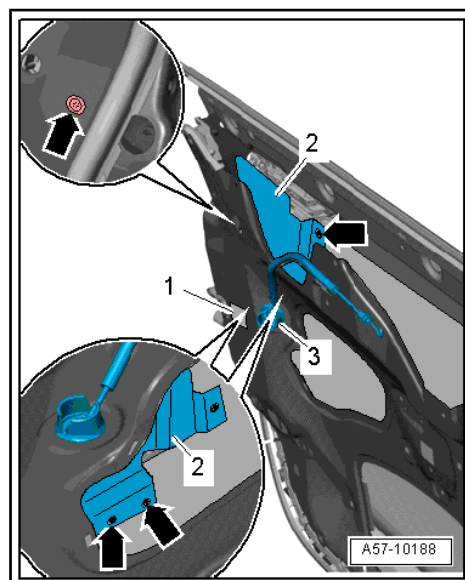
Note

The bottom bolts can be accessed via openings -1- and -3- (press in cable grommet).

Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tightening torque ⇒ [page 77](#)



2.9 Removing and installing reinforcement for door anchorage (rear)

Removing

- Remove window regulator ⇒ [page 79](#) .
- Remove bolts -arrows- and take out reinforcement for door anchorage (rear) -1-.

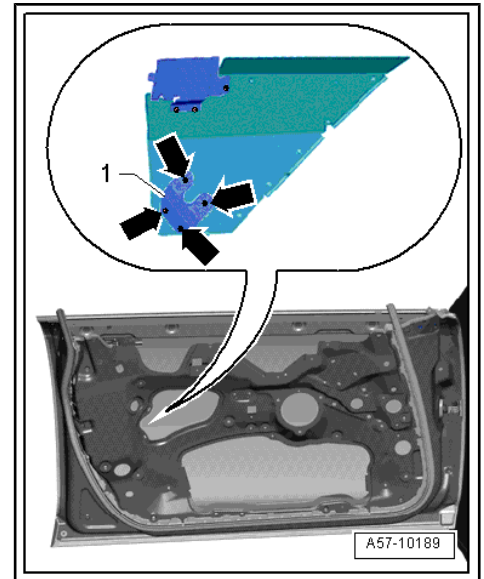
Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.

- Tightening torque ⇒ [page 77](#)

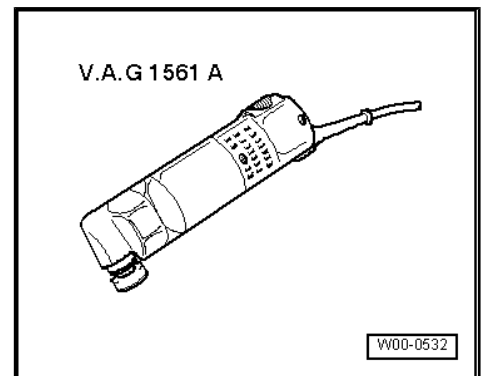
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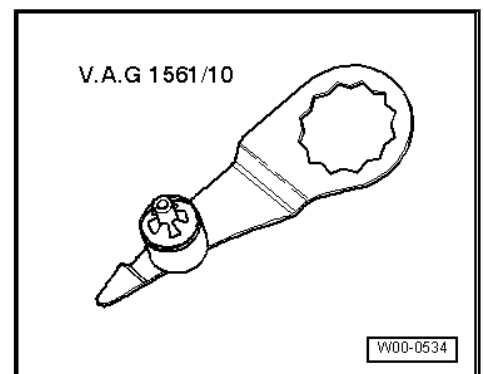
2.10 Removing and installing rear reinforcement for front door

Special tools and workshop equipment required

- ◆ Electric cutter - V.A.G 1561 A-



- ◆ Blade (offset) - V.A.G 1561/10-



- ◆ 1-component window adhesive - DH 009 100 03-

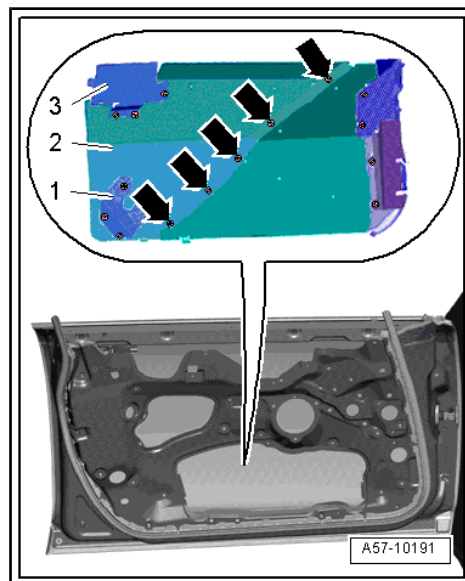
Removing

- Remove cover -3- for grip moulding ⇒ [page 82](#) .
- Remove reinforcement -1- for rear door anchorage ⇒ [page 83](#) .
- Cut through adhesive bead using a sharp knife.
- Remove bolts -arrows-.
- Swivel rear reinforcement -2- for front door upwards at front edge.
- Lift out rear reinforcement for front door.



Note

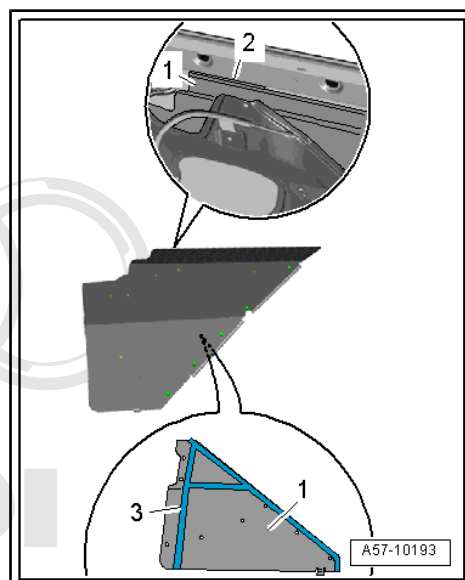
Make sure that exterior door handle is not damaged when lifting out rear reinforcement for front door.



Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Check foam strips -3- for damage and renew if necessary.
- Use electric cutter - V.A.G 1561 A- and blade, offset - V.A.G 1561/10- to cut back rest of adhesive sealant on rear reinforcement for front door and door frame. However, do not remove sealant completely.
- Insert rear reinforcement -1- for front door.
- Keep bonding areas free of dirt and grease.
- Apply 1-component window adhesive - DH 009 100 03- -item 2- all round as shown.
- Tightening torque ⇒ [page 77](#)



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2.11 Removing and installing reinforcement for hinge cover

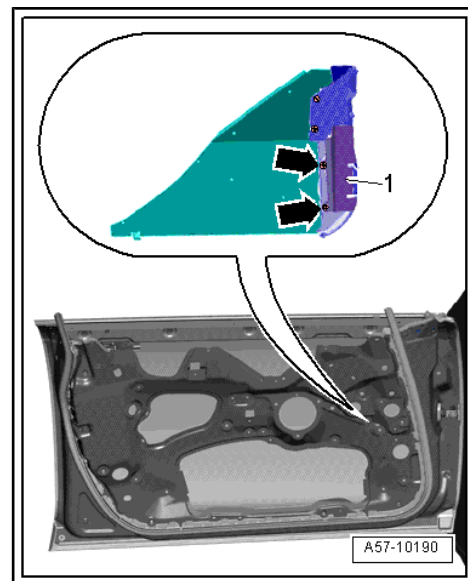
Removing

- Remove window regulator ⇒ [page 79](#) .
- Remove bolts -arrows-.
- Detach reinforcement -1- for hinge cover.

Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tightening torque ⇒ [page 77](#)

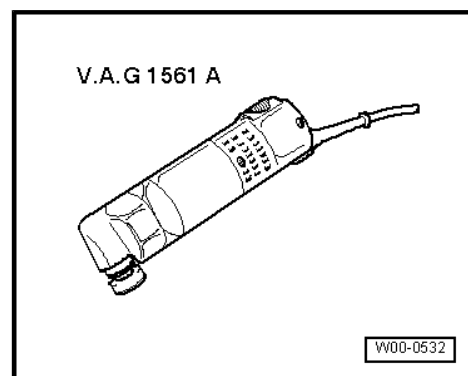


2.12 Removing and installing front reinforcement for front door

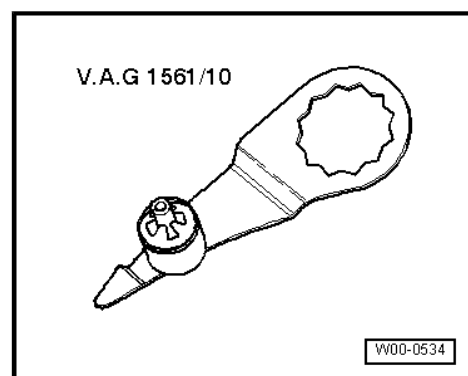
Special tools and workshop equipment required

- ◆ Electric cutter - V.A.G 1561 A-

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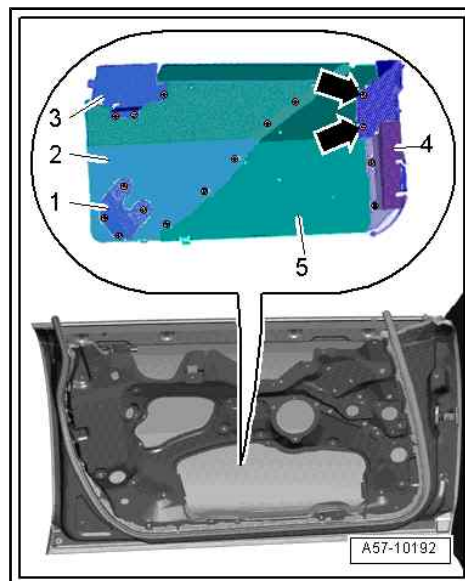
- ◆ Blade (offset) - V.A.G 1561/10-



- ◆ 1-component window adhesive - DH 009 100 03-

Removing

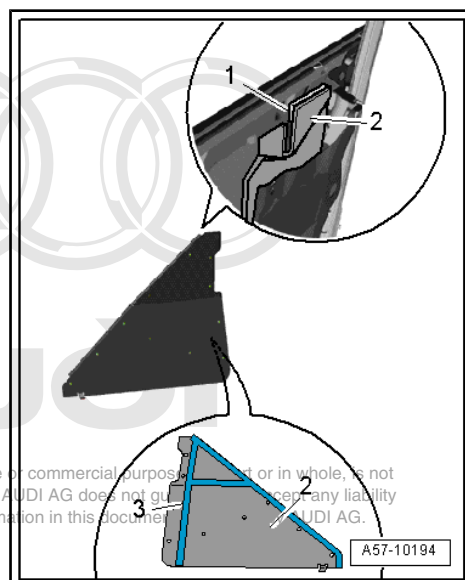
- Remove reinforcement -2- for rear door anchorage
⇒ [page 83](#) .
- Remove reinforcement -4- for hinge cover ⇒ [page 85](#) .
- Cut through adhesive bead using a sharp knife.
- Remove bolts -arrows-.
- Lift out front reinforcement -5- for front door.



Installing

Installation is carried out in reverse order; note the following:

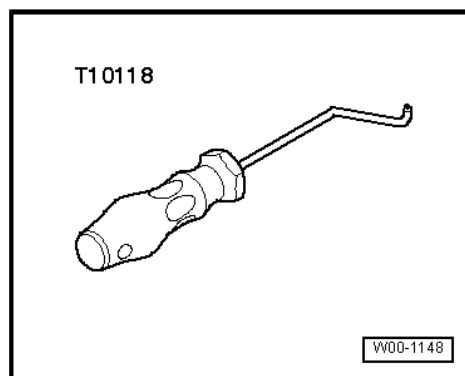
- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Check foam strips -3- for damage and renew if necessary.
- Use electric cutter - V.A.G 1561 A- and blade, offset - V.A.G 1561/10- to cut back rest of adhesive sealant on rear reinforcement for front door and door frame. However, do not remove sealant completely.
- Insert front reinforcement -2- for front door.
- Keep bonding areas free of dirt and grease.
- Apply 1-component window adhesive - DH 009 100 03-
-item 1- all round as shown.
- Tightening torque ⇒ [page 77](#)



2.13 Removing and installing reinforcement for door anchorage

Special tools and workshop equipment required

- ◆ Assembly tool - T10118-



Removing

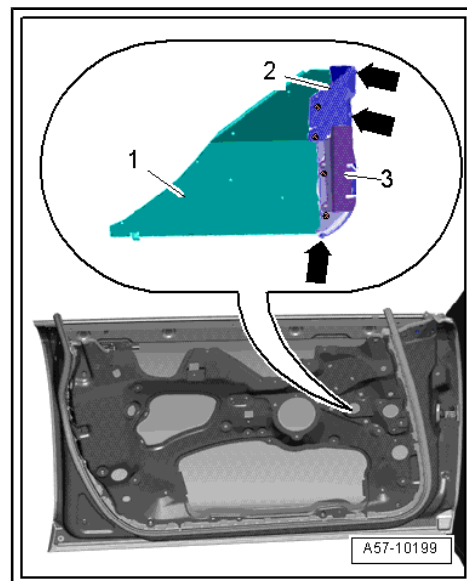
- Remove reinforcement -3- for hinge cover ⇒ [page 85](#) .
- Remove front reinforcement -1- for front door ⇒ [page 85](#) .
- Remove front door ⇒ Rep. gr. 57 .



Note

Before removal, slacken remaining bolts at door hinges.

- Remove door hinges (top and bottom) ⇒ Rep. gr. 57 .
- Remove bolts -arrows-.
- Remove bolts at door lock ⇒ Rep. gr. 57 .
- Pull exterior door handle and use assembly tool - T10118- to unplug electrical connectors at door lock and exterior door handle.
- Move door wiring harness clear.
- Guide door wiring harness through reinforcement for door anchorage and lift out reinforcement -2- for door anchorage.



Installing

Installation is carried out in reverse order; note the following:

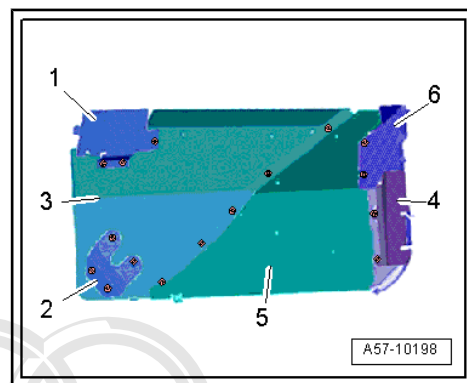
- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tighten bolts on reinforcement for door anchorage.



Note

Before tightening bolts, all reinforcements and cover must be attached loosely.

- Tighten bolts on reinforcements ⇒ [page 78](#) .
- Tightening torque ⇒ [page 77](#)



3 Central locking system

Overview of components - saloon

1 - Front passenger door control unit - J387-

- ❑ Removing and installing
⇒ [page 90](#)

2 - Rear right door control unit - J389-

- ❑ Removing and installing
⇒ [page 90](#)

3 - Tank filler flap locking motor - V155-

- ❑ Removing ⇒ [page 90](#)

4 - Convenience system central control unit - J393-

- ❑ Fitting location: in side panel (rear right)
⇒ "3.1 Removing and installing convenience system central control unit J393", [page 91](#)

5 - Interface control unit for vehicle location system - J843-

- ❑ Removing ⇒ [page 90](#)

6 - Rear lid release motor - V139-

- ❑ Removing and installing
⇒ [page 34](#)

7 - Rear left door control unit - J388-

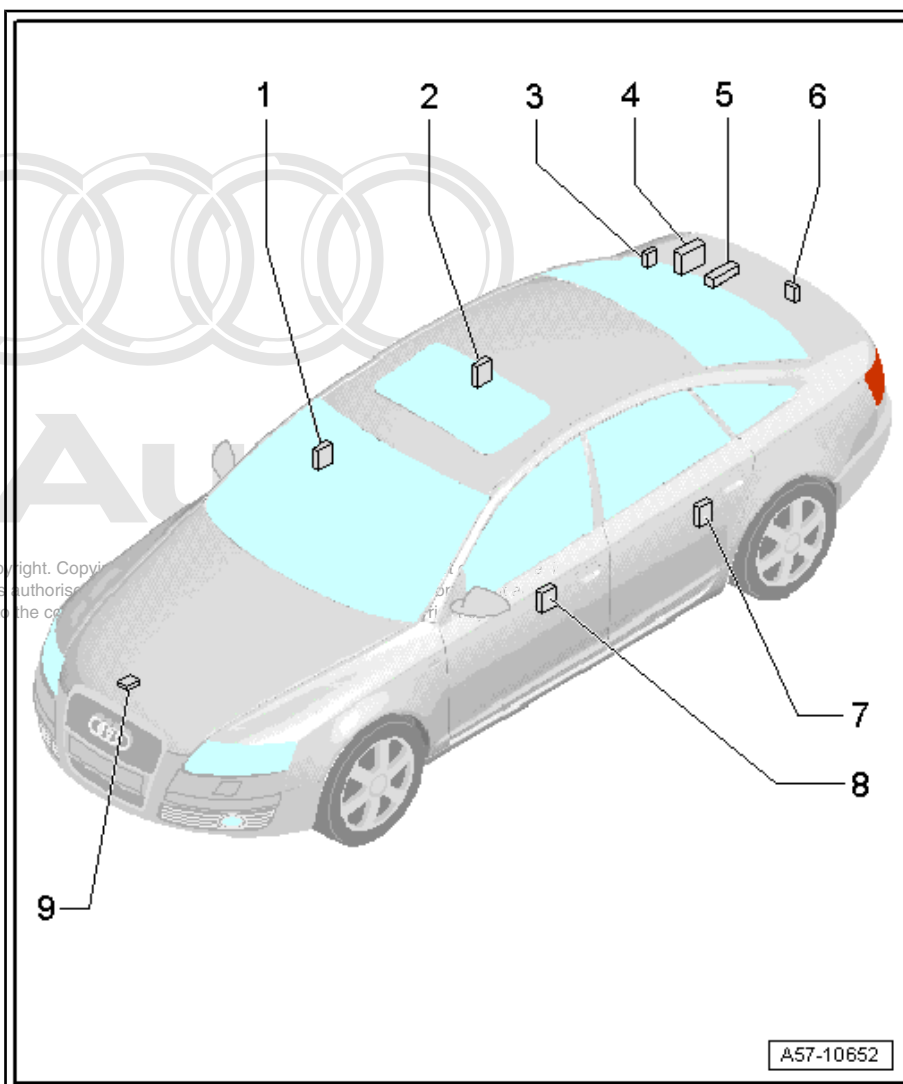
- ❑ Removing and installing
⇒ [page 90](#)

8 - Driver door control unit - J386-

- ❑ Removing and installing
⇒ [page 90](#)

9 - Bonnet contact switch - F266-

- ❑ Fitting location: in lock carrier



Overview of components - Avant

1 - Front passenger door control unit - J387-

- ❑ Removing and installing
⇒ [page 90](#)

2 - Rear right door control unit - J389-

- ❑ Removing and installing
⇒ [page 90](#)

3 - Tank filler flap locking motor - V155-

- ❑ Removing ⇒ [page 90](#)

4 - Convenience system central control unit - J393-

- ❑ Fitting location: In side panel (rear right)
- ❑ Removing and installing
⇒ [page 91](#)

5 - Interface control unit for vehicle location system - J843-

- ❑ Fitting location: In side panel (rear right)
- ❑ Removing ⇒ [page 90](#)

6 - Rear lid release motor - V139-

- ❑ Removing and installing
⇒ [page 34](#)

7 - Rear lid control unit 2 - J765-

- ❑ Procedure for removal and installation same as for rear lid control unit - J605-

8 - Rear lid control unit - J605-

- ❑ Removing and installing ⇒ [page 40](#)

9 - Rear left door control unit - J388-

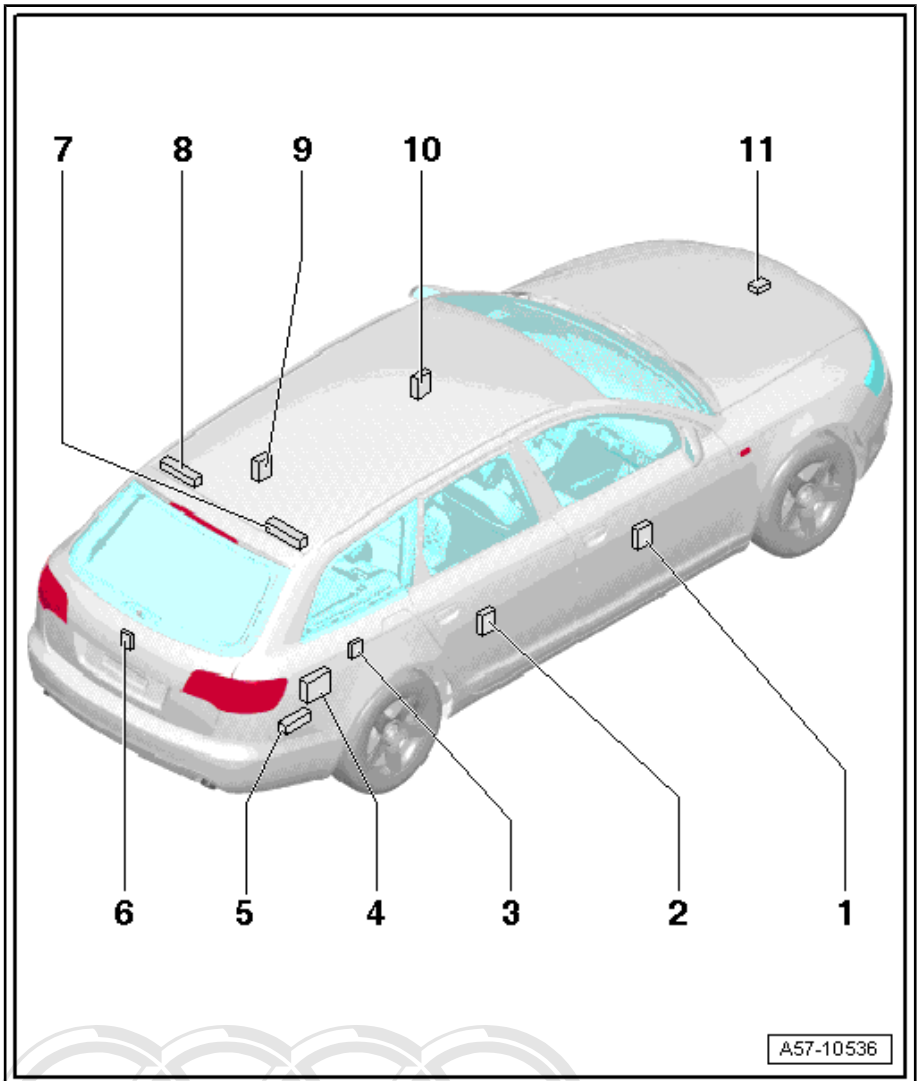
- ❑ Removing and installing ⇒ [page 90](#)

10 - Driver door control unit - J386-

- ❑ Removing and installing ⇒ [page 90](#)

11 - Bonnet contact switch - F266-

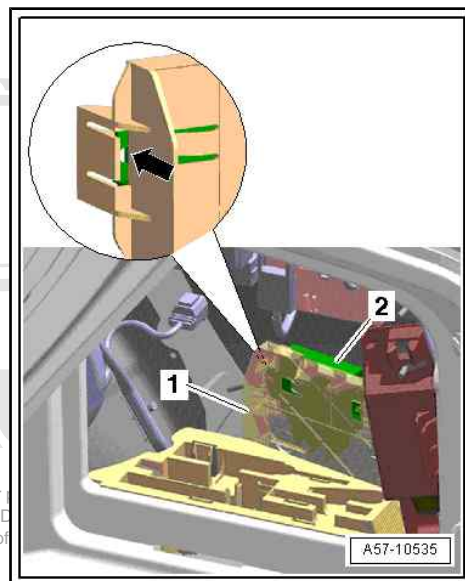
- ❑ Fitting location: in lock carrier



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Removing interface control unit for vehicle location system - J843-

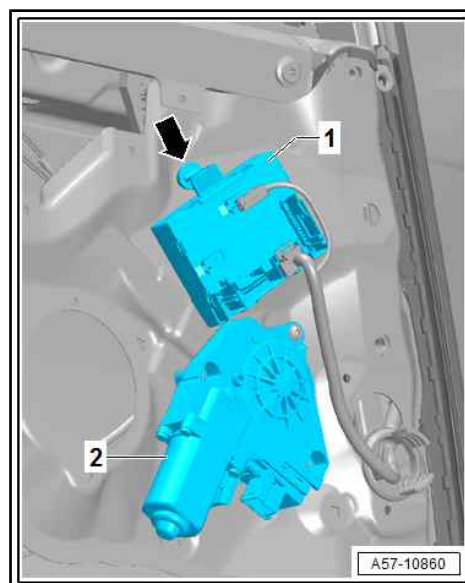
- Press retainers -arrow- on bracket -1- and take out interface control unit for vehicle location system - J843- -2- on rear of bracket.



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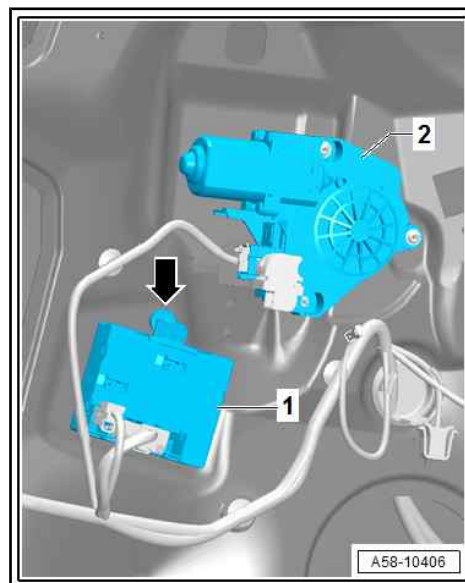
Removing and installing driver door control unit - J386- and front passenger door control unit - J387-

- Remove door trim (front) ⇒ General body repairs, interior; Rep. gr. 70 ; Door trim (front); Removing and installing door trim (front) .
- Window regulator motor -2-.
- Unplug electrical connectors from front passenger door control unit - J387- .
- Press retaining catch in direction of -arrow- and disengage door control unit -1- from door shell.
- To install, insert door control unit -1- in lower mounting points, swivel in at top and engage.



Removing and installing rear left door control unit - J388- and rear right door control unit - J389-

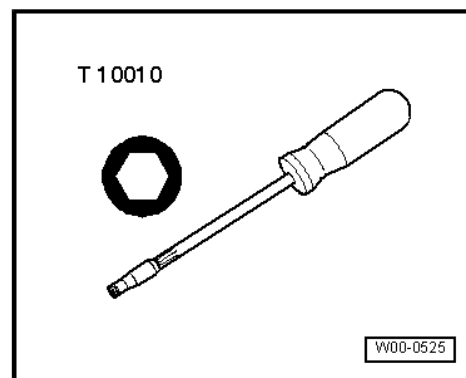
- Remove door trim (rear) ⇒ General body repairs, interior; Rep. gr. 70 ; Door trim (rear); Removing and installing door trim (rear) .
- Window regulator motor -2-.
- Unplug electrical connectors from rear left door control unit - J388- .
- Press retaining catch in direction of -arrow- and disengage door control unit -1- from door shell.
- To install, insert door control unit -1- in lower mounting points, swivel in at top and engage.



Removing tank filler flap locking motor - V155-

Special tools and workshop equipment required

◆ Hexagon socket screwdriver - T10010-



1 - Tank filler flap locking motor
- V155-

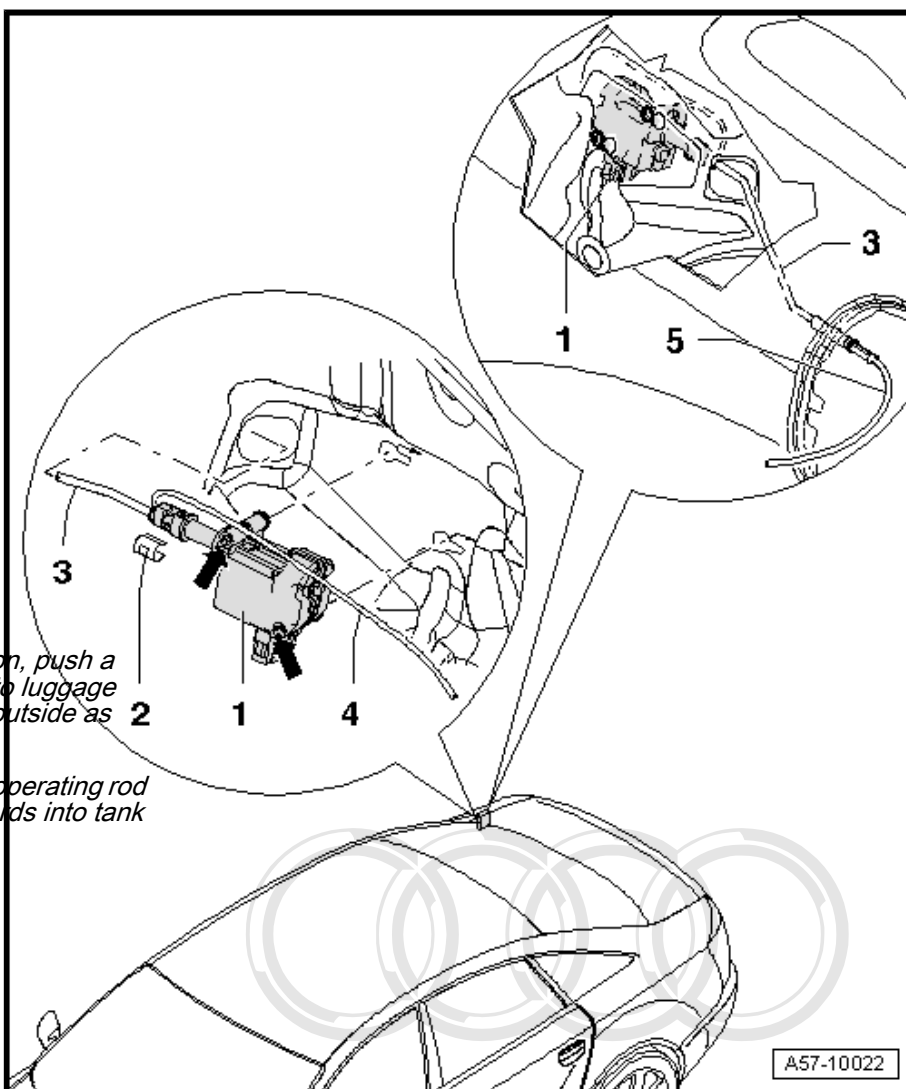
- Luggage compartment side trim (right-side) removed
- Unplug electrical connector for motor.
- Slacken bolts -arrow- in clockwise direction using hexagon socket screwdriver - T10010- and push motor -1- out of elongated holes.
- Before installing new motor, eye of manual release -4- must be pushed over locking pin.



Note

- ◆ *For easier installation, push a suitable hose -5- into luggage compartment from outside as auxiliary tool.*
- ◆ *Push hose -5- onto operating rod -4- and pull it outwards into tank cup.*

- Insert motor in elongated holes and tighten bolts to 1.5 Nm in anti-clockwise direction.



2 - Retaining clip

3 - Operating rod

4 - Cable for manual release

3.1 Removing and installing convenience system central control unit - J393-

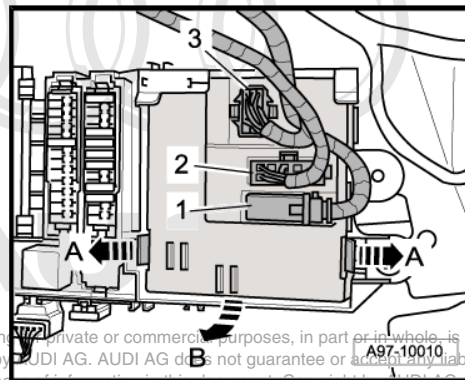
Fitting location: in luggage compartment (right-side)

Removing

- When control unit is renewed, select appropriate control unit in “Guided Functions” ⇒ Vehicle diagnostic tester.
- Switch off ignition and remove ignition key.
- Remove cover of luggage compartment side trim (right-side).
- Release retaining clips -arrows A- and pull convenience system central control unit - J393- downwards out of relay and fuse holder -arrow B-.
- Release retaining clip on connector -item 1- and unplug connector.
- Unplug electrical connectors -2- and -3-.

Installing

Install in reverse order of removal.



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3.2 Servicing central locking system

- The central locking system is an electrical system.
- The actuators in the doors are integrated in the lock and have 2 motors.
- The actuators cannot be renewed separately.
- The first motor locks the door, whereas the second motor locks the interior door handle (SAFE function = country-specific).
- The locked doors can no longer be opened from inside the car.
- On vehicles equipped with “advanced key”, the vehicle must be locked separately using the remote control after leaving the vehicle in order to activate the SAFE function.
- Alternatively, the SAFE function can be activated via buttons in the door handles.
- After an accident involving activation of the airbags, the central locking control unit will unlock any doors which are locked.
- Central locking system control unit is located in rear right side panel.

58 – Rear doors, door components

1 Rear door

1.1 Removing and installing door



Note

- ◆ For various assembly activities, the entire door can be lifted right out of its hinges after you have unplugged the electrical connections at the bottom of A-pillar / B-pillar.
- ◆ No adjustment work is required after fitting.

1 - Door panel

- Pull bellows out of B-pillar (bottom).
- Unplug electrical connectors at B-pillar (bottom).
- Loosen bolt -4- at door hinge (top).
- Unscrew lower bolt with washer -9- at door hinge (bottom).
- Pull cap off hinge pin.



Caution

Protect painted surfaces on front and rear doors against damage.

- Carefully lift the door up and off the hinges.

2 - Upper section of door hinge (top)

- ☐ Not available as separate part
- ☐ Remains bolted to door

3 - Lower section of door hinge (top)

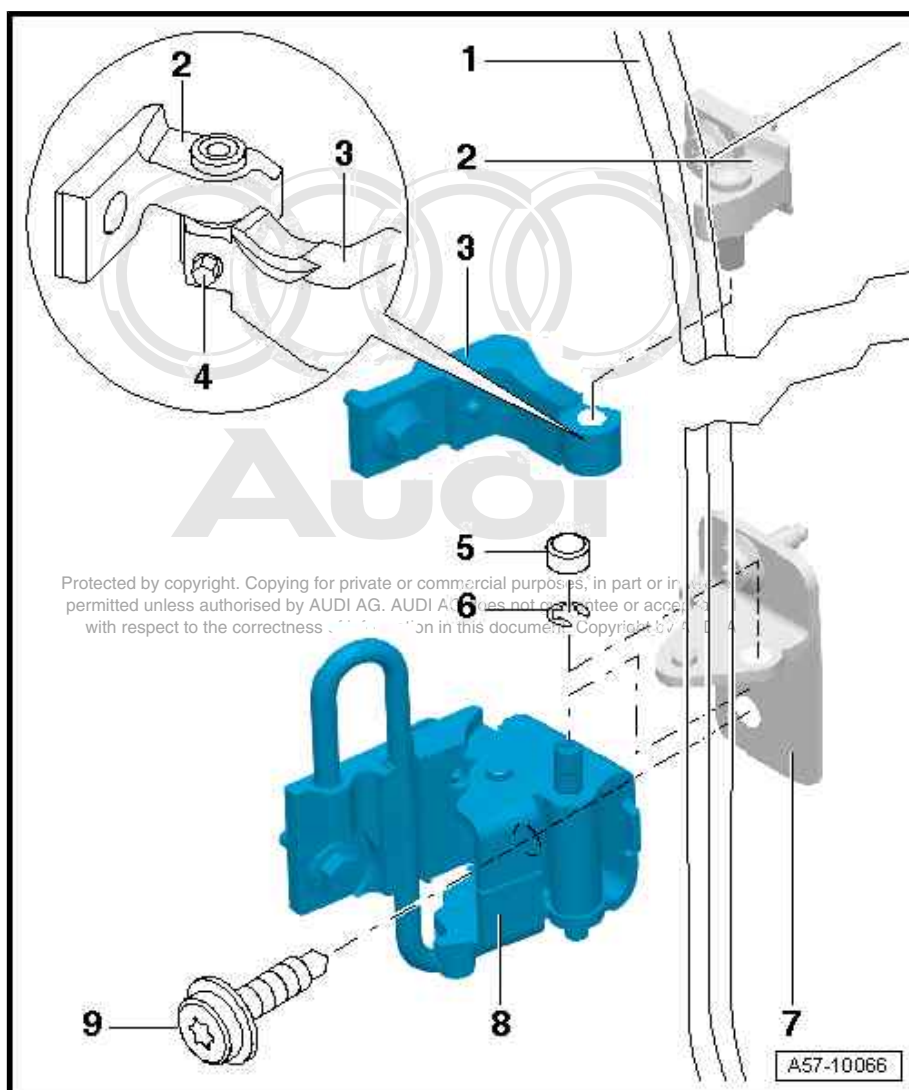
- ☐ Not available as separate part
- ☐ Remains bolted to B-pillar

4 - Locking bolt

- ☐ 25 Nm

5 - Cap

- ☐ Fit on pivot pin



A57-10066

6 - Retaining clip

- ☐ Only fitted on replacement part
- ☐ Pull off after fitting a new hinge.

7 - Upper section of door hinge (bottom)

- If necessary, slacken any tension between upper and lower section of door hinge (bottom) using a screwdriver.
- ☐ Not available as separate part
- ☐ Remains bolted to door

8 - Lower section of door hinge (bottom)

- ☐ Not available as separate part
- ☐ Remains bolted to B-pillar

9 - Bolt with washer

- ☐ 32 Nm

1.2 Removing and installing window frame and window regulator

1 - Window frame

Removing:

- ☐ Remove door trim. ⇒ Rep. gr. 70
- ☐ Remove window regulator motor.
- ☐ Unplug electrical connectors.
- ☐ Remove self-tapping screws -6- and flange bolts -7- and -8-.
- ☐ Remove fitted bolts -5- and flange bolts -3- and lift window frame with window regulator out of door.

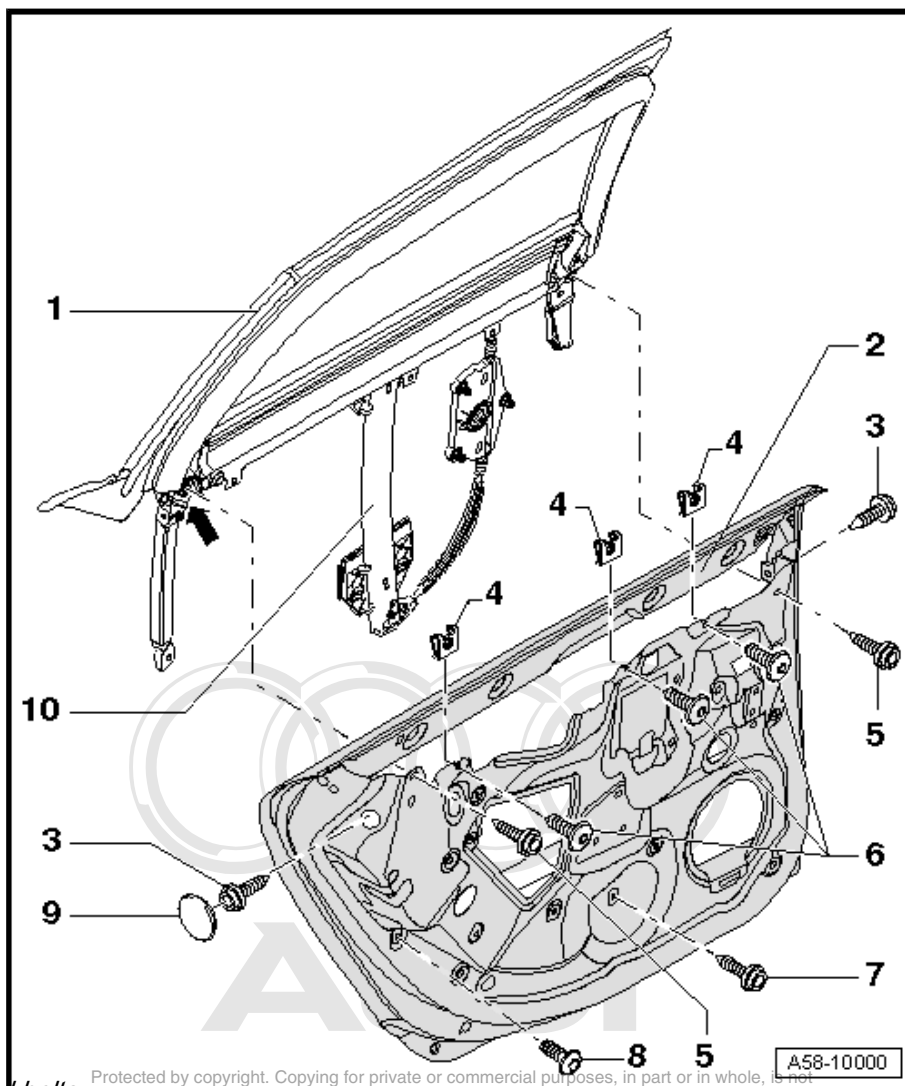
Installing:

- ☐ Insert window frame and window regulator into door from above.
- ☐ Attach upper half of seal (on door side) into window frame (top).
- ☐ Loosely screw in flange bolts -3- at front and rear.
- Also screw in Torx bolt -8-.
- ☐ Screw in fitted bolts -5- and tighten to 32 Nm.



Note

- ◆ After tightening fitted bolts, height of window frame is already adjusted.



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A58-10000

- ◆ *However, if it is still necessary to adjust height of window frame, fitted bolt must be exchanged for standard bolt of same property class and length.*

- ☐ To adjust angle, press top of window frame -1- gently past point of resistance and tighten bolts -3- to 32 Nm.
- ☐ Tighten bolt -8- to 10 Nm.
- ☐ Tighten locking bolt for longitudinal adjustment -arrow- in window frame to 32 Nm.
- ☐ Attach lower half of door seal to inner door panel.
- ☐ Secure window regulator rail to inner door panel with bolt -7- and tighten to 6 Nm.
- ☐ Press threaded pins of window regulator drum through inner door panel until they engage.
- Install window regulator motor.

2 - Rear door

3 - Flange bolt

- ☐ 32 Nm

4 - Speed nut

- ☐ Fitted to door flange

5 - Fitted bolt



Note

- ◆ *Height of window frame is already correctly adjusted via fitted bolt.*
- ◆ *However, should adjustments be required after all, the fitted bolts can be replaced by bolts of the same size, length and strength, as offered in the Parts catalogue.*

- ☐ 32 Nm

6 - Self-tapping screw

- ☐ 2.5 Nm

7 - Flange bolt

- ☐ 6 Nm

8 - Torx bolt

- ☐ 10 Nm

9 - Cap

- ☐ Clipped into door

10 - Window regulator

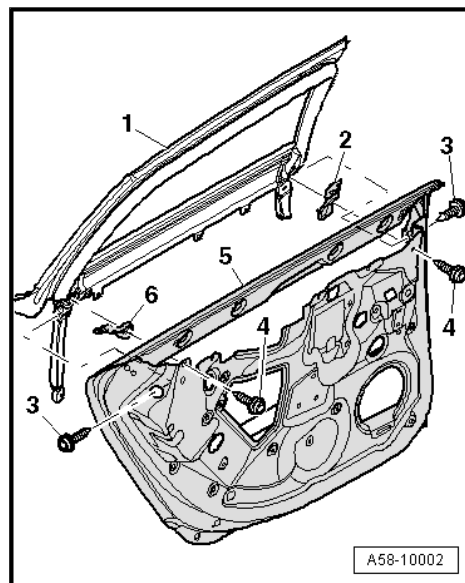
- ☐ Bolted to window frame for installation in door



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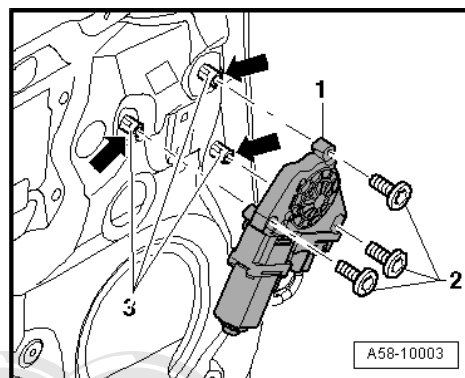
Seal for window frame

- Before installing window frame -1- in door -5-, check for correct seating of seals -6- and -2-.
- If necessary, renew seals.
- Detach protective paper from seals and press seals into place on window frame, as shown.
- Insert window frame into door and screw in fitted bolts -4- and flange bolts -3-.



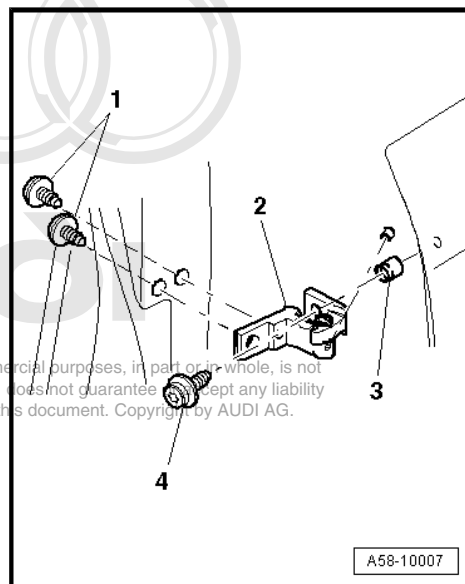
Removing and installing window regulator motor

- To remove, unscrew bolts -2- and detach window regulator motor.
- Installing window regulator motor ⇒ [page 101](#) .



Door hinge (top)

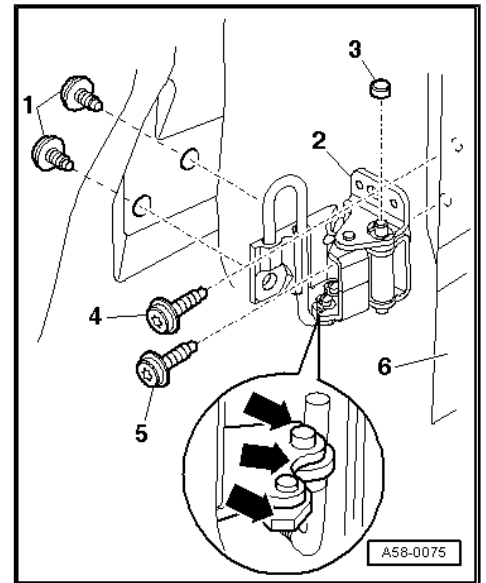
- Torx bolt -T 45- -1- to B-pillar (top), fitted from inside of vehicle: 32 Nm
- Door hinge (top) -2-
- Spacer sleeve -3-
- Torx bolt -T 45- -4-: 32 Nm



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Door hinge (bottom)

- B-pillar trim removed
- Torx bolts -T 45- -1- (32 Nm) secured to B-pillar from inside of vehicle
- Door hinge (bottom) -2-
- Cap -3-
- Torx bolt -T 45- -4-: 32 Nm
- Fitted bolt -T 45- -5-: 32 Nm
- Re-grease lubrication points -arrows- at prescribed service intervals.
- Front door -6-



1.3 Removing window regulator and door window

1 - Window frame

- ☐ Removing:



Note

*When removing the window regulator, the self-adhesive seal for the window frame must be renewed
⇒ [page 100](#).*

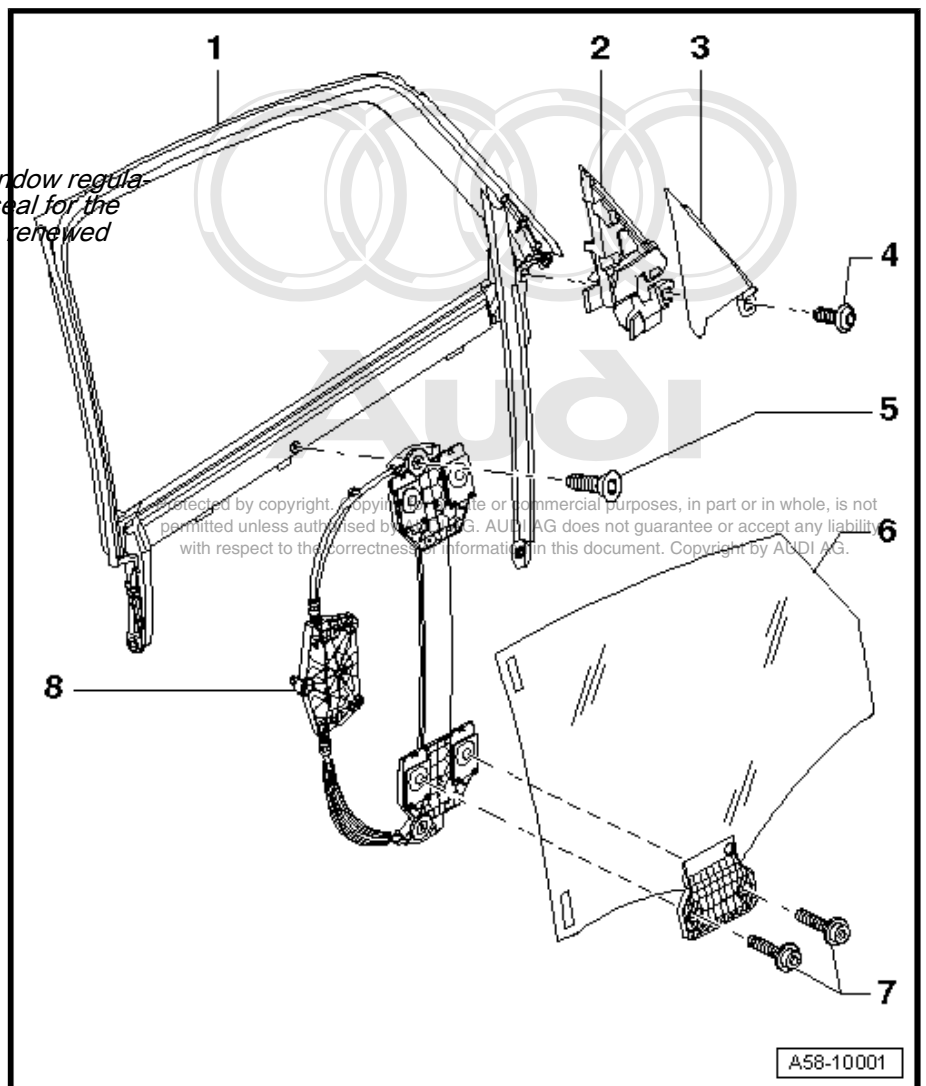
- ☐ Remove door trim. ⇒ Rep. gr. 70
- ☐ Window frame removed from door together with window regulator
⇒ [page 94](#)
- ☐ Door window -6- removed
- ☐ To remove, unscrew countersunk-head bolt -5- and detach window regulator from window frame.
- ☐ Installing:
- ☐ When installing, ensure that guide rail runs parallel to guide -arrow-.
- ☐ Tighten bolt -5- to 6 Nm.

2 - Seal

- ☐

3 - Triangular trim

- ☐ Before removing, take out window frame and window regulator
- ☐ Unscrew bolt -4- and de-





tach trim panel to side

4 - Bolt with washer

- ☐ 7.5 Nm

5 - Countersunk-head bolt

- ☐ 6 Nm

6 - Door window

Removing:

- ☐ Lower door window.
- ☐ Unscrew bolts -7- and detach door window from window regulator.

Installing:

- ☐ Insert window in window regulator.
- ☐ Screw bolts -7- loosely into window regulator, but do not tighten yet.
- ☐ Move door window upwards into window frame.
- ☐ Pull door window forwards into window guide on window frame at B-pillar and tighten bolts -7- to 4 Nm.

7 - Countersunk-head bolt

- ☐ 4 Nm

8 - Window regulator

- ☐ Window frame removed from door together with window regulator [→ page 94](#)
- ☐ Door window removed
- ☐ To remove, unscrew countersunk-head bolt -5- and detach window regulator from window frame.

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1.4 Renewing seal for window frame

1 - Window frame

- ❑ Removing and installing ⇒ [page 94](#)

2 - Seal for window frame



Note

When removing the window regulator, the self-adhesive seal for the window frame must be renewed ⇒ [page 100](#).

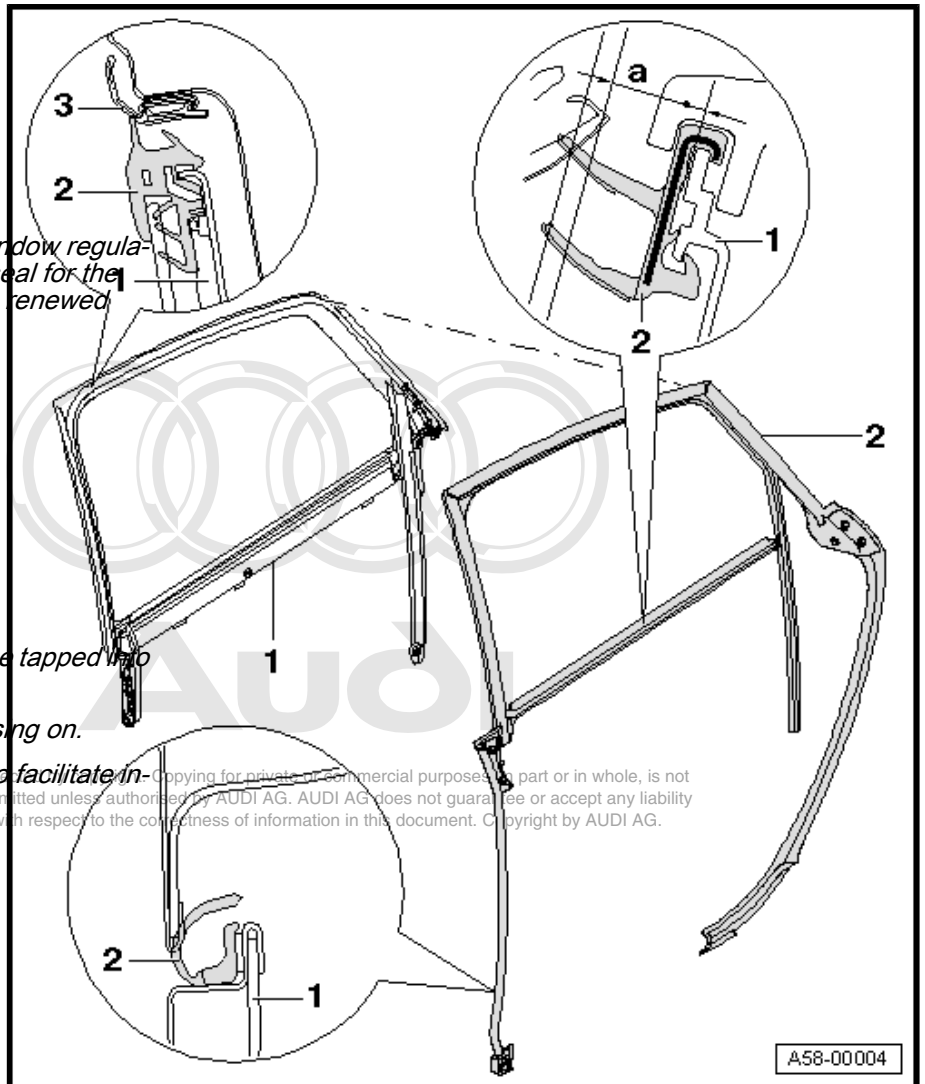
- To install, hook securing parts of seal into window frame at corners of B-pillar and C-pillar.

- ❑ Press seal onto window frame from side.



Note

- ◆ *The seal must not be tapped into place.*
- ◆ *Install seal by pressing on.*
- ◆ *Use soap solution to facilitate installation of seal.*



A58-00004

3 - Roof trim strip

Installing lower joint seal



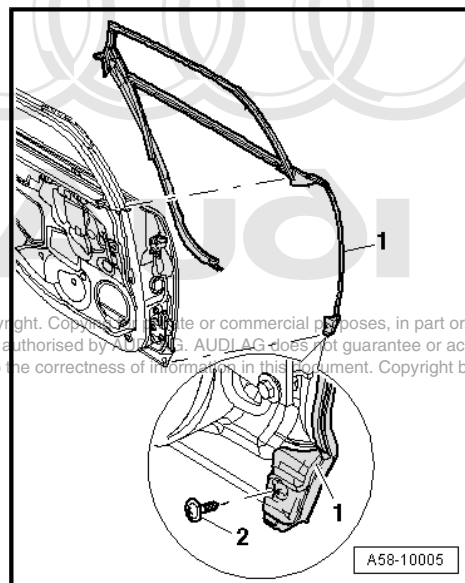
Note

- ◆ *When removing the window regulator, the self-adhesive seal -1- for the window frame must be renewed.*
- ◆ *To facilitate installation of the joint seal, you can remove the entire door from its hinges and refit without any adjustment work ⇒ [page 93](#).*



Note

- ◆ *Clean bonding surface before installing seal.*
- ◆ *Bonding surface must be free of dust and grease.*
- Clip in seal at top.
- Detach protective foil from seal -1- starting at bottom up to embossed area.
- Bond on seal up to embossed area.
- Fix moulding in position at bottom and fully bond on seal in lower area.
- Detach rest of protective foil and bond on seal in upper area.
- Screw in bolt -1- at bottom of seal and tighten to 1 Nm.
- Insert rubber lip of door cover in moulding on A-pillar (bottom).



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1.5 Removing and installing outer door seal

1 - Window frame

- ☐ Installed in door

2 - Retaining rail

- ☐ Retaining rails are clipped in all around door.

3 - Retaining rail

4 - Retaining rail

5 - Retaining rail

6 - Retaining rail

7 - Outer door seal

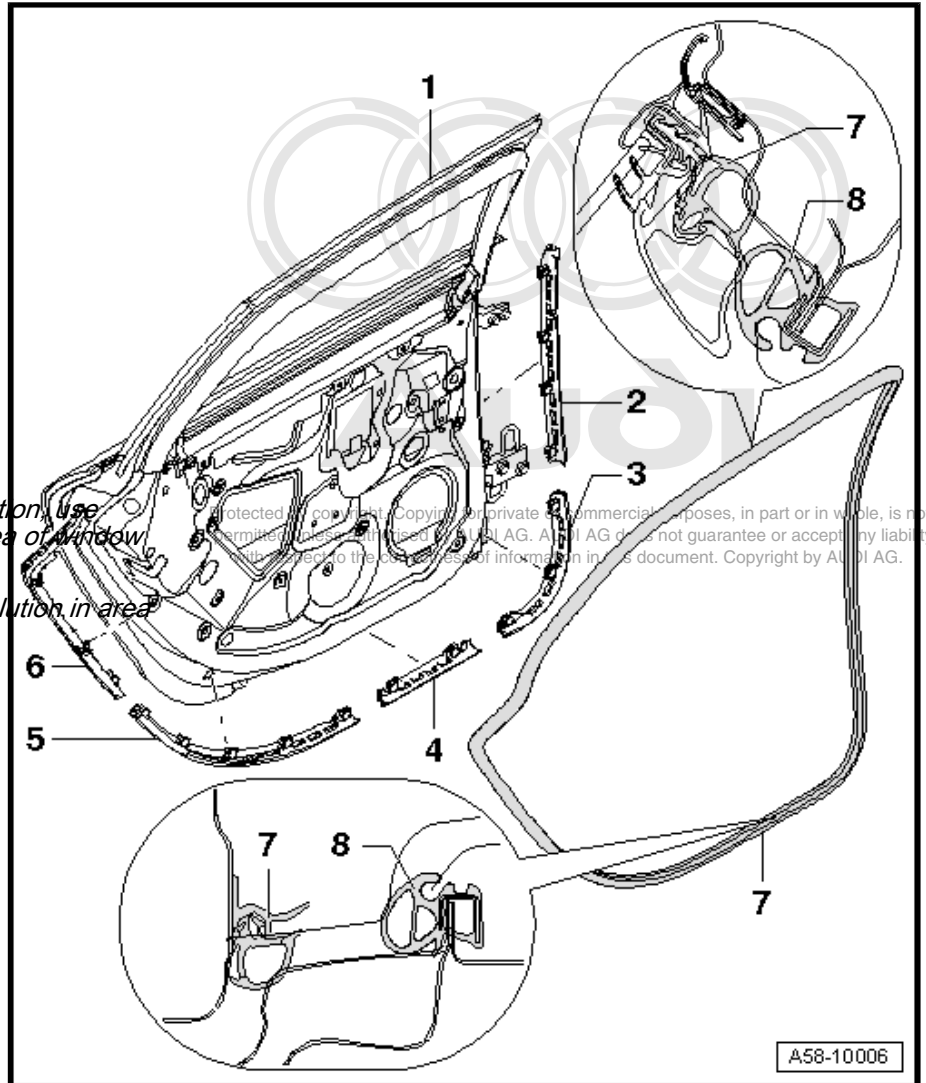


Note

- ◆ *To facilitate installation, use soap solution in area of window frame.*
- ◆ *Do not use soap solution in area of retaining rails.*

- Starting at top of window frame, press in seal all around retaining rails.

8 - Inner door seal



1.6 Removing and installing window regulator motor

Removing

- Door trim removed ⇒ Rep. gr. 70



Note

- ◆ *Window regulator motor can be removed or installed with motor or side window in any position.*
- ◆ *Unplug connectors before removing motor.*

- Unscrew Torx bolts -2- -T 30- and detach motor.

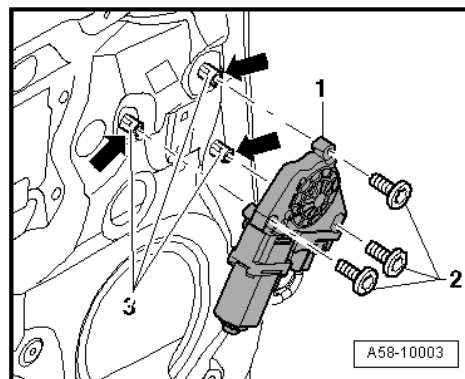
Installing

- When installing, make sure threaded pins -arrows- are engaged in inner door panel.
- Push on window regulator motor -1- and secure with bolts -2-.
- Tightening torque: 3.5 Nm



Note

- ◆ After installing the electric motor and attached wiring, first turn the ignition on and then off again.
- ◆ Then raise door window as far as it will go and keep window regulator switch pulled for approx. 2 seconds.
- ◆ The window regulator is now in the basic setting and the opening/closing function is activated.



1.7 Removing and installing power latching system

1 - Bolt

- 2.5 Nm

2 - Rear left power latching motor - V307-

- Disengaging and engaging ⇒ [page 103](#)
- Unscrew bolts and take motor out of mounting bracket.

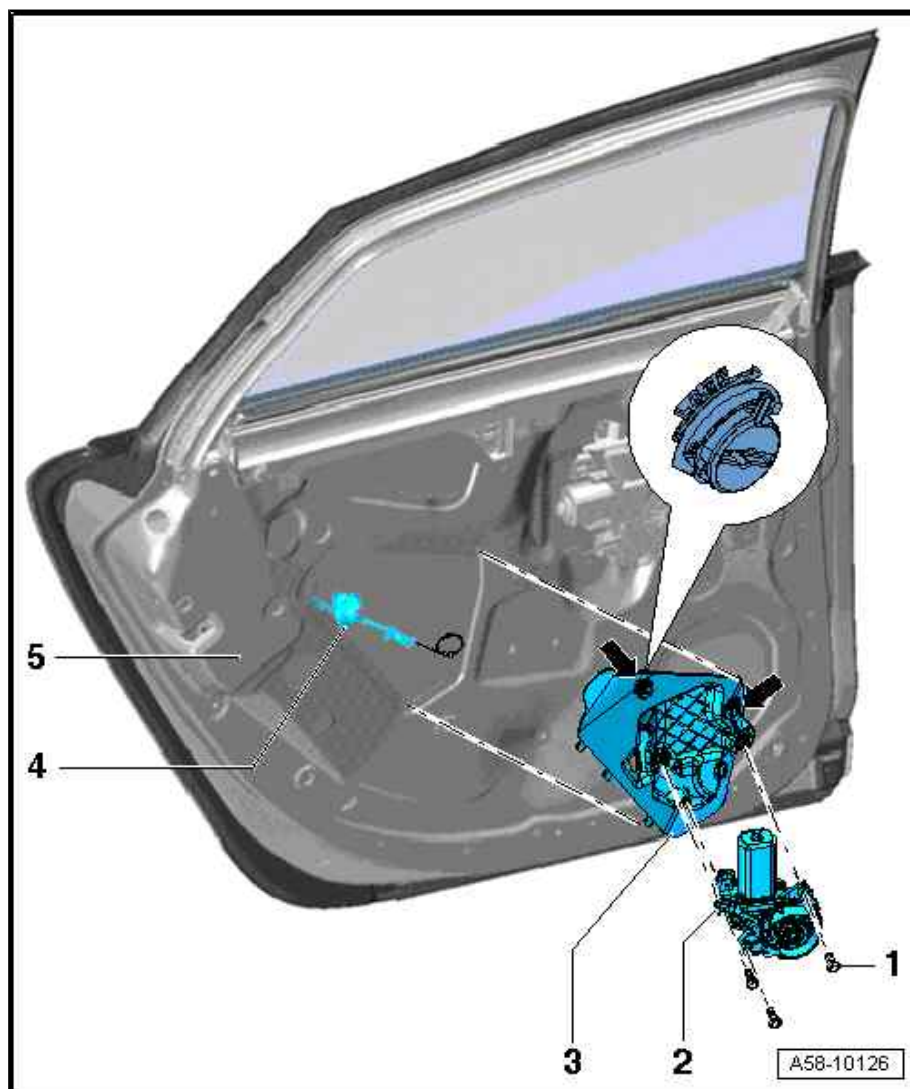
3 - Mounting bracket

- When removing from door lock, disengage cable at motor.
- Release catches -arrows- using a screwdriver, and fold out motor together with mounting bracket.
- When installing, fasteners must engage audibly.

4 - Cable

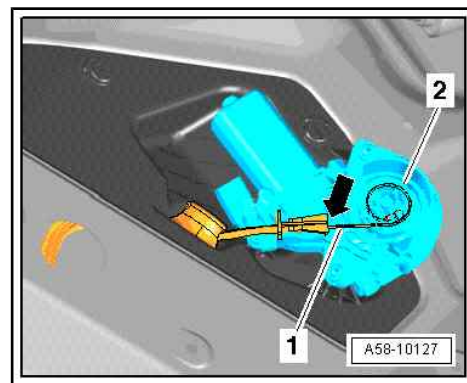
- When installing, grommet for cable must be pressed all the way into mounting bracket.

5 - Rear door



Disengaging and engaging cable

- To remove, unclip cable from retainers -arrow- and pull out of guide towards rear.
- Thread cable -1- out of cable reel -2-.
- To install, first insert nipple of cable into cable reel.
- Insert cable into groove on cable reel through 360° as shown.
- Slide cable into guide and fasten with retaining hooks.
- Press grommet for cable all the way into mounting bracket.



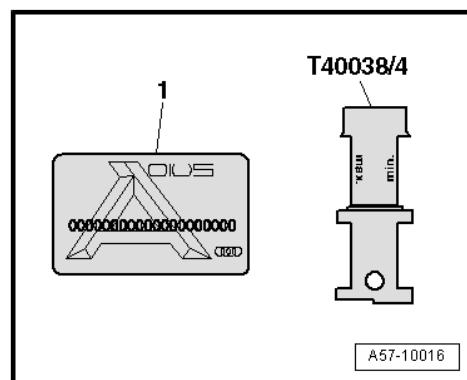
1.8 Checking door adjustment

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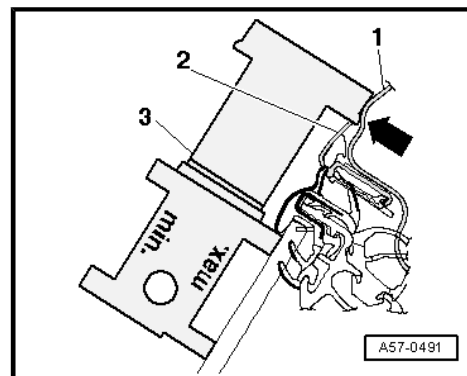
Special tools and workshop equipment required

◆ Template - T40038/4-

- Use template - T40038/4- for checking (e.g. for wind noise) and adjusting door as described below:
- Use a regular bank card -1- or similar to check contact pressure of sealing lip on roof trim strip.



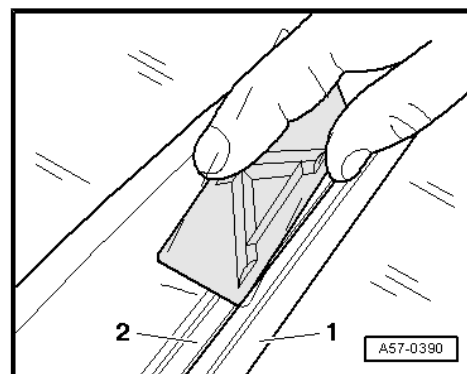
- For correct adjustment, template -3- should make contact with top of roof trim strip -2- and roof -1- -arrow-.



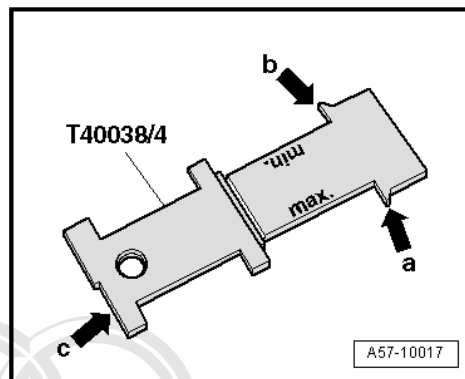
Checking contact of sealing lip on roof trim strip

- Move a regular bank card along the area of contact between the sealing lip and the roof trim strip, applying light pressure.
- Card must not penetrate between sealing lip -1- and roof trim strip -2-.

Lateral adjustment of door (setting angle)

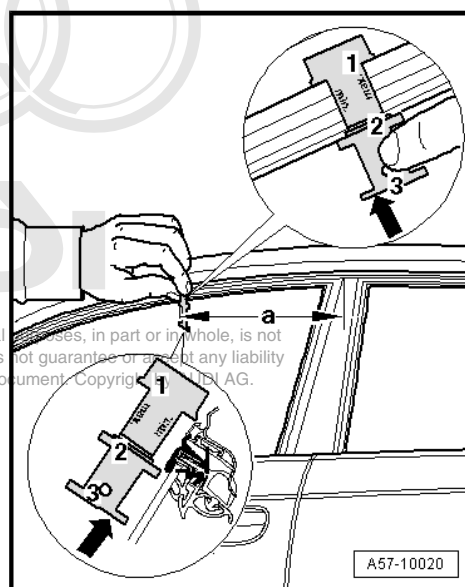


- Template has arms of different length at arrows -a- and -b-.
- These can be used to check lateral adjustment of doors.
- Use side with “max” mark to check whether window frame is positioned too far outwards.
- Use side with “min” mark to check whether window frame is positioned too far inwards.

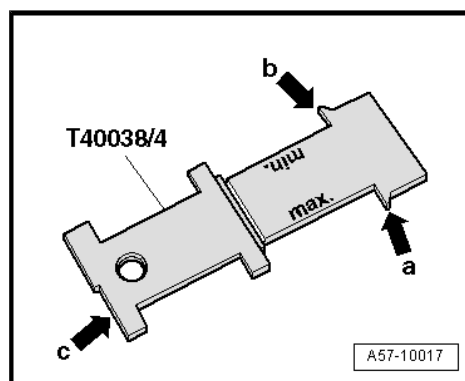


- Position template at distance -a- = 200 mm and with cut-out -arrow- pointing towards the door window.
- Make sure points -1- and -3- make contact.
- A gap is permissible at point -2- of the template.
- This position (max) represents outermost door setting within tolerance range.
- If there is no gap at point -2- or if there is a gap at point -1-, window frame is positioned too far outwards and must be adjusted.

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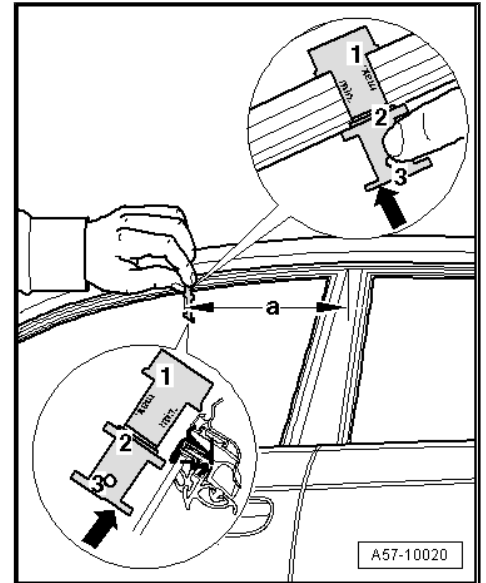
- Use side with arrow -b- (min mark) to check whether window frame is positioned too far inwards towards body.
- Position template at distance -a- = 125 mm and with cut-out -arrow- pointing away from door window as shown.



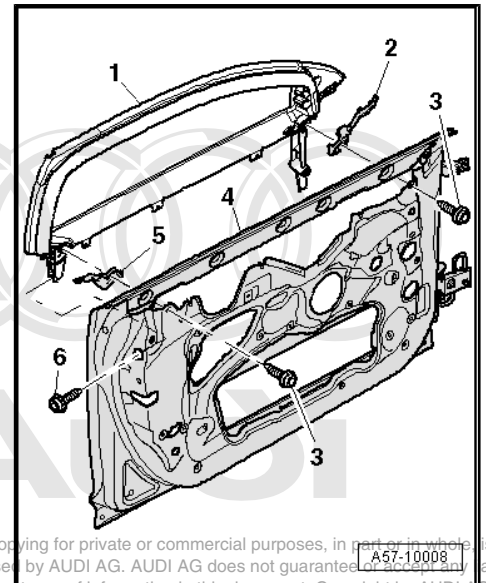
- Make sure points -2- and -3- make contact with door window.
- A gap is permissible at point -1- of the template.
- This position (min) represents innermost door setting within tolerance range.
- If there is no gap at point -1- or if template contact cannot be established at point -2-, window frame is positioned too far towards inside and must be adjusted. ⇒ [page 103](#)

Height adjustment of window frame

- If height of window frame has to be adjusted, replace fitted bolts -6- with standard bolts (of same length and strength).



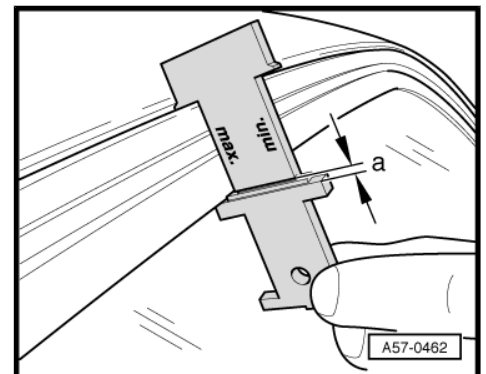
- Height of window frame -1- can now be adjusted in relation to door -4-.
- Seals -2- and -5- are inserted into window frame.
- Place template on roof as shown, or on upper edge of rain channel.



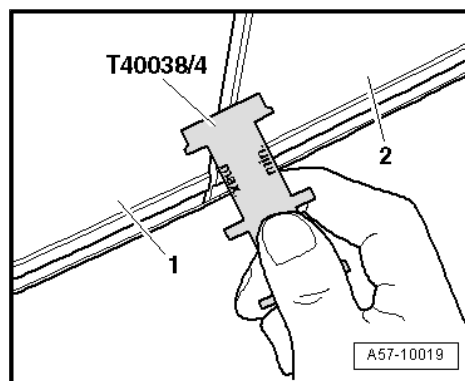
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- When correctly adjusted, lower edge of window frame should be inside grooved area -a- on template.
- Check/adjust angle of window frame.

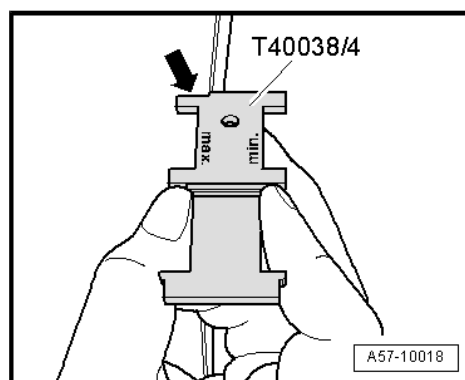
Adjusting front door



- Underside of template -T40038/4- (illustration shows different template) can be used to check position of door.
- The door must not be recessed relative to the side panel -2-.
- The front door -1- must not be recessed relative to the side panel -2- (wind noise).



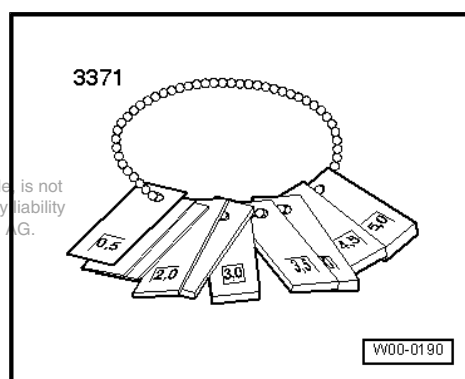
- The front door may protrude (max. 0.8 mm) relative to the side panel in the area of the cut-out in the template -arrow-.



1.9 Adjusting door

Special tools and workshop equipment required

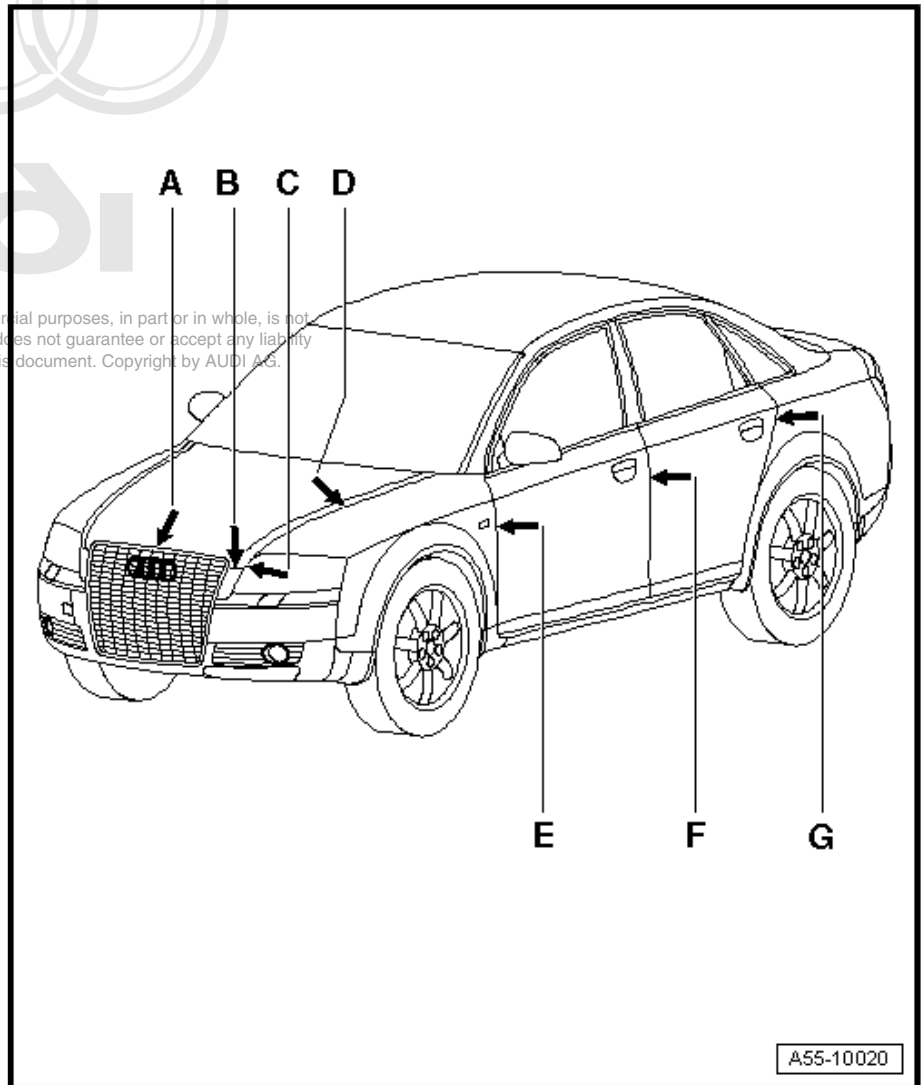
- ◆ Setting gauge - 3371-



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Panel gaps

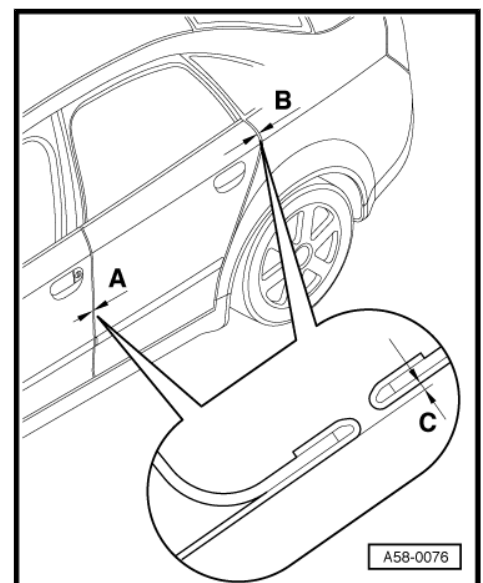
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Adjustment dimensions

- Dimension A = $4.5 \text{ mm} \pm 0.5 \text{ mm}$
- Dimension B = $3.5 \text{ mm} \pm 0.5 \text{ mm}$
- Flush alignment, dimension C = $0 \text{ mm} - 1 \text{ mm}$ (parallel to body contour)

Longitudinal adjustment

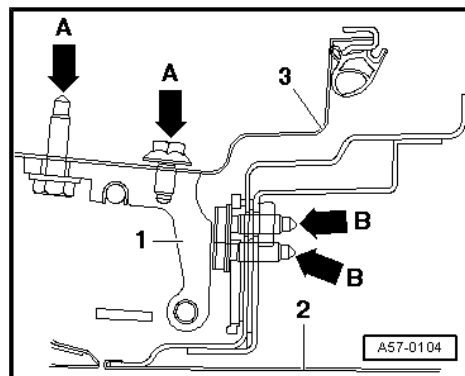


- For longitudinal adjustment of the door slacken hinge bolts -arrow A- on B-pillar at door hinge (top and/or bottom) and move door -2- within elongated holes in hinge or B-pillar.
- Tightening torque: 32 Nm
- Door hinge -1-
- A-pillar -3-
- Door -2-



Note

Illustration shows door hinge (bottom).



Adjusting the door inwards/outwards



Note

- ◆ A fitted bolt is installed on each of the lower door hinges on the door side.
- ◆ As a result, an adjustment is not usually required during repair work.
- ◆ However, should an adjustment be required after all, the fitted bolts can be replaced by bolts of the same size, length and strength class, as offered in the Parts catalogue.

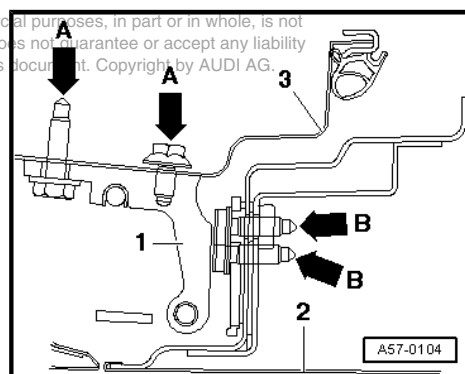
- The door can be adjusted inwards or outwards by loosening the top and/or bottom door hinge bolts -arrow B- and moving the door within the elongated holes in the hinge.

- Tightening torque: 32 Nm



Note

Adjust rear end of door by altering position of striker inwards or outwards.



Adjustment via striker

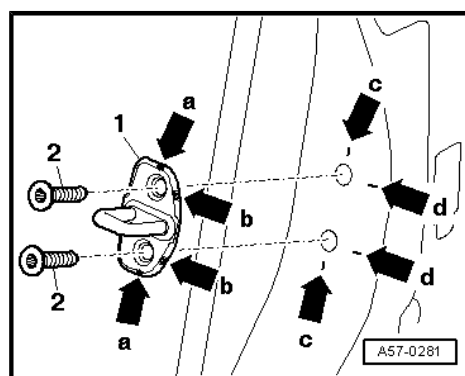
- Loosen bolts -2-.
- Use markings -arrows a- and -arrows c- for lateral adjustment.
- Move striker -1- until door is flush with body contour.



Note

Use this adjustment only to adjust door inwards or outwards, not vertically.

- Use markings -arrows b- and -arrows d- for height adjustment.
- If adjustment is correct, striker should engage centrally in door lock.
- Tighten bolts to 25 Nm.



1.10 Adjustment dimensions for window frame

1 - Window frame

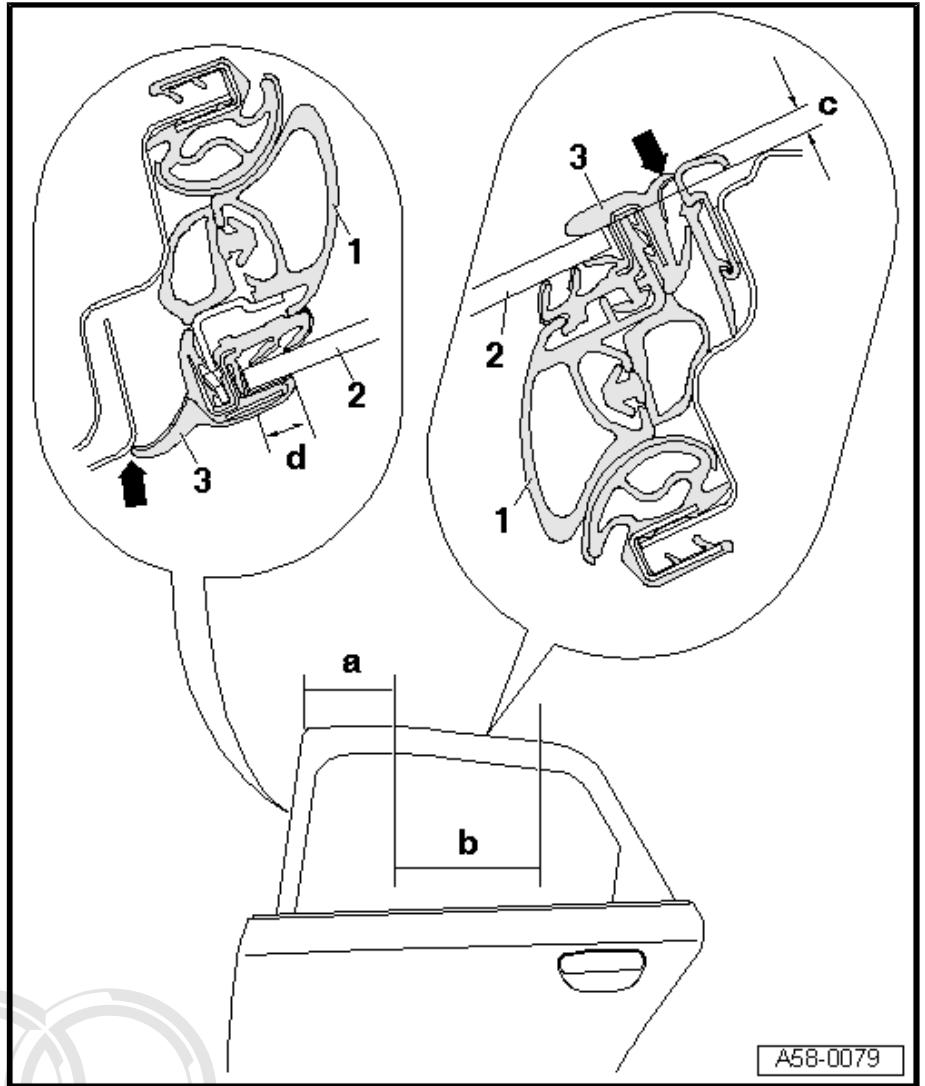
- ❑ If door is adjusted correctly, sealing lip must fit flush with contours of roof frame and B-pillar; see arrows.

2 - Door window

- ❑ Adjust door to achieve dimension -c- = 4 mm in area -b- = 300 mm
- ❑ Dimension -c- can be checked with a template -T40038/4- .
- ❑ Dimension -a- measured from front edge of door at B-pillar = 200 mm

3 - Window frame

- ❑ Door window -2- must fit into window frame at B-pillar (dimension -d- = 7.5 mm -1 mm).



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1.11 Rear door handle and door lock

Exploded view

1 - Door handle mounting

- ☐ Releasing ⇒ [page 112](#) .

2 - Door handle

- ☐ Prior to removal take out window frame and window regulator.
- ☐ Cover -5- removed
- ☐ Removing ⇒ [page 94](#)

3 - Operating rod

- ☐ Clip into door lock
⇒ [page 112](#)

4 - Clip

- ☐ Hook operating rod into clip, swivel clip through 90° and engage at operating rod.

5 - Cover

- ☐ Remove before detaching door handle.

6 - Trim for door handle

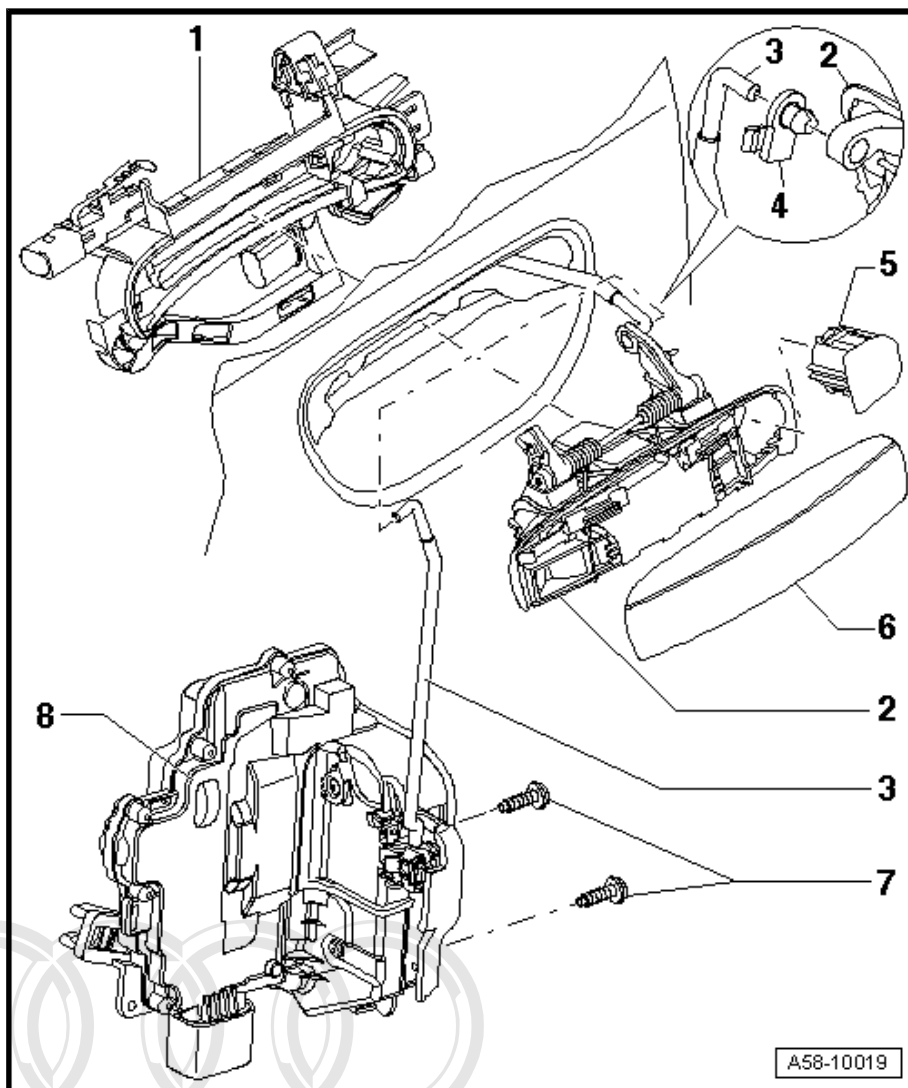
- ☐ Removing ⇒ [page 112](#)

7 - Multi-point socket head bolt

- ☐ 20 Nm

8 - Door lock

- ☐ Removing:
- ☐ Door trim removed
- ☐ Window frame and window regulator removed
⇒ [page 94](#)
- ☐ To remove, unscrew multi-point socket head bolts -5- and take door lock out downwards.



1.12 Removing door handle

1 - Door handle

- ❑ Before detaching, remove cover
⇒ [Item 5 \(page 110\)](#) and
door handle trim
⇒ [page 112](#).

2 - Clip

- ❑ When dismantling door handle -1-, disengage operating rod -3- at clip.

3 - Operating rod

- ❑ Before removing door handle, disengage operating rod at clip -2-.
- ❑ After fitting new door lock, first insert operating rod in slide of release lever -4- and lock in retaining hook -5-
⇒ [page 112](#).

4 - Release lever

- ❑ To lock operating rod -3-, engage locking element in retaining hook -5- for release lever in direction of -arrow-.

5 - Retaining hook

- ❑ Locking element for release lever must engage properly in retaining hook.

6 - Door lock

- ❑ Removing ⇒ [page 113](#)

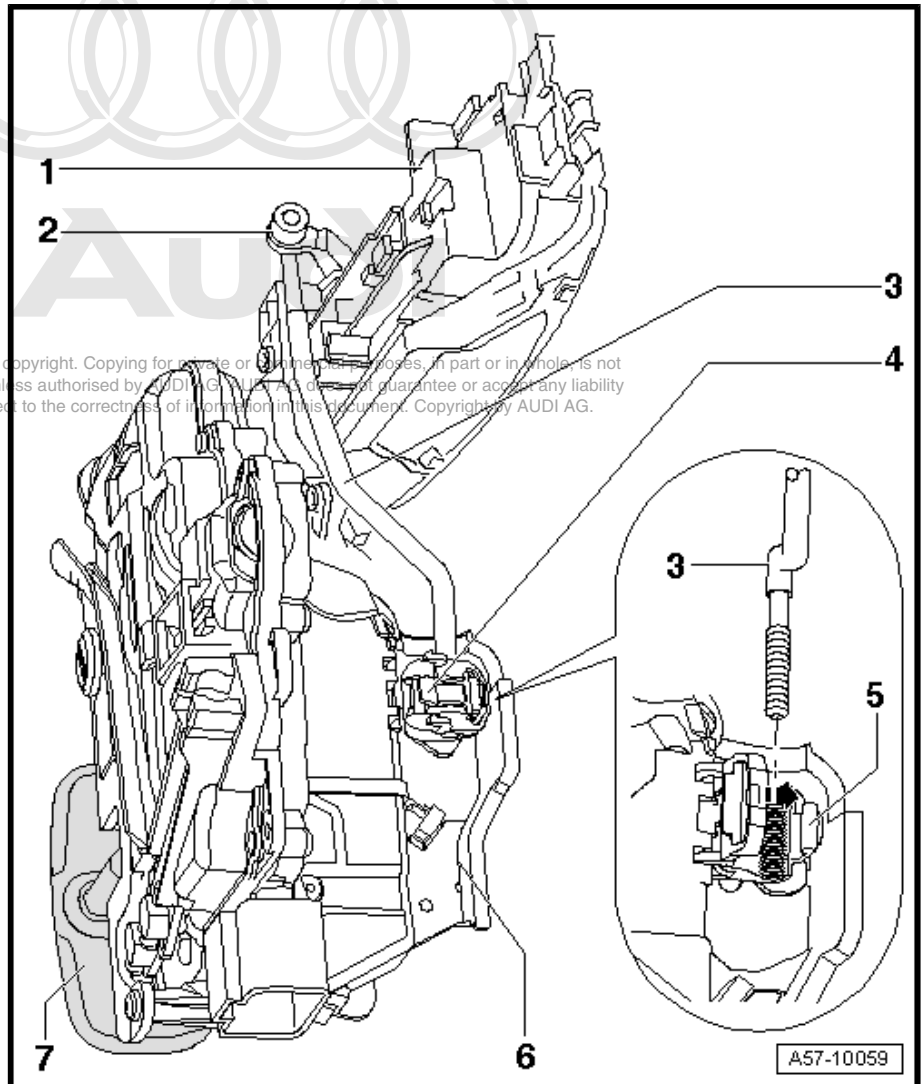


Note

Before removing, cable must be disengaged from motor on vehicles with power latching system.

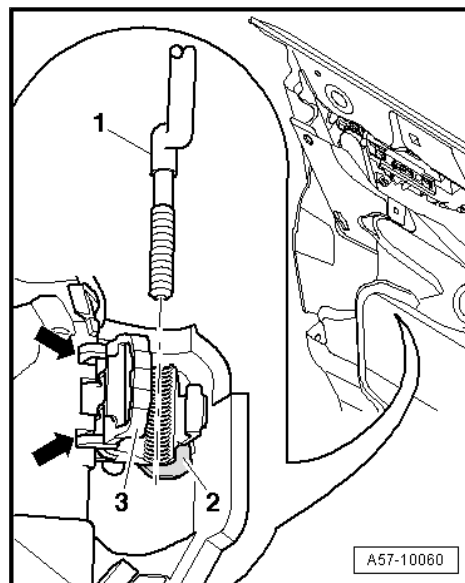
7 - Striker

- ❑ Adjusting ⇒ [page 108](#)



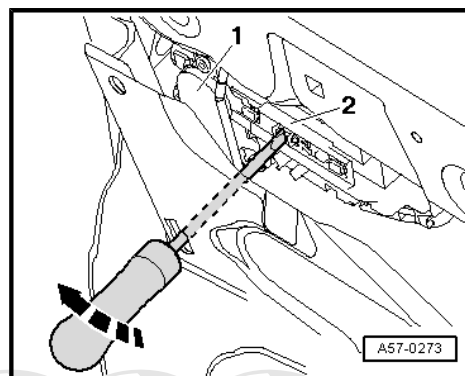
Engaging operating rod in door lock

- To install a new door lock, clip operating rod -1- into release lever -2-.
- To lock operating rod, fold over locking element -3- until it engages in release lever mounting.
- To remove door lock, release locking element and engage in recesses at door lock -arrows-.
- Clip in operating rod in this position only.



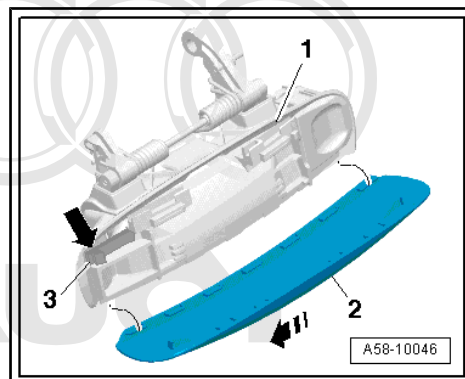
Releasing door handle mounting

- Door trim, window frame and window regulator removed
- Insert screwdriver through door panel and release slide -2- from door handle -1- in direction of -arrow-.



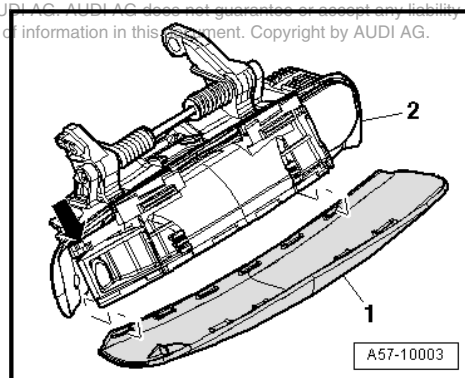
Removing trim panel

- To remove, pull up door handle -1- and use a small screwdriver to release locking element -3-.
- Push trim panel -2- slightly towards front of vehicle, disengage at top to one side and detach from door handle.



Catch for handle trim

- When installing, locking element -arrow- on door handle -2- must engage in trim panel -3-.



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1.13 Removing rear door lock

Exploded view

1 - Multi-point bolts, M8

- ☐ 20 Nm

2 - Rear door

3 - Seal

4 - Bowden cable for interior door handle

- ☐ Engage in release lever -7- at door lock -5-
⇒ [page 113](#).

5 - Door lock



Note

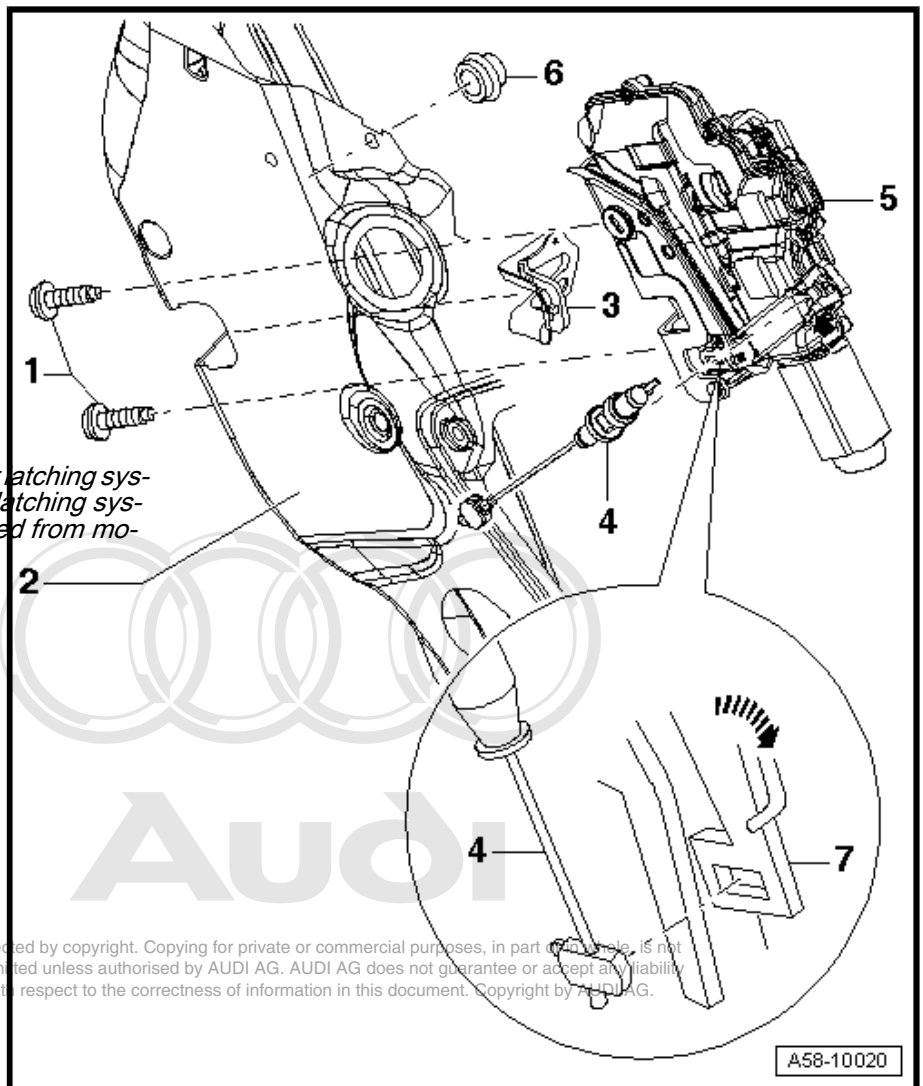
On vehicles with power latching system, cables for power latching system must be disengaged from motors.

- ☐ Door trim removed
- ☐ Window frame and window regulator removed
- ☐ Unplug electrical connector at door lock.
- ☐ Release locking element at release lever and unclip operating rod
⇒ [page 112](#).
- ☐ Unscrew multi-point bolts -1- and take out door lock.

6 - Seal

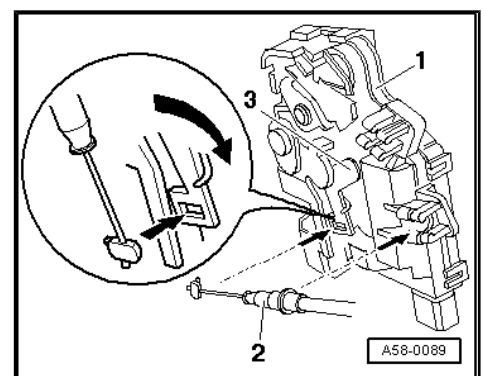
- ☐ Clip into door

7 - Release lever



Engaging Bowden cable in door lock

- To install, first insert Bowden cable -2- vertically into release lever -3- as shown in detail view, then swivel 90° and clip into door lock -1- to secure.



2 Security door (rear)

2.1 Exploded view - window frame, door window, rear door

1 - Door shell

2 - Bolt

□ 5 Nm

3 - Bolt

□ Hand-tight

4 - Bolt

□ 18 Nm

□ Left-side: fitted bolt

5 - Bolt

□ 18 Nm

6 - Bolt

□ 2 Nm

7 - Triangular trim

□ Removing and installing

⇒ [page 118](#)

8 - Window frame

□ Removing and installing

⇒ [page 116](#)

9 - Door window

□ Removing and installing

⇒ [page 116](#)

10 - Locking strip

□ For locking door window
in window frame

11 - Nut

□ For locking adjuster
screw

12 - Adjuster screw

□ For locking door window
in window frame

□ Tighten until door window rests in guide

13 - Bolt

□ 8 Nm

14 - Bolt

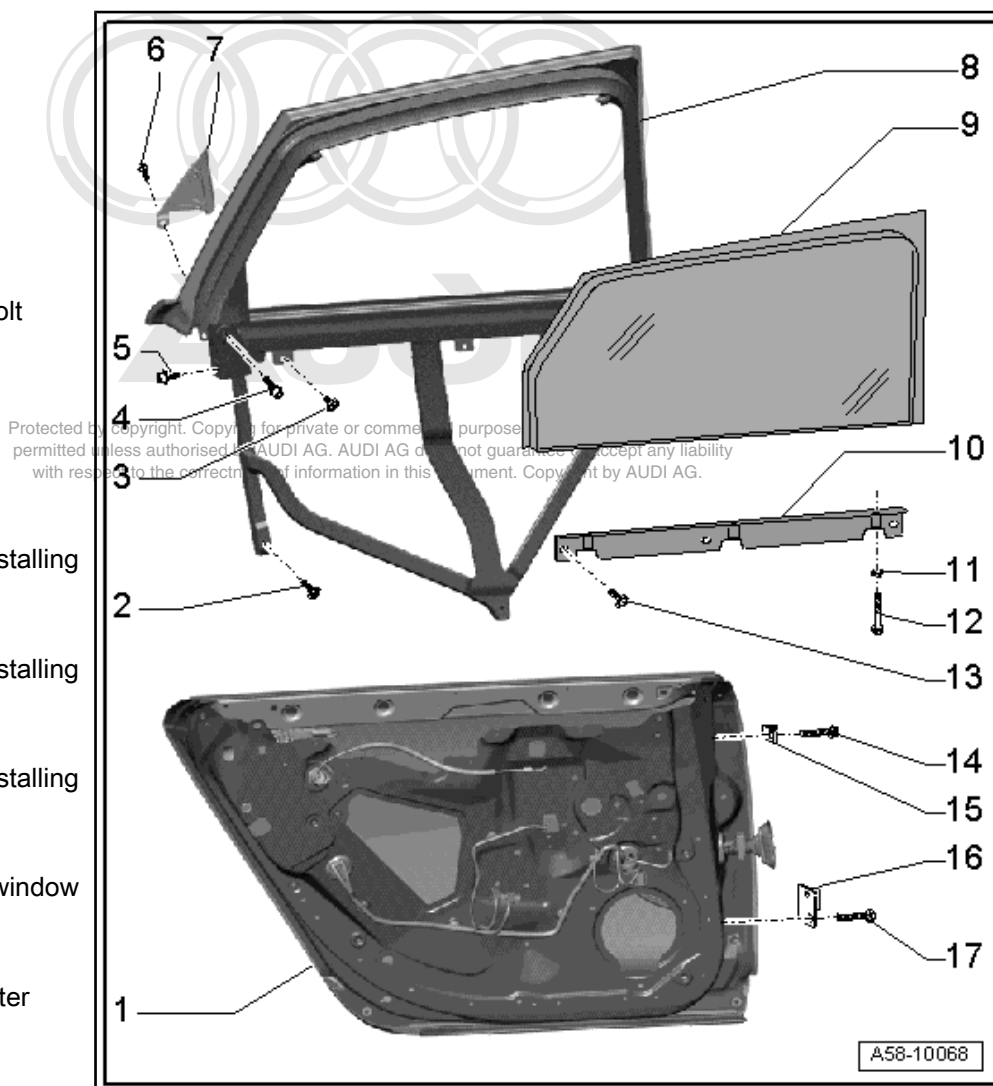
□ 48 Nm

15 - Door hinge (top)

16 - Door hinge (bottom)

17 - Bolt

□ 48 Nm



2.2 Exploded view - reinforcements for rear door

1 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

2 - Reinforcement for door anchorage (rear)

- ☐ Order of removal ⇒ [page 116](#)
- ☐ Removing and installing ⇒ [page 119](#)

3 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

4 - Rear reinforcement for rear door

- ☐ Order of removal ⇒ [page 116](#)
- ☐ Removing and installing ⇒ [page 119](#)

5 - Front reinforcement for rear door

- ☐ Order of removal ⇒ [page 116](#)
- ☐ Removing and installing ⇒ [page 121](#)

6 - Bolt

- ☐ 12 Nm

7 - Reinforcement for door anchorage

- ☐ Order of removal ⇒ [page 116](#)
- ☐ Removing and installing ⇒ [page 122](#)

8 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

9 - Reinforcement for hinge cover

- ☐ Order of removal ⇒ [page 116](#)
- ☐ Removing and installing ⇒ [page 121](#)

10 - Bolt

- ☐ 12 Nm

11 - Bolt

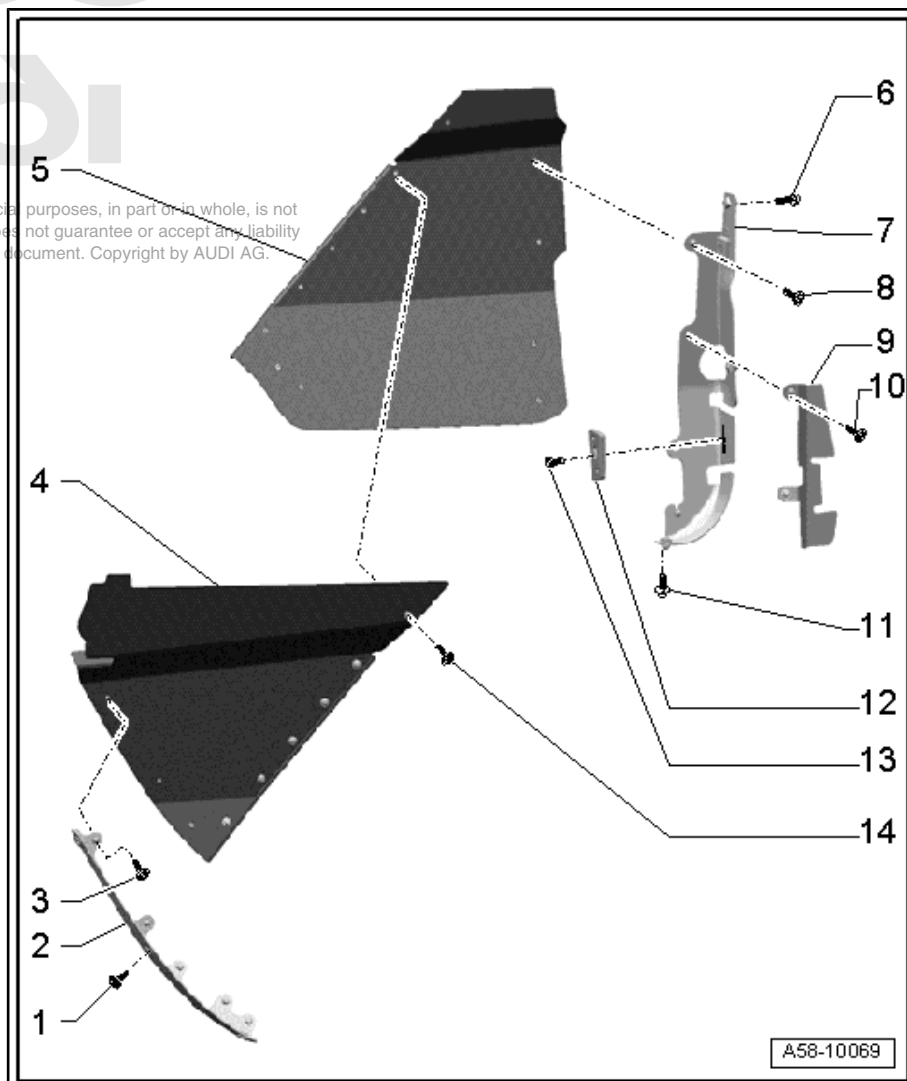
- ☐ 11 Nm

12 - Threaded plate

- ☐ For adjusting bottom door hinge

13 - Bolt

- ☐ 10 Nm

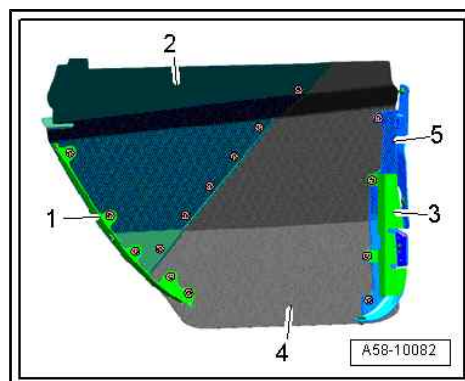


14 - Bolt

- ☐ Apply locking fluid when fitting; locking fluid ⇒ Parts catalogue
- ☐ 12 Nm

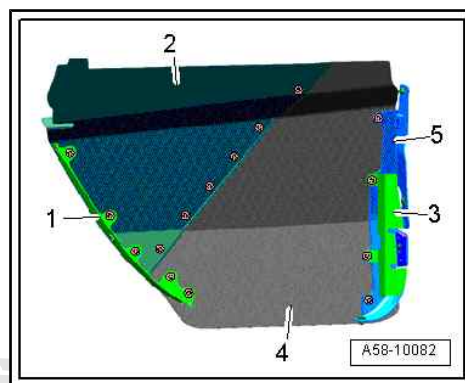
Order of removal of reinforcements

- 1 - Reinforcement for door anchorage (rear)
- 2 - Rear reinforcement for rear door
- 3 - Reinforcement for hinge cover
- 4 - Front reinforcement for rear door
- 5 - Reinforcement for door anchorage



Tightening sequence for reinforcements

- 5 - Reinforcement for door anchorage
- 1 - Reinforcement for door anchorage (rear)
- 2 - Rear reinforcement for rear door
- 4 - Front reinforcement for rear door
- 3 - Reinforcement for hinge cover



2.3 Removing and installing window frame with door window

Removing

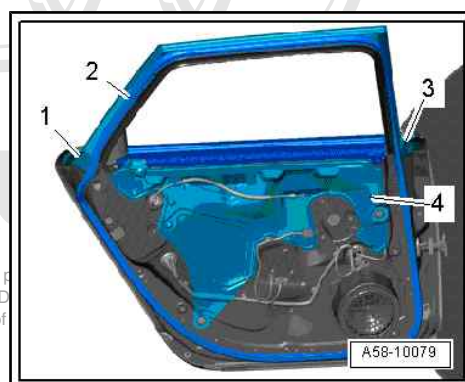
- Remove door trim ⇒ Rep. gr. 70 .
- Pull door seal -2- out of groove on door frame.
- Detach insulating mat -4- at upper section of door frame.
- Detach rubber covers -1- and -3- from door frame.



Note

To facilitate removal, you can use a silicone-free lubricant spray.

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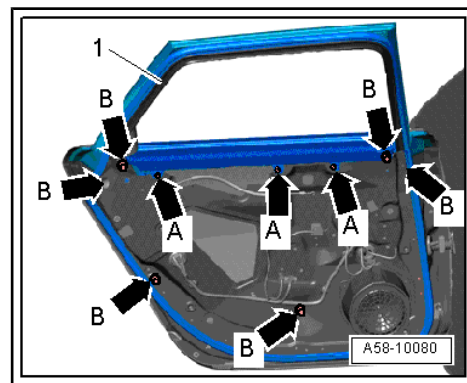
- Remove bolts -arrows A-.
- Mark bolts -arrows B- for re-installation. Remove bolts.



Caution

A second mechanic is required to remove the window frame with the door window.

- Take window frame -1- with door window out of door frame.
- Set down window frame with door window with outside resting on a soft surface.



Caution

Make sure inside of door window is not damaged.

Installing

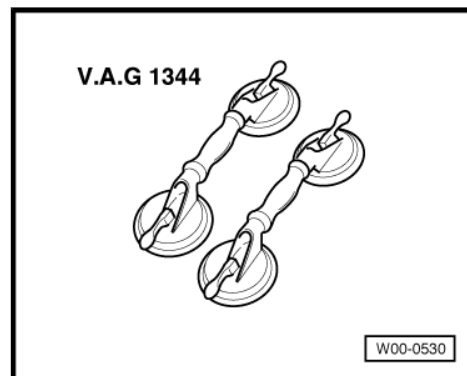
Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tightening torque ➔ [page 114](#)

2.4 Removing and installing door window

Special tools and workshop equipment required

- ◆ Suction lifter - V.A.G 1344-



Removing

- Remove window frame with door window ⇒ [page 116](#) .
- Slacken lock nuts -2- and unscrew adjuster screws -3- approx. 2 turns.
- Remove bolts -arrows- and detach locking strip -4- for door window.



Caution

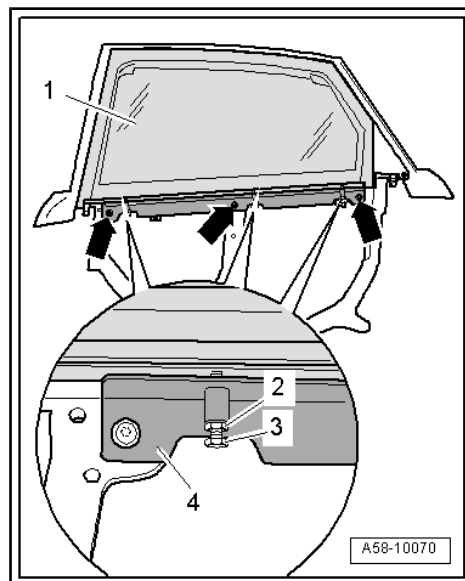
A second mechanic is required to remove the door window.

- Apply suction lifter - V.A.G 1344- to outside of door window -1- and carefully press window out of guide on window frame.
- Set down door window -1- with outside resting on a soft surface.



Caution

Make sure inside of door window is not damaged.



Installing

Installation is carried out in reverse order; note the following:

- Tighten adjuster screw for door window until door window rests against guide.
- Tightening torque ⇒ [page 114](#)

2.5 Removing and installing triangular trim

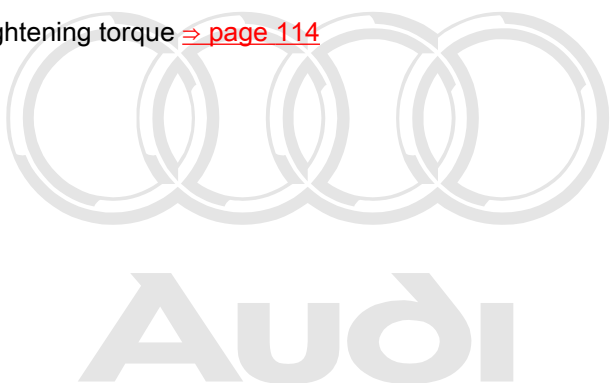
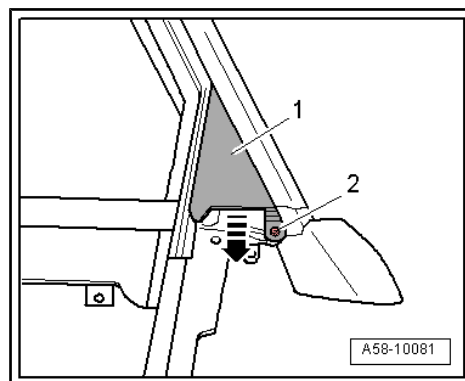
Removing

- Remove door window ⇒ [page 117](#) .
- Remove bolt -2-.
- Pull triangular trim -1- out of window frame in direction of -arrow-.

Installing

Install in reverse order of removal.

- Tightening torque ⇒ [page 114](#)



2.6 Removing and installing rear reinforcement for door anchorage

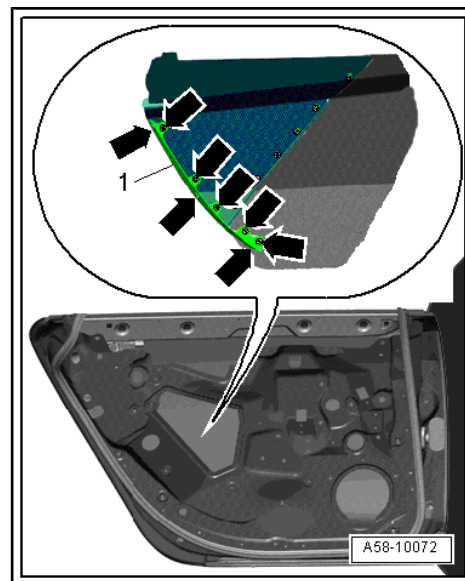
Removing

- Remove window frame with door window ⇒ [page 116](#) .
- Remove bolts at door lock ⇒ Rep. gr. 58 .
- Press door lock to side as far as possible.
- Remove bolts -arrows-.
- Lift rear reinforcement -1- for door anchorage out of door frame.

Installing

Installation is carried out in reverse order; note the following:

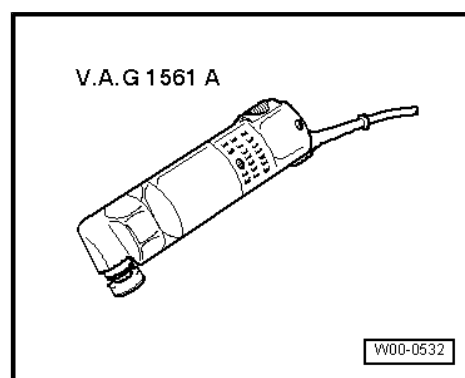
- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tightening torque ⇒ [page 115](#)



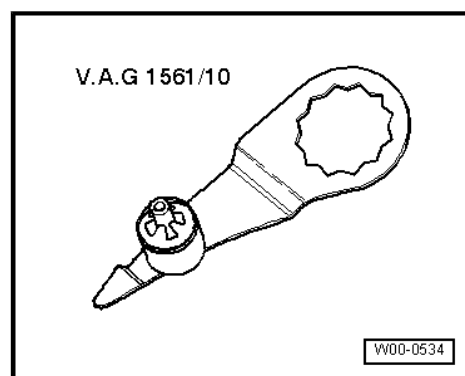
2.7 Removing and installing rear reinforcement for rear door

Special tools and workshop equipment required

- ◆ Electric cutter - V.A.G 1561 A-



- ◆ Blade (offset) - V.A.G 1561/10-

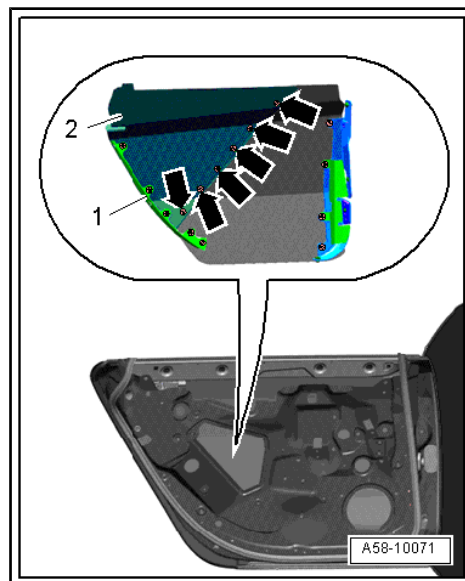


- ◆ 1-component window adhesive - DH 009 100 03-

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Removing

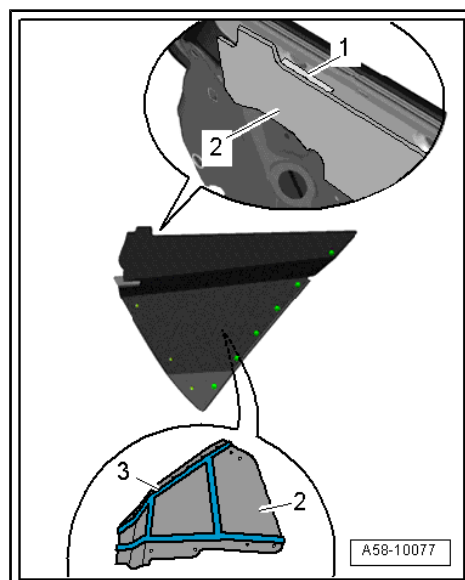
- Remove rear reinforcement -1- for door anchorage
⇒ [page 119](#) .
- Cut through adhesive bead using a sharp knife.
- Remove bolts -arrows-.
- Lift rear reinforcement -2- for rear door out of door frame.



Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Check foam strips -3- for damage and renew if necessary.
- Use electric cutter - V.A.G 1561 A- and blade, offset - V.A.G 1561/10- to cut back rest of adhesive sealant on rear reinforcement for rear door and door frame. However, do not remove sealant completely.
- Insert rear reinforcement -2- for rear door.
- Keep bonding areas free of dirt and grease.
- Apply 1-component window adhesive - DH 009 100 03- -item 1- all round as shown.
- Tightening torque ⇒ [page 115](#)



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2.8 Removing and installing reinforcement for hinge cover

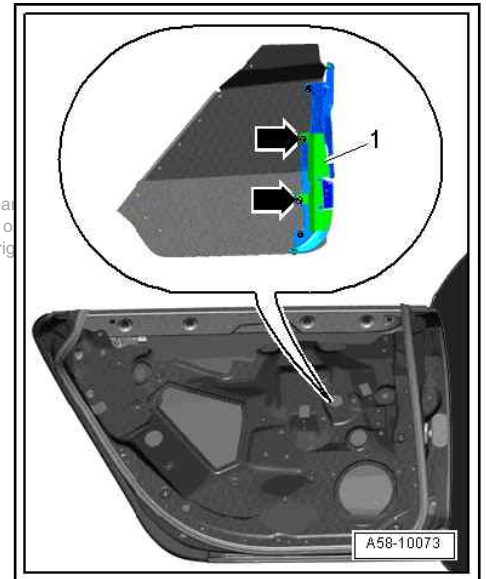
Removing

- Remove window frame with door window ⇒ [page 116](#) .
- Remove loudspeaker ⇒ Rep. gr. 91 .
- Remove bolts -arrows-.
- Take out reinforcement 1- for hinge cover through loudspeaker opening.

Installing

Install in reverse order of removal.

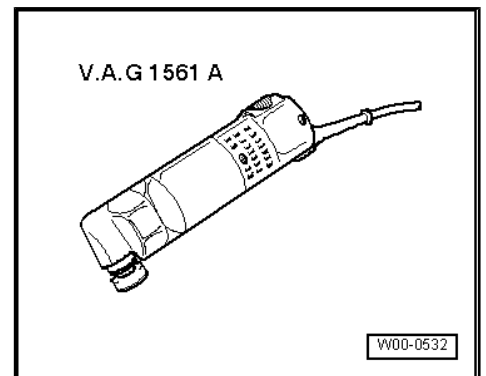
- Tightening torque ⇒ [page 115](#)



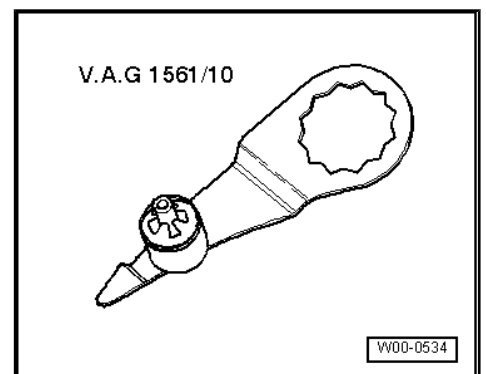
2.9 Removing and installing front reinforcement for rear door

Special tools and workshop equipment required

- ◆ Electric cutter - V.A.G 1561 A-



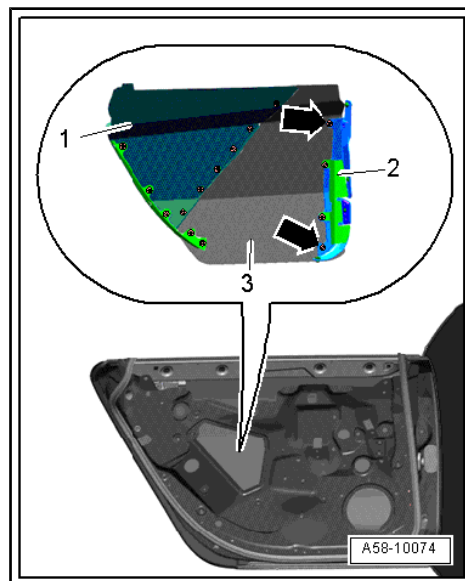
- ◆ Blade (offset) - V.A.G 1561/10-



- ◆ 1-component window adhesive - DH 009 100 03-

Removing

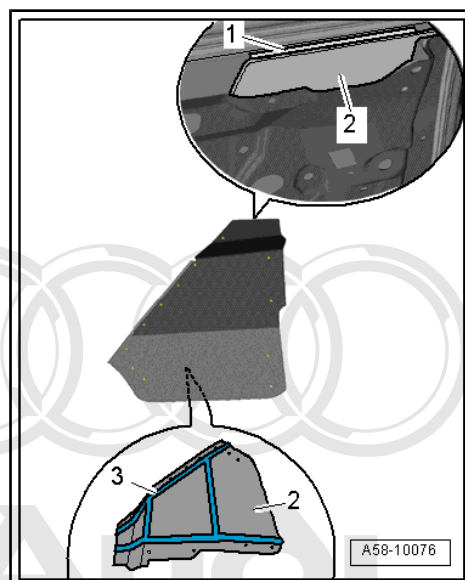
- Remove rear reinforcement -1- for rear door ⇒ [page 119](#) .
- Remove reinforcement -2- for hinge cover ⇒ [page 121](#) .
- Cut through adhesive bead using a sharp knife.
- Remove bolts -arrows-.
- Remove front reinforcement -3- for rear door.



Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Check foam strips -3- for damage and renew if necessary.
- Use electric cutter - V.A.G 1561 A- and blade, offset - V.A.G 1561/10- to cut back rest of adhesive sealant on front reinforcement for rear door and door frame. However, do not remove sealant completely.
- Insert front reinforcement -2- for rear door.
- Keep bonding areas free of dirt and grease.
- Apply 1-component window adhesive - DH 009 100 03- -item 1- all round as shown.
- Tightening torque ⇒ [page 115](#)

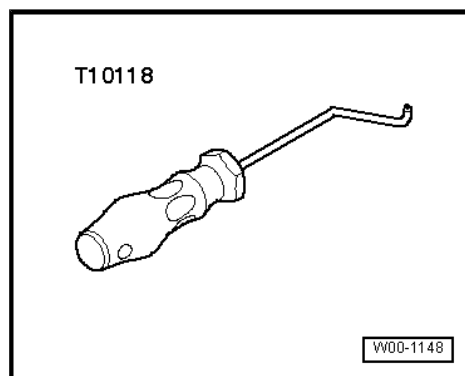


2.10 Removing and installing reinforcement for door anchorage

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Special tools and workshop equipment required

- ◆ Assembly tool - T10118-



Removing

- Remove reinforcement -3- for hinge cover ➤ [page 121](#) .
- Remove front reinforcement -1- for rear door ➤ [page 121](#) .
- Pull exterior door handle and use assembly tool - T10118- to unplug electrical connectors at door lock and exterior door handle.
- Move door wiring harness clear.
- Remove rear door ➤ Rep. gr. 58 .



Note

Before removal, slacken remaining bolts at door hinges.

- Remove door hinges (top and bottom) ➤ Rep. gr. 58 .
- Remove bolts -arrows-.
- Guide door wiring harness through reinforcement for door anchorage and lift out reinforcement -2- for door anchorage.

Installing

Installation is carried out in reverse order; note the following:

- Before installing, it is necessary to remove any locking fluid residue from the threaded holes using a thread tap.
- Tighten bolts on reinforcement for door anchorage.

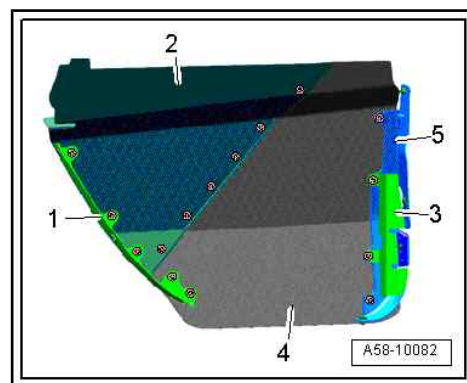
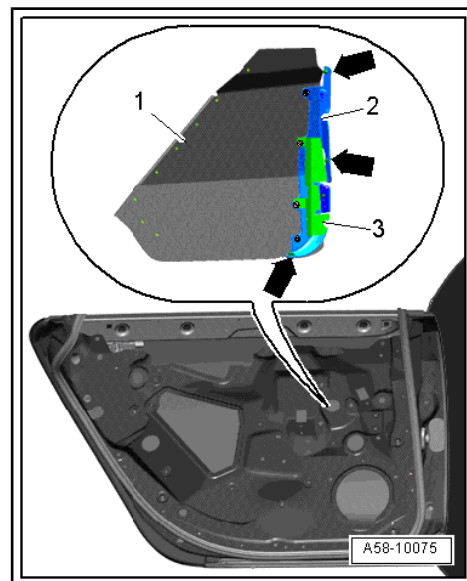


Note

Before tightening bolts, all reinforcements and cover must be attached loosely.

Tighten bolts on reinforcements ➤ [page 116](#) .

- Tightening torque ➤ [page 114](#)



60 – Sunroof

1 Removing and installing sunroof

1.1 Exploded view - sliding/tilting sunroof

1 - Sunroof motor

- ☐ Removing and installing

2 - Nut with washer

- ☐ 8 Nm
- ☐ Self-locking
- ☐ Renew

3 - Water drain hose (front)

4 - Spring

- ☐ For wind deflector

5 - Wind deflector

- ☐ Removing and installing
⇒ [page 125](#)

6 - Sunroof headliner

- ☐ Removing and installing
⇒ [page 134](#)

7 - Trim

- ☐ Removing and installing
⇒ [page 131](#)

8 - Bolt

- ☐ 4.5 Nm
- ☐ Apply locking fluid when fitting
- ☐ Locking fluid ⇒ Parts catalogue

9 - Glass sunroof panel

- ☐ Removing and installing
⇒ [page 133](#)
- ☐ Adjusting ⇒ [page 133](#)

10 - Seal

- ☐ For glass sunroof panel
- ☐ Removing and installing ⇒ [page 134](#)

11 - Torx bolt

- ☐ 1 Nm

12 - Carrier plate for slide

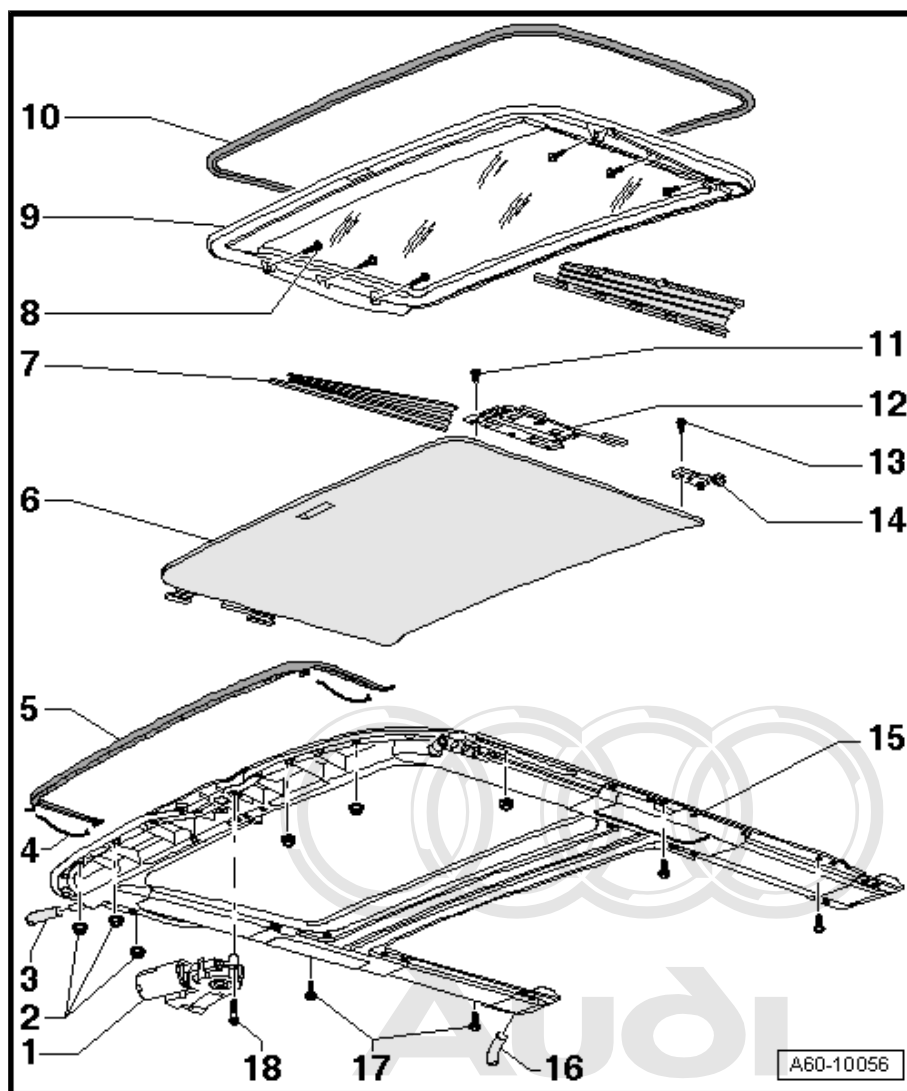
13 - Torx bolt

- ☐ 1 Nm

14 - Slide (rear)

15 - Frame

- ☐ Removing and installing ⇒ [page 137](#)



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16 - Water drain hose (rear)

17 - Bolt

- ☐ 8 Nm
- ☐ Self-locking
- ☐ Renew

18 - Bolt

- ☐ 3.5 Nm

1.2 Removing and installing wind deflector

Removing

- Open sliding sunroof fully.
- Pull rear end of air deflector out of joint in direction of arrow.



Note

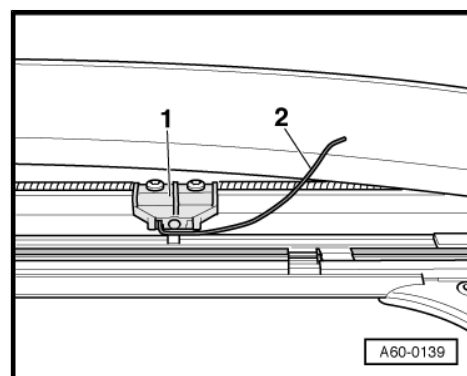
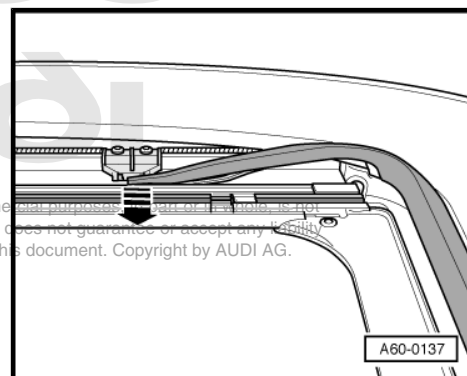
Spring for air deflector is relieved when it is disengaged.

- Repeat procedure on opposite side of vehicle and take air deflector out of roof opening towards the rear.

Installing

Installation is carried out in reverse order; note the following:

- Insert angled side of spring -2- for wind deflector into groove on joint -1-.
- Push contact -arrow 1- of air deflector forwards under the roof opening.
- Position spring -arrow 2- in groove at wind deflector and press retaining pin into joint.
- Repeat procedure on opposite side of vehicle.



1.3 Removing and installing sliding sunroof motor

Removing front interior light

1 - Moulded headliner

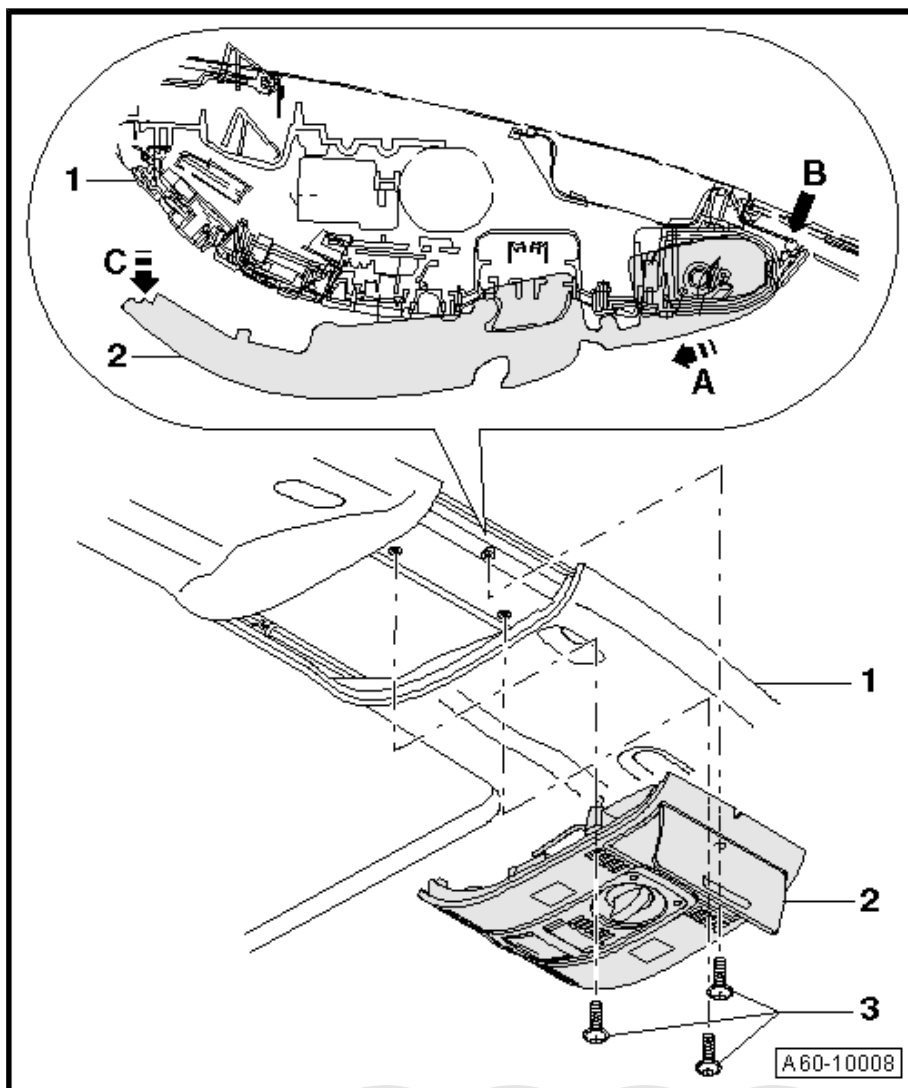
- Removing and installing
⇒ Rep. gr. 70

2 - Cover

- Detach cover before re-
moving sunroof motor.

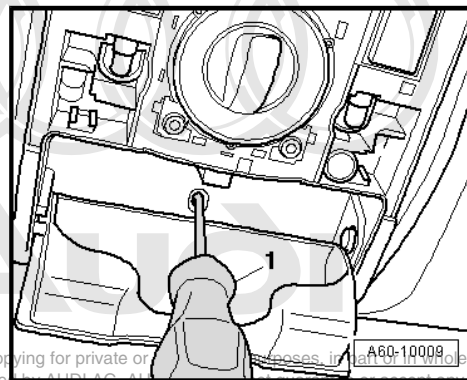
3 - Bolt with washer

- 2 Nm



Removing cover

- Open storage compartment in cover and remove front bolt.



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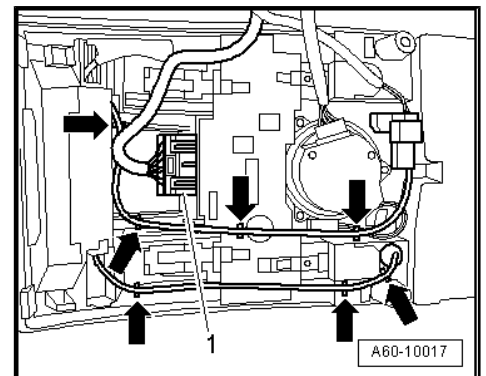
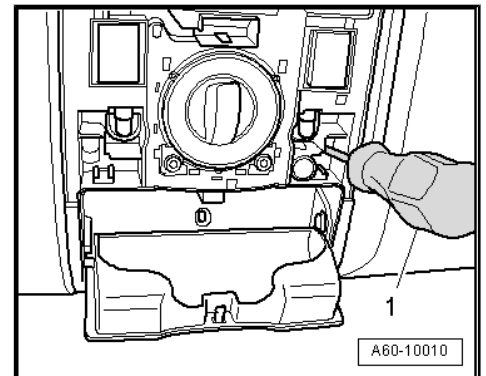
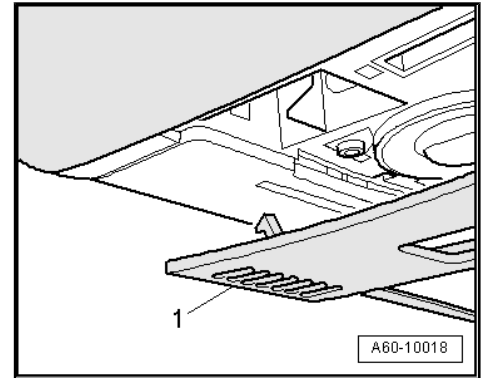
- Unclip trim -1- from cover.

Audi

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- Remove bolts on left and right adjacent to rotary knob for sunroof operation.
- First, release front of cover at windscreen and detach cover.

- Unplug electrical connectors.
- When installing, press wires all the way back into clips -arrows-.



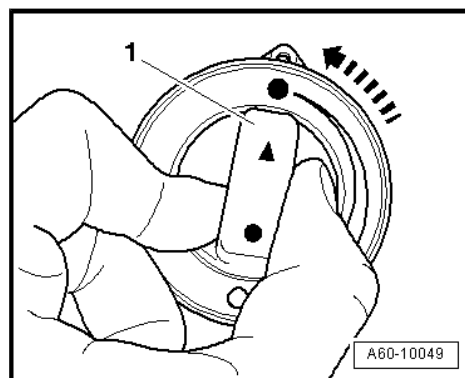
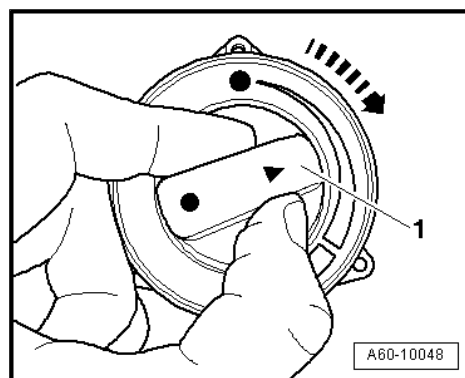
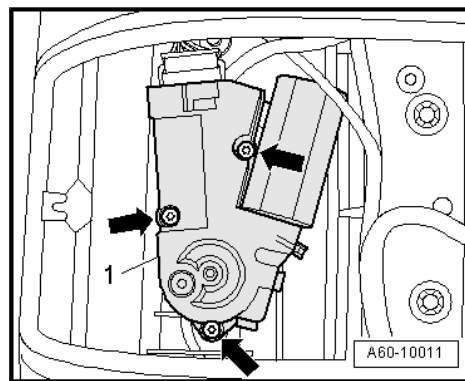
- Remove bolts -arrows- at motor.
- Unplug electrical connector and remove motor -1- from roof module.

Initialisation procedure for sunroof motor



Note

- ◆ *Initialisation/adaption must be performed following replacement of the sunroof motor or if a motor is installed in a new sunroof frame.*
- ◆ *The initialisation procedure sets the zero position for the motor.*
- ◆ *The adaption procedure sets a defined force for the roll-back function.*
- ◆ *The exact steps described below must be followed for an accurate adjustment.*
- Install motor in sunroof frame.
- Connect rotary switch to electric drive.
- Plug in connector for power supply at sunroof motor.
- Remove sunroof fuse, wait at least 10 seconds and then re-insert.
- Turn rotary switch -1- in -direction of arrow- and open sunroof.



- Turn rotary switch -1- in -direction of arrow- and close sunroof again.

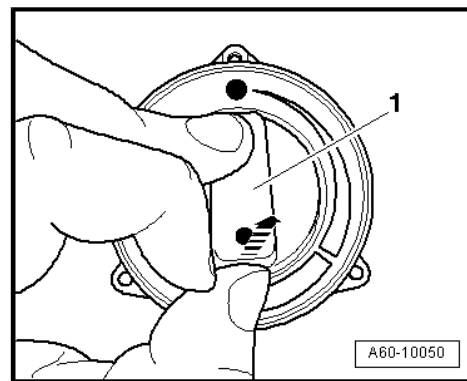
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- Within the next 5 seconds, pull rotary switch -1- in -direction of arrow-.
- Hold rotary switch in this position until sunroof is tilted, fully opened and closed again.



WARNING

- ◆ *After pulling the rotary switch, it takes approx. 8..10 seconds for the roof to start moving.*
- ◆ *The subsequent initialisation procedure is performed without roll-back function.*



- This completes initialisation and adaption and the sunroof can then be operated in the normal manner.

1.4 Checking zero position for sliding/tilting sunroof



Note

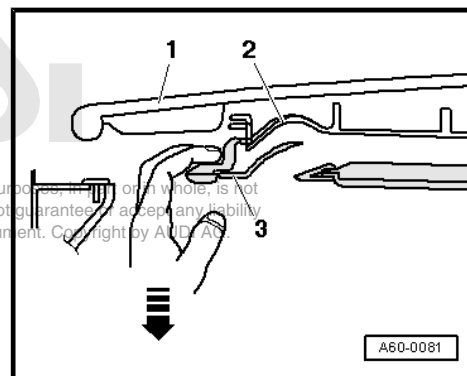
Zero position can be checked with sunroof panel fitted.

- Remove trim => [page 131](#) .
- Close sunroof.
- Push sunroof headliner completely to rear.

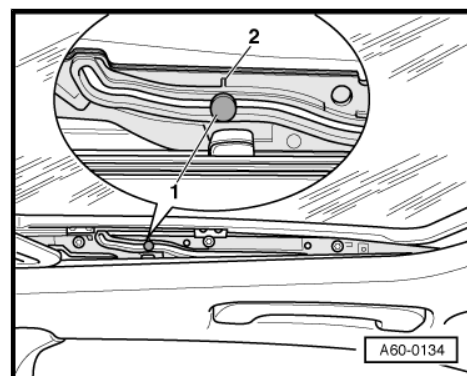
Vehicles with solar panel only

- Move sunroof panel back slightly.
- Pull sunroof headliner downwards slightly in direction of -arrow- and push it in towards rear of vehicle.

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- If zero position is correct, guide pin -1- must be centrally aligned with mark on slotted guide -2-.



1.5 Adjusting zero position for sliding/tilting sunroof



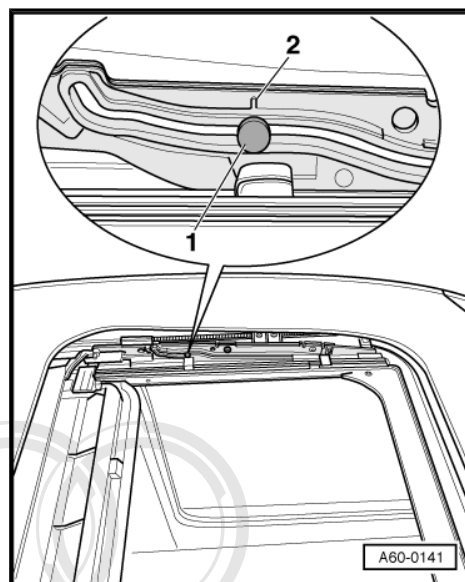
Note

- ◆ Zero position must be adjusted if:
 - ◆ the sunroof motor was not removed in zero position.
 - ◆ the sliding/tilting sunroof was opened or closed manually.
 - ◆ parts of sliding/tilting sunroof were removed and re-installed.
- Remove trim ⇒ [page 131](#) .
- Close sunroof.
- Push sunroof headliner completely to rear.
- Remove sunroof motor ⇒ [page 126](#) .
- Align guide pins -1- (left and right), so that marking -2- on slot-
ted guide is in centre.

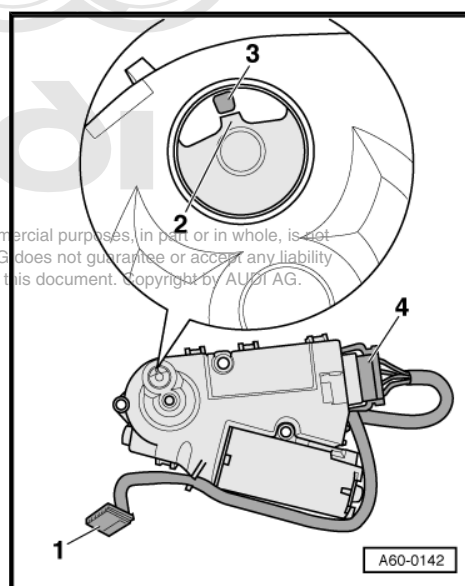


Note

Glass sunroof panel has been removed in illustration.



- Plug in electrical connector -4- for voltage supply at removed sunroof motor.
- Plug in electrical connector -1- at switch for sunroof operation (in interior light).
- Use rotary control to select “roof opened” or “roof tilted”.
- ◆ Motor automatically goes into end position.
- Move rotary control to “roof closed” position.
- ◆ Motor automatically moves to zero position and switches off - the marks -2- and -3- must be opposite one another.
- Install motor in this position with sunroof closed.



1.6 Removing and installing trim for slotted guide

Removing and installing detent segment

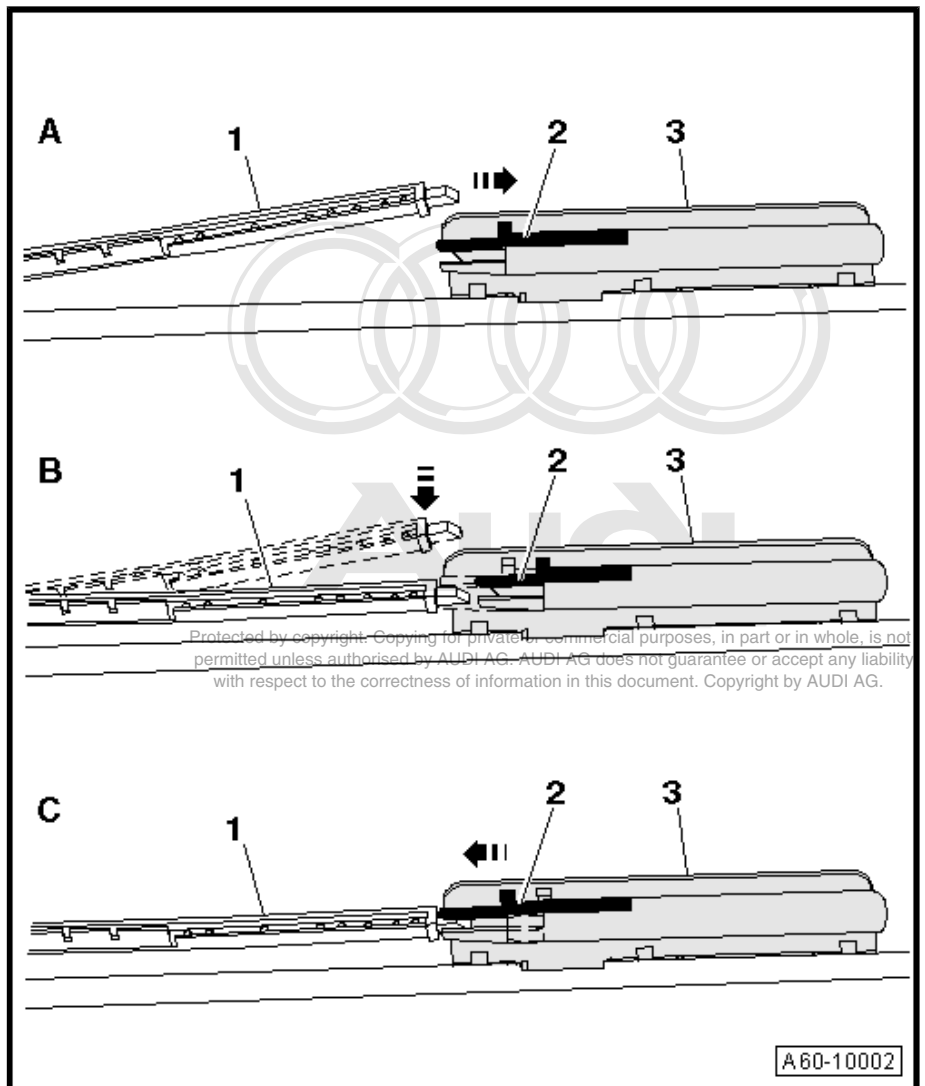
1 - Guide spring for sliding headliner

2 - Release slide for guide spring

- ☐ To release, push slide towards rear into detent segment.
- ☐ Engaging guide spring:
 - -A- Push slide -2- towards rear into detent segment -3-.
 - -B- Allow guide spring -1- to engage in detent segment -3- in direction of -arrow-.
 - -C- Allow slide -2- to spring back and lock guide spring.

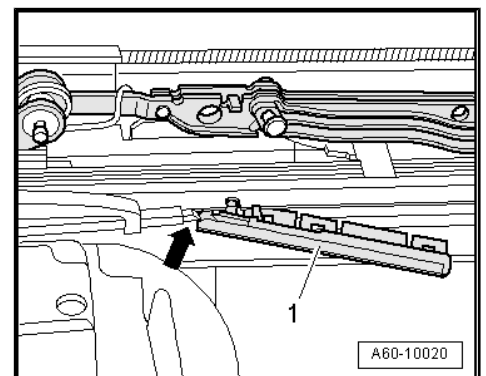
3 - Detent segment

- ☐ To remove, pull out of sunroof frame towards side.

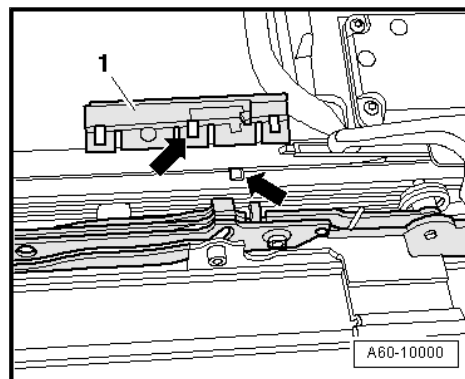


Installing detent segment

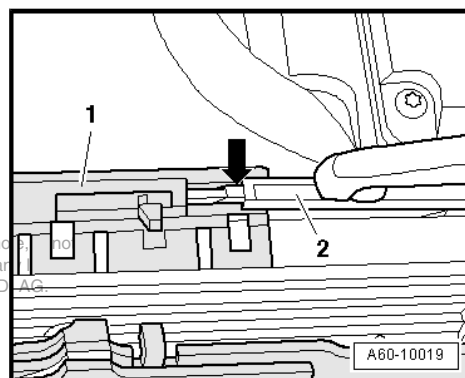
- Position detent segment -1- against spring guide as shown and press detent segment into guide on sunroof frame



- Retaining tab in detent segment -arrow- must engage in groove on sunroof frame -arrow-.



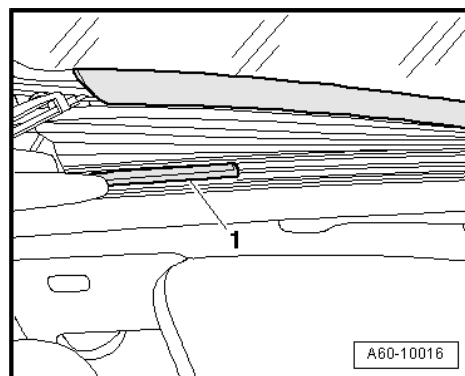
- For this purpose, lug -arrow- of spring guide -2- must engage under slide -arrow- of detent segment -1-.



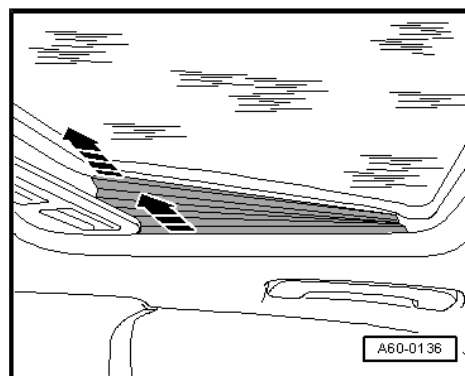
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Removing trim

- Open sunroof to tilt position.
- Push sunroof headliner all the way towards rear.
- Pull detent segment -1- out of rail towards side.



- Starting at the bottom, pull off lower trim from frame and from glass sunroof panel -arrows-.



Installing

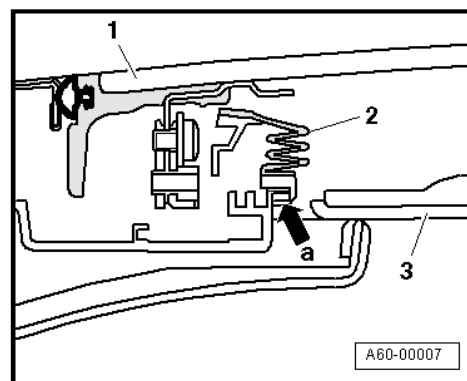
Installation is carried out in reverse order; note the following:

- Press trim -2- into retainers on glass sunroof panel -1-.
- Press trim (bottom) onto retaining strip -arrow- on frame for sunroof operation.
- Sliding headliner -3-



Note

Take special care to ensure that trim is correctly seated in rear retainer on glass sunroof panel.



1.7 Removing and installing sunroof panel

Removing

- Remove trim ⇒ [page 131](#).



Note

- ◆ Trim is fitted only on vehicles with glass panel.
- ◆ The further instructions given below apply to both glass and solar panels.
- Remove bolts -1- and -3-.
- Slacken off bolt -2- several turns.
- Lift glass sunroof panel out of roof opening.

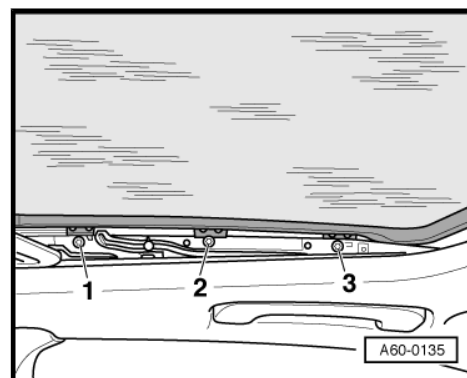
Installing

Installation is carried out in reverse order; note the following:

- Adjust sunroof panel ⇒ [page 133](#).

Tightening torque

Component	Nm
Glass sunroof panel to slotted guide	4.5

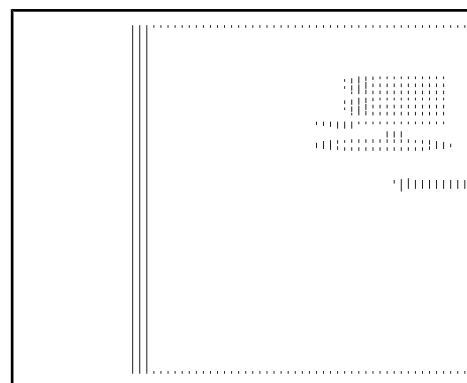


1.8 Adjusting sliding sunroof panel

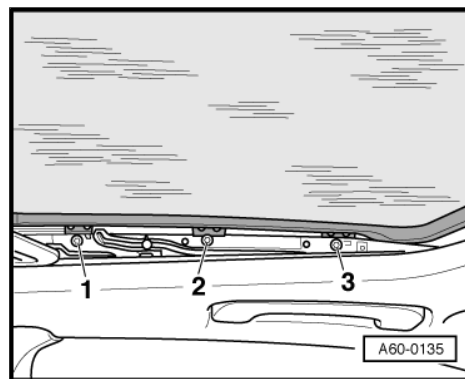
Checking adjustment

- To avoid wind noise, adjust the height of the sunroof panel at the front and rear as shown in illustration.
- Check the height adjustment at the points where the rounded corners merge with the straight parts of the roof cut-out at the front and back.
- The sunroof panel should not be higher than the roof at any point at the front or lower than the roof at any point at the rear.
- For height adjustment, always close sunroof from open (non-tilted) position.

Adjusting



- Loosen bolts -1 ... 3- several turns.
- Adjust panel.



1.9 Removing and installing seal for glass sunroof panel

Removing

- Remove glass sunroof panel ⇒ [page 133](#) .
- Pull seal -2- out of glass sunroof panel -3-.

1 - Roof opening

Installing

Installation is carried out in reverse order; note the following:

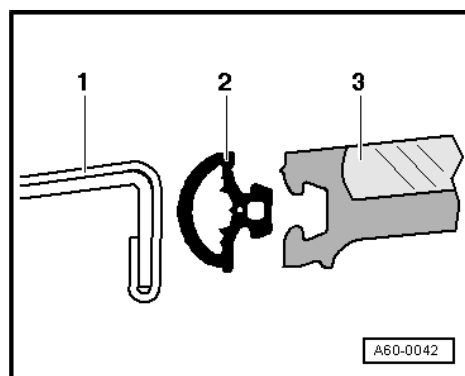
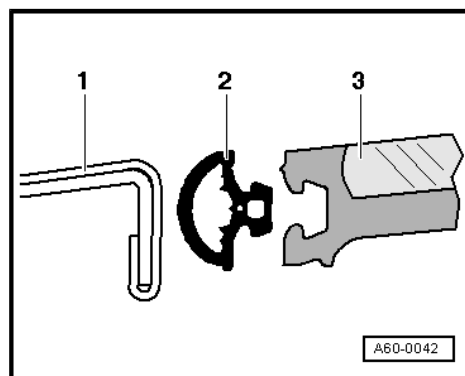


Note

To facilitate installation of seal, apply soapy water to edge of sunroof panel.

- Press new panel seal -2- into groove on reverse side of glass sunroof panel -3-, starting in the middle.

1 - Roof opening



1.10 Removing and installing sliding headliner

Removing

1 - Sliding headliner

- ☐ Sunroof panel removed
- ☐ Remove bolts -4-.
- ☐ The rear slide remains in the guide rail of the sunroof frame.
- ☐ Remove carrier plate -7- and lift out sliding headliner.

2 - Torx bolt

- ☐ 1 Nm

3 - Slide (rear)

- ☐ Remains in the guide rail on the frame.

4 - Torx bolt

- ☐ 1 Nm

5 - Extension spring

- ☐ To remove, unscrew bolts -2-.

6 - Torx bolt

- ☐ 1 Nm

7 - Carrier plate for rear slide

- ☐ To remove, unscrew bolts -2-.

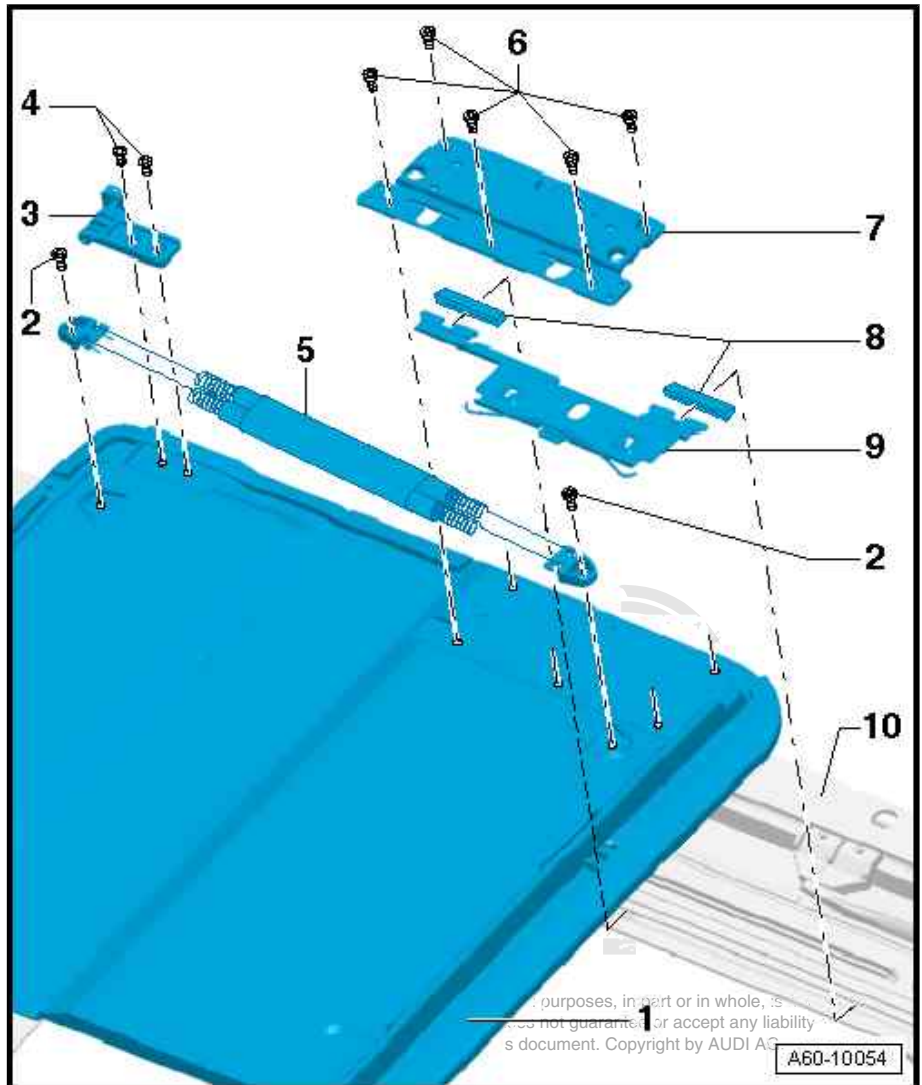
8 - Slide

- ☐ Pushed on to retaining plate for spring.

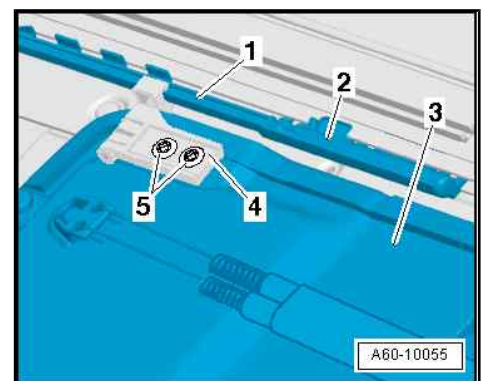
9 - Retaining plate for spring

- ☐ Not available as a separate replacement part

10 - Frame



- Remove glass sunroof panel ➔ [page 133](#).
- Pull sliding headliner -3- forwards until bolts -5- for rear slides -4- are accessible.
- Unscrew bolts -5-.
- The slides -4- remain with the guide in the guide rail -1-.
- Remove detent segment -2- ➔ [page 131](#).
- Unscrew bolts -4- and remove cover plate -3-.



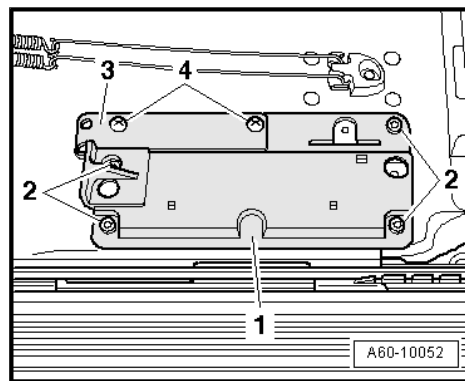
- Remove bolts -2- and lift carrier plate -1- for slides out of guide rail at an angle.
- Push sunroof headliner forwards out of frame for sunroof operation.
- The rear slides remain in the guide rail.

Installing

Install in reverse order of removal.

Tightening torque

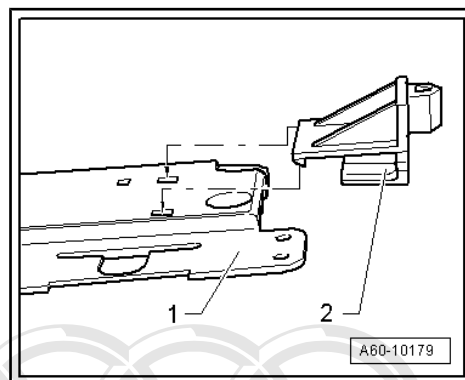
Component	Nm
Sunroof headliner to slide	1



Stop for carrier plate

- Slide the stop -2- onto carrier plate -1- as shown in illustration, making sure that the retaining hooks engage in the holes.

Vehicles with solar panel only

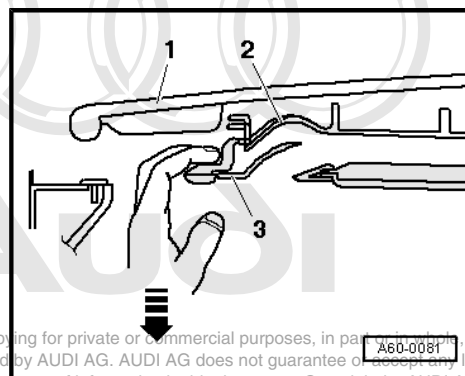


- Move sunroof panel back slightly.
- Pull sunroof headliner downwards slightly in direction of -arrow- and push it in towards rear of vehicle.



Note

This causes the guide pins on the headliner to be pushed out of the guides towards the rear, allowing the headliner to be removed after the sunroof panel is detached.



- Tilt the solar panel.
- Remove the sunroof panel (follow the instructions for the glass panel ⇒ [page 133](#)) and pull out the headliner.
- Install in reverse order, paying attention to the following.
- Insert headliner in roof and slide it through roof opening towards rear of vehicle.
- Install and adjust solar panel.
- Close solar panel.



Caution

The headliner must be pushed in towards the front of the vehicle with the solar panel closed so that the guide pins on the solar panel slide into the guides at the rear of the headliner.

- Slide the headliner forwards and allow it to engage with the solar panel at the centre.

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1.11 Removing and installing frame for sunroof operation

Exploded view

1 - Sunroof frame

- To install, secure frame using nuts with washers -4- and bolts with washers -3- beginning at front centre, then alternately left and right towards rear.

- ☐ After installing frame, push water drain hoses fully into position.

2 - Water drain hose (rear)

3 - Bolts with washers

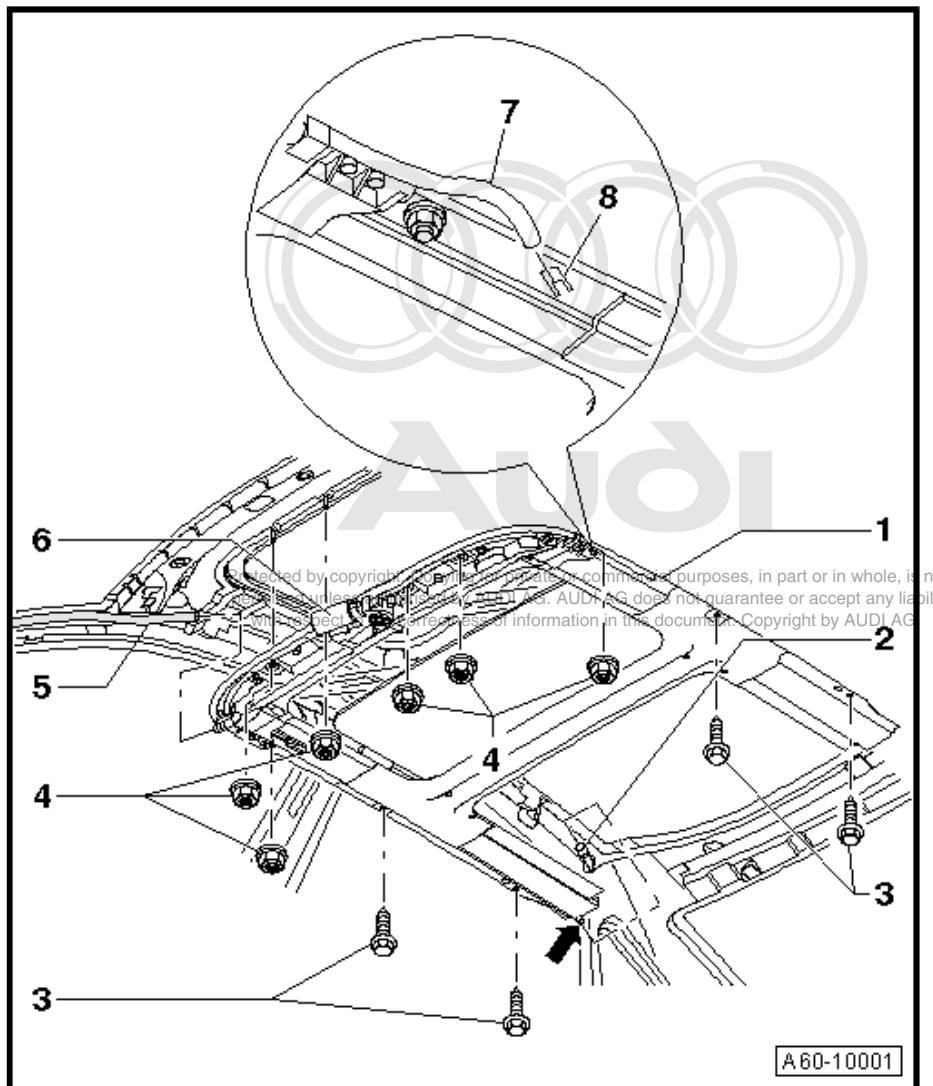
- ☐ 8 Nm

4 - Nuts

- ☐ 8 Nm

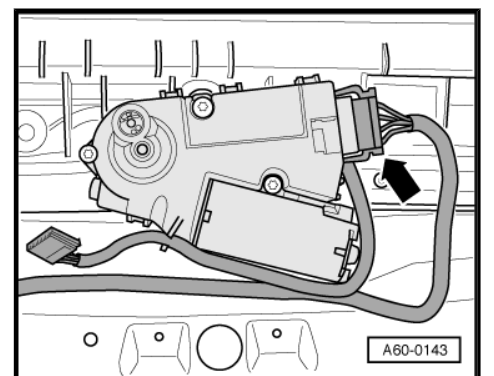
5 - Water drain hose (front)

6 - Sunroof motor

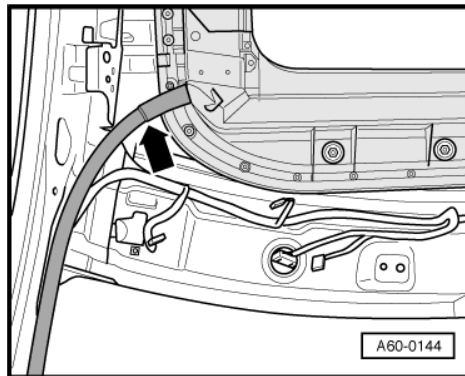


Removing

- Remove moulded headliner. ⇒ Rep. gr. 70
- Unplug electrical connector -arrow- at motor.



- Detach water drain hoses -arrow- (front and rear) from frame.



- Unscrew nuts and bolts -arrows-.



Note

A 2nd mechanic is required for removing the frame for sunroof operation.

- Remove frame for sunroof operation.

Installing

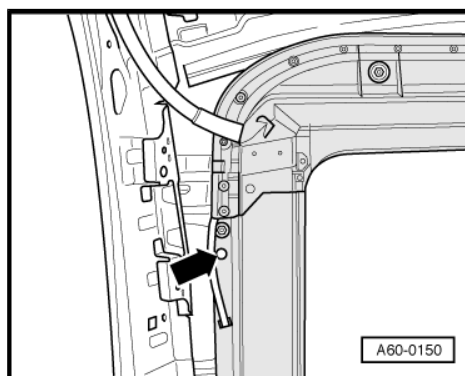
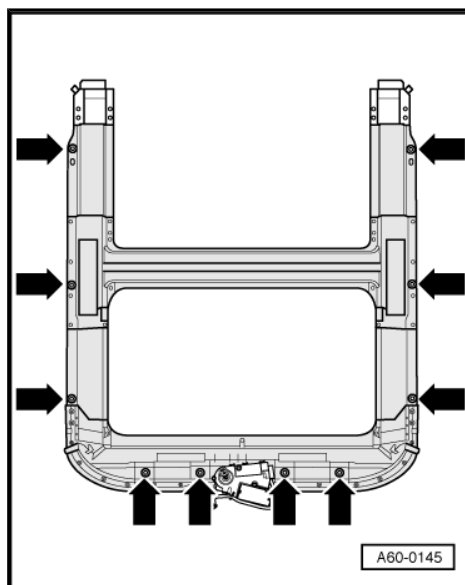
Installation is carried out in reverse order; note the following:



Note

Renew self-locking nuts and bolts when performing assembly work.

- Insert frame for sunroof operation into body and hand-tighten bolts on left and right.
- Align centring holes of frame for sunroof operation and body at front -arrow- ...

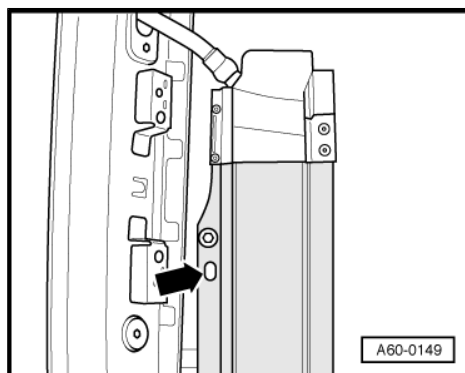


- and rear -arrow-.
- Tighten nuts and bolts in the specified sequence.
- ◆ Front centre, side, rear
- Adjust glass sunroof panel ⇒ [page 133](#) .

Tightening torque

- 1) Renew nuts/bolts

Component	Nm
Frame for sunroof operation to body	8

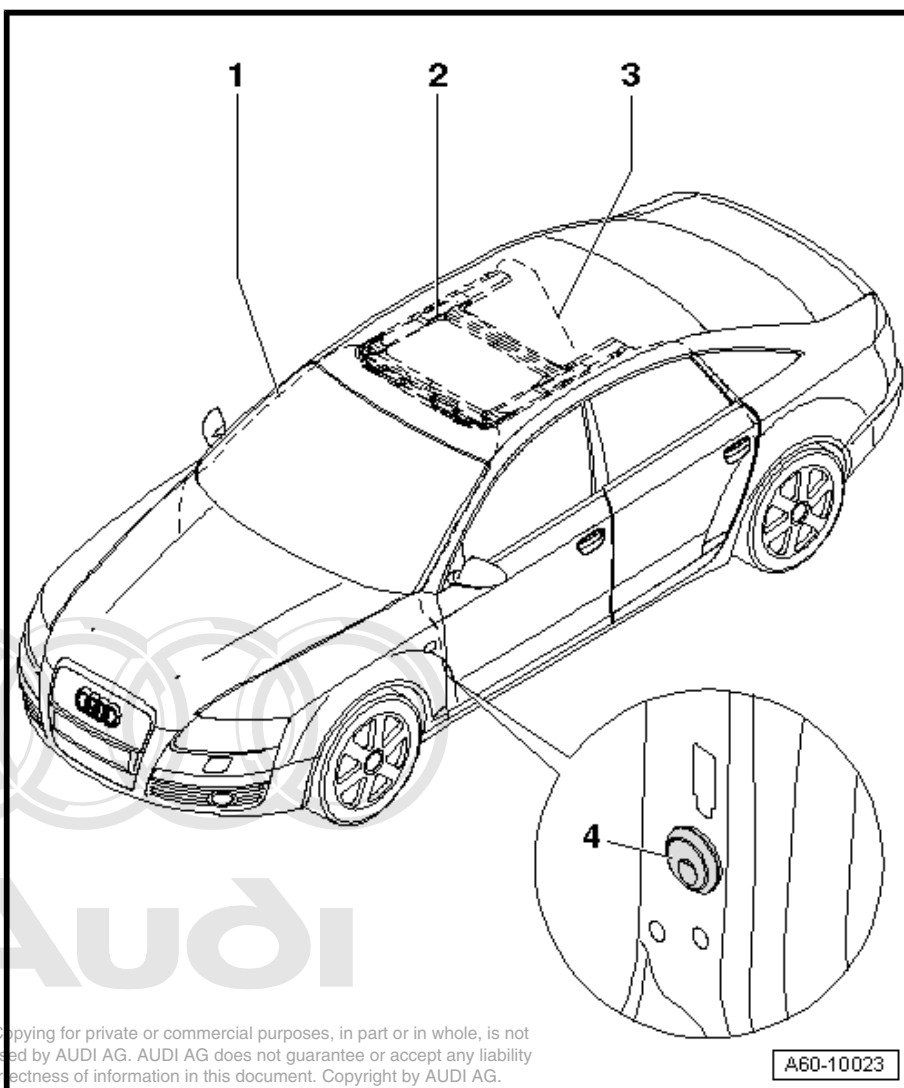


2 Water drain hoses

Saloon

1 - Water drain hose (front)

- The water drain hoses (front) are routed along the A-pillars and end at the bottom behind the door.
- Cleaning is performed from sunroof frame.
- ☐ Removing and installing
 - Remove A-pillar trim (top and bottom).
 - Lower moulded headliner in area of connections on sunroof frame.
 - Pull water drain hose off sunroof at front and unclip it from clips on A-pillar.
 - Unfasten grommet at bottom of A-pillar and pull water drain hose out downwards.
 - Install in reverse order of removal.



2 - Sunroof frame

3 - Water drain hose (rear)

- Water drain hoses (rear) are located in C-pillars and end in wheel housing below wheel housing liner.
- Clean from lower end of hose.
- ☐ Removing and installing
 - Remove C-pillar trim and lower moulded headliner in area of connections on sunroof frame.
 - Detach water drain hose at connection on sunroof frame.
 - Attach a cord to top of water drain hose to make it easier to pull it in.
 - Unfasten wheel housing liner in area of water drain hose and push to one side.
 - Unfasten C-pillar grommet under wheel housing liner at wheel housing and firmly pull out water drain hose downwards.
 - To make it easier to install new water drain hose, spray it with soap solution or similar. Then use cord to pull it back up through the C-pillar.
 - Working from below, also push the water drain hose through (with the help of a second mechanic if required).

4 - Grommet for A-pillar

5 - Grommet for C-pillar

Avant

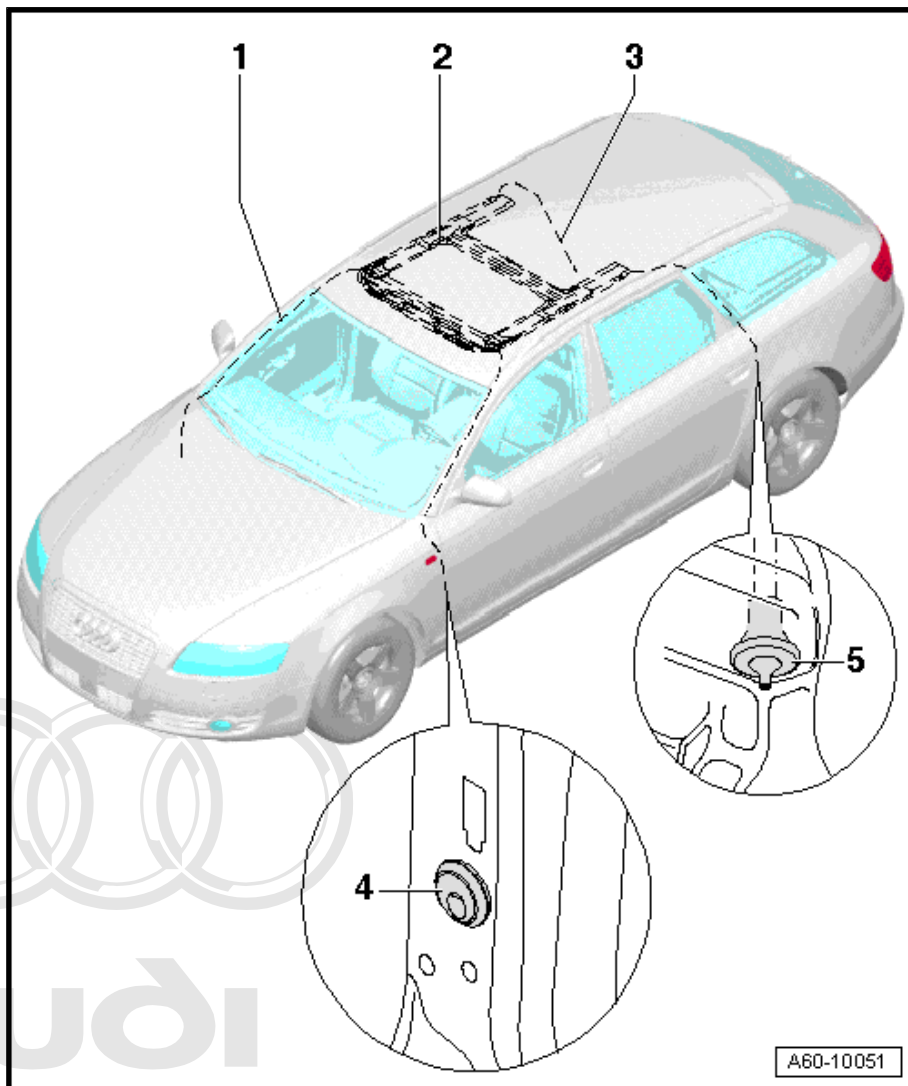
1 - Water drain hose (front)

- The water drain hoses (front) are routed along the A-pillars and end at the bottom behind the door.
- Cleaning is performed from sunroof frame.
- ☐ Removing and installing
- Remove A-pillar trim (top and bottom).
- Lower moulded headliner in area of connections on sunroof frame.
- Pull water drain hose off sunroof at front and unclip it from clips on A-pillar.
- Unfasten grommet at bottom of A-pillar and pull water drain hose out downwards.
- Install in reverse order of removal.

2 - Sunroof frame

3 - Water drain hose (rear)

- Water drain hoses (rear) are located in C-pillars and end in wheel housing below wheel housing liner.



A60-10051

- Clean from lower end of hose.

☐ Removing and installing

- Remove C-pillar trim and lower moulded headliner in area of connections on sunroof frame.
- Detach water drain hose at connection on sunroof frame.
- Attach a cord to top of water drain hose to make it easier to pull it in.
- Unfasten wheel housing liner in area of water drain hose and push to one side.
- Unfasten C-pillar grommet under wheel housing liner at wheel housing and firmly pull out water drain hose downwards.
- To make it easier to install new water drain hose, spray it with soap solution or similar. Then use cord to pull it back up through the C-pillar.
- Working from below, also push the water drain hose through (with the help of a second mechanic if required).

4 - Grommet

2.1 Cleaning water drain hoses



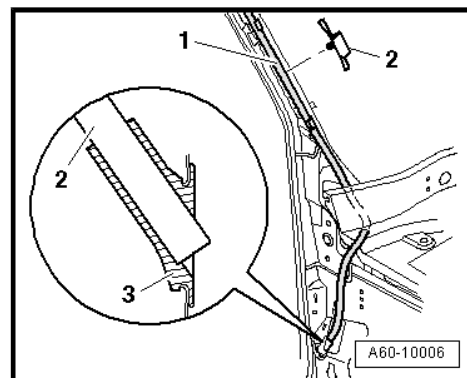
Note

To clean the water drain hoses we recommend that you use an improvised tool (approx. 2300 mm long), made of the speedometer drive cable core.

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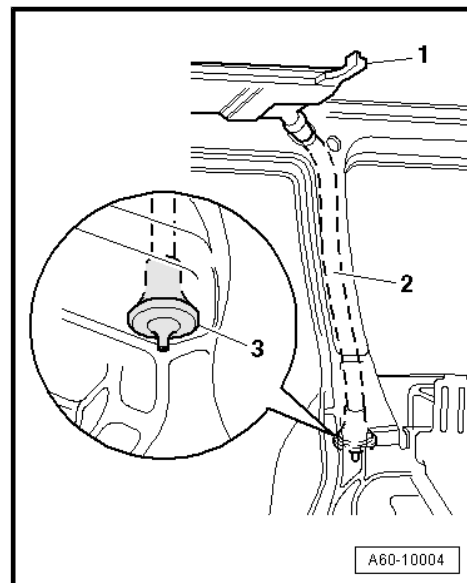
Water drain hose (front)

- Water drain hoses (front) -1- are located in A-pillars and end behind door at bottom of A-pillar in grommet -3-.
- They can be cleaned from the sunroof opening.



Water drain hose (rear)

- Water drain hoses (rear) -2- are located in C-pillars and end in wheel housing above wheel housing liner -3-.
- Clean from lower end of hose.
- For this purpose, remove rear wheel housing liner
⇒ [page 231](#).

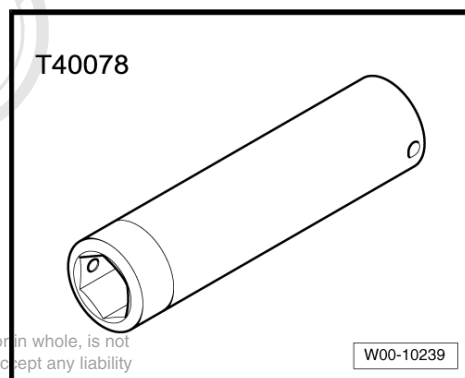


63 – Bumpers

1 Bumper (front)

Special tools and workshop equipment required

- ◆ Socket - T40078-



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1.1 Removing and installing bumper (front)

Exploded view

1 - Bumper



Note

On vehicles with »ACC« the heated cover must be pulled off before the bumper is dismantled and the electrical connectors must be unplugged
⇒ [page 146](#).

- ☐ Cover for lock carrier removed ⇒ [page 145](#)
- ☐ Removing and installing bumper ⇒ [page 147](#)
- ☐ Removing and installing number plate carrier ⇒ [page 145](#)

When installing, retaining tab -arrow- must engage behind wing -6-.

2 - Bolt with washer

- ☐ M6 x 50 mm
- ☐ 8 Nm

3 - Torx bolt

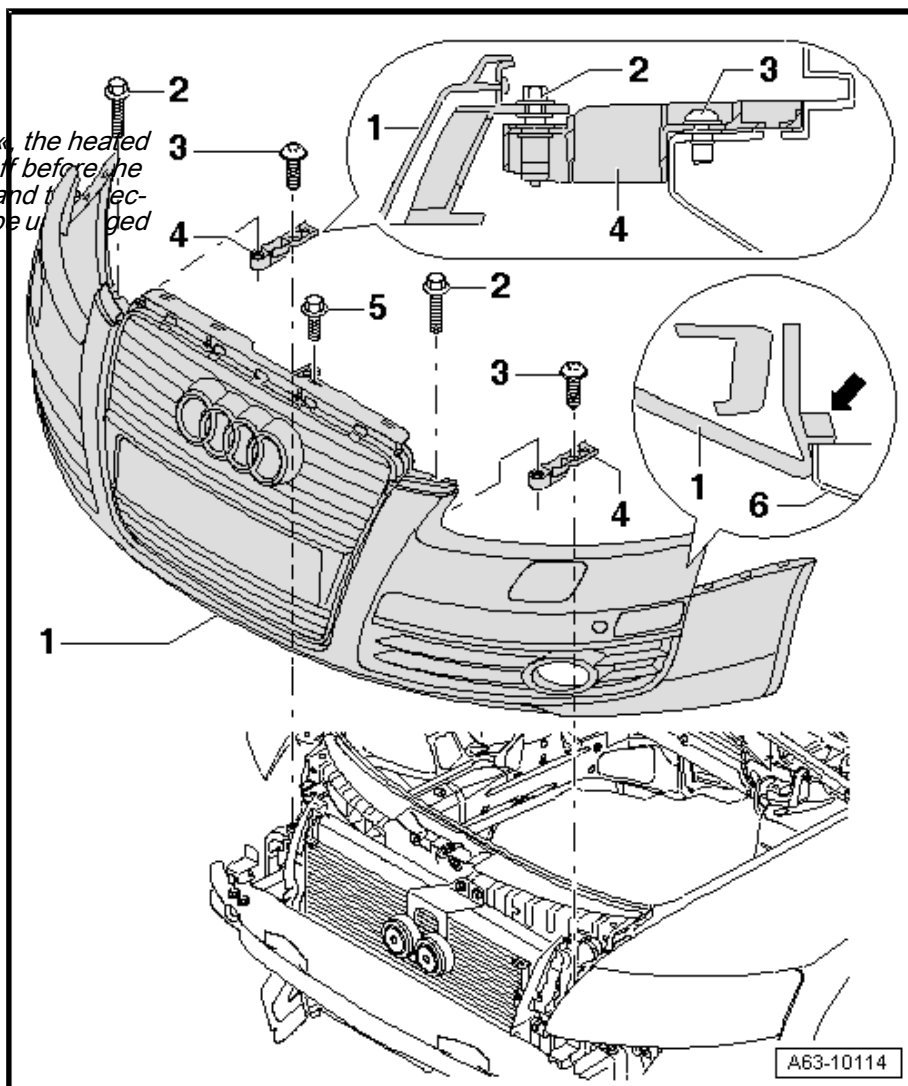
- ☐ 3.5 Nm

4 - Bracket

5 - Bolt with washer

- ☐ M6 x 25mm
- ☐ 8 Nm

6 - Wing



allroad vehicles

Only features which are different from the standard bumper are described.

1 - Bumper

- ☐ The procedure for removal and installation is the same as for standard bumpers.

2 - Bolt

- ☐ 2 Nm

3 - Bolt

- ☐ 2 Nm

4 - Spoiler

- ☐ Bumper removed
- ☐ Spoiler is clipped to bumper ⇒ [page 143](#).
- ☐ Release clips one by one to remove.

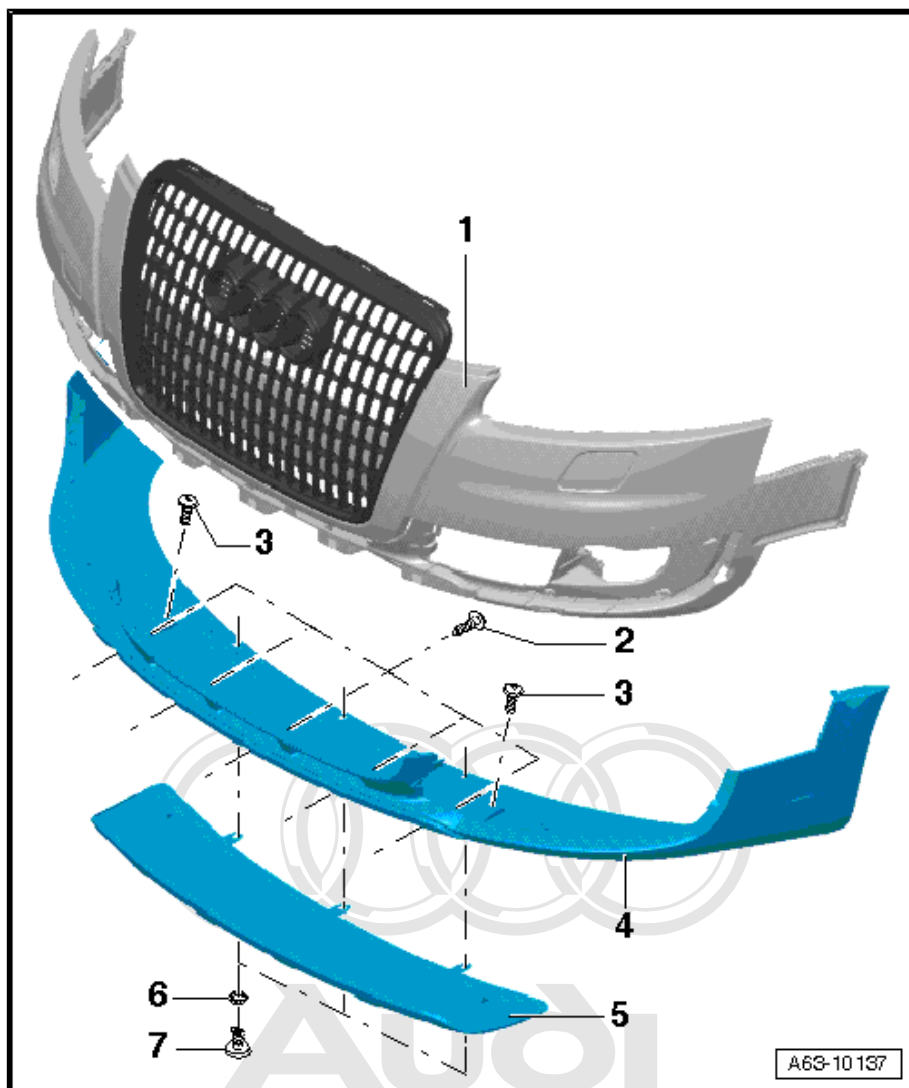
5 - Impact protection

- ☐ To remove, unscrew bolts -2- and -3-, slide impact protection slightly forwards out of spoiler and detach.

6 - Washer

7 - Quick-release fastener

- ☐ 4 Nm

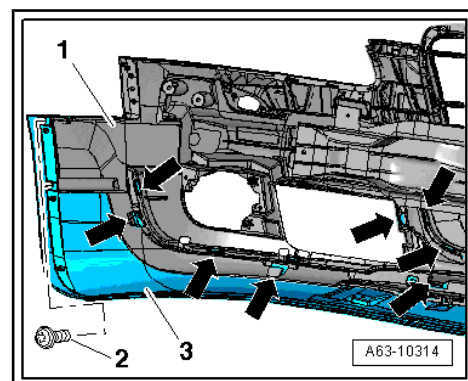


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Outer attachment points

- Bumper removed
- Unscrew bolts -2- on left and right.
- Release fasteners -arrows- and gradually unfasten spoiler -3- from bumper -1-.
- Clip spoiler onto bumper at all fastening points -arrows-.
- Tighten bolts to 2 Nm on both sides.

Attachment points



1 - Bolts with washers

- These bolts are located under the wheel housing liner.

□ 1.5 Nm

2 - Cover

3 - Speed nut

4 - Securing clip

5 - Quick-release fastener

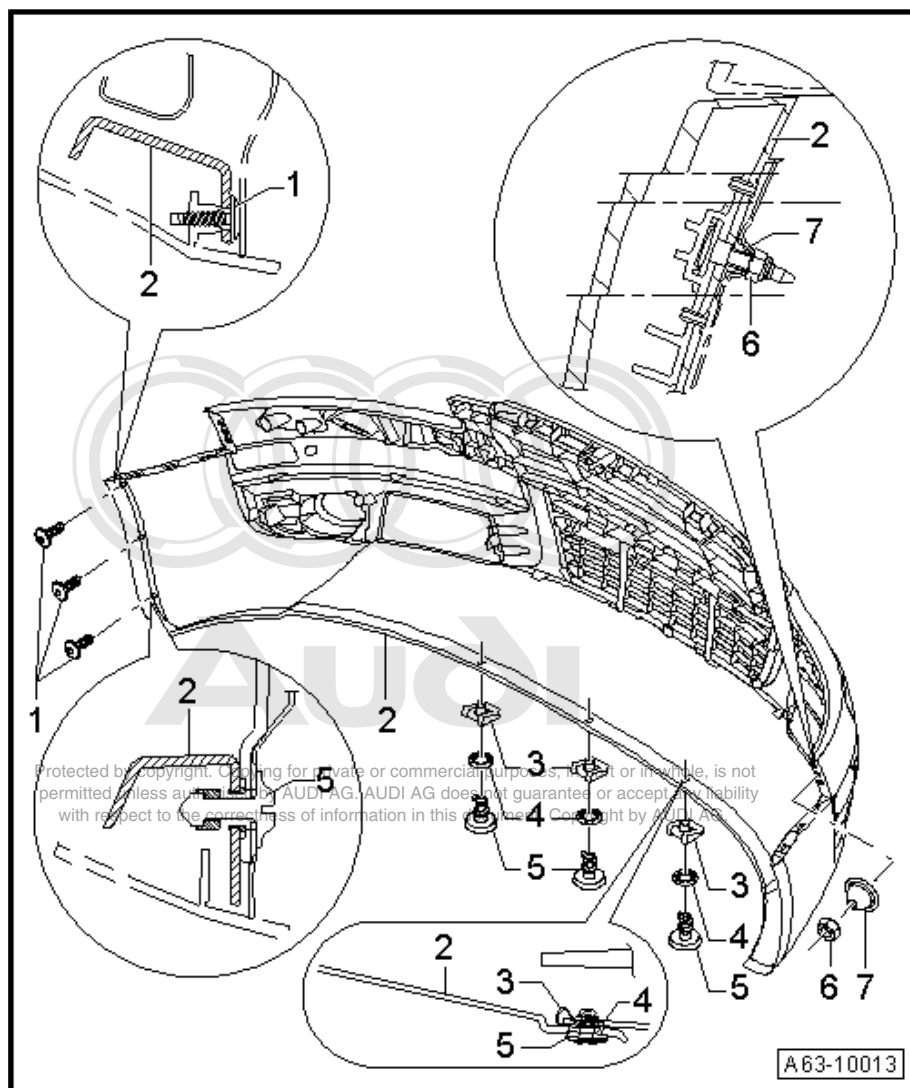
□ 4 Nm

6 - Hexagon nut

□ 4 Nm

- Use special socket - T40078- to loosen and tighten this nut.

7 - Grommet



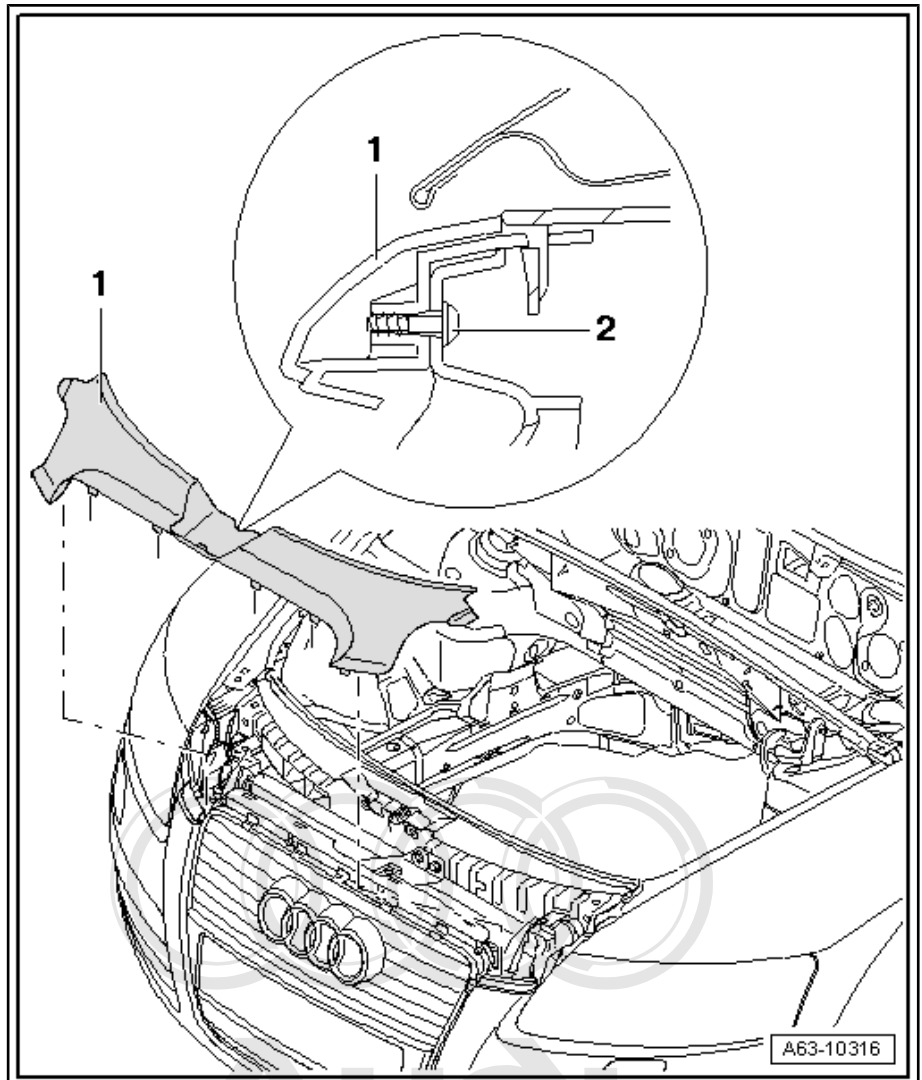
1.2 Removing and installing lock carrier cover

1 - Cover

- To remove, first unclip on front side of lock carrier, then detach towards front.

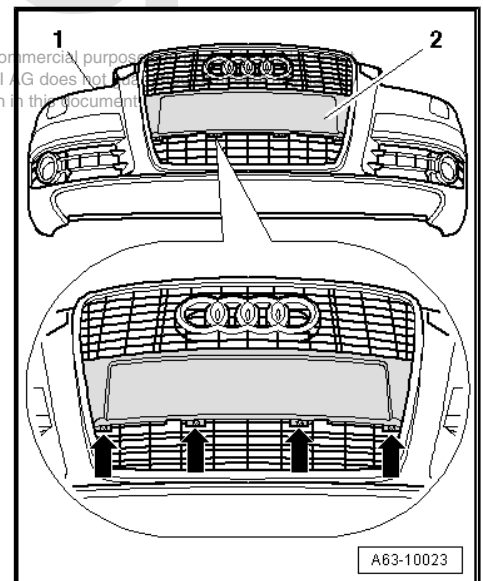
2 - Self-tapping screw

- 1.5 Nm



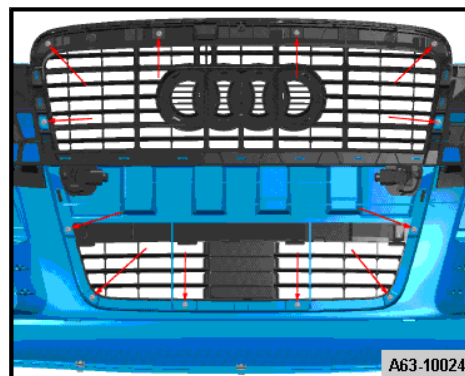
1.3 Removing and installing number plate carrier

- Remove bolts (bottom) -arrows-.
- First pull out number plate carrier at bottom and then pull it off towards the front.



1.4 Removing and installing radiator grille

- Bumper cover removed
- Remove all bolts -arrows- and remove trim grille from bumper cover.
- When installing, tighten bolts to 1 Nm.



1.5 Removing and installing cover on vehicles with ACC (adaptive cruise control)

1 - Cover for radiator grille (standard)

- ☐ To remove, carefully pull cover forwards slightly out of bumper cover without damaging louvres.
- ☐ Unplug electrical connectors and remove cover from bumper cover towards front.

2 - Cover for radiator grille (S-line)

- ☐ The procedure for removal and installation is the same as for standard version.

3 - Lens for ACC

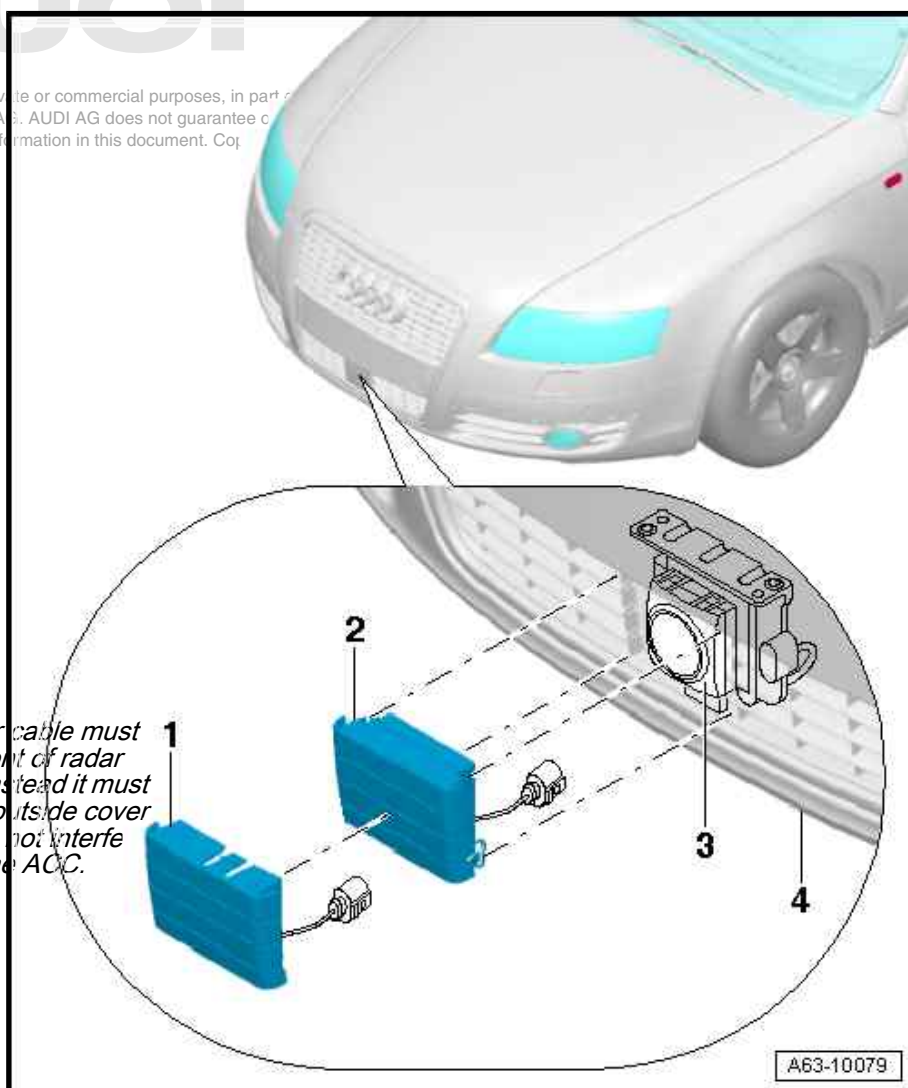
- ☐ Removing and installing ⇒ Rep. gr. 44



Note

When installing, heater cable must not be positioned in front of radar lens for ACC sensor. Instead it must be placed to the side, outside cover housing so that it does not interfere with the operation of the ACC.

4 - Bumper cover

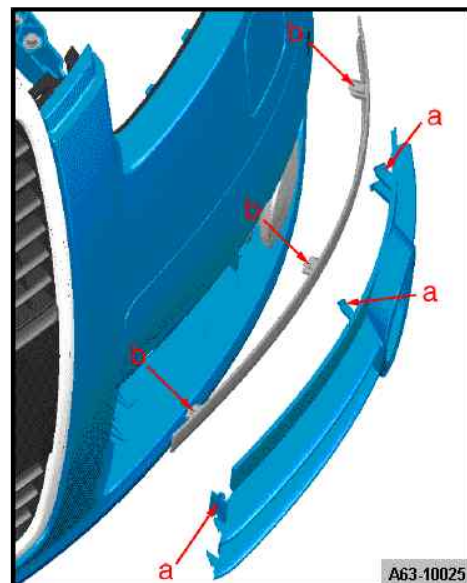


1.6 Removing and installing air intake grille

Note

The trim strip is secured additionally by double-sided adhesive tape and cannot be removed undamaged.

- To remove, pull air intake grille -arrows a- out of bumper cover from inside outwards.
- Bumper cover must be removed before detaching trim strip.
- Remove bolts from inside -arrows b- and detach trim strip towards front.
- When installing, tighten bolts to 1 Nm.



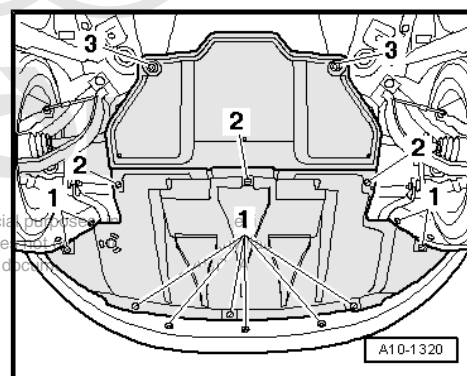
1.7 Removing and installing bumper (front)

Removing

- Remove lock carrier cover ➔ [page 145](#) .
- Remove bolts at top of cover ➔ [page 142](#) .

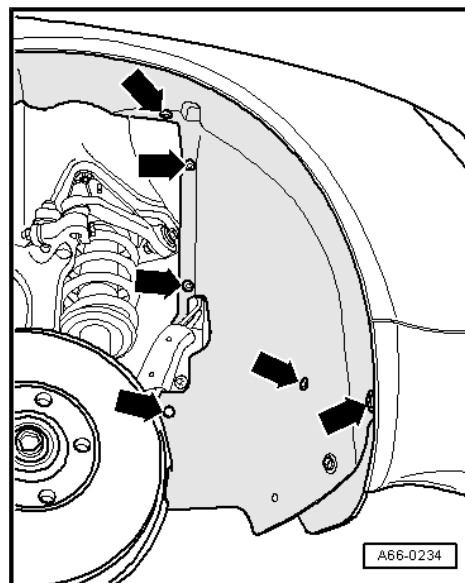
Note

- ◆ *For greater clarity, illustrations are shown with wheels removed from vehicle.*
- ◆ *The wheels remain installed when removing the bumper.*
- ◆ *Set steering so that front wheel points inwards on side of vehicle on which wheel housing liner is to be folded back.*
- For this purpose, release bolts/quick-release fasteners -1- and -2-. Leave quick-release fasteners -3- for noise insulation panel (rear) in position.

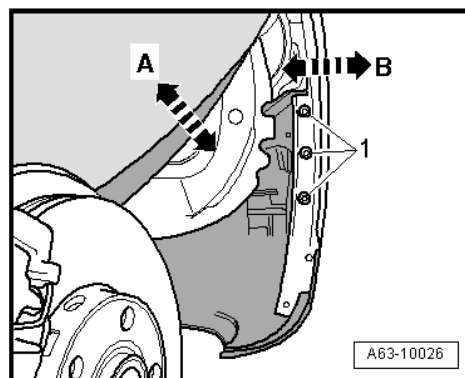


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- Release left and right wheel housing liners in front area -arrows-.



- Press off wheel housing liner upwards -arrow A-.
- Unscrew bolts -1-.
- Use socket - T40078- to unscrew nuts for zero-gap panel joint connection ⇒ [Item 6 \(page 144\)](#) (nuts are located above bolts).
- Unclip side section of bumper from retainer -arrow B-.



- Repeat procedure on opposite side of vehicle.
- Unplug all electrical connectors -2- and, if necessary, detach hose connection -1- for headlight washer system at bumper.

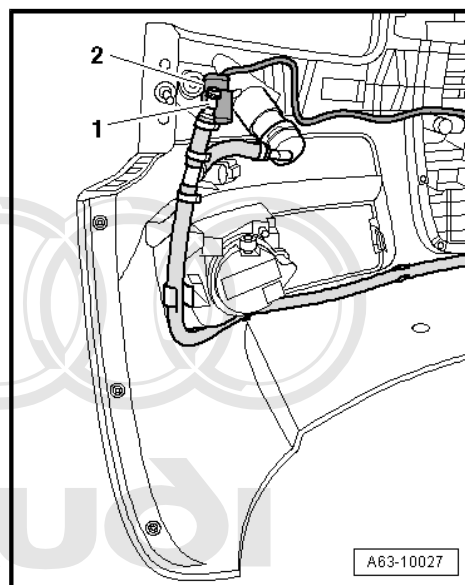
Installing

Installation is carried out in reverse order; note the following:



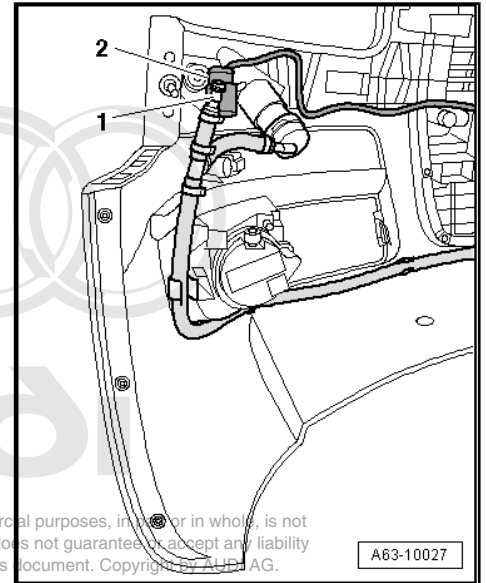
Note

Before installing bumper, check that threaded pins have been fitted at side sections of bumper, and that fasteners and grommets have been fitted in wings.



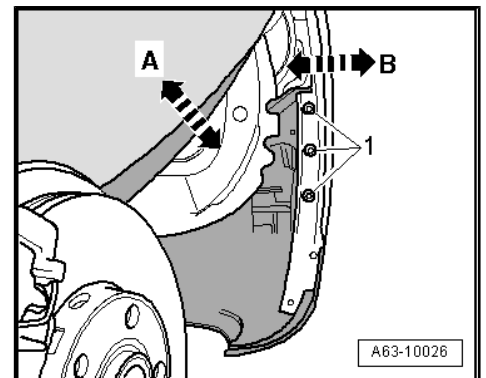
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- Fit bumper, reattach hose -1- for headlight washer system and reattach connectors.
- Push bumper into installation position. Ensure that threaded pins in bumper side sections engage in holes in wing.



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- Fold back wheel housing liner -arrow A-.
- Press side section of bumper inwards into retainer on guide -arrow B-.
- Tighten bolts -1- (1 Nm).
- Repeat procedure on opposite side of vehicle.

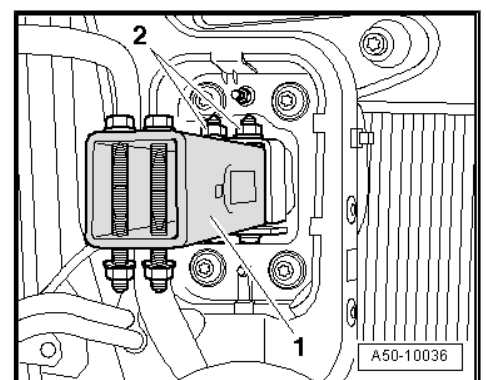


1.8 Removing and installing impact dampers

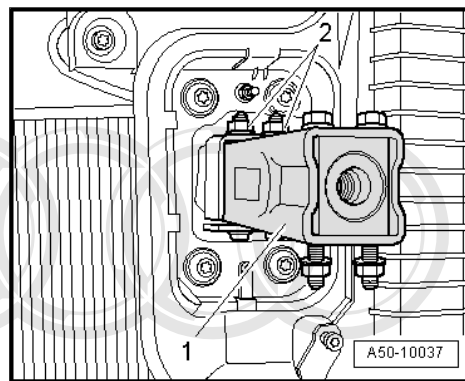
Impact damper (right-side)

- Bumper removed
- Unscrew nut -2- and remove bolts.
- Pull impact damper -1- out of longitudinal member.
- To install, tighten bolts with washers -2- to 20 Nm.

Impact damper (left-side)



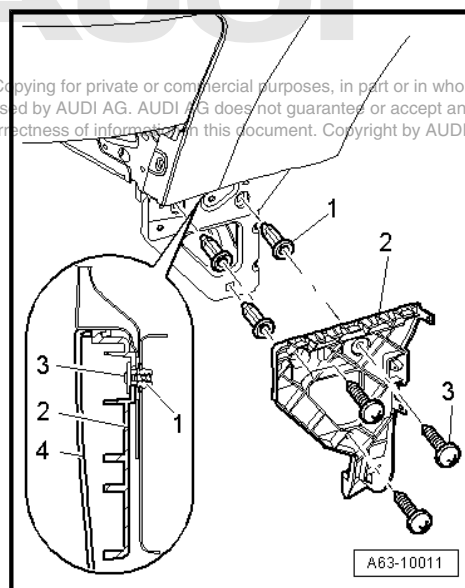
- Bumper removed
- Pull impact damper -1- out of longitudinal member.
- To install, tighten bolts with washers -2- to 20 Nm.



1.9 Removing front guide

- Bumper removed
- To remove, unscrew bolts -3- and detach guide.
- When installing, tighten bolts to 1 Nm.
- When installing, cover -4- must engage in retainers on guide (top) -2-.
- ◆ Clip -1- inserted in wing (bottom).

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2 Bumper (rear)

2.1 Removing and installing bumper cover

Saloon

1 - Cover

- ☐ Removing:



Note

On vehicles with lane change assist the control unit must be re-calibrated after removing the bumper → Rep. gr. 96.

- ☐ Remove luggage compartment side trim. → Rep. gr. 70
- ☐ Unplug electrical connectors for parking aid senders from control unit (on right side in side panel).
- ☐ Unscrew bolts from underside of cover and from wheel housing liner → [page 154](#).
- ☐ Unscrew cap nuts -12- (can be accessed from luggage compartment) → [page 154](#).
- ☐ Unbolt wheel housing liners (rear section).
- ☐ Unclip side sections of cover from guide.
- ☐ Detach cover.

2 - Grommet

- ☐ Grommets must be pushed onto studs before installing cover.

3 - Bolt

- ☐ 1 Nm

4 - Bolt

- ☐ 1 Nm

5 - Adjuster element (left-side)

6 - Clip

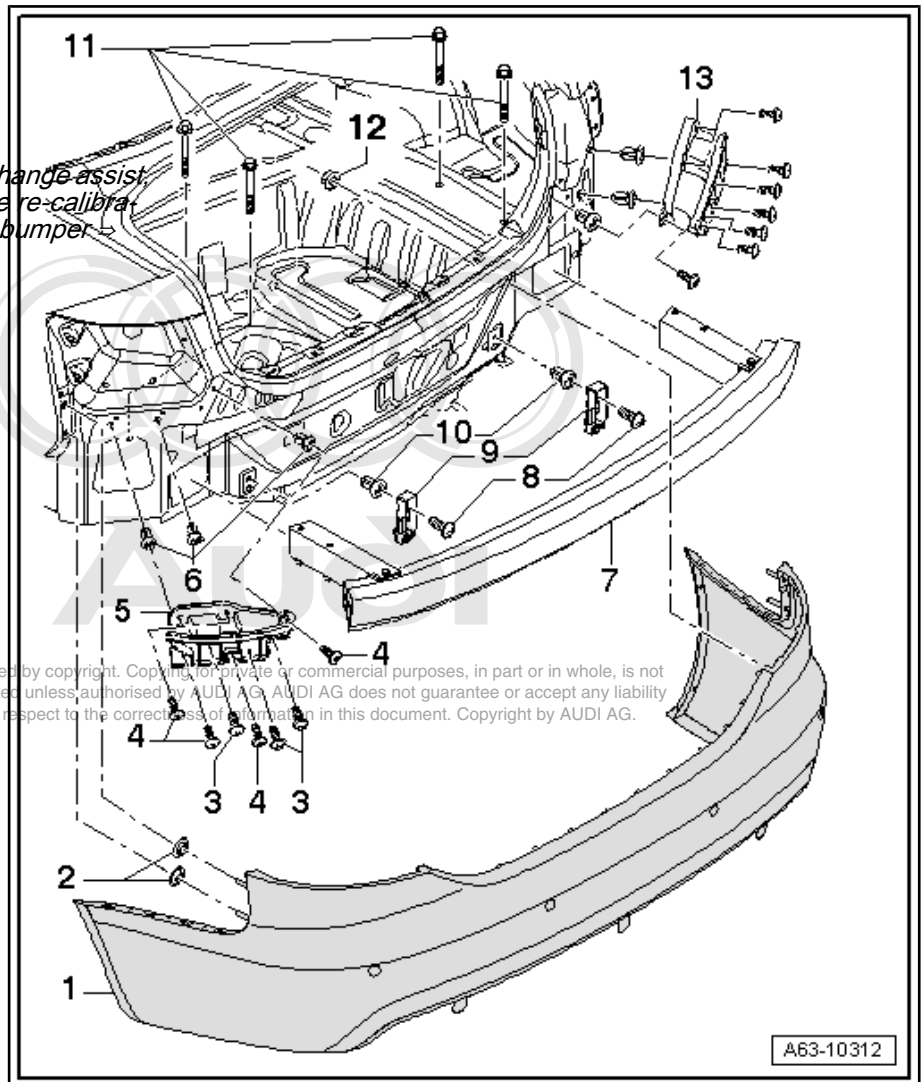
- ☐ Inserted into rear cross panel

7 - Cross member for bumper

- Before removing, detach cover -1-.
- ☐ Removing → [page 156](#)

8 - Bolt

- ☐ 1.5 Nm



9 - Retaining strap

10 - Clip

- ☐ Insert in rear cross panel.

11 - Bolt

- ☐ 20 Nm

12 - Nut

- ☐ 4 Nm

13 - Adjuster element (right-side)

Avant

1 - Bumper

- ☐ Removing:
- ☐ Remove luggage compartment side trim. ⇒ Rep. gr. 70
- ☐ If fitted, unplug electrical connectors for parking aid senders at control unit (on left beneath rear light).
- ☐ Unscrew cap nuts -8- (can be accessed from luggage compartment) ⇒ [page 154](#).
- ☐ Unscrew bolts for wheel housing liners in area of cover.
- ☐ Remove bolts on left and right at guide ⇒ [page 156](#).
- ☐ Unclip side sections of cover on side of guide.
- ☐ Detach cover.

2 - Grommet

- ☐ Fit onto studs before installing cover.

3 - Adjuster element (left-side)

4 - Bolt

- ☐ 1 Nm

5 - Clip

- ☐ Inserted into rear cross panel

6 - Adjuster element (left-side)

7 - Bolt

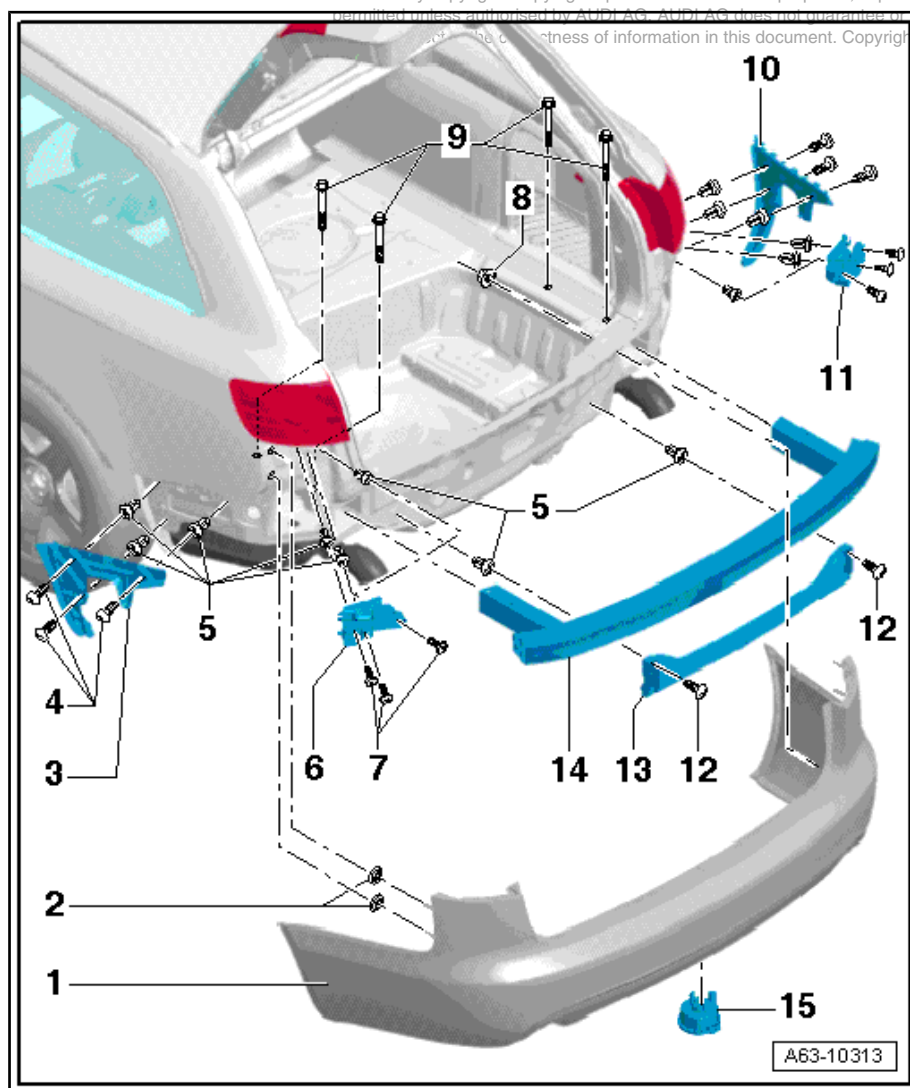
- ☐ 4 Nm

8 - Nut

- ☐ 4 Nm

9 - Bolt

- ☐ 20 Nm



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10 - Guide (right-side)

- ❑ Removing ➔ [page 156](#)

11 - Adjuster element (right-side)

12 - Bolt

- ❑ 1.5 Nm

13 - Retaining strap

14 - Cross member for bumper

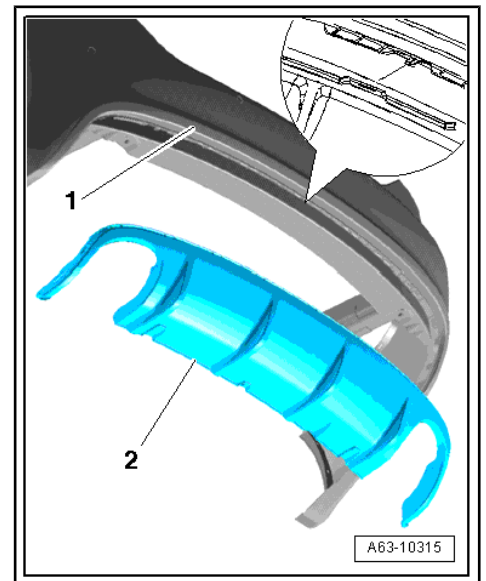
- ❑ Removing and installing ➔ [page 156](#)

15 - Support piece

- ❑ Removing and installing ➔ [page 155](#)

Removing spoiler (RS 6)

- Bumper -1- removed
- Unclip spoiler -2- at all fastening points and pull out.
- When installing, ensure that fasteners are fully engaged.

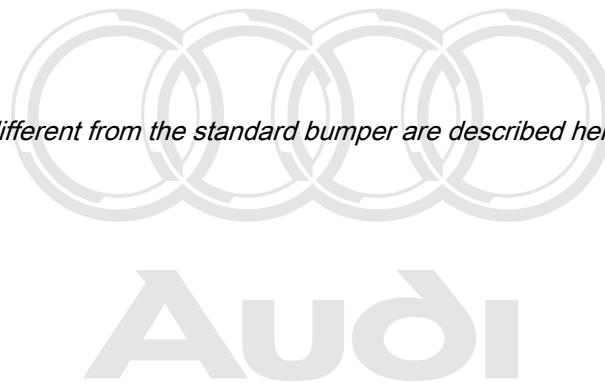


allroad vehicles



Note

Only features which are different from the standard bumper are described here.



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1 - Bumper (rear)

- ☐ The procedure for removal and installation is the same as for standard bumpers.
- ☐ Does not have to be removed to detach spoiler and impact protection

2 - Bolt

- ☐ 2 Nm

3 - Bolt

- ☐ 2 Nm

4 - Spoiler

- ☐ Bumper installed
- ☐ Remove bolts -2- and -5- and pull spoiler out of bumper together with impact protection.

5 - Bolt

- ☐ 2 Nm

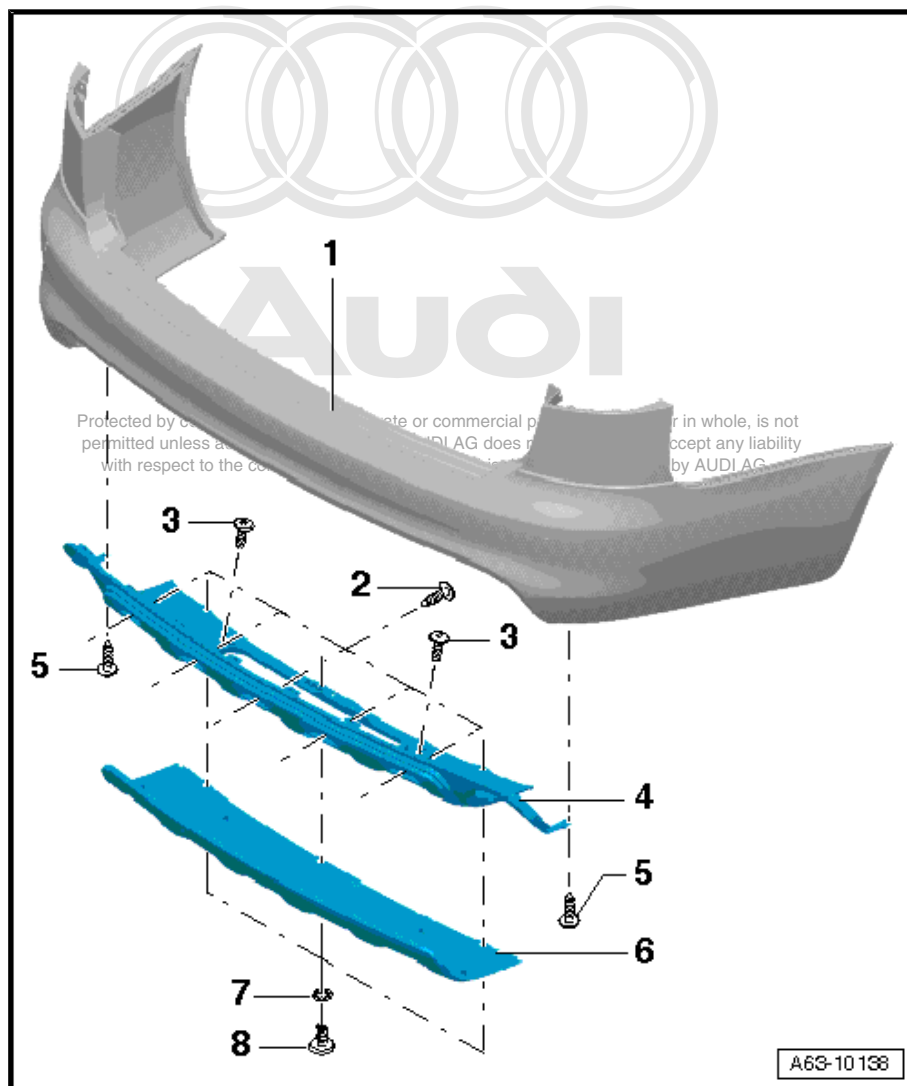
6 - Impact protection

- ☐ Bumper installed
- ☐ Spoiler removed
- ☐ Remove bolts -3- and -8- and detach impact protection from retainers.

7 - Washer

8 - Quick-release fastener

- ☐ 4 Nm



A63-10 138

Attachment points

1 - Cover

- To remove, unscrew all nuts and bolts and detach cover towards rear.

2 - Self-tapping screw

- 1 Nm

3 - Self-tapping screw

- 1 Nm

4 - Cap nut

- 4 Nm

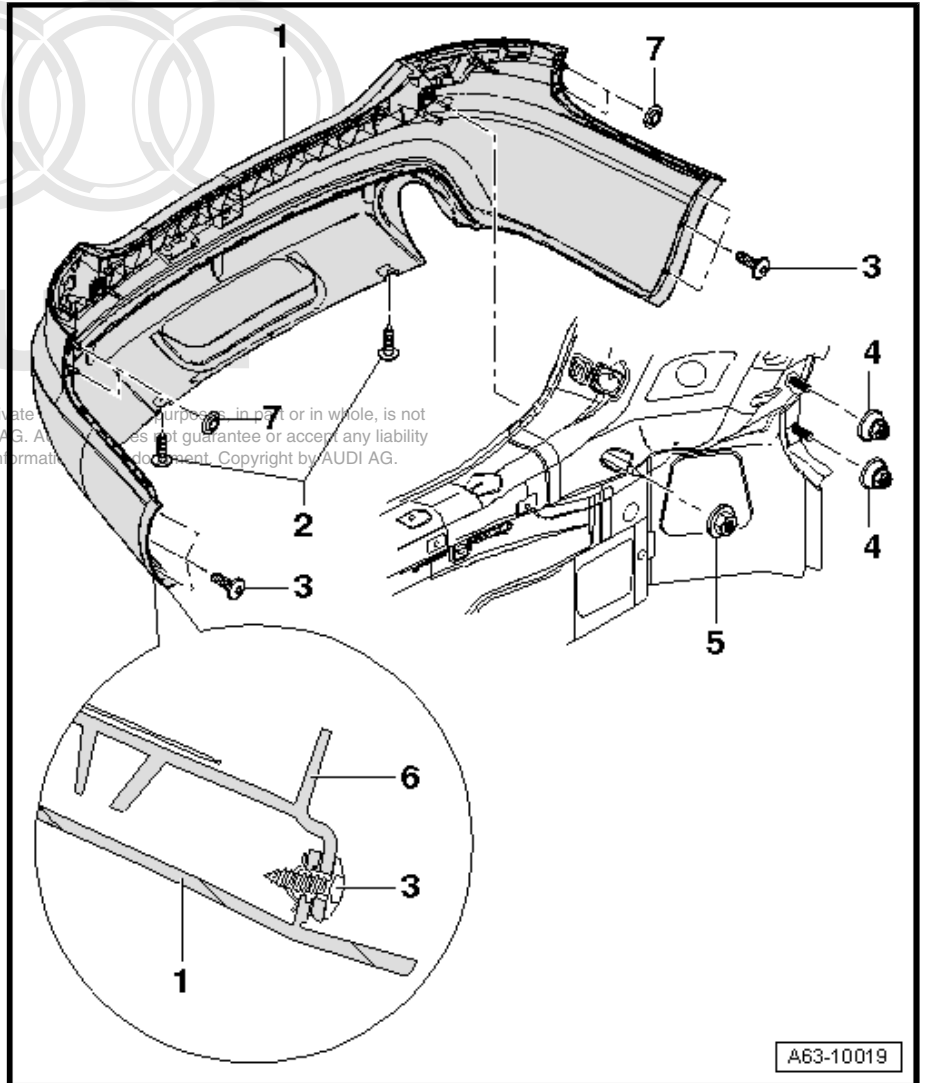
5 - Nut with washer

- 4 Nm

6 - Guide

7 - Grommet

- Grommets must be pushed onto studs before installing cover.



A63-10019

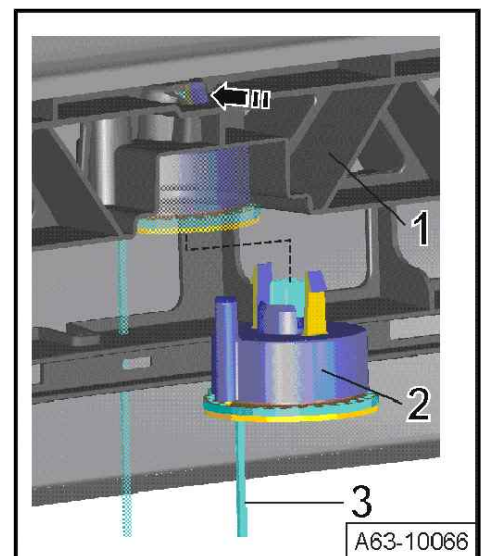
Installing support piece



Note

The support piece only has to be installed if you are fitting a new bumper cover.

- To remove, press catch -arrow- to side and detach support piece downwards out of cover -1-.
- Fit support piece -2- in cover as shown and make sure it engages.
- Do not remove retaining tab until you have completed installation of cover.



A63-10066

Releasing support piece



WARNING

Never release support piece following removal, as this could cause injury.

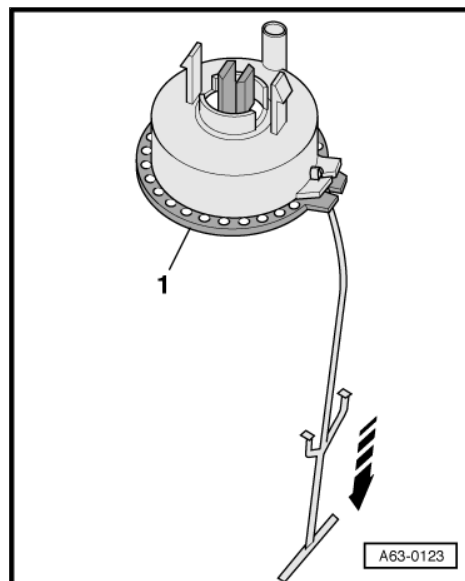
When re-installing the "old" bumper cover, the "old" support piece can remain installed.

- If bumper cover is renewed, new support piece must be clipped into bumper cover from underneath.
- Once you have completed installation of the bumper cover, release support piece by pulling retaining tab -arrow-.



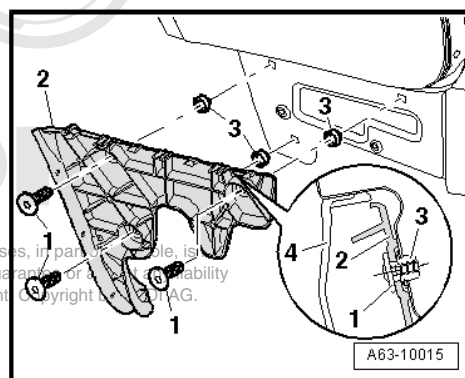
Note

Pulling the release tab releases the support piece, so that it then supports the bumper cover against the cross member.



2.2 Removing and installing guide

- Bumper removed
- Remove bolts -1- and detach guide -2-.
- Tightening torque: 1.5 Nm
- Clip -3-



2.3 Removing and installing cross member for bumper



Note

Bumper cover removed

1 - Impact damper

2 - Bolt

- ☐ Tightening torque
⇒ [Item 11 \(page 152\)](#)
⇒ [Item 9 \(page 152\)](#)

- ☐ 4x

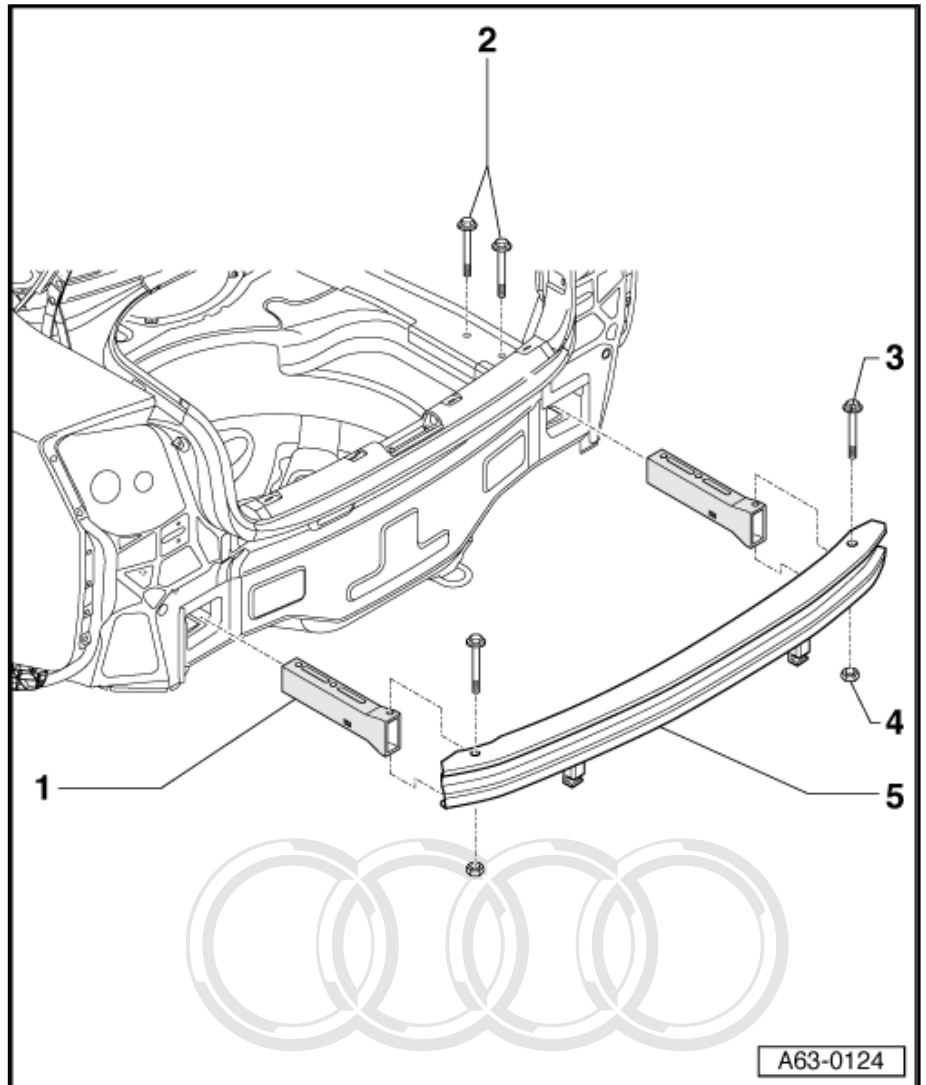
3 - Bolt

- ☐ 20 Nm
- ☐ 2x

4 - Nut

- ☐ 20 Nm
- ☐ 2x

5 - Cross member



2.4 Removing and installing cross member for bumper (country-specific version)



Note

Bumper cover removed

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1 - Impact damper

2 - Bolt

- 10 Nm
- 4x

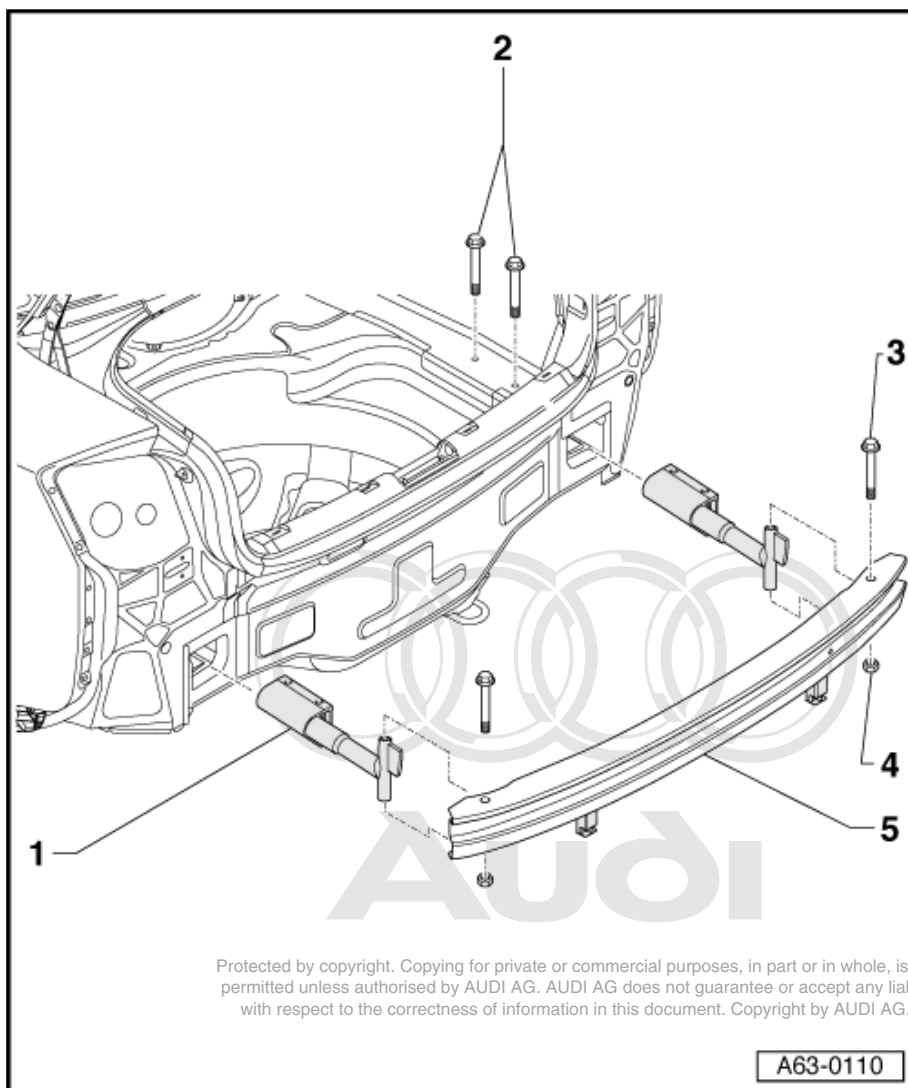
3 - Bolt

- 20 Nm
- 2x

4 - Nut

- 20 Nm
- 2x

5 - Cross member



2.5 Removing and installing cross member for bumper - vehicles with towing bracket



Note

Bumper cover removed

1 - Threaded plate

- ❑ Installing ➔ [page 161](#)

2 - Carrier for towing bracket



Note

Cross member and towing bracket form a single part and should only be renewed as a complete unit.



WARNING

When removing cross member -2- for bumper cover, disengage cable -3- at hand wheel only. Do NOT unscrew cable from towing bracket at swivel joint.

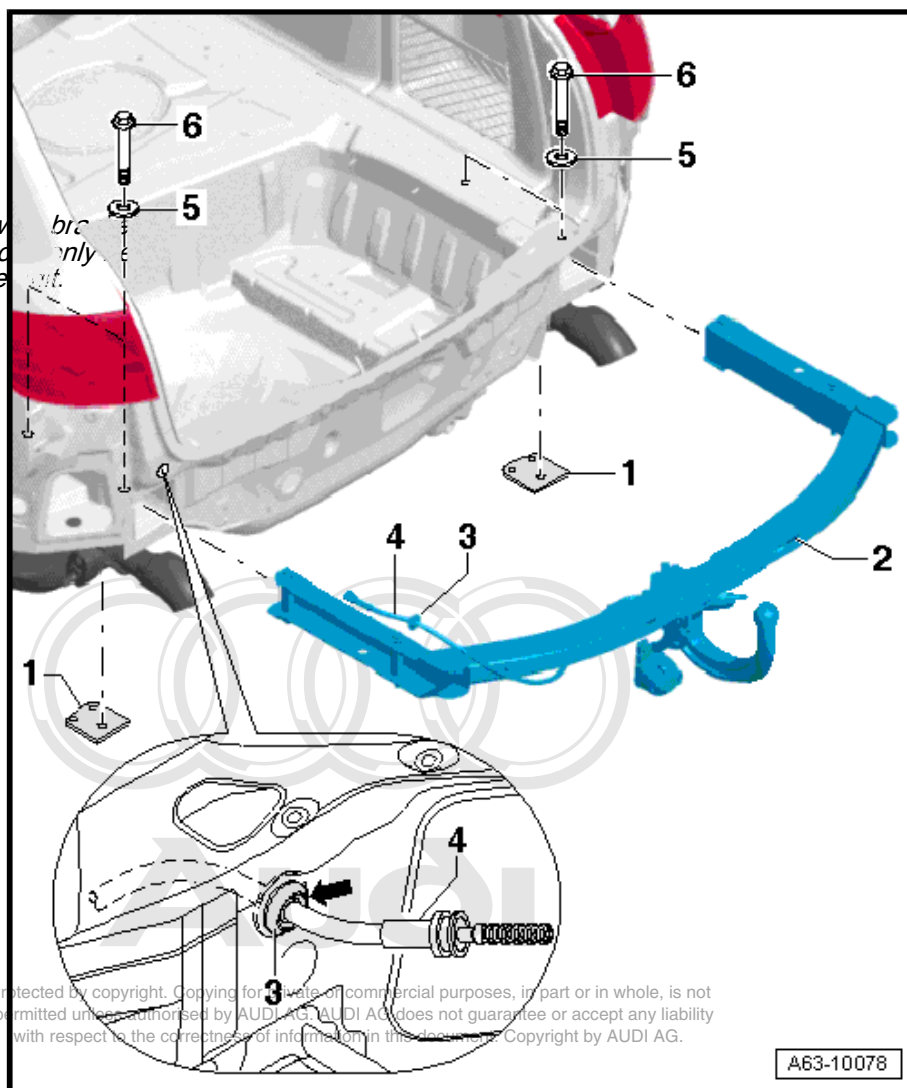
Install cable only if hand wheel is in basic position.

Disengaging the cable causes the hand wheel to engage in a defined basic position.

Before fitting cable, turn hand wheel slightly to check whether it is still set to basic position.

A slight resistance should be felt when doing so.

If necessary, turn hand wheel back to basic position. A slight resistance will again be felt.



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A63-10078

- ❑ Removing:

- Remove rear cross panel trim ➔ [Rep. gr. 70](#).
- Remove retaining rail for fastening hooks.
- Unfasten both side trim panels and press them to one side.
- Remove bumper ➔ [page 151](#).



Note

On vehicles with air suspension, remove heat shields above silencers and also unscrew bolts (2x) underneath ➔ [page 161](#).

- Unscrew bracket for socket.
- Unfasten towing bracket control unit in luggage compartment and move to side.
- Unscrew bolts -6- from longitudinal member on both sides.
- Unscrew bolt from bracket for release mechanism ➔ [Item 2 \(page 160\)](#).
- Before removing towing bracket, disconnect release cable at hand wheel ➔ [page 160](#).

- ❑ Pull towing bracket towards rear out of longitudinal member.

3 - Cable grommet

- ❑ Press grommet as shown into rear cross panel -arrow-.

4 - Cable for releasing towing bracket

- Disengage release cable from hand wheel before removing towing bracket.
- Hand wheel must be in basic position before fitting cable.
- Insert cable in hand wheel. This causes hand wheel to move from basic position to operating position.
- Insert retaining clip in hand wheel.

5 - Washer

6 - Bolt

- ❑ 60 Nm
- ❑ 4x

2.6 Cable for towing bracket

1 - Cable for towing bracket



WARNING

When removing cross member for bumper cover, disengage cable -1- only at hand wheel -5-. Do NOT unscrew cable from towing bracket at swivel joint.

- Before removing towing bracket, pull retaining clip -4- out of adjuster knob -5-.
- Pull cable -1- out of hand wheel -5-.
- Push cable through grommet -arrow-.
- When installing, ensure grommet -arrow- is correctly seated in rear cross panel.

2 - Hexagon bolt

- ❑ 20 Nm

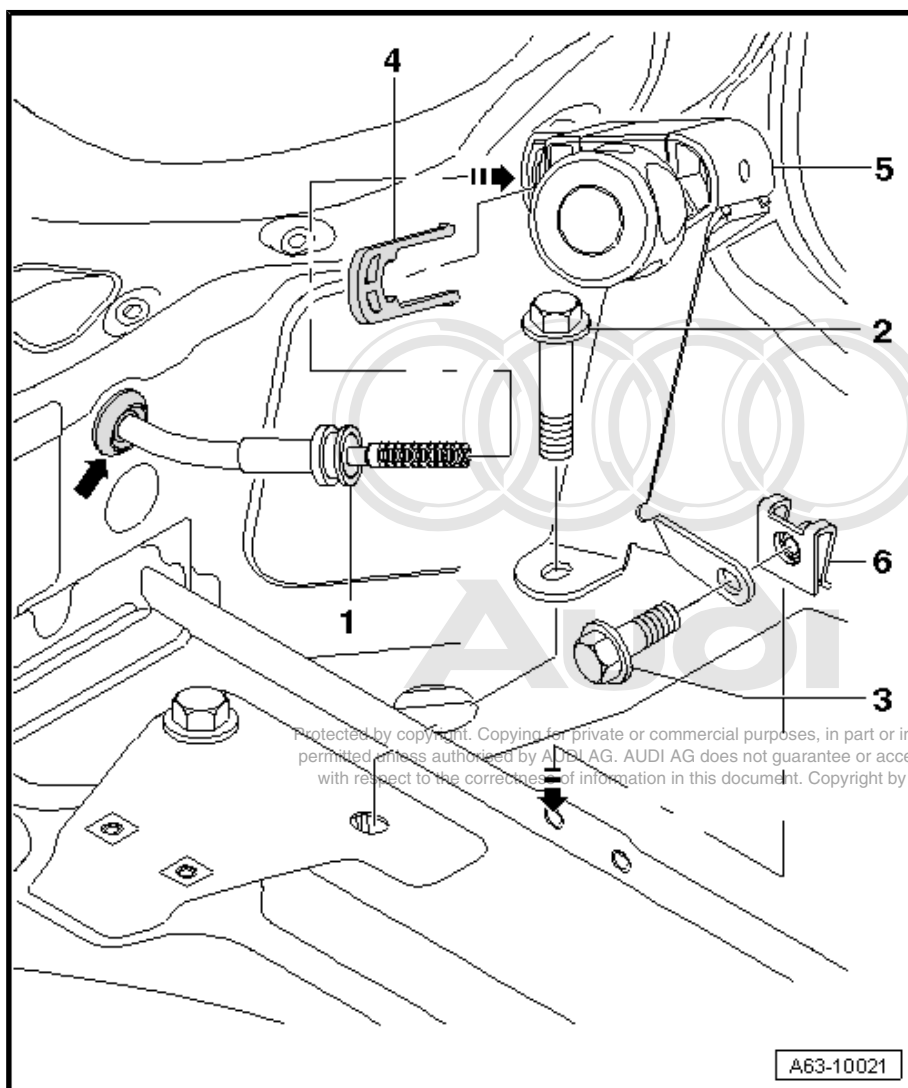
3 - Hexagon bolt

- ❑ 20 Nm

4 - Retaining clip

- Insert cable into hand wheel.

- Secure towing bracket cable by pushing clip into hand wheel as shown.



A63-10021

5 - Release hand wheel

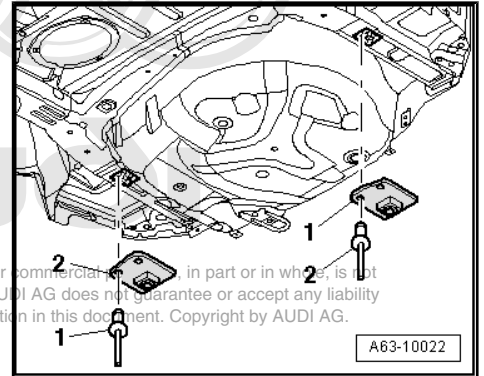
6 - Speed nut

- Attached to body flange

Threaded plate for towing bracket

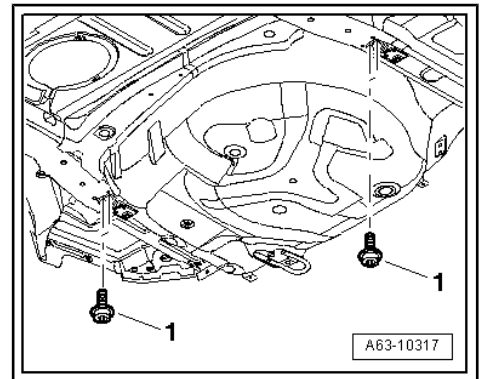
- Before installing threaded plate, clean dirt and deposits from this area of longitudinal member.
- Secure threaded plate -2- with 2 pop rivets -1-.

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Vehicles with air suspension

- When removing towing bracket, unscrew bolts -1- on both sides.
- When installing, tighten bolts to 23 Nm.



64 – Glazing

1 Flush-bonded windows

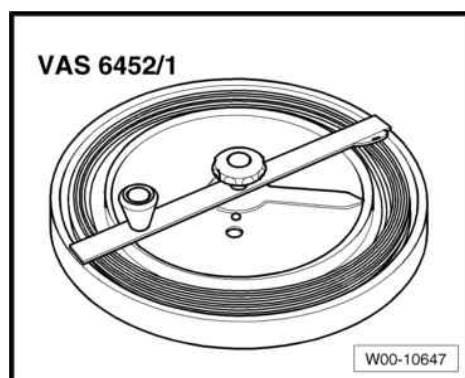
1.1 Removing and installing flush-bonded windows

Special tools and workshop equipment required

- ◆ Removal kit for flush bonded windows - VAS 6452-

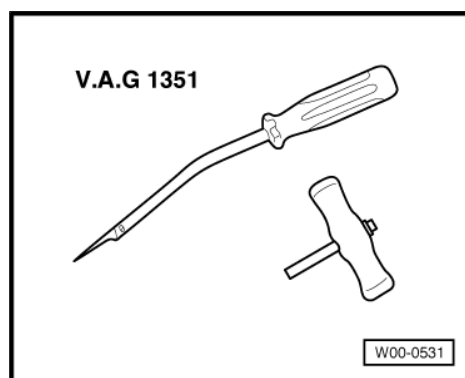


- ◆ Wire reel - VAS 6452/1-



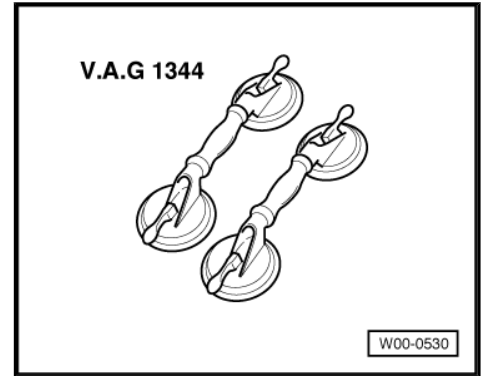
- ◆ Wire for removal kit - VAS 6452/2-

- ◆ Cutting tool - V.A.G 1351-

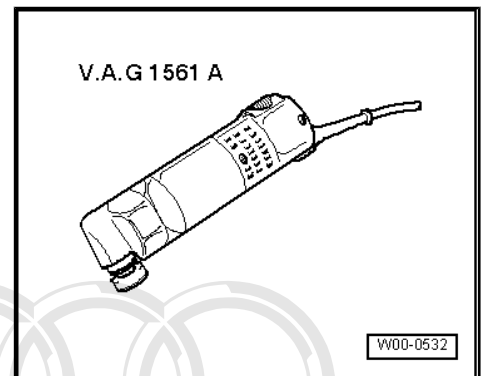


- ◆ Pull handle - V.A.G 1351/1-

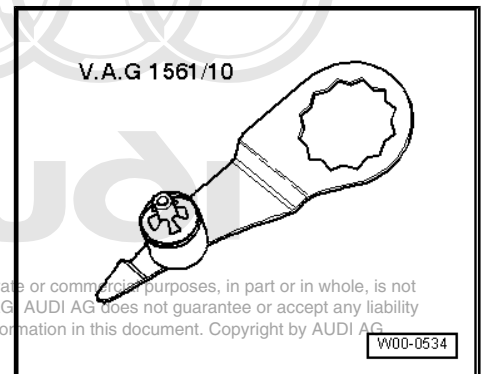
◆ Suction lifter - V.A.G 1344-



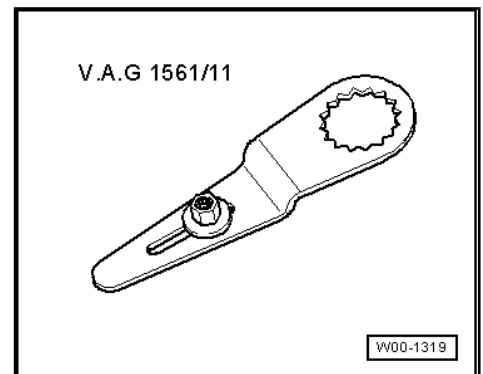
◆ Electric cutter - V.A.G 1561A-



◆ Blade, offset - V.A.G 1561/10-

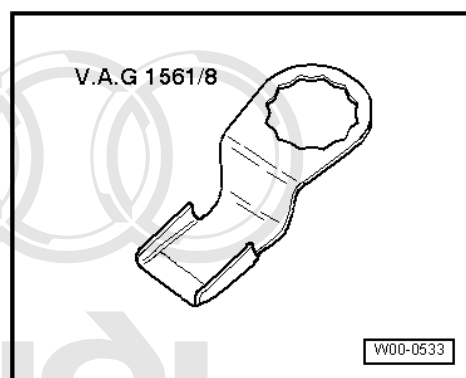


◆ Universal blade - V.A.G 1561/11-



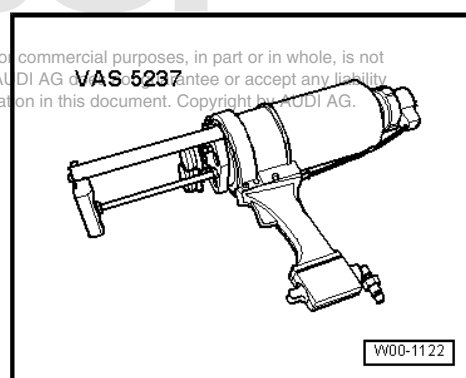
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- ◆ Scraper (15 + 25 mm) - V.A.G 1561/7+8-

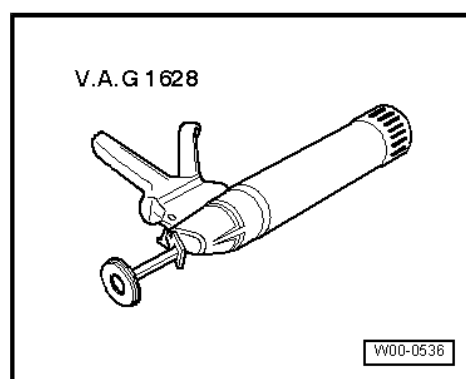


- ◆ Double cartridge gun - VAS 5237-

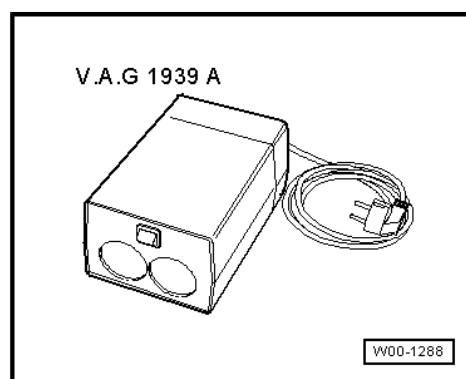
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- ◆ Hand-cartridge gun - V.A.G 1628-



- ◆ Cartridge heater - V.A.G 1939A-



Minimum drying times

 **WARNING**

- ◆ *For safety reasons, when installing windscreen or rear window, use only non-conductive 2-component adhesive with the designations listed below.*
- ◆ *You must NOT drive the vehicle until the minimum drying time has elapsed, as the vehicle is otherwise not safe to drive.*

Window	Vehicle	Adhesive sealant	Drying time in hours
Windscreen	With/without airbag	2-component window adhesive - DA 004 600 A2-	3
Rear window		2-component window adhesive - DA 004 600 A2-	3
Side windows		1-component window adhesive - DH 009 100 03-	3

Cleaning off adhesive sealant

We recommend using adhesive remover - D 002 000 10- for cleaning. Always follow the safety instructions.

 **Caution**

When cleaning from inside the vehicle passenger compartment, make sure you do not exert outward pressure on the window you have just fitted.

Painted surfaces

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- First clean painted surface with a dry cloth. Then clean off remaining adhesive sealant with adhesive remover - D 002 000 10- .

Plastic trim

- Allow adhesive sealant to dry (approx. 1 hour) and then pull off.

1.2 Materials

- ◆ 2-component window adhesive - DA 004 600 A2- ²⁾
- ◆ 1-component window adhesive - DH 009 100 03- ⁵⁾
- ◆ Glass and paint primer - D 009 200 02-
- ◆ Cleaning solution - D 009 401 04-
- ◆ Applicator - D 009 500 25-
- ◆ Adhesive remover - D 002 000 10-
- ◆ Cutting wire - 6452/2- / cutting thread - 357 853 999-

2) Note minimum drying times ⇒ ["1.4 Minimum drying times", page 166](#) .

- 3) To process this material use double cartridge gun - VAS 5237- .
- 4) Heat using cartridge heater - V.A.G 1939 A- according to manufacturer's instructions.
- 5) Small 110 ml cartridge for sealing and/or for use when the 400 ml double cartridge is not sufficient.

1.3 Repairing windscreen using windscreen repair kit - VAS 6092- and resin, Talon - VAS 1993/2-



Special tools and workshop equipment required

- ◆ Windscreen repair kit - VAS 1993- or -VAS 6092-



Note

- ◆ *Windscreens damaged by stone chipping can be repaired using windscreen repair kit - VAS 6092- and resin, Talon - VAS 1993/2- .*
- ◆ *The damaged areas must not exceed a certain size and area, and must not be within the main field of vision.*
- ◆ *For detailed information, refer to the instructions supplied with each kit.*

1.4 Minimum drying times



WARNING

- ◆ *For safety reasons, when installing windscreen or rear window, use only non-conductive 2-component adhesive with the designations listed below.*
- ◆ *You must NOT drive the vehicle until the minimum drying time has elapsed, as the vehicle is otherwise not safe to drive.*

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Window	Vehicle	Adhesive sealant	Drying time in hours
Windscreen	With airbag	DA 004 600 A2	3
Rear window		DA 004 600 A2	3
Side windows		DH 009 100 03	3

Cleaning off adhesive sealant

We recommend using adhesive remover D 002 000 10 for cleaning. Always follow the safety instructions.



WARNING

When cleaning from inside the vehicle passenger compartment, make sure you do not exert outward pressure on the window you have just fitted.

Painted surfaces:

- First clean painted surface with a dry cloth. Then clean off any residual dirt using adhesive remover D 002 000 10.

Plastic trim:

- Allow adhesive sealant to dry (approx. 1 hour) and then pull off.

1.5 Re-sealing windows

- Allow leaking area to dry and then clean.
- Apply and spread adhesive sealant in leaking area between window and metal flange.
- Allow adhesive sealant to harden.
- Perform leak test with water.
- Carry out visual inspection from passenger compartment.

1.6 Exploded view - windscreen



Note

On vehicles with lane departure warning, the camera must be recalibrated after renewing the windscreen ⇒ Rep. gr. 44 .

1 - Plenum chamber cover

- ❑ On new replacement windows, the protective beading in the fastening strip must be pulled out before installing the plenum chamber cover.
- ❑ Allow glass adhesive to harden before pressing component into retaining strip.

2 - Water deflector strip

- ❑ Allow glass adhesive to dry before pressing water deflector strip home into fasteners.
- ❑ When pressing in, ensure sealing lip of water deflector makes contact with windscreen -arrow- and does not slip behind edge of windscreen.

3 - Windscreen

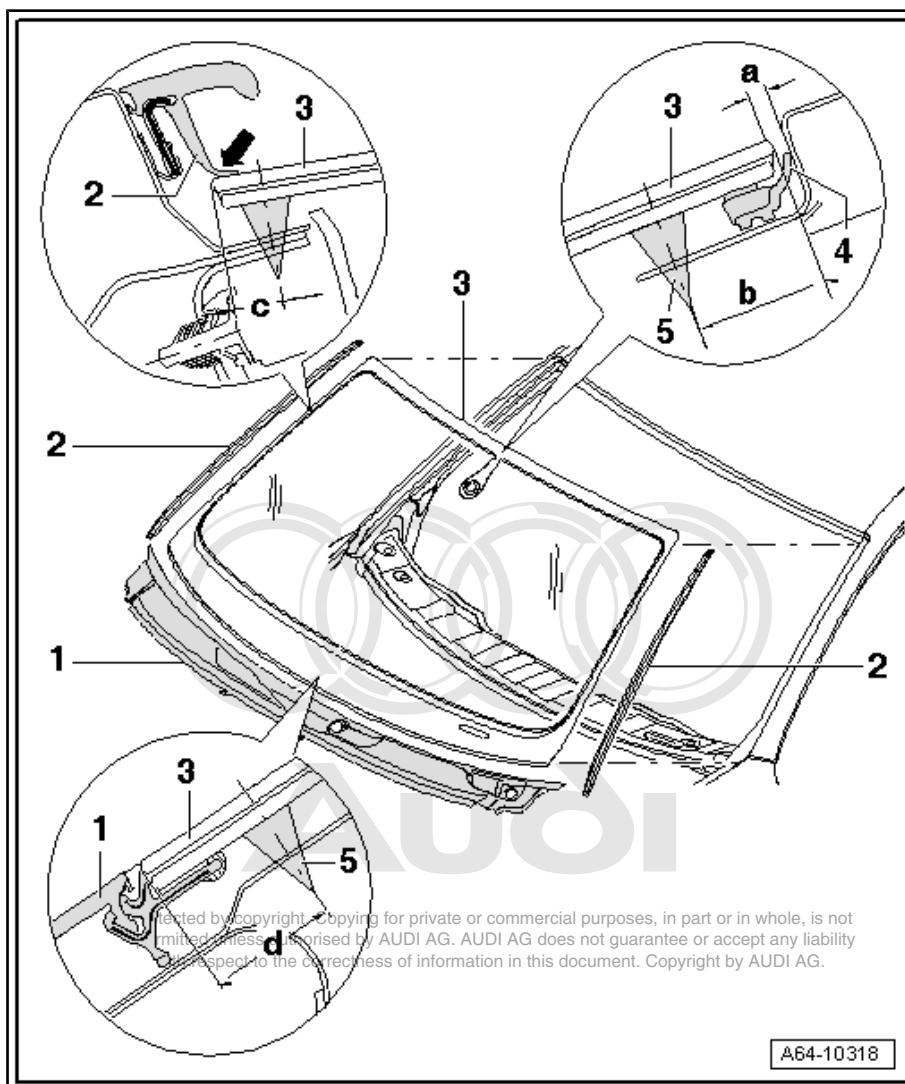
- ❑ Removing and installing ⇒ [page 172](#).
- ❑ Distance from roof: Dimension -a- = 2 mm ± 0.5 mm
- ❑ Align windscreen centrally between sides of frame.

4 - Trim section

- ❑ Renewing ⇒ [page 168](#)

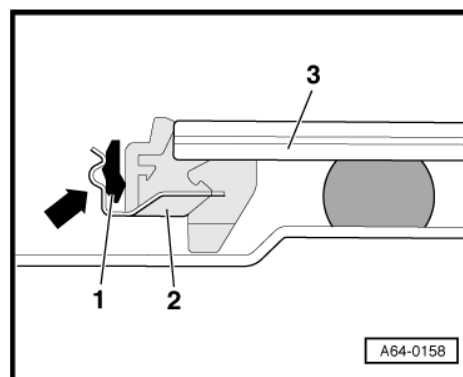
5 - Adhesive bead

- ❑ Note drying times.
- ❑ Note different distances from edge of windscreen:
- ❑ Dimension -b- = 19 mm ± 2 mm
- ❑ Dimension -c- = 8 mm ± 2 mm
- ❑ Dimension -d- = 19 mm ± 2 mm



Removing protective beading for fastening strip

- Fit windscreen before pulling protective beading out of fastening strip.
- Before fitting plenum chamber cover, pull protective beading -1- out of fastening strip -2- of windscreen -3-.



1.7 Renewing trim section

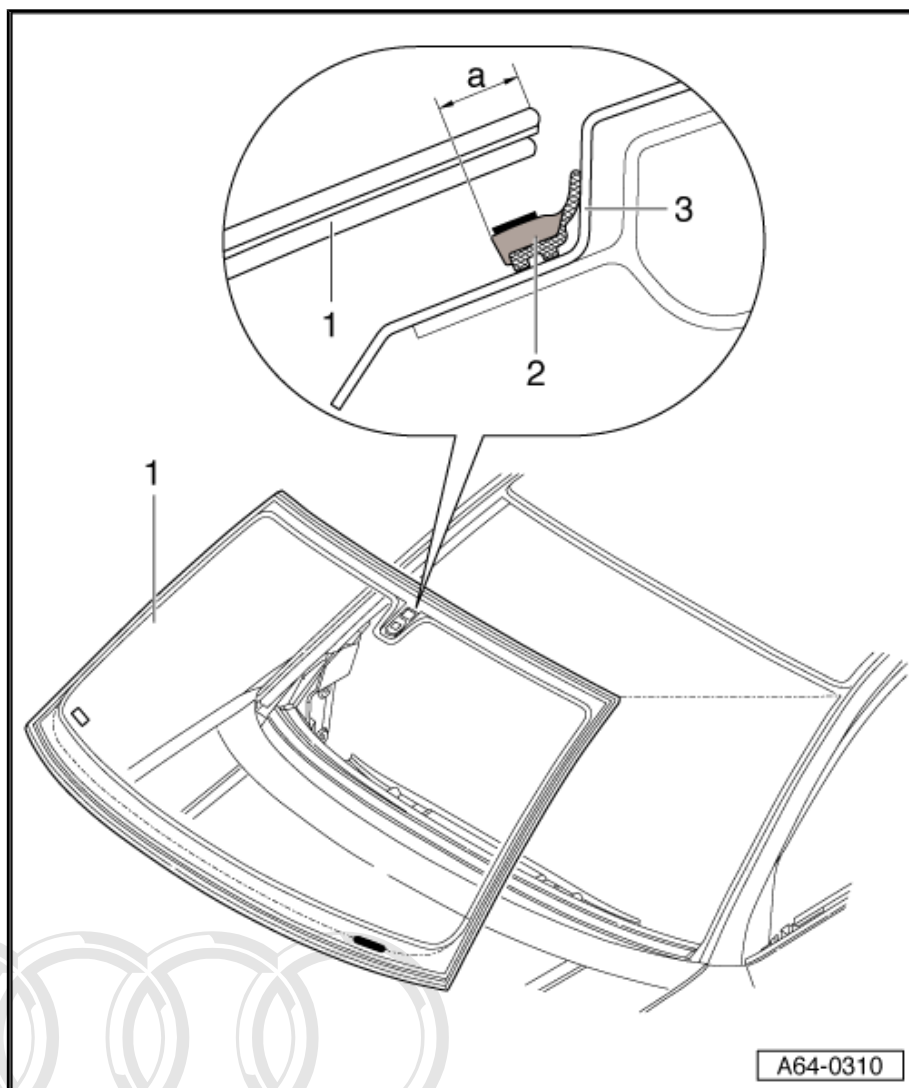
Trim section can only be renewed with windscreen removed.

1 - Windscreen

- ❑ Removing ➔ [page 172](#)

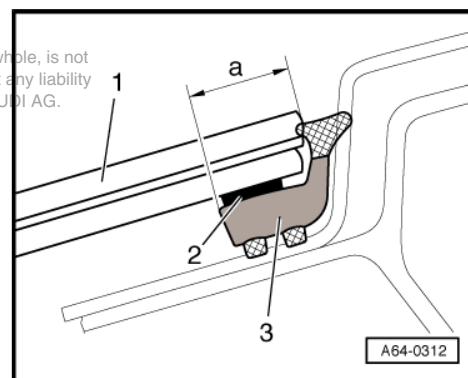
2 - Trim section

- ❑ Bonding on
➔ [page 169](#).
- ❑ Before fitting new trim section, use commercially available glass scraper to completely remove remaining material, taking care not to damage ceramic band.
- ❑ Clean bonding surface using cleaning solution D 009 401 04.
- ❑ Use soft pencil, for example, to make mark on inside of windscreen at a distance $-a- = 8 \text{ mm}$ from top edge of windscreen.
- ❑ Prime bonding surface with D 009 200 02 as far as mark made earlier and allow to flash off for at least 10 minutes.
- ❑ Press trim section centrally onto windscreen in such a way that rear edge aligns with end of primed area (pencil marking).
- ❑ Use roller to firmly press on trim section.
- ❑ Re-install windscreen.



1.8 Bonding on trim section

- Windscreen -1- with ceramic band
- Clean bonding surface using cleaning solution D 009 041 04.
- Then make a marking at an even distance of $-a- = 8 \text{ mm}$ from top edge of windscreen.
- Carefully apply primer D 009 200 02 as far as marking.
- Allow primer to flash off for at least 10 minutes.
- Pull backing off double-sided adhesive strip -2-.
- Press trim section -3- centrally onto windscreen in such a way that rear edge aligns with end of primed area (marking).
- Use roller to firmly press trim section onto windscreen.



1.9 Removing and installing rain and light sensor - G397-



Note

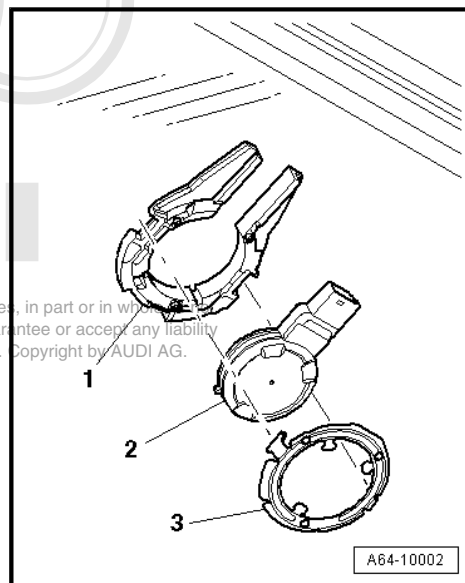
When removing the rain and light sensor - G397- a foil must be peeled off. This must be renewed before the sensor is re-installed.

– Interior mirror removed – Rep. gr. 68

◆ Retaining plate -1-

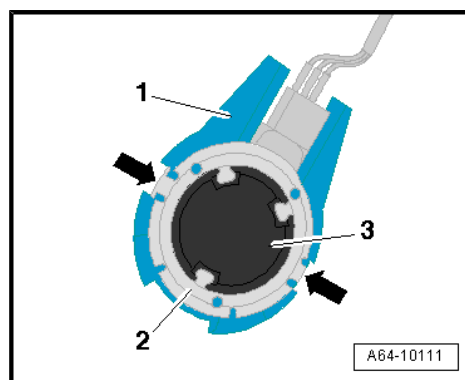
◆ Rain and light sensor - G397- -2-

◆ Retaining clip -3-



Unclipping retaining clip

- Unplug connector.
- Use a small screwdriver or similar tool to press retaining clip -2- outwards at points marked by -arrows-.
- Detach retaining clip -2- from mirror base -1-.
- Take rain and light sensor - G397- -3- out of mirror base.
- Sensor foil will remain attached to the windscreen.
- If you are re-installing the same windscreen, the sensor foil has to be completely removed from the glass.
- Clean glass surface using cleaning solution D 009 401 04.



Installing rain and light sensor - G397-



Caution

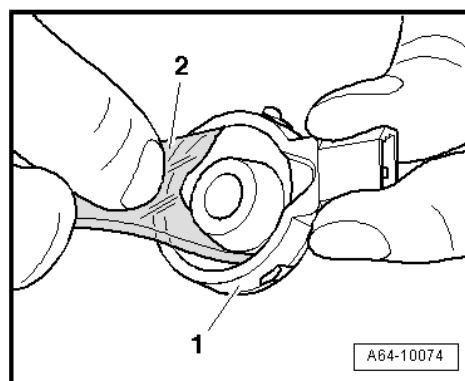
If the same rain and light sensor - G397- is re-installed, the sensor foil must be renewed.

- Also remove any remaining sensor foil residues from the rain and light sensor - G397- .
- Carefully peel sensor foil -2- off rain and light sensor - G397- -1-.
- Clean glass surface using cleaning solution D 009 401 04.

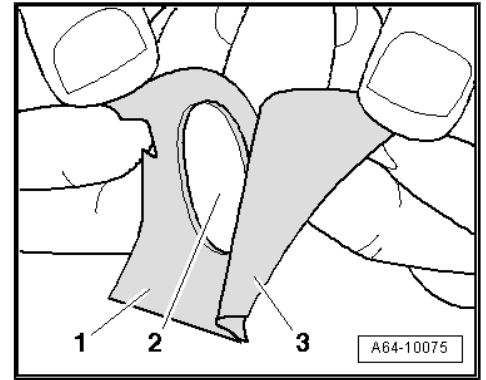


Caution

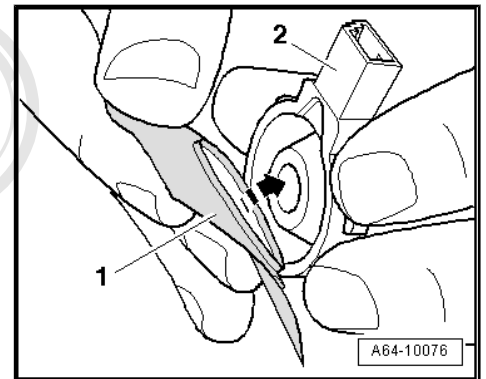
The surface on the sensor must be completely free of foil remnants.



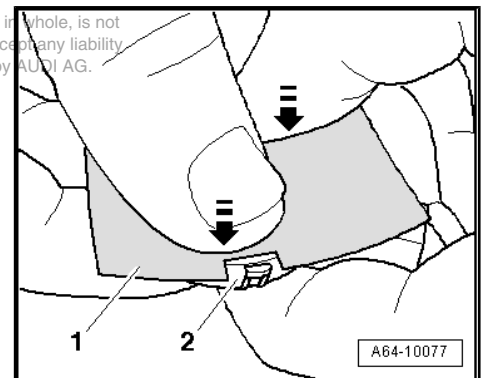
- Detach silicone paper -3- from sensor foil -2-.
- Transparent protective film -1- remains on the sensor foil for the time being in order to facilitate installation.



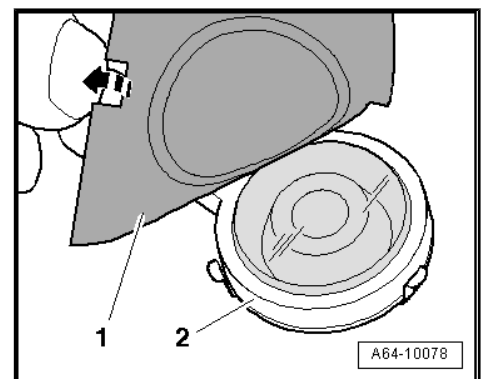
- Place the sensor foil with the aid of the transparent protective film -1- on the rain and light sensor - G397- -2-.



- Press sensor foil with aid of protective film -1- onto rain and light sensor - G397- -2- (as shown), making sure there are no air bubbles.



- Peel transparent protective film -1- off sensor foil -2-.



- Spray the sensor foil -1- over its entire surface with cleaning solution D 009 401 04 and insert the rain and light sensor - G397- in the mirror base.



Caution

In order to function correctly, the rain and light sensor - G397- must be clear and there must be no air bubbles between it and the windscreen.

- Press retaining clip for sensor onto mirror base.

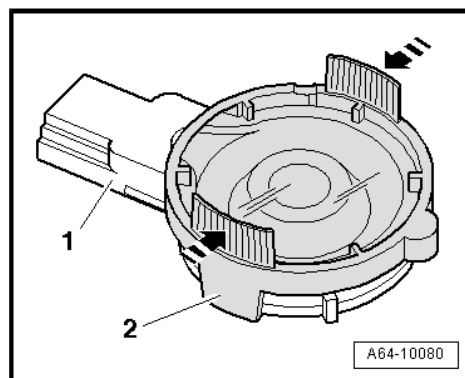
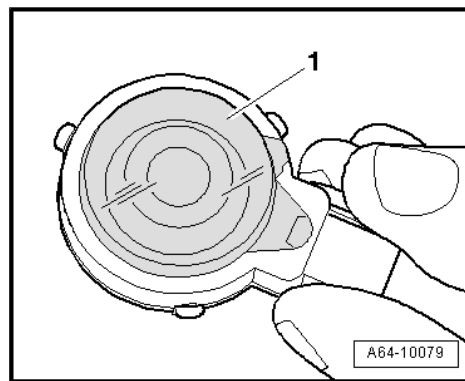
Renewing rain and light sensor - G397-



Note

To remove the sensor please proceed as already described.

- Remove any remaining foil residues from old rain and light sensor - G397- completely from windscreen.
- Clean contact surface on windscreen using cleaning solution D 009 401 04.

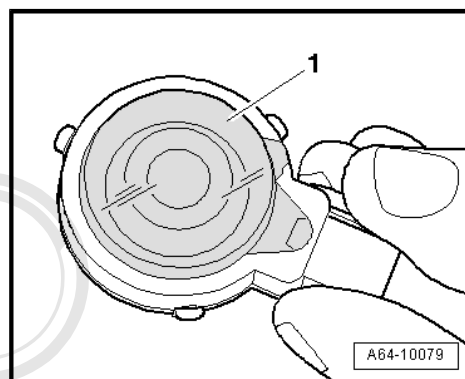


- Lightly compress ribbed tabs -arrows- on protective cap -2- and detach protective cap from rain and light sensor - G397- -1-.
- Spray the sensor foil -1- over its entire surface with cleaning solution D 009 401 04 and insert the rain and light sensor - G397- in the mirror base.
- Attach rain and light sensor - G397- to windscreen (without air bubbles) and press retaining clip onto mirror base.



Caution

In order to function correctly, the rain and light sensor - G397- must be clear and there must be no air bubbles between it and the windscreen.



1.10 Removing and installing windscreen

Removing windscreen

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- Remove wiper arms ⇒ Rep. gr. 92 .
- Remove cowl panel trim ⇒ [page 8](#) .
- Remove sun visors ⇒ Rep. gr. 70 .
- Remove interior mirror ⇒ Rep. gr. 68 .

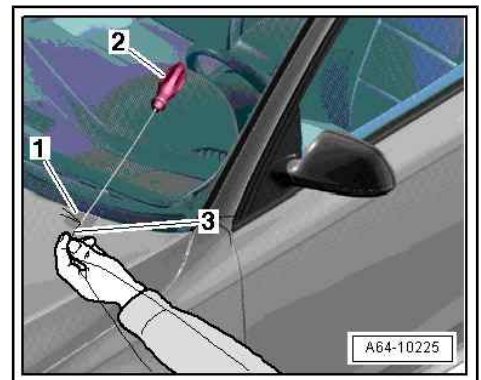
- Remove rain and light sensor - G397- .
- Remove A-pillar trim (top, left and right) ⇒ Rep. gr. 70 .



WARNING

Always wear safety goggles and leather gloves when removing windscreen.

- Disconnect all wires leading to sensors, interior mirror and window heater, if fitted.
- Use wire reel - VAS 6452/1- to reel off about 6.5 metres of cutting wire (corresponding to 6 turns) and cut off.
- Mask over body flange with adhesive tape -1- to avoid damage where awl is pushed through at the bottom.
- Pierce adhesive bead in this area with awl -2- from inside to outside, as shown.
- Thread both ends of cutting wire -3- into awl -2- and pull through to the inside.

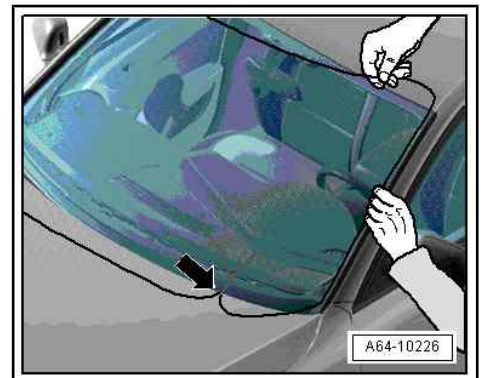


- Position cutting wire under glass all around windscreen, as shown.

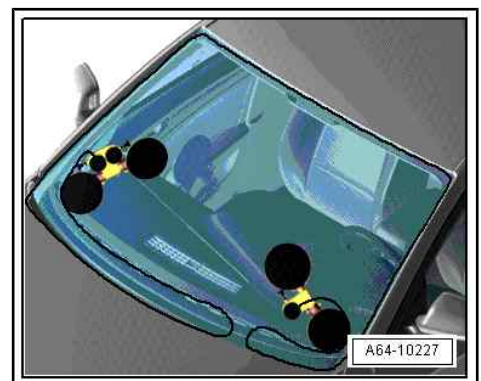


Caution

The wire ends must not be twisted at the point where they pass through the adhesive bead -arrow-.

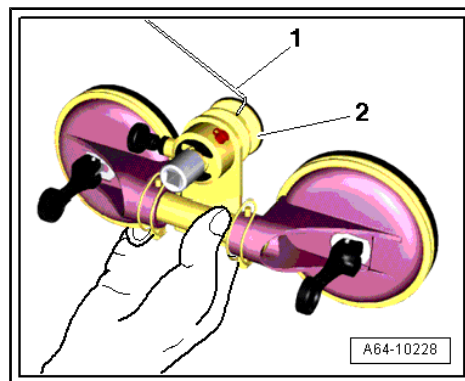


- Attach both reels to inside of windscreen, as shown.

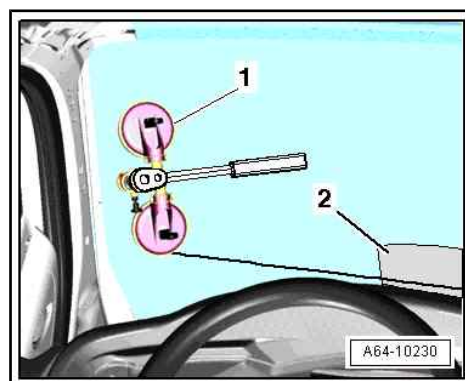


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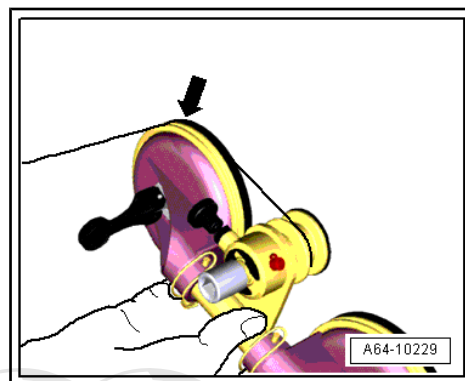
- Insert end of cutting wire -1- into reel -2-.



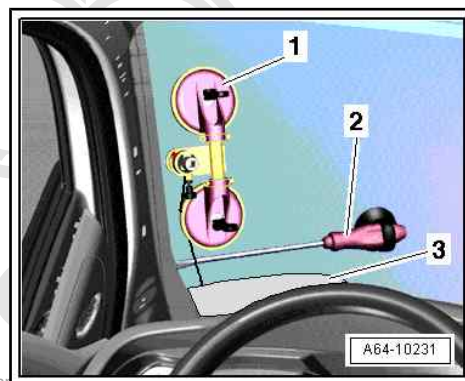
- Tension cutting wire and insert protective film -2- between dash panel and wire.



- Cut clear the first area. While doing so, wire is guided into integrated idler pulley -arrow- on reel.

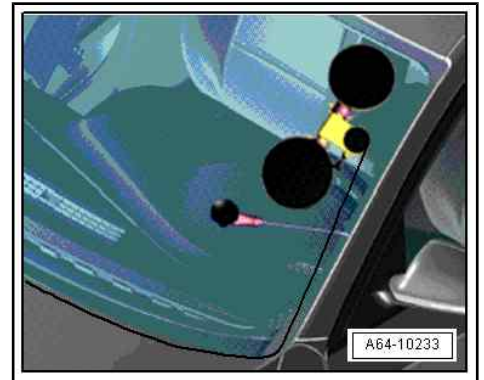


- Additionally insert guide awl -2- into adhesive bead, as shown, and attach it to windscreen using suction pad so that wire runs along windscreen as close to the glass as possible.
- Adjust protective film -3- as necessary with length of wire and continue cutting clear using reel -1-.

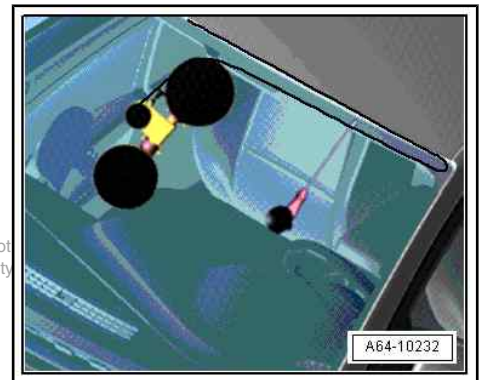


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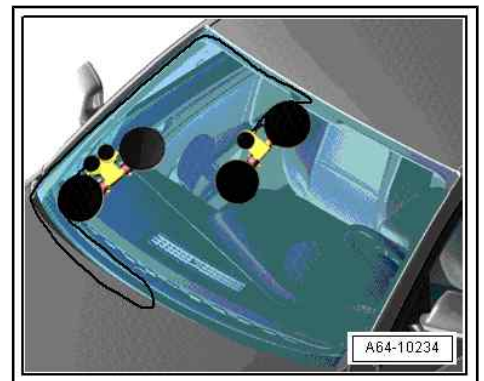
- Adjust reel and guide awl as shown, and cut clear area at A-pillar.
- Adjust reel and guide awl to approx. centre of windscreen, as shown.



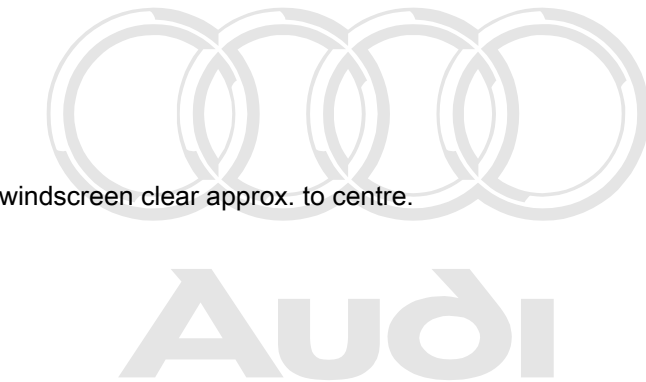
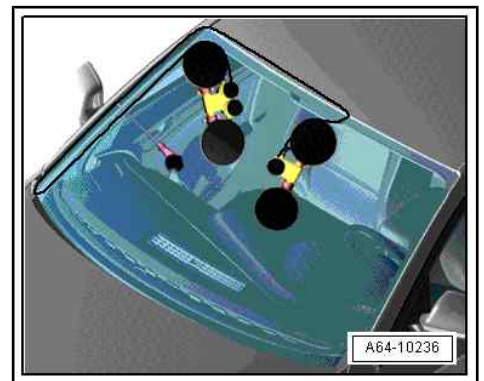
- Cut windscreen clear approx. to centre.



- Use second reel to cut clear bottom area of windscreen.

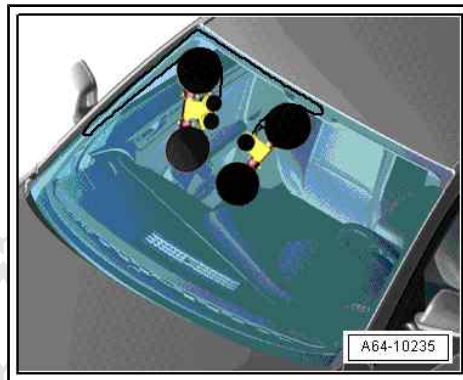


- Move reel up and insert guide awl, as shown.



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- Cut windscreen clear upwards along A-pillar.



- Adjust reel over centre of windscreen, adjust first reel as shown and cut windscreen fully clear at top.
- Lift windscreen out of vehicle using two double suction lifters.

Preparations before installing windscreen

- If windscreen flange has been damaged, paintwork structure must be repaired and, if necessary, anti-corrosion measures must be taken ⇒ Audi Paintwork Guide.
- Clean repaired area using cleaning solution - D 009 401 04- and then apply glass and paint primer - D 009 200 02- .
- Just before re-installing an undamaged windscreen, use electric cutter - V.A.G 1561 A- and scraper (25 mm) - V.A.G 1561/8- to cut back the remaining adhesive sealant on the windscreen and flange to give a smooth surface, but do NOT remove completely.



Note

The remaining sealant is required as a base for better adhesion of the new adhesive sealant.



Caution

- ◆ **Keep bonding surface clean and free from grease.**
- ◆ **Do not cut back bonding surface until shortly before installation.**
- ◆ **Do not apply primer to bonding surface and do not use cleaning solution.**

If installing a new windscreen:

- Clean all around windscreen bonding area with cleaning solution - D 009 401 04- .
- Apply glass and paint primer - D 009 200 02- as described in the following.



Caution

The ceramic coating on the glass is not a primer. The glass must always be primed before applying adhesive sealant.

- Use applicator -2- to apply primer -3- evenly and in one movement onto windscreen -4- beside moulding -1-.
- Start application with fully soaked felt.
- Primer width approx. 20 mm
- Apply primer centrally in relation to adhesive bead.
- Flash-off time: 10 minutes

Installing windscreen



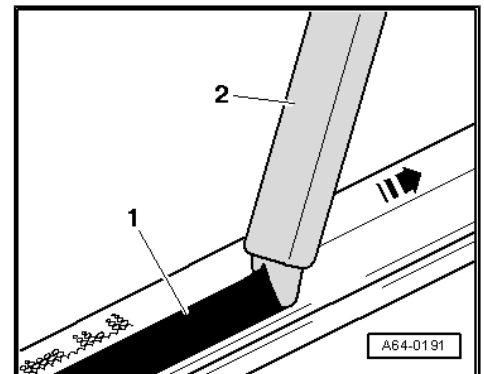
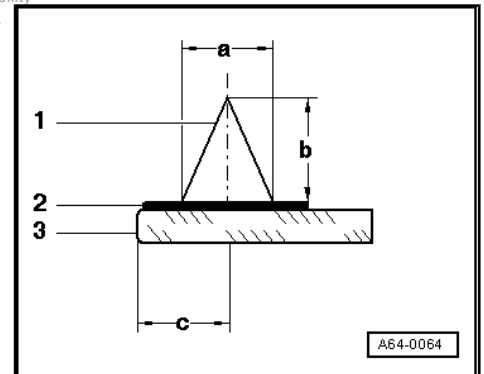
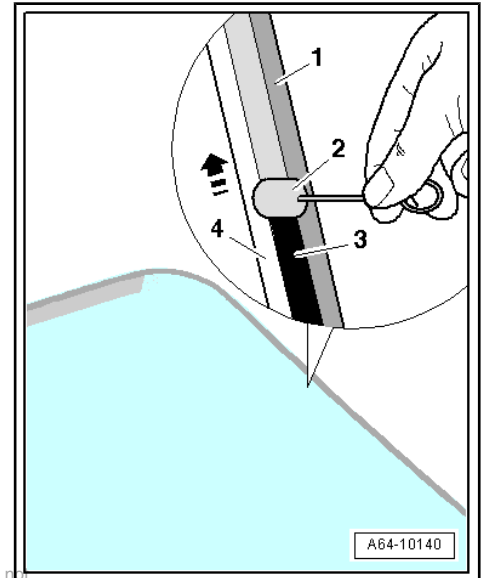
Note

The cross-section of the adhesive bead is determined by the nozzle opening and the rate of application.

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Dimensions for applying adhesive:

- 1 - Adhesive bead
- 2 - Primer
- 3 - Windscreen
- Dimension -a- = 8 mm
- Dimension -b- = 12 mm
- Dimension -c-: note different distances from edge of windscreen ⇒ [Item 5 \(page 168\)](#) .
- Apply full surface of nozzle -2- to windscreen.
- Direction of application -arrow- for adhesive bead -1-.



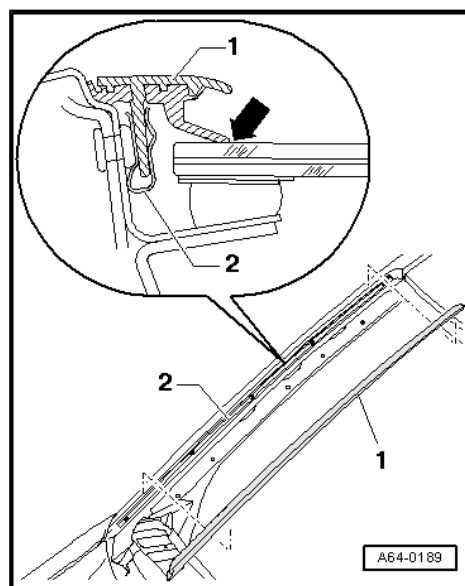
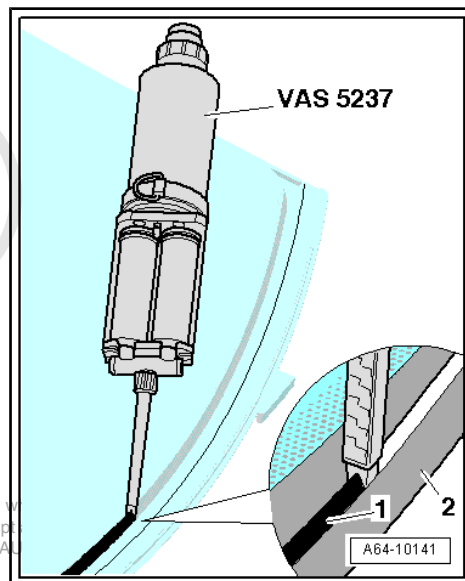
- Apply adhesive sealant -1- all around windscreen -2-, as shown.
- When reinstalling an undamaged windscreen, apply adhesive to remaining adhesive bead.
- Install windscreen glass in windscreen opening using two double suction lifters.



Caution

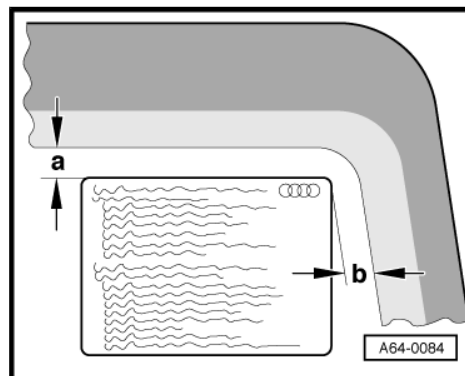
The glass must be fitted within 10 minutes; otherwise the adhesive properties of the adhesive sealant will be impaired.

- Align glass so that spacing is equal on both sides.
- Distance from edge of windscreen to roof frame
⇒ [Item 3 \(page 168\)](#).
- Secure windscreen to roof at top with adhesive tape.
- Pull protective strip out of fastening strip before fitting plenum chamber cover ⇒ [page 168](#).
- Note minimum drying time ⇒ [page 166](#).
- Allow adhesive to dry before pushing water deflector strip -1- into retaining clips -2- as far as it will go.
- When pressing in, ensure sealing lip -arrow- of water deflector makes contact with windscreen and does not slip behind edge of windscreen.



Sticker: Attention - Safety precautions

- Re-attach stickers for windscreen (e.g. for airbag) at same locations on new windscreen.
- Sticker can be applied wet, using distilled water.
- Attach sticker free of air bubbles and slide it into correct position.
- Dab off any surplus water with paper.
- ◆ Dimension a = 25 mm
- ◆ Dimension b = 12 mm



1.11 Exploded view - side window (saloon)

Vehicle with standard windows

1 - Side window

- ☐ Removing ⇒ [page 180](#)
- ☐ Note differing distances between adhesive bead and edge of window.
- ☐ Note minimum drying times.

2 - Moulding for side window (bottom)

- ☐ Supplied with parts kit; not available separately.

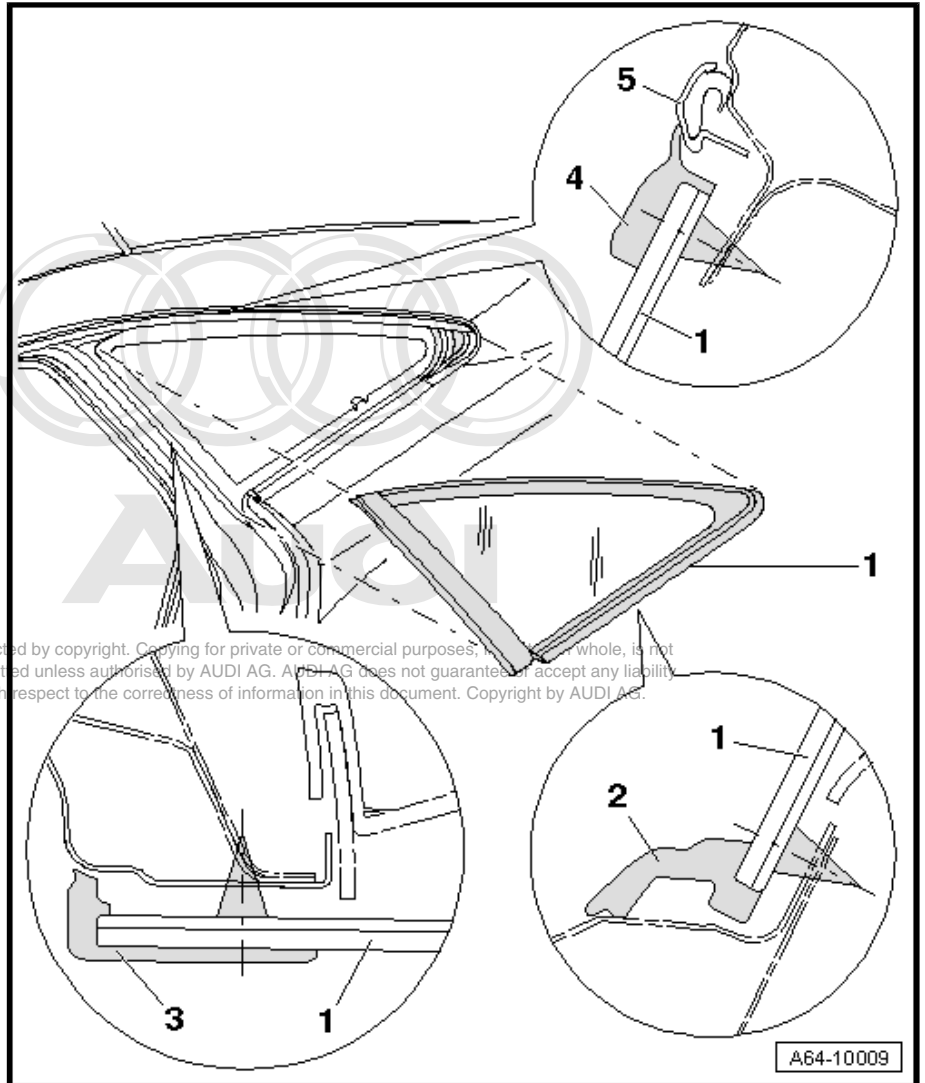
3 - Moulded surround for side window, C-pillar

- ☐ Supplied with parts kit; not available separately.

4 - Moulding for side window (top)

- ☐ Supplied with parts kit; not available separately.

5 - Roof trim strip, D-pillar



Vehicle with high-gloss package

1 - Side window

- ❑ Removing ⇒ [page 180](#)

2 - Trim strip for side window (bottom)

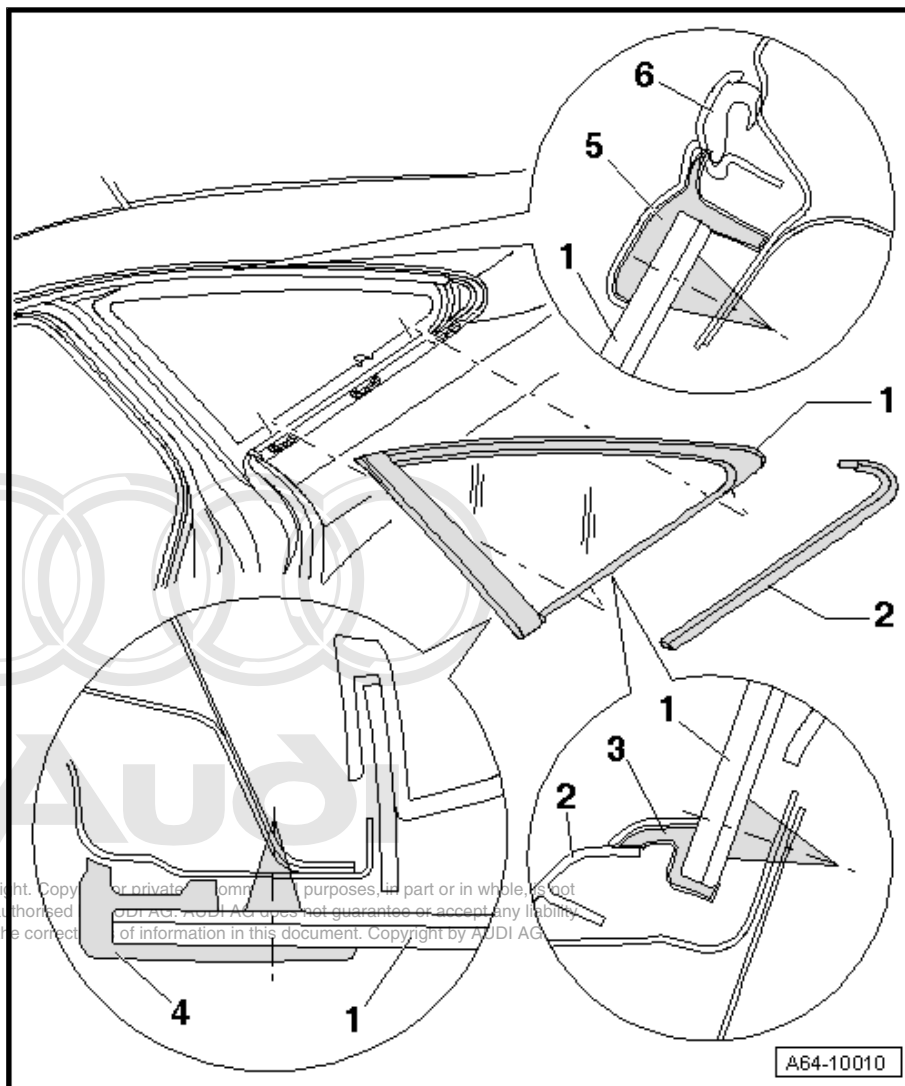
- ❑ Removing ⇒ [page 218](#)

3 - Moulding for side window (bottom)

- ❑ Supplied with parts kit; not available separately.

4 - Moulding for side window, C-pillar

- ❑ Supplied with parts kit; not available separately.



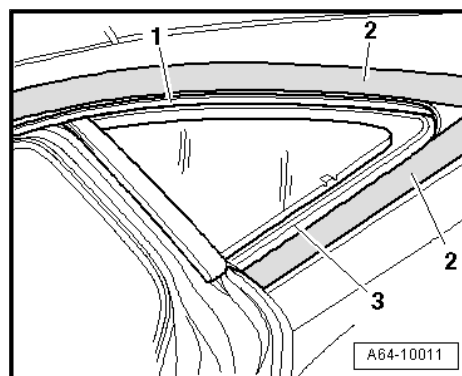
1.12 Removing undamaged window



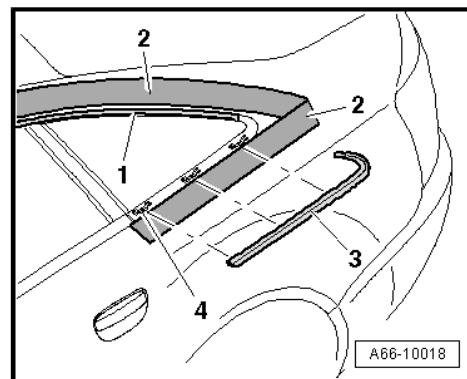
WARNING

Always wear safety goggles and leather gloves when removing window.

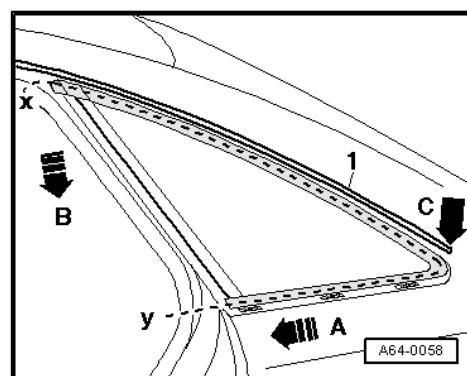
- Remove C/D-pillar trim ⇒ Rep. gr. 70 .
- Mask D-pillar above roof trim strip -1- and side panel below roof trim strip -3- with adhesive tape -2- to protect paint from damage.



- On vehicles with high-gloss package, remove trim strip (bottom) -1-.
- Route cutting cord around side window as shown in illustration.
- Pull cord at top and bottom of B-pillar through adhesive bead towards vehicle interior.



- Secure ends X and Y in two handles of cutting tool - V.A.G 1351- .
- Employing a gentle sawing motion, pull cutting thread in direction of arrow -A- and cut through adhesive bead at bottom of side panel and at roof frame.
- Then pull cutting cord downwards in direction of -arrow B- through adhesive bead.
- Take window out of window opening.



1.13 Removing damaged window

- Protect body and interior against damage from glass splinters.
- Mask flange all round with fabric-backed adhesive tape.
- Remove glass fragments down to adhesive sealant.



WARNING

Always wear safety goggles and leather gloves when removing window.

- Cut through adhesive sealant (with glass fragments) in window opening using electric cutter - V.A.G 1561A- and universal cutter - V.A.G 1561/11- (with roller stop).

1.14 Installing side window

If "old" rear window is undamaged

- If window flange has been damaged, paintwork structure must be repaired and, if necessary, anti-corrosion measures must be taken ⇒ Audi Paintwork Guide .
- Clean repaired area using cleaning solution - D 009 401 04- and then apply glass and paint primer - D 009 200 02- .
- Shortly before installing the window, use a carpet knife to cut back the remaining adhesive sealant on the window and body flange for an even surface, but do not remove completely.
- The remaining sealant is required as a base for better adhesion of the new adhesive sealant.


WARNING

- ◆ *Keep bonding surface clean and free from grease.*
- ◆ *Do not cut back bonding surface until shortly before installation.*
- ◆ *Do not apply primer to bonding surface and do not use cleaning solution.*

– Apply adhesive bead to remaining adhesive material.

◆ Width of bead = 8 ± 2 mm

◆ Height of bead = 13.5 ± 1.5 mm


Note

We recommend the use of adhesive sealant 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.

If installing a new window:

– Clean window in bonding area using D 009 401 04 and apply glass/paint primer D 009 200 02.

– Note 10-minute flash-off time for primer.

– Apply adhesive.

1 - Adhesive bead

2 - Primer

3 - Window

◆ Width of bead -a- = 8 ± 2 mm

◆ Height of bead = 13.5 ± 1.5 mm

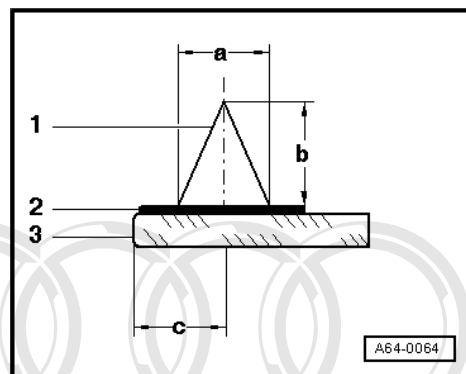
◆ Distance from edge of window c =


Note

Install trim strip (bottom) before fitting side window.

– Position bottom of window at side panel and press into opening.

– Secure window in opening using adhesive tape.



1.15 Exploded view - rear window (saloon)

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1 - Rear window

- ☐ Distance -a- to top edge of window = 2 mm
- ☐ Distance -b- to side edge of window = 2 mm; align if necessary.

2 - Adhesive bead

- ☐ Distance to edge of window 16 mm (all way around)
- ☐ Bead cross-section
- ☐ Width of bead = $8 \text{ mm} \pm 2 \text{ mm}$
- ☐ Height of bead = $12 \text{ mm} \pm 3 \text{ mm}$

3 - Trim section

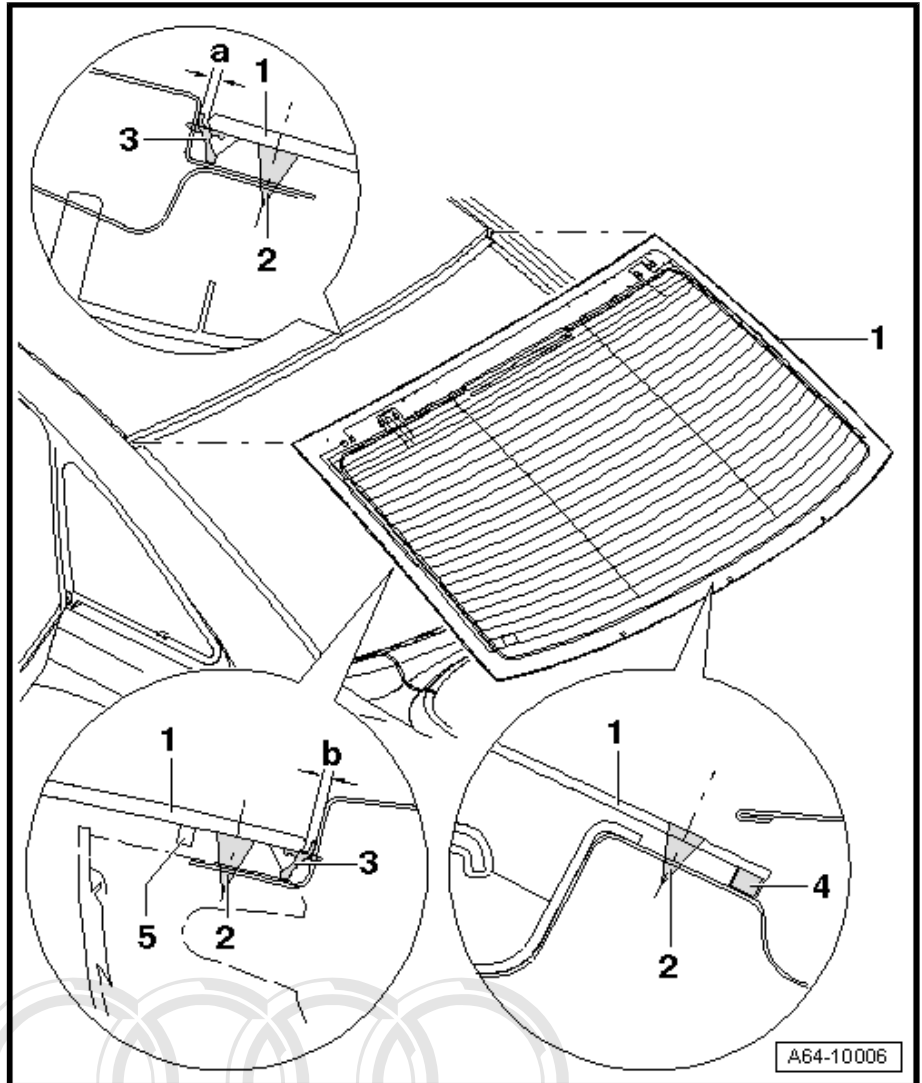
- ☐ Not available as a separate replacement part

4 - Spacer

- ☐ Note that spacers have different heights for insulating glass and standard glass.
- ☐ Bond spacer onto markings at bottom edge of window.

5 - Adhesive stopper strip

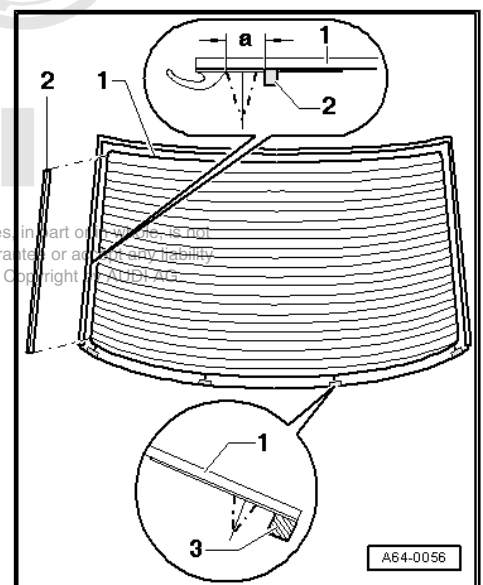
- ☐ Glue onto window next to bus bar.
- ☐ Position inner edge of adhesive stopper strip at outer edge of bus bar for heated rear window and press on.



A64-10006

Bonding on adhesive stopper strip

- Must be bonded on next to busbars for heated rear window before window adhesive.
- Position inner edge of adhesive stopper strip -2- at outer edge of busbar for heated rear window and press on.
- Bond on spacers -3- in accordance with marks on rear window -1-.



A64-0056

1.16 Removing and installing rear window

Removing undamaged window

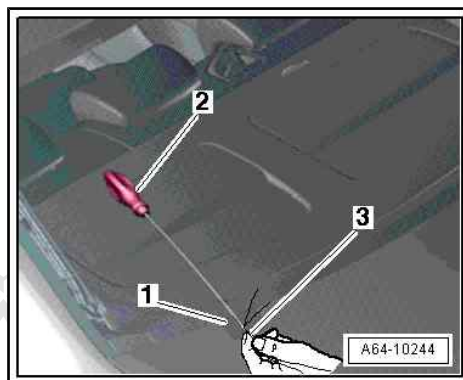
- ◆ C-pillar trim removed
- ◆ High-level brake light removed
- Unplug electrical connectors for heated rear window and window aerial, move towards centre of window and secure with adhesive tape.



WARNING

Always wear safety goggles and leather gloves when removing window.

- Use wire reel - VAS 6452/1- to reel off about 6.5 metres of cutting wire (corresponding to 6 turns) and cut off.
- Mask over body flange with adhesive tape -1- to avoid damage where awl is pushed through at the bottom.
- Thread both ends of cutting wire -3- into awl -2- and pull through to the inside.

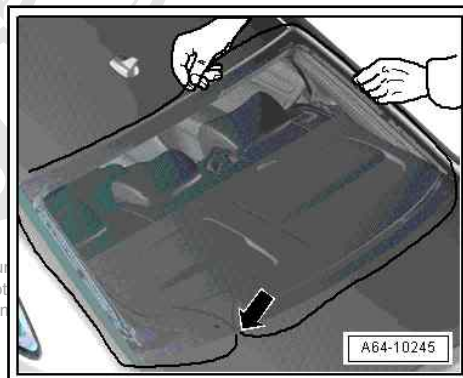


- Position cutting wire under glass all round rear window, as shown.
- Position cutting wire around rear window (under window), as shown.

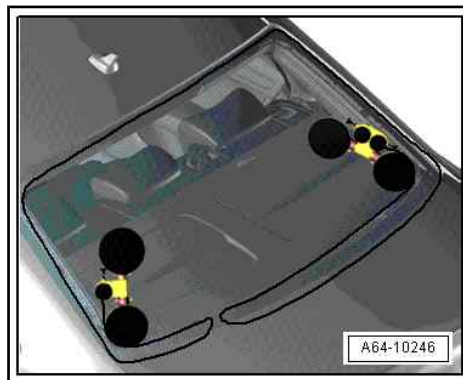


Caution

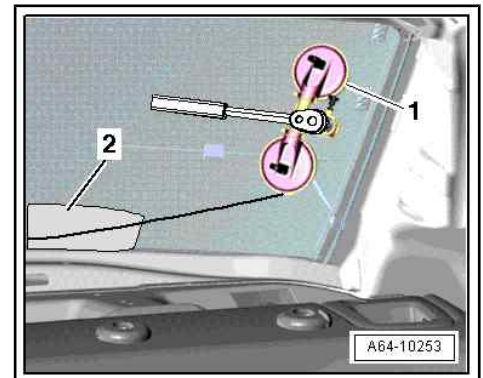
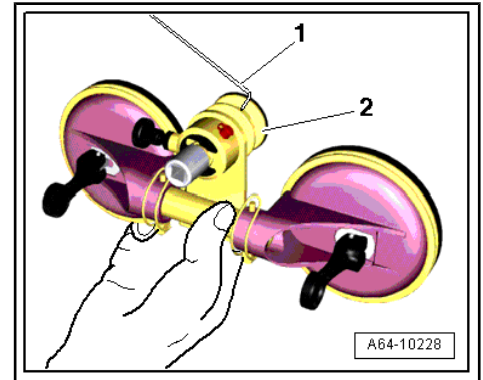
The wire ends must not be twisted at the point where they pass through the adhesive bead -arrow-.



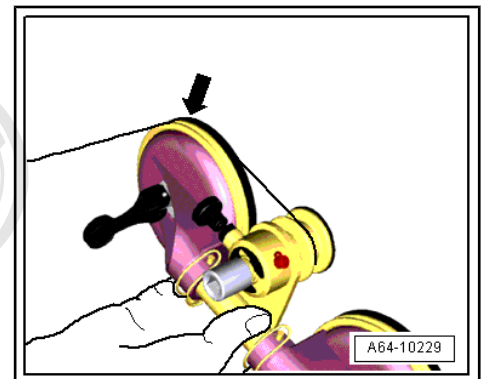
- Attach both reels to inside of window, as shown.



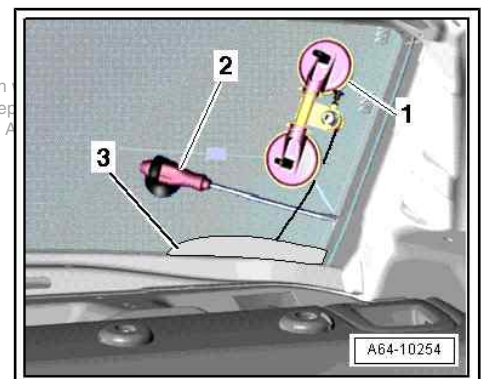
- Insert end of cutting wire -1- into reel -2-
- Tension cutting wire with reel -1- and insert plastic film -2- from removal kit - VAS 6452- as protection between wire and window.



- Cut clear the first area. While doing so, wire is guided into integrated idler pulley -arrow- on reel.

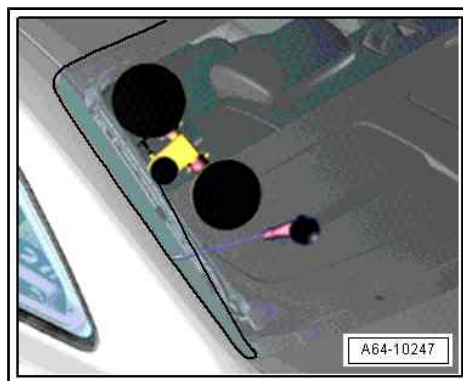


- Additionally insert guide awl -2- into adhesive bead, as shown, and attach it to window using suction pad so that wire runs along window as close to the glass as possible.

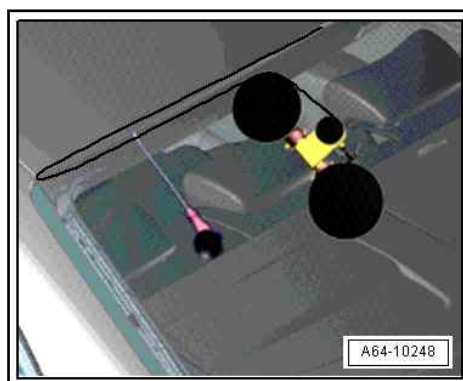


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- Adjust reel and guide awl, as shown, and cut clear area on D-pillar.
- Adjust reel and guide awl, as shown.



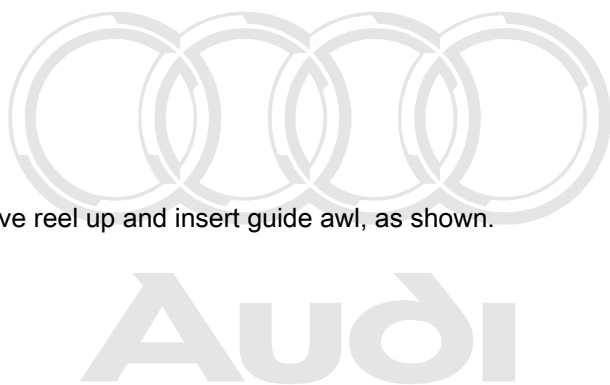
- Continue cutting window clear up to around its centre.



- Use second reel to cut clear bottom area of window.

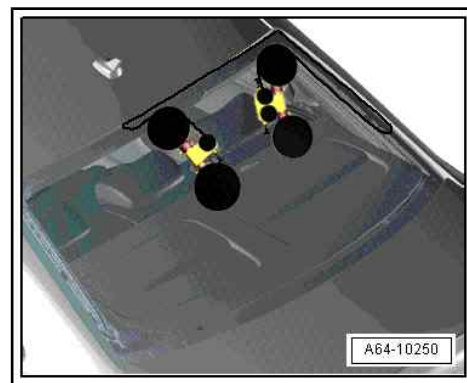


- Move reel up and insert guide awl, as shown.



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- Cut window clear upwards along D-pillar.



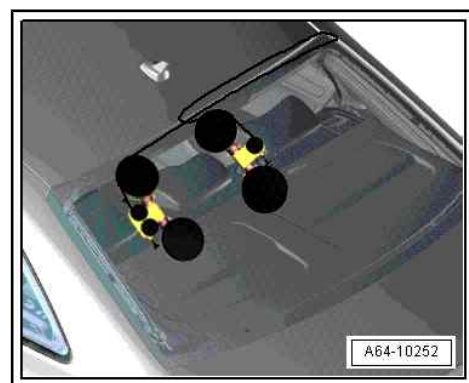
- Move reel across centre of window and past first reel, as shown, and cut window fully clear at top.
- Remove window from window opening using double suction lifters.

Removing damaged window

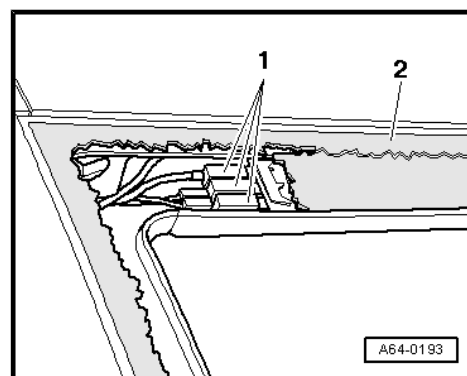


WARNING

Always wear safety goggles and leather gloves when removing window.



- Protect body and interior against damage from glass splinters.
- Remove glass fragments down to adhesive sealant.
- Unplug connectors -1- for aerals/amplifiers.
- Unplug connectors for heated rear window.
- Mask flange all round with fabric-backed adhesive tape.



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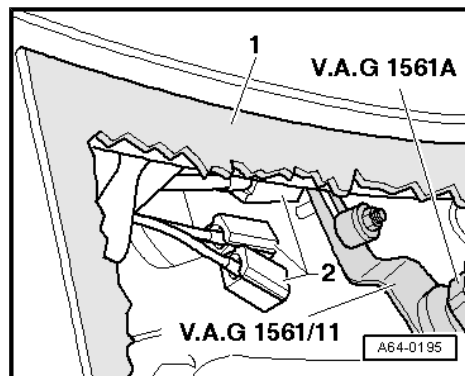
- Cut through adhesive sealant (with glass fragments) -1- in window opening with electric cutter and blade -V.A.G 1561/11- (with stop roller).

Preparations before installing rear window



Note

- ◆ *Just before re-installing an undamaged window, use electric cutter - V.A.G 1561 A- and scraper (25 mm) - V.A.G 1561/8- to cut back the remaining adhesive sealant on the window and flange to give a smooth surface, but do NOT remove completely.*
- ◆ *The remaining sealant is required as a base for better adhesion of the new adhesive sealant.*



Caution

- ◆ *Keep bonding surface clean and free from grease.*
- ◆ *Do not cut back bonding surface until shortly before installation.*
- ◆ *Do not apply primer to bonding surface and do not use cleaning solution.*

If installing a new window:

- Clean all around window bonding area with cleaning solution - D 009 401 04- .



Caution

- ◆ *The ceramic coating on the glass is not a primer.*
- ◆ *The glass must always be primed before applying adhesive sealant.*

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- Use applicator -2- to apply primer -3- evenly and in one movement to bonding surface on window -4-.
- Start application with fully soaked felt.
- Flash-off time: 10 minutes



Caution

Primer is conductive and must not come into contact with the bus bar of the rear window heating.

Window flange:

- If window flange has been damaged, paintwork structure must be repaired and, if necessary, anti-corrosion measures must be taken ⇒ Audi Paintwork Guide .
- Clean treated area with cleaning solution - D 009 401 04- and then apply glass and paint primer - D 009 200 02- .

Installing

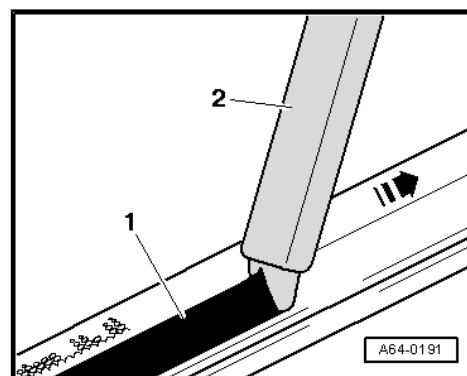
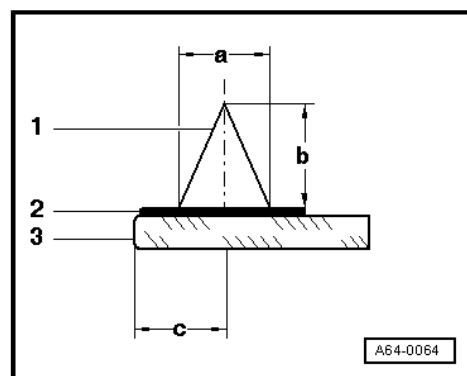
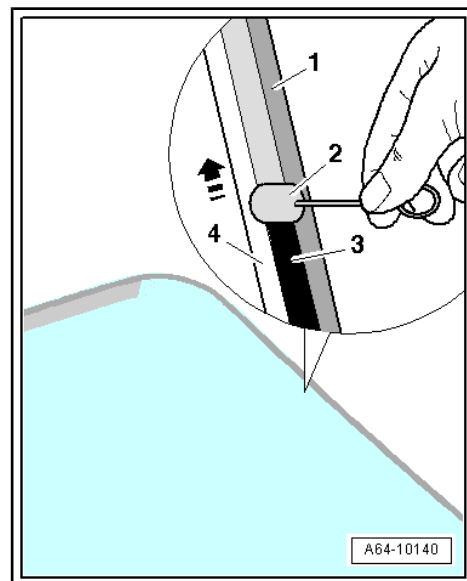


Note

The cross-section of the adhesive bead is determined by the nozzle opening and the rate of application.

Dimensions for applying adhesive:

- 1 - Adhesive bead
- 2 - Primer
- 3 - Window
- Dimension -a- = 8 mm ± 2 mm
- Dimension -b- = 12 mm ± 2 mm
- Dimension -c-: note distances from edge of window
⇒ [Item 1 \(page 183\)](#) .
- Apply full surface of nozzle -2- to window.
- Direction of application -arrow- for adhesive bead -1-.



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- Apply adhesive sealant all around window.
- In the case of an undamaged window, apply adhesive to remaining adhesive bead.
- Fit rear window into window opening using double suction lifters.



Caution

The glass must be fitted within 10 minutes; otherwise the adhesive properties of the adhesive sealant will be impaired.

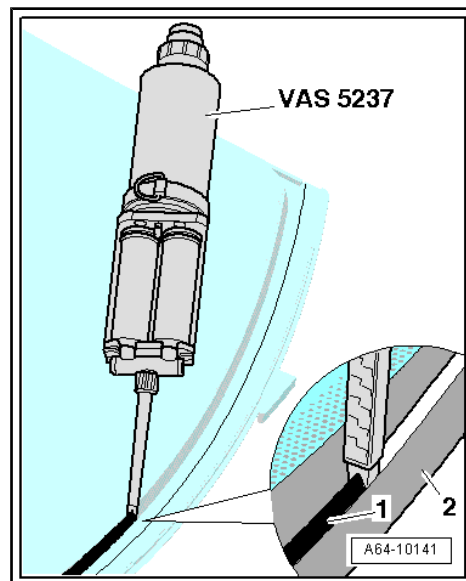
- Align glass so that spacing is equal on both sides.
- Observe distance from roof = ⇒ [Item 1 \(page 183\)](#) .
- Note minimum drying time ⇒ [page 166](#) .

Overview of aerals for rear window



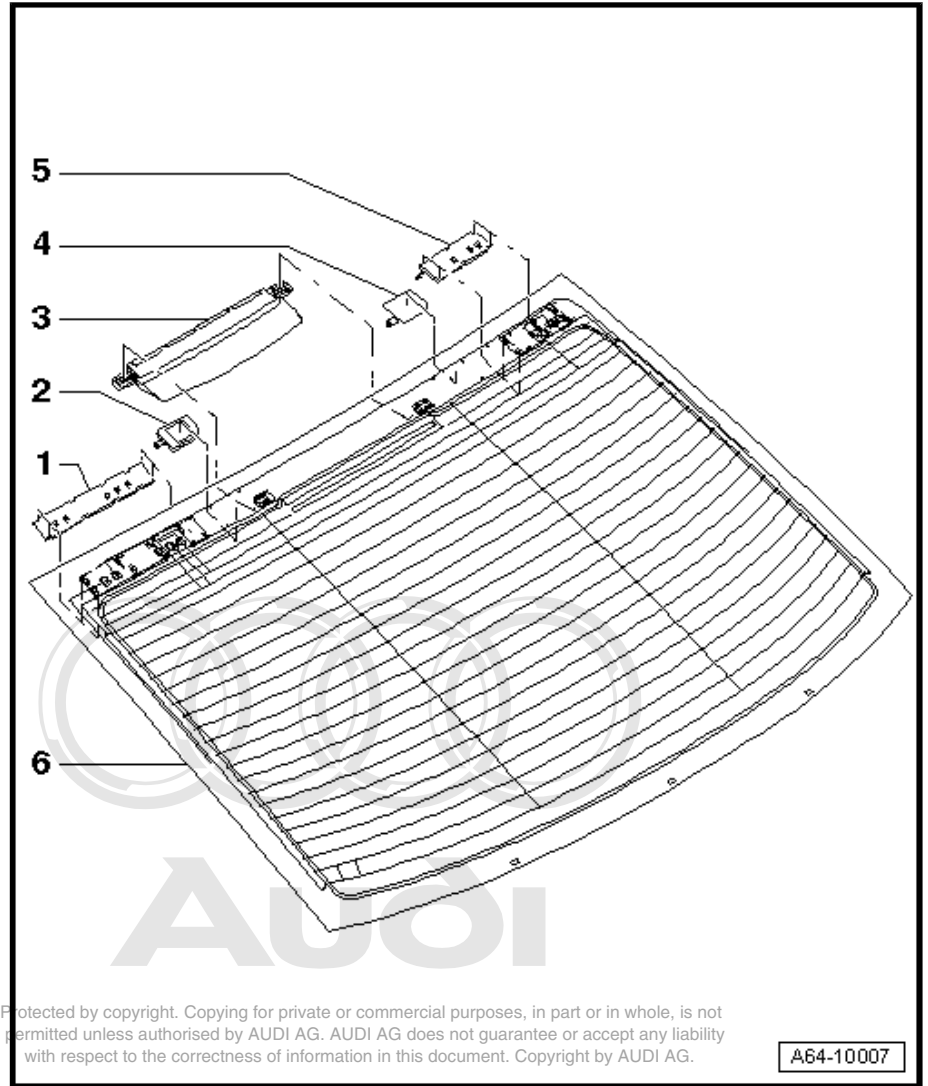
Note

Certain aerals are only fitted as optional equipment.



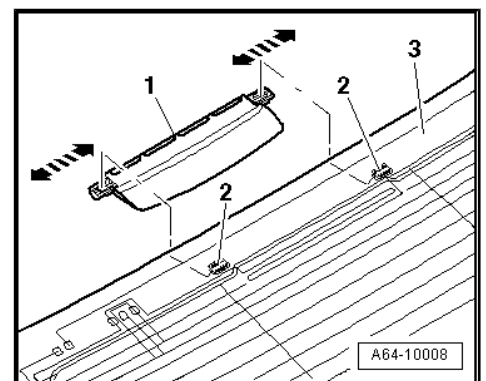
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- 1 - Radio aerial amplifier
- 2 - Bracket for GPS aerial
- 3 - Brake light
- 4 - Telestart module
- 5 - Remote control aerial amplifier
- 6 - Rear window



Removing brake light

- When removing, disengage catches by pressing outwards in direction of arrows and detach brake light.
- When installing, position brake light and engage catches by pressing inwards in direction of arrows.



1.17 Exploded view - side window (Avant)



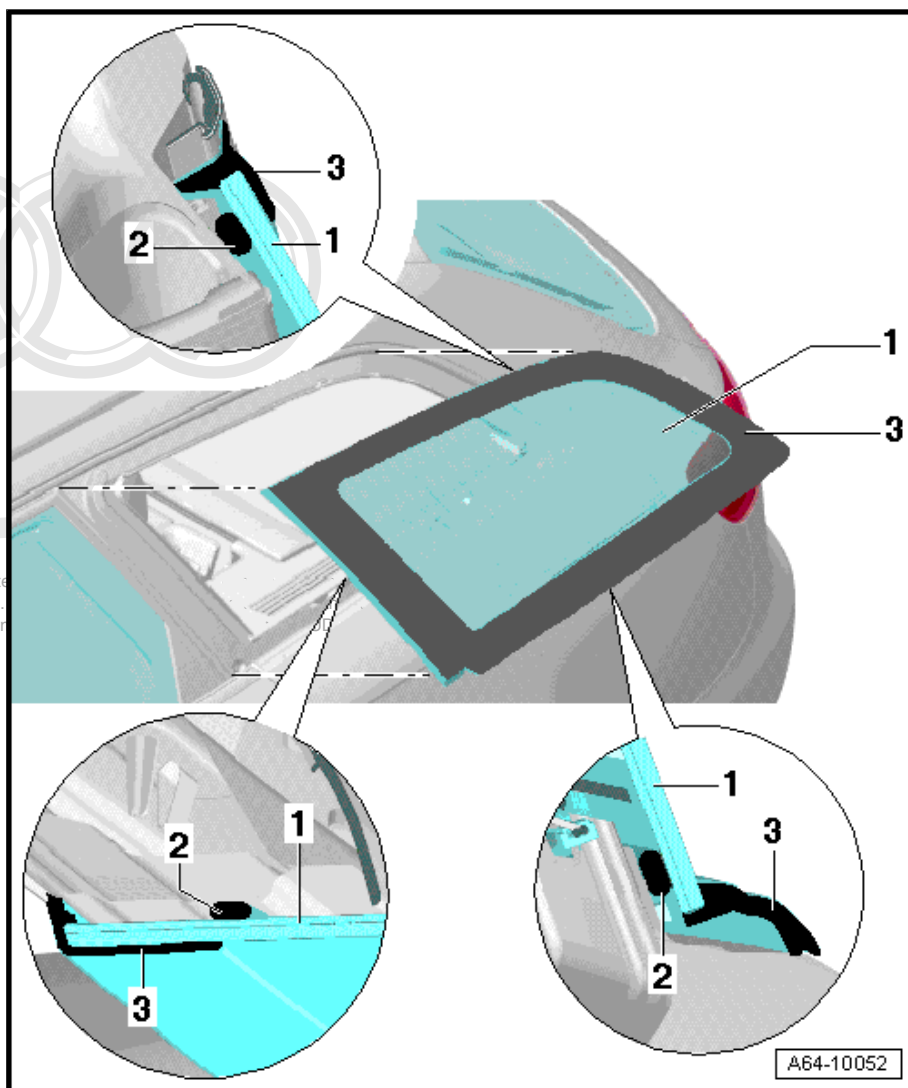
Prior to removal, unplug all electrical connectors, move contacts/wiring inwards towards the centre of the window and fix in position with adhesive tape.

1 - Side window

2 - Adhesive bead

3 - Moulding for side window

- ☐ Not available as a separate replacement part
- ☐ Visible area must not be damaged.



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Vehicles with high-gloss package

1 - Side window

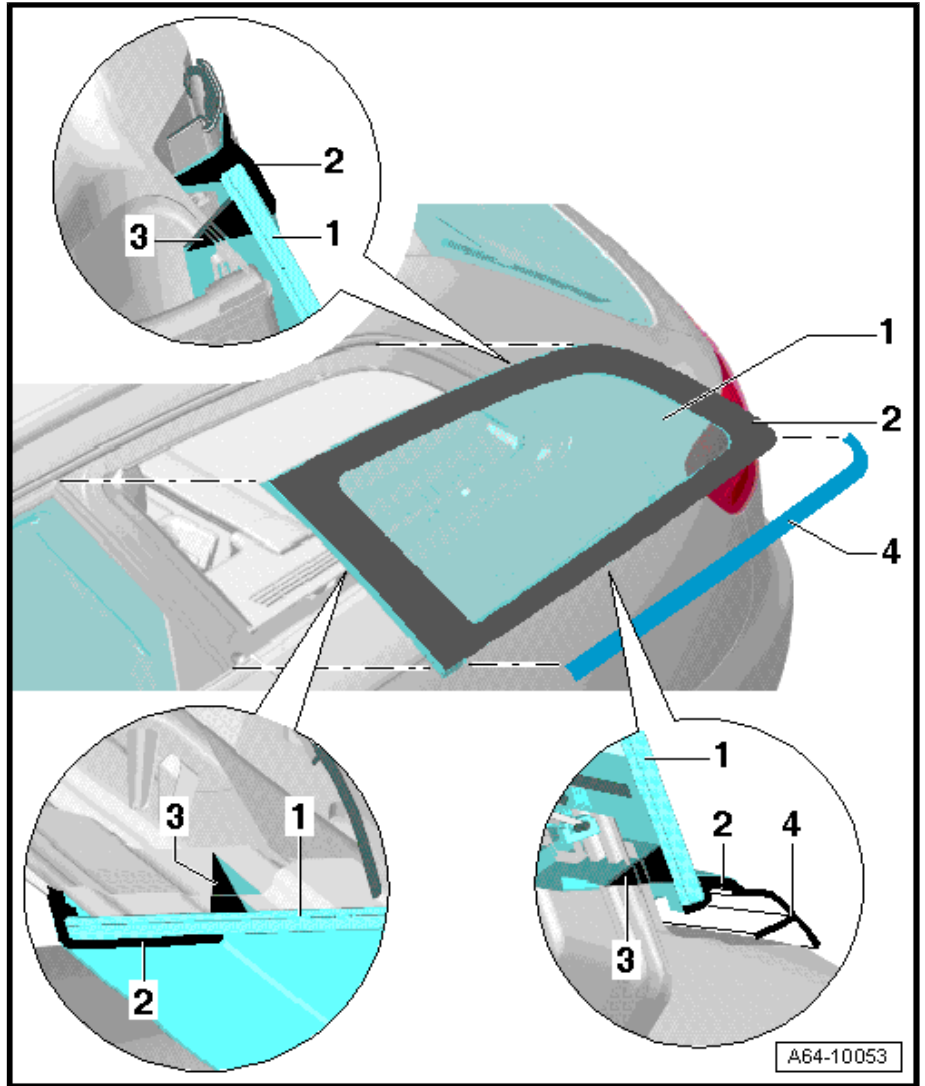
- ❑ Prior to removal, detach trim strip for side panel -4- and pull roof trim strip in area of D-pillar sideways out of fasteners.

2 - Moulding for side window

- ❑ Not available as a separate replacement part
- ❑ Visible area must not be damaged.

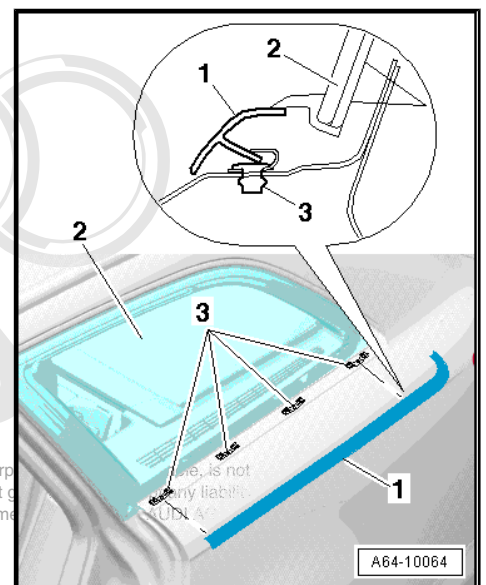
3 - Adhesive bead

4 - Trim strip



Trim strip for side panel

- Before removing trim strip, mask side panel in this area with adhesive tape.
- Pull trim strip -1- (starting from C-pillar) out of fasteners -3- under moulding for side window -2-.



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1.18 Removing and installing side window

Removing undamaged window



WARNING

Always wear safety goggles and leather gloves when removing window.

Remove the following trim panels:

- Luggage compartment side trim ⇒ Rep. gr. 70
- D-pillar trim ⇒ Rep. gr. 70
- Trim above rear side window ⇒ Rep. gr. 70
- C-pillar trim ⇒ Rep. gr. 70 .

Side window (high-gloss package)

- Pull trim strip -1- (starting from C-pillar) out of fasteners -3- under moulding for side window -2-.
- Pull trim strip downwards out of roof trim strip.

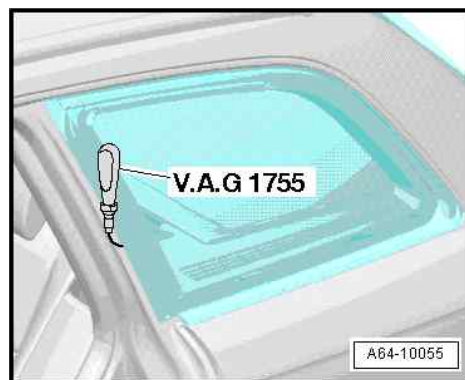
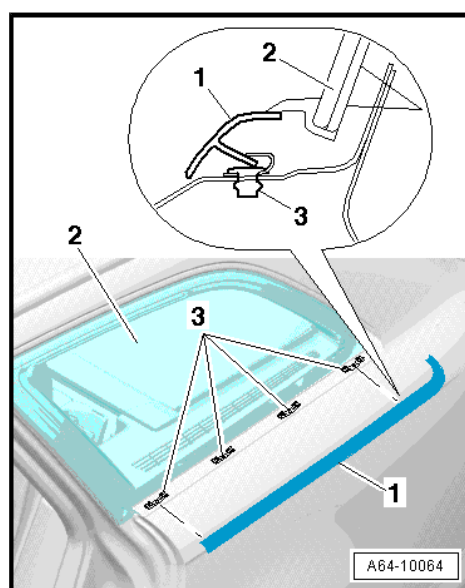


WARNING

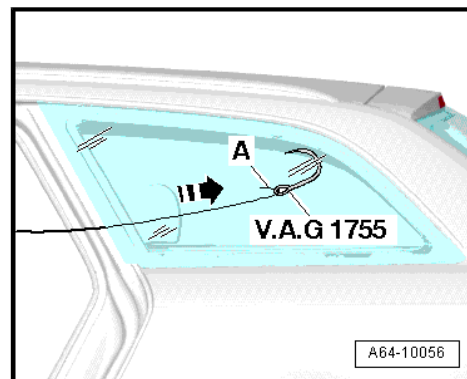
- ◆ *To prevent paintwork damage when removing and installing trim strip, always mask area beneath side window and on side panel with adhesive tape.*
- ◆ *Even a slightly bent roof trim strip is damaged and must be renewed.*

All versions:

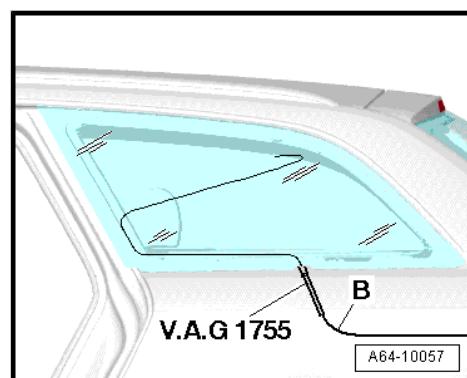
- Pierce adhesive bead using trimming needle and handle from -V.A.G 1755- .
- Unscrew handle and thread cutting cord into eye of trimming needle.



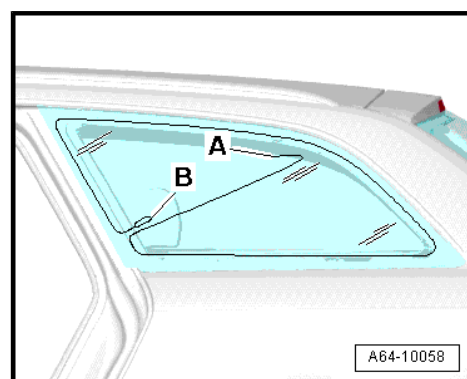
- Pull one end of cutting cord -A- into vehicle interior as far as opposite side of the window using trimming needle from - V.A.G 1755- (use pliers and protective gloves).



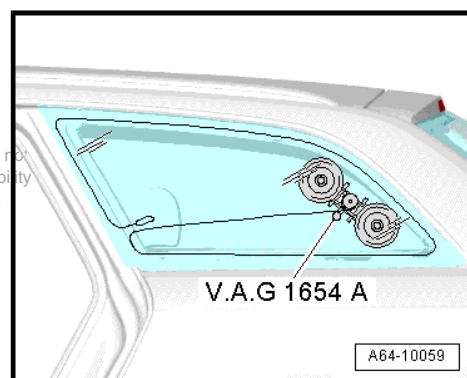
- Pull cutting cord -B- with tube from -V.A.G 1755- into moulded trim (made of PU foam) around side window.



- Position cutting cord all round window.
- Pierce adhesive bead using trimming needle and handle from -V.A.G 1755- .
- Unscrew handle and thread end of cutting cord -B- into eye of trimming needle.
- Pull end of cutting cord -B- into interior of vehicle using trimming needle (use pliers and protective gloves).
- Attach end of cutting cord -B- to bracket for belt guide.



- Attach reel -V.A.G 1654- as shown and secure cutting cord in it.



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- Cut out first section at C-pillar and at bottom of window.

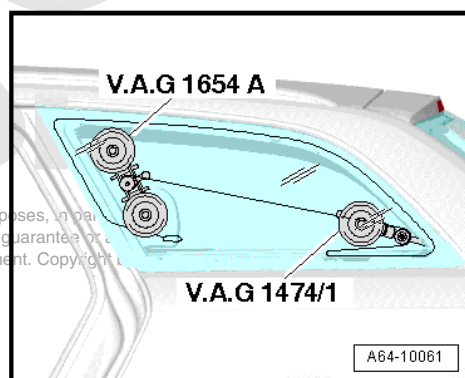
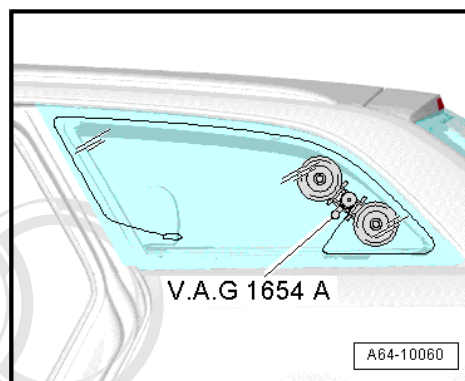


Note

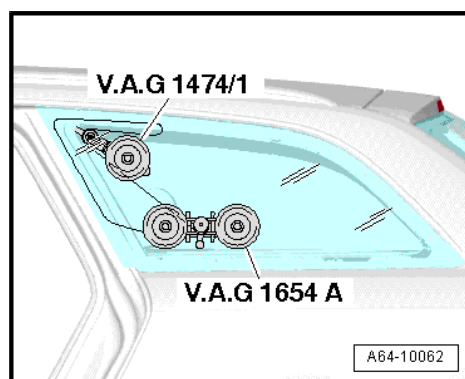
Press cutting cord towards body whilst cutting.

- Attach guide roller -V.A.G 1474/1- as shown in illustration.
- Move reel -V.A.G 1654- to next position and continue cutting.

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- Attach guide roller -V.A.G 1474/1- as shown in illustration.
- Move reel -V.A.G 1654- to next position and continue cutting.



- Lift out side window using double suction lifter -V.A.G 1344- .

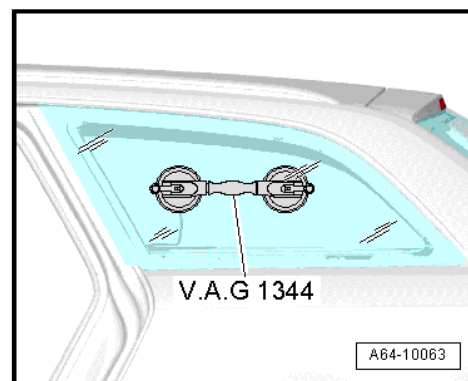
Removing damaged window

- Protect body and interior against damage from glass splinters.
- Mask flange all round with fabric-backed adhesive tape.
- Unplug connectors for aerals/amplifiers.
- Remove glass fragments down to adhesive sealant.



WARNING

Always wear safety goggles and leather gloves when removing window.



- Cut through adhesive sealant (with glass fragments) in window opening using electric cutter - V.A.G 1561A- and universal cutter - V.A.G 1561/11- (with roller stop).

Installing undamaged window

- If window flange has been damaged, paintwork structure must be repaired and, if necessary, anti-corrosion measures must be taken ⇒ Audi Paintwork Guide .
- Clean repaired area using cleaning solution - D 009 401 04- and then apply glass and paint primer - D 009 200 02- .
- Shortly before installing the window, use a carpet knife to cut back the remaining adhesive sealant on the window and body flange for an even surface, but do not remove completely.
- The remaining sealant is required as a base for better adhesion of the new adhesive sealant.



WARNING

- ◆ ***Keep bonding surface clean and free from grease.***
- ◆ ***Do not cut back bonding surface until shortly before installation.***
- ◆ ***Do not apply primer to bonding surface and do not use cleaning solution.***

- Apply adhesive bead to remaining adhesive material.

- ◆ Width of bead = 8 ± 2 mm
- ◆ Height of bead = 13.5 ± 1.5 mm



Note

We recommend the use of adhesive sealant 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.

If installing a new window:

- Clean window in bonding area using D 009 401 04 and apply glass/paint primer D 009 200 02.
- Note 10-minute flash-off time for primer.
- Apply adhesive.
- ◆ Width of bead -a- = 8 ± 2 mm

- ◆ Height of bead = 13.5 ± 1.5 mm
- ◆ Correct distance from edge of window will be attained if adhesive is applied directly adjacent to moulding.



Note

Install trim strip (bottom) before fitting side window.

- Position bottom of window at side panel and press fully into window opening.
- Secure window in opening using adhesive tape.

1.19 Exploded view - rear window (Avant)

1 - Rear window

2 - Adhesive stopper strip

- ☐ Must be bonded on next to bus bars for heated rear window before window adhesive.
- ☐ Position inner edge of adhesive stopper strip at outer edge of bus bar for heated rear window and press on.
- ☐ Window adhesive must not make contact with busbar for heated rear window.

3 - Adhesive bead



Note

Observe different distance from edge of window.

- ☐ Dimension -a- = 2 mm
- ☐ Dimension -b- = 15 mm
- ☐ Align dimension -c- centrally with body on left and right.
- ☐ Dimension -d- = 32 mm
- ☐ Dimension -e- = 15 mm

4 - Cover strip

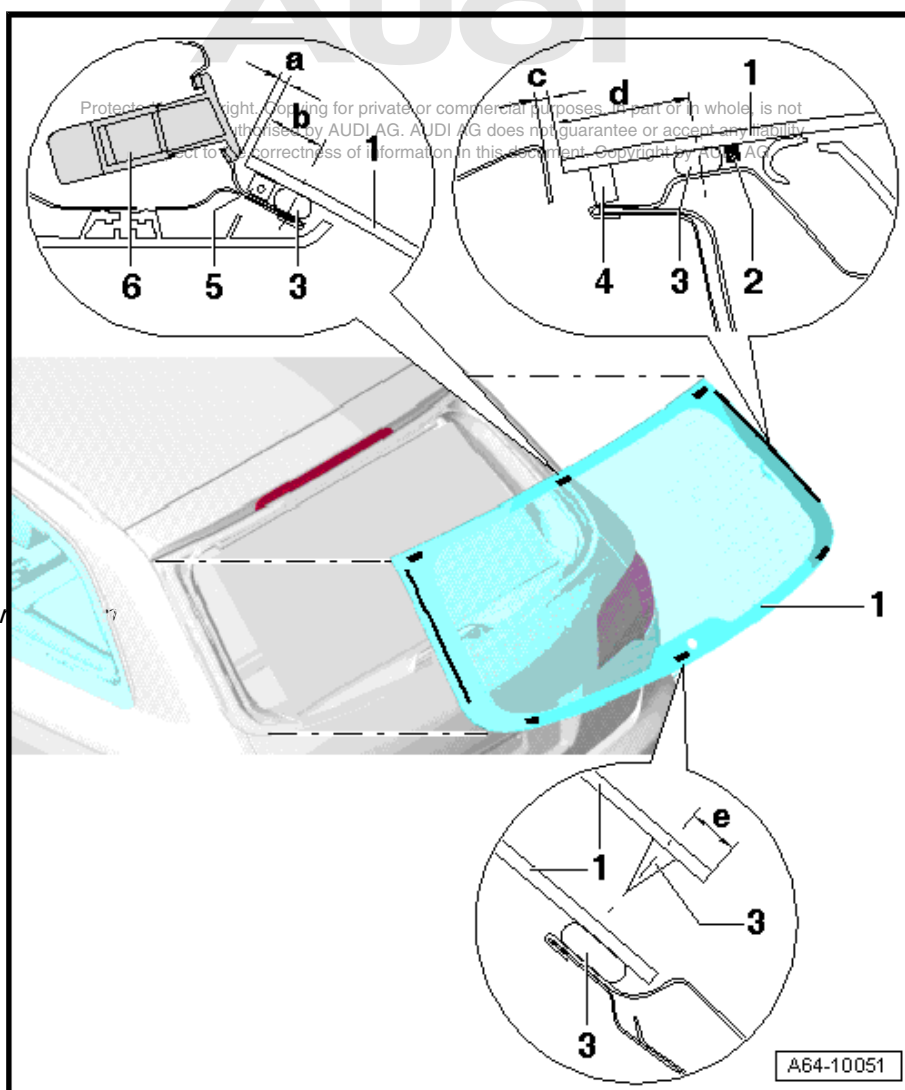
- ☐ Not available as a separate replacement part
- ☐ Make sure that visible area is not damaged when removing window.

5 - Spacer

- ☐ Bonded onto top and bottom edge of window (3 at top, 3 at bottom).

6 - High-level brake light

- ☐ Does not have to be removed to take out rear window



Adhesive stopper strip

1 - Cover strip

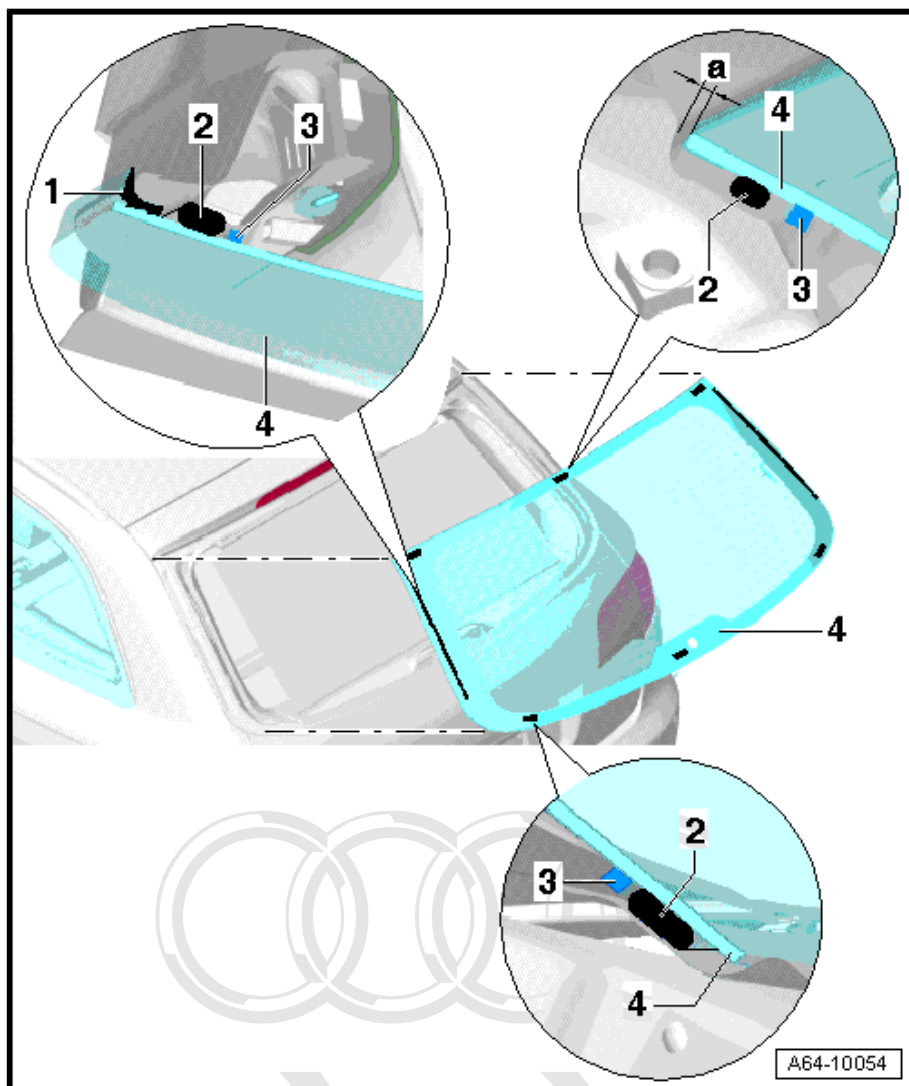
- ☐ Not available as a separate replacement part
- ☐ Make sure that visible area is not damaged when removing window.

2 - Adhesive bead

3 - Adhesive stopper strip

- ☐ Must be bonded on next to bus bars for heated rear window before window adhesive.
- ☐ Position inner edge of adhesive stopper strip at outer edge of bus bar for heated rear window and press on.
- ☐ Window adhesive must not make contact with bus bar for heated rear window when fitted.

4 - Rear window



1.20 Removing and installing rear window

Removing undamaged rear window

- Rear lid trim removed ⇒ Rep. gr. 70
- Rear window wiper removed ⇒ Rep. gr. 92 .
- Unplug electrical connectors for heated rear window and window aerial, move towards centre of window and secure with adhesive tape.

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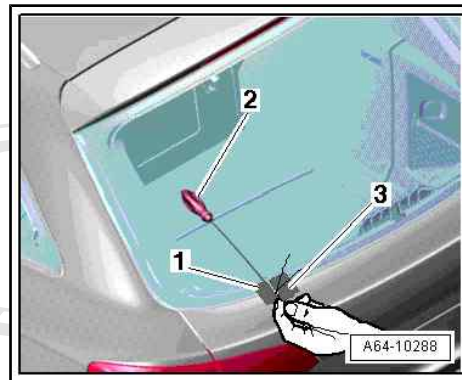


WARNING

Always wear safety goggles and leather gloves when removing window.

- Use wire reel - VAS 6452/1- to reel off about 6.5 metres of cutting wire (corresponding to 6 turns) and cut off.

- Mask over body flange with adhesive tape -1- to avoid damage where awl is pushed through at the bottom.
- Thread both ends of cutting wire -3- into awl -2- and pull through to the inside.



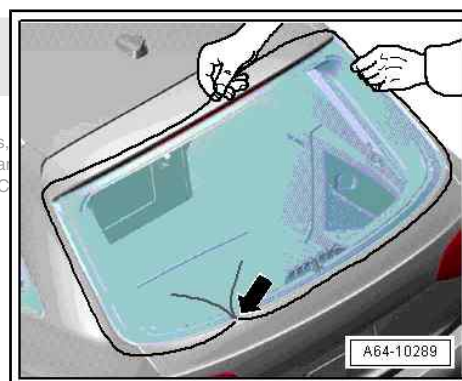
- Position cutting wire under glass all round rear window, as shown.
- Position cutting wire around rear window (under window), as shown.

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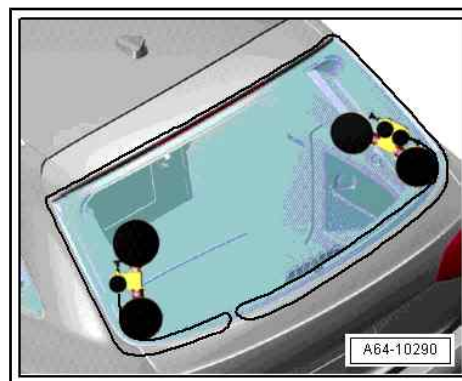


Caution

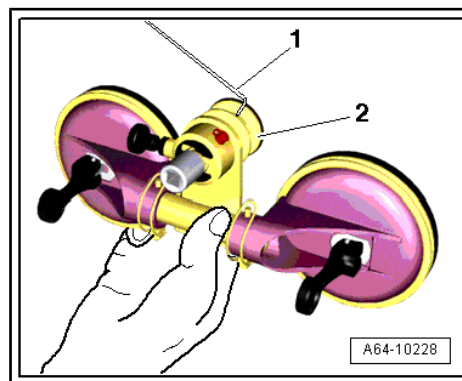
The wire ends must not be twisted at the point where they pass through the adhesive bead -arrow-.

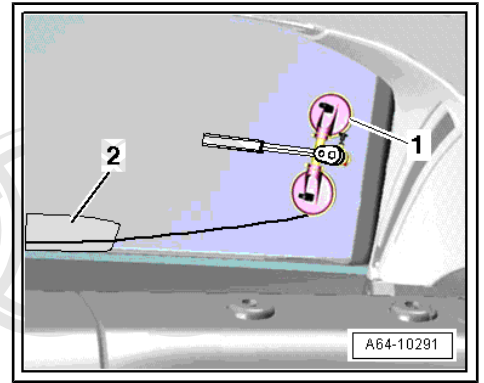


- Attach both reels to inside of window, as shown.

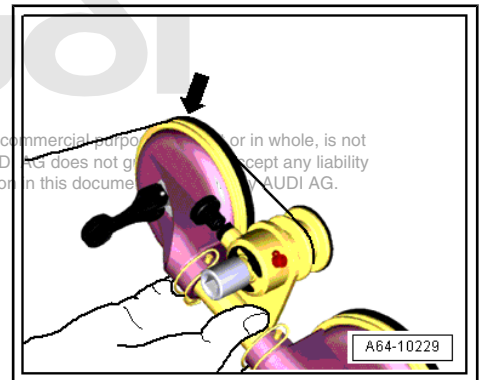


- Insert end of cutting wire -1- into reel -2-
- Tension cutting wire with reel -1- and insert plastic film -2- from removal kit - VAS 6452- as protection between wire and window.

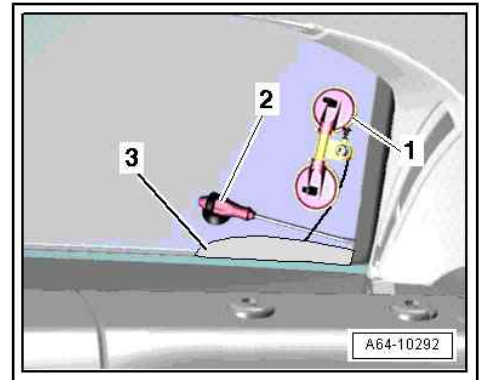




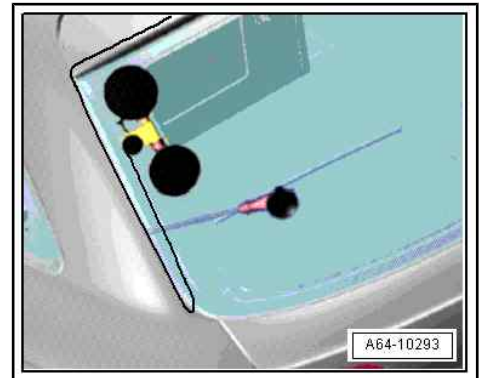
- Cut clear the first area. While doing so, wire is guided into integrated idler pulley -arrow- on reel.



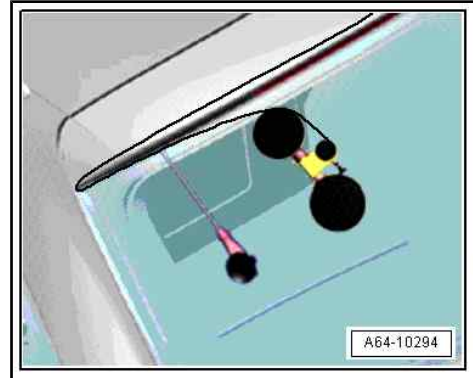
- Additionally insert guide awl -2- into adhesive bead, as shown, and attach it to window using suction pad so that wire runs along window as close to the glass as possible.



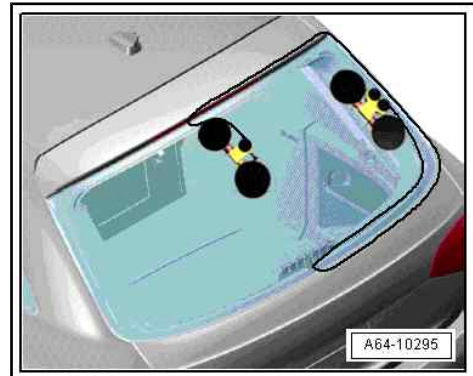
- Adjust reel and guide awl, as shown, and cut clear area on D-pillar.
- Adjust reel and guide awl, as shown.



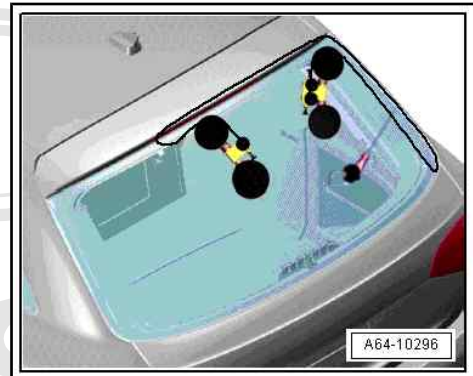
- Continue cutting window clear up to around its centre.



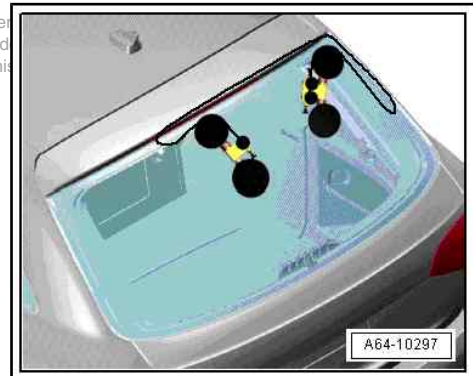
- Use second reel to cut clear bottom area of window.



- Move reel up and insert guide awl, as shown.



- Cut window clear upwards along D-pillar.



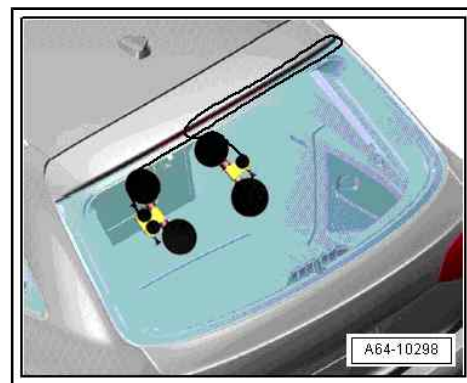
- Move reel across centre of window and past first reel, as shown, and cut window fully clear at top.
- Remove window from window opening using double suction lifters.

Removing damaged rear window



WARNING

Always wear safety goggles and leather gloves when removing window.



- Protect body and interior against damage from glass splinters.
- Remove glass fragments down to adhesive sealant.
- Unplug electrical connectors for heated rear window and window aerial.
- Mask flange all round with fabric-backed adhesive tape.
- Cut through adhesive sealant (with glass fragments) in window opening using electric cutter - V.A.G 1561A- and offset blade - V.A.G 1561/10- (with roller stop).

Preparations before installing rear window



Note

- ♦ *Just before re-installing an undamaged window, use electric cutter - V.A.G 1561 A- and scraper (25 mm) - V.A.G 1561/8- to cut back the remaining adhesive sealant on the window and flange to give a smooth surface, but do NOT remove completely.*
- ♦ *The remaining sealant is required as a base for better adhesion of the new adhesive sealant.*



Caution

- ♦ *Keep bonding surface clean and free from grease.*
- ♦ *Do not cut back bonding surface until shortly before installation.*
- ♦ *Do not apply primer to bonding surface and do not use cleaning solution.*

If installing a new window:

- Clean all around window bonding area with cleaning solution - D 009 401 04- .



Caution

- ♦ *The ceramic coating on the glass is not a primer.*
- ♦ *The glass must always be primed before applying adhesive sealant.*

- Apply glass and paint primer - D 009 200 02- as described.

Applying primer:

- Use applicator -2- to apply primer -3- evenly and in one movement to bonding surface on window -4-.
- Start application with fully soaked felt.
- Flash-off time: 10 minutes



Caution

Primer is conductive and must not come into contact with the bus bar of the rear window heating.

Window flange:

- If window flange has been damaged, paintwork structure must be repaired and, if necessary, anti-corrosion measures must be taken ⇒ Audi Paintwork Guide .
- Clean treated area with cleaning solution - D 009 401 04- and then apply glass and paint primer - D 009 200 02- .

Installing

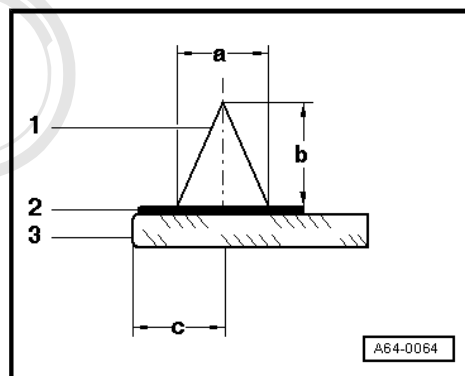


Note

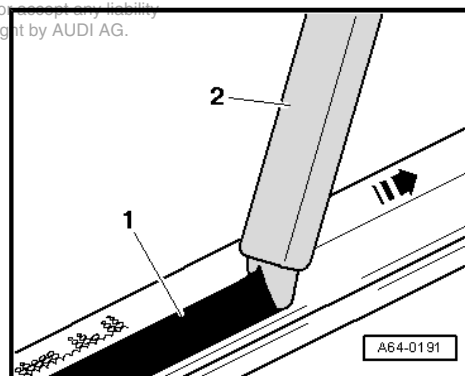
The cross-section of the adhesive bead is determined by the nozzle opening and the rate of application.

Dimensions for applying adhesive:

- 1 - Adhesive bead
- 2 - Primer
- 3 - Window
- Dimension -a- = 8 mm ± 2 mm
- Dimension -b- = 12 mm + 2 mm
- Dimension -c-: note different distances from edge of window ⇒ [Item 3 \(page 198\)](#) .



- Apply full surface of nozzle -2- to window.
- Direction of application -arrow- for adhesive bead -1-.



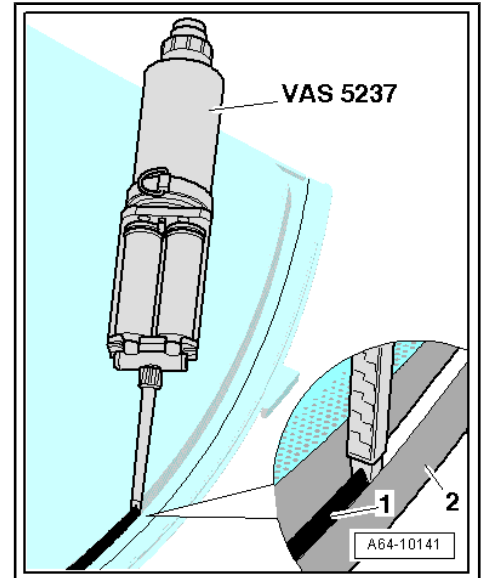
- Apply adhesive sealant all around window.
- When reinstalling an undamaged window, apply adhesive to remaining adhesive bead.
- Fit rear window into window opening using double suction lifters.



Caution

The glass must be fitted within 10 minutes; otherwise the adhesive properties of the adhesive sealant will be impaired.

- Align glass so that spacing is equal on both sides.
- Note minimum drying time ⇒ [page 166](#) .



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66 – Exterior equipment

1 Strips and panels

1.1 Removing and installing roof trim strip



Note

Removal of roof trim strip does not involve taking out side window.

1 - Roof trim strip



Note

Side window roof trim strip must NOT be twisted or bent as this would cause visible damage.

- ☐ Door seals detached in area of roof trim strip.
- ☐ Prise trim strip -2- out of roof trim strip.
- ☐ Drill heads off pop rivets -3-, knock out shanks and detach roof trim strip.

2 - Trim strip

- ☐ Apply lubricant to edges to facilitate installation.
- ☐ Press into roof trim strip, working from front to rear.

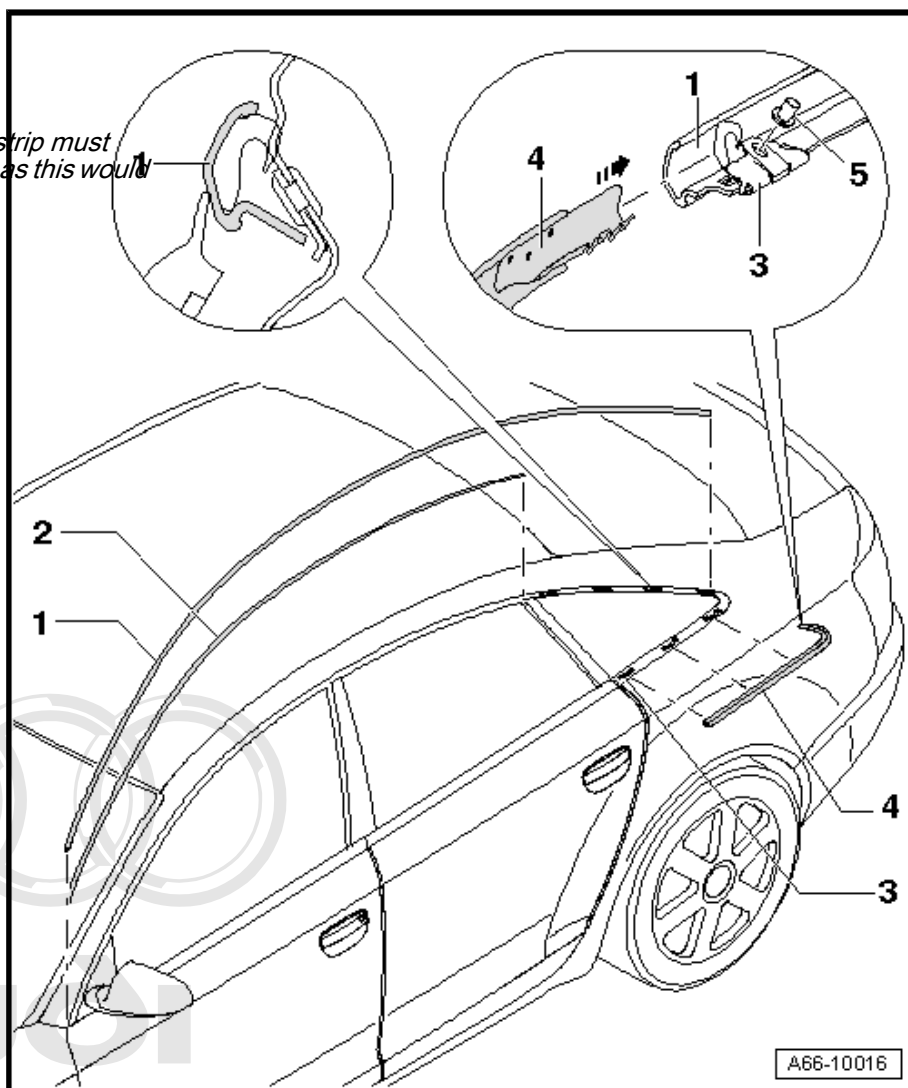
3 - Retaining clip

- ☐ 4x on roof frame
- ☐ 3x on side frame

4 - Trim strip for side window

- ☐ Using a plastic wedge and starting at bottom, lever out of retaining clips sideways and then remove from roof trim strip.

5 - Pop rivet



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1.2 Removing and installing window slot trim strips

Front door

1 - Front door

2 - Window slot trim strip

- ☐ Window frame and window regulator removed
- ☐ Release clip and pull it out.
- ☐ Drill off rivet heads, knock out rivet stems and pull window slot trim strip upwards to remove.



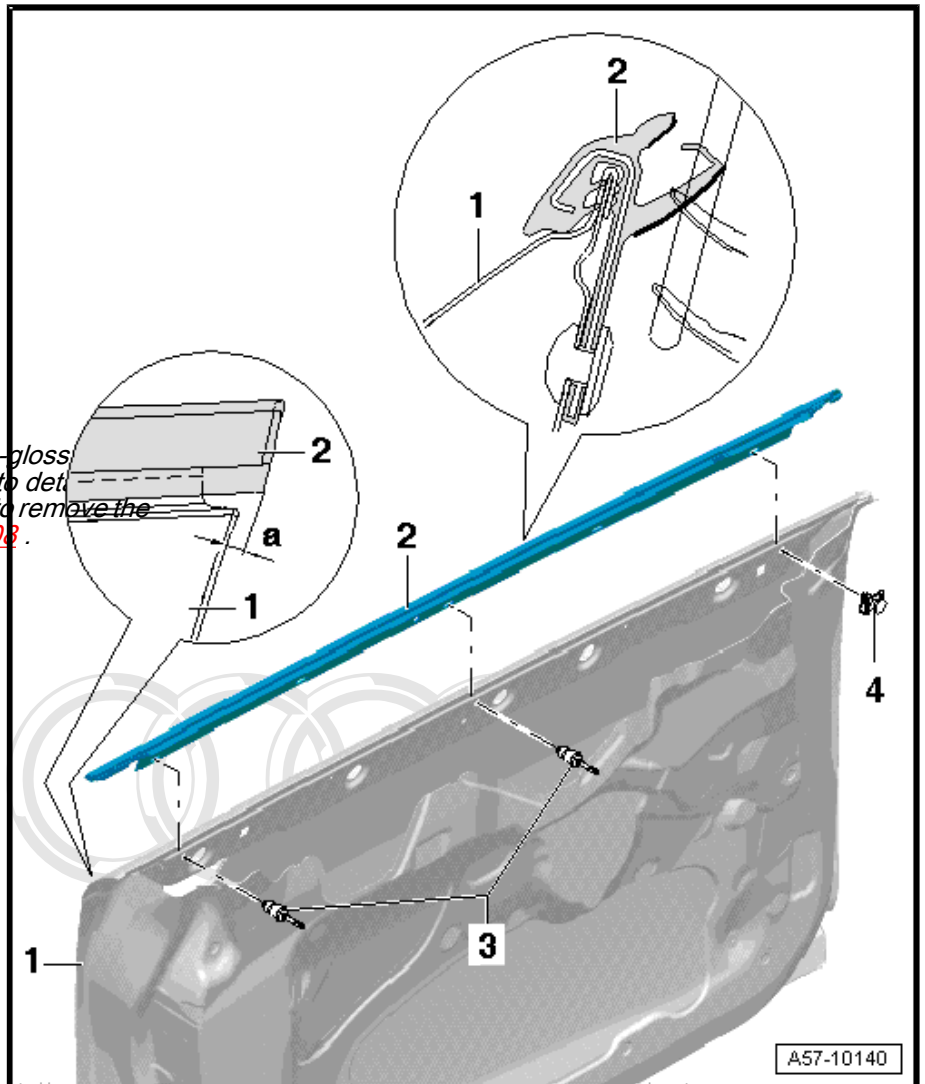
Note

On vehicles with »high-gloss age« you do not have to det window frame in order to remove the chrome trim => [page 208](#).

- ☐ To install, press in window slot trim strip starting at rear end of door.
- ☐ Dimension -a- = 0...0.5 mm
- ☐ Rivet window slot trim strip starting at rear end and finish by fastening clip -3-.

3 - Pop rivet

4 - Clip



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Rear door

1 - Front door

2 - Window slot trim strip

- ☐ Window frame and window regulator removed
- ☐ Release clip and pull it out.
- ☐ Drill off rivet heads, knock out rivet stems and pull window slot trim strip upwards to remove.



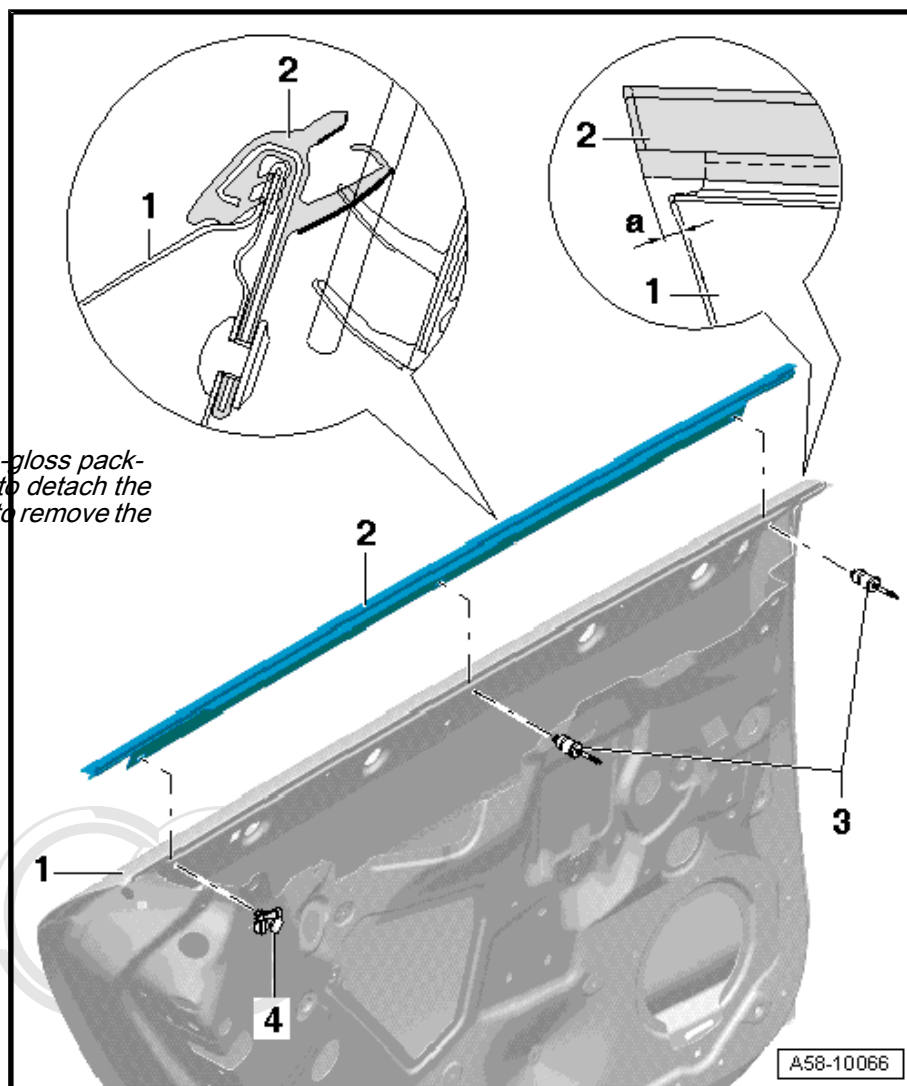
Note

On vehicles with »high-gloss package« you do not have to detach the window frame in order to remove the chrome trim.

- ☐ To install, press in window slot trim strip starting at front end of door.
- ☐ Dimension -a- = 0...0.5 mm
- ☐ Rivet window slot trim strip starting at front end and finish by fastening clip -4-.

3 - Pop rivet

4 - Clip



Vehicles with high-gloss package

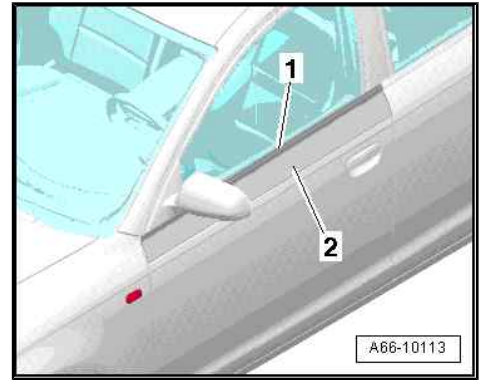


Note

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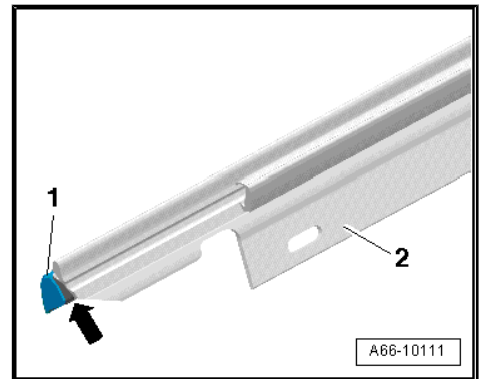
- ◆ *The window slot trim strip consists of two parts on vehicles with high-gloss package.*
- ◆ *The chrome trim can be renewed without detaching the window frame.*
- Exterior mirror on front doors removed ⇒ [page 227](#)

- Mask area of door beneath window slot trim strip -1- with adhesive tape -2-.

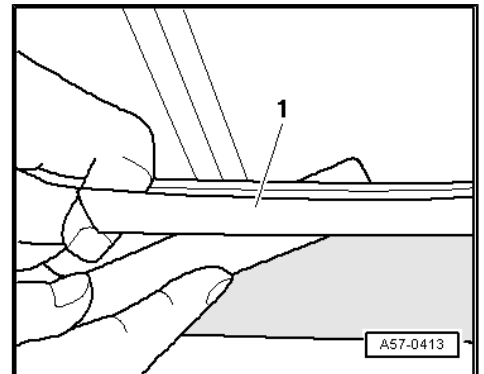


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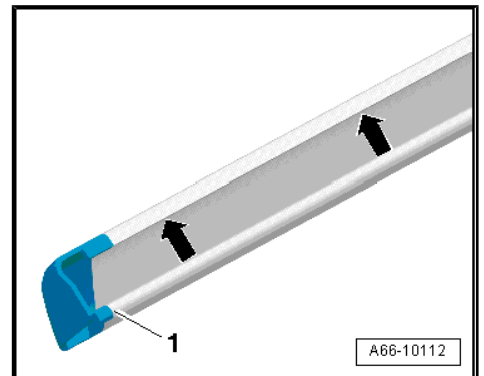
- Bend up window slot trim strip -1- at rear -arrow-.
- Mounting section -2- remains riveted and clipped to vehicle.



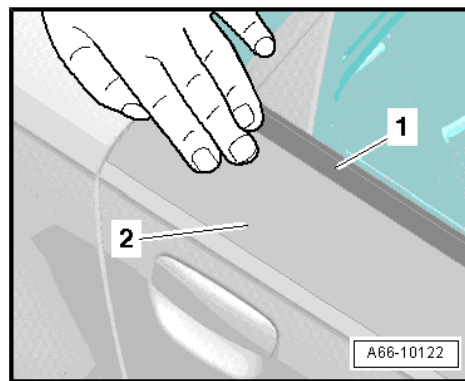
- Use plastic wedge to prise window slot trim strip -1- up sideways and off mounting section.



- Open up top lip -1- of trim strip -arrows- slightly using a plastic wedge.
- Apply soap solution to lip and mounting section.



- Insert window slot trim strip -1- from above and press it all the way onto mounting section.
- Pull off protective film -2- after completing installation.



1.3 Removing and installing trim cover for side member



Note

- ◆ The trim cover is additionally secured with adhesive tape on vehicles from model year 2009 onwards.
- ◆ On these vehicles, the trim cover must be renewed after removal.
- ◆ Before installation, the bonding surfaces must be at room temperature and free from dust and grease.
- ◆ When installing, the protective film must only be pulled out from between door and adhesive tape using the removal aid once the trim cover has been inserted.
- ◆ After installation, the trim cover must be pressed into position in the bonding area using the roller - 3356- .

Front door

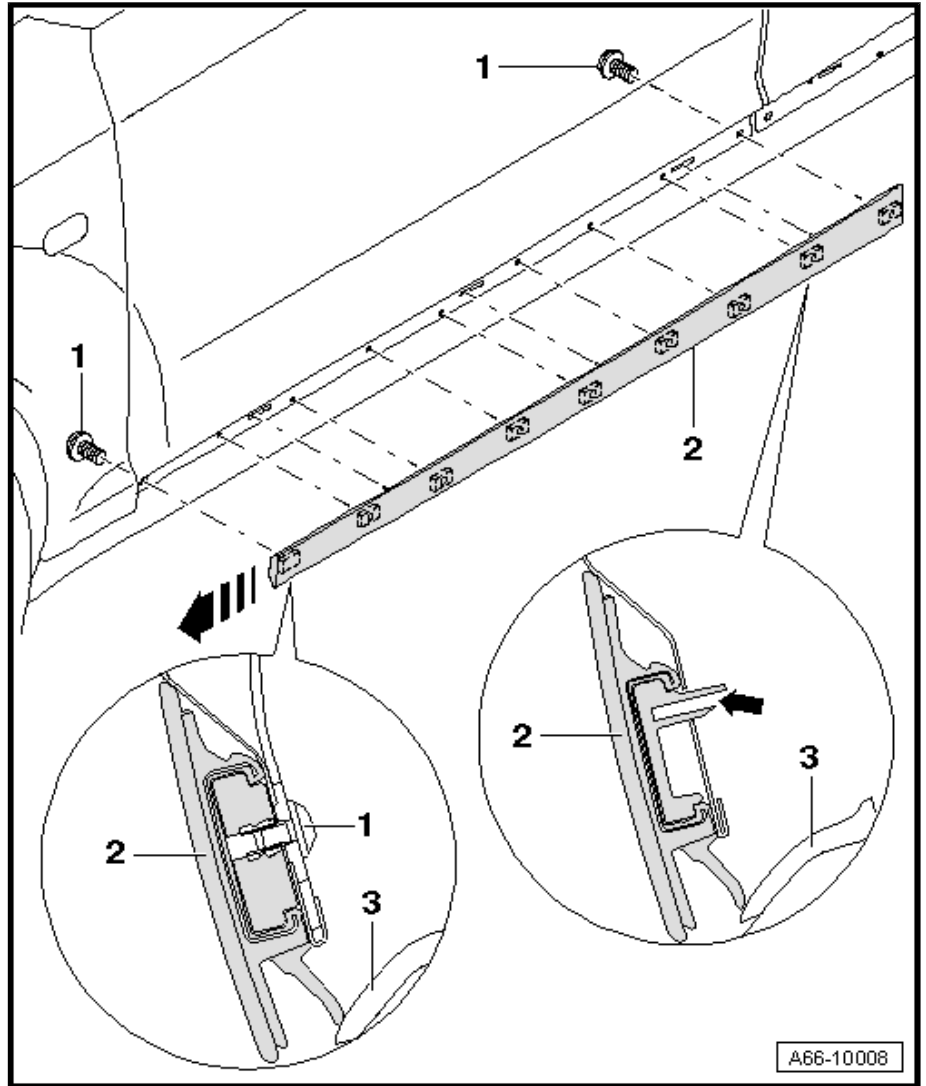
1 - Bolt

□ 2 Nm

- Remove bolts -1- at front and rear.
- Lift out centring pin -arrow- from rear side and pull trim cover out of retainers.
- To install, position trim cover on retainers.
- Push trim cover forwards in direction of -arrow- until centring pin -arrow- engages.
- Tighten bolts.

2 - Trim cover

3 - Outer sill panel trim



Rear door



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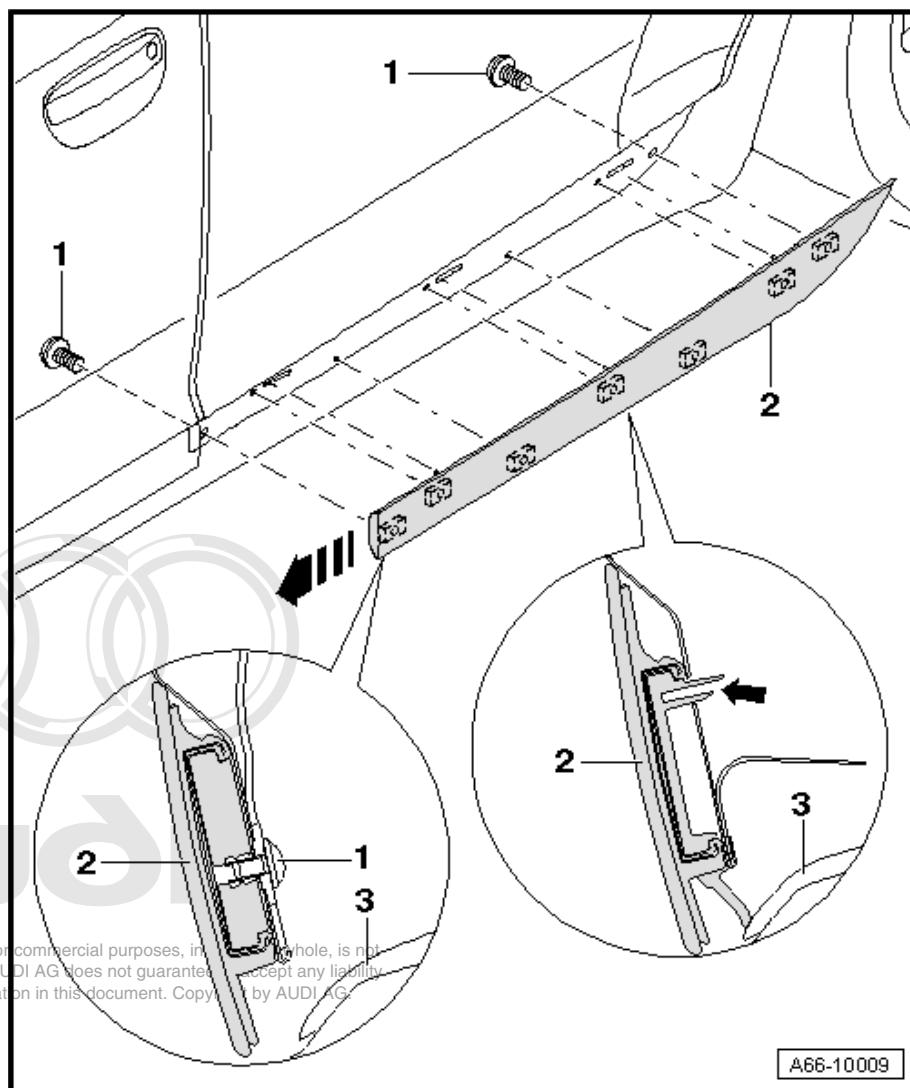
1 - Bolt

□ 2 Nm

- Remove bolts -1- at front and rear.
- Lift out centring pin -arrow- from rear side and pull trim cover out of retainers.
- To install, position trim cover on retainers.
- Push trim cover forwards in direction of -arrow- until centring pin -arrow- engages.
- Tighten bolts.

2 - Trim cover

3 - Outer sill panel trim



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allroad vehicles

1 - Bolt

- 2.5 Nm

2 - Trim cover (front)

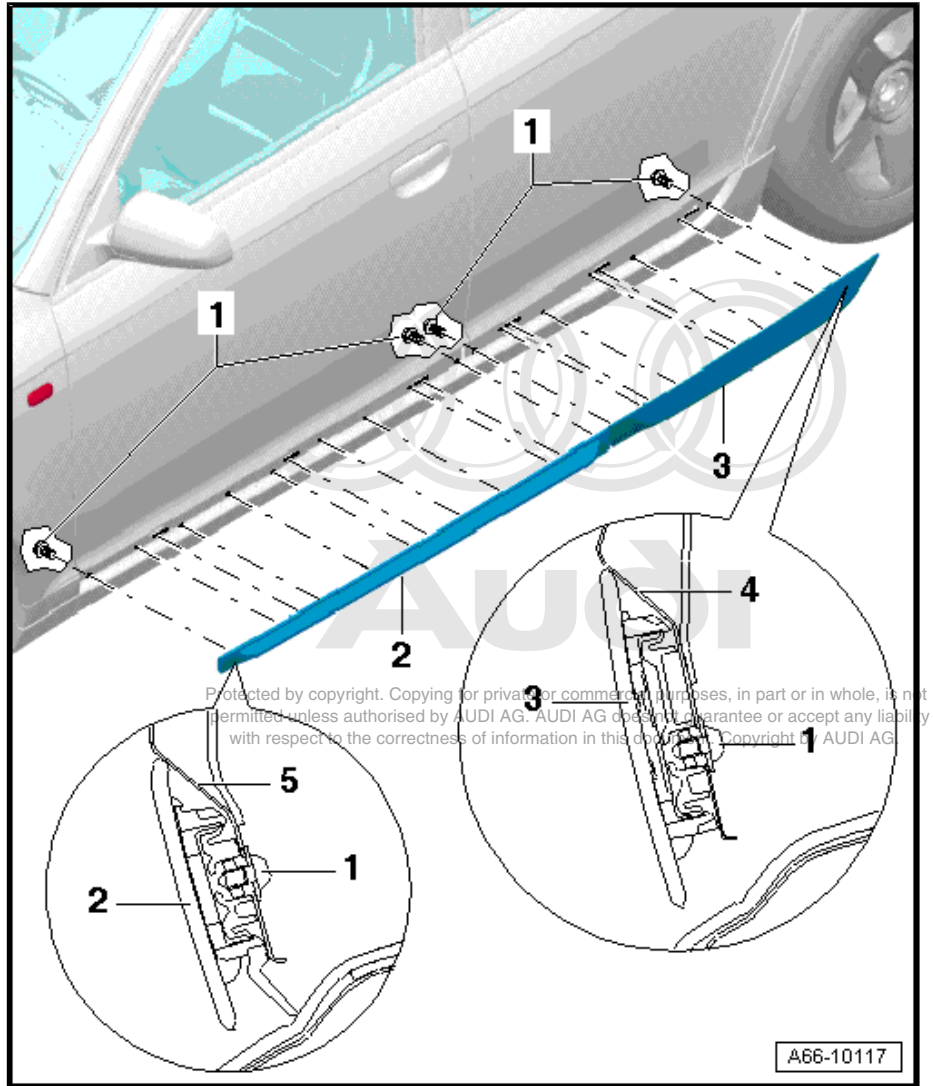
- To remove, unscrew bolts -1- from trim cover (front).
- Slide trim cover towards rear out of retainers and remove sideways.

3 - Trim cover (rear)

- To remove, unscrew bolts -1- from trim cover (rear).
- Slide trim cover towards rear out of retainers and remove sideways.

4 - Rear door

5 - Front door



1.4 Removing and installing side member trim

1 - Side member trim

❑ Removing

- Release fastener and pull it out of side member trim.
- Carefully heat bonding surfaces with hot air blower.
- Gradually pull off side member trim.

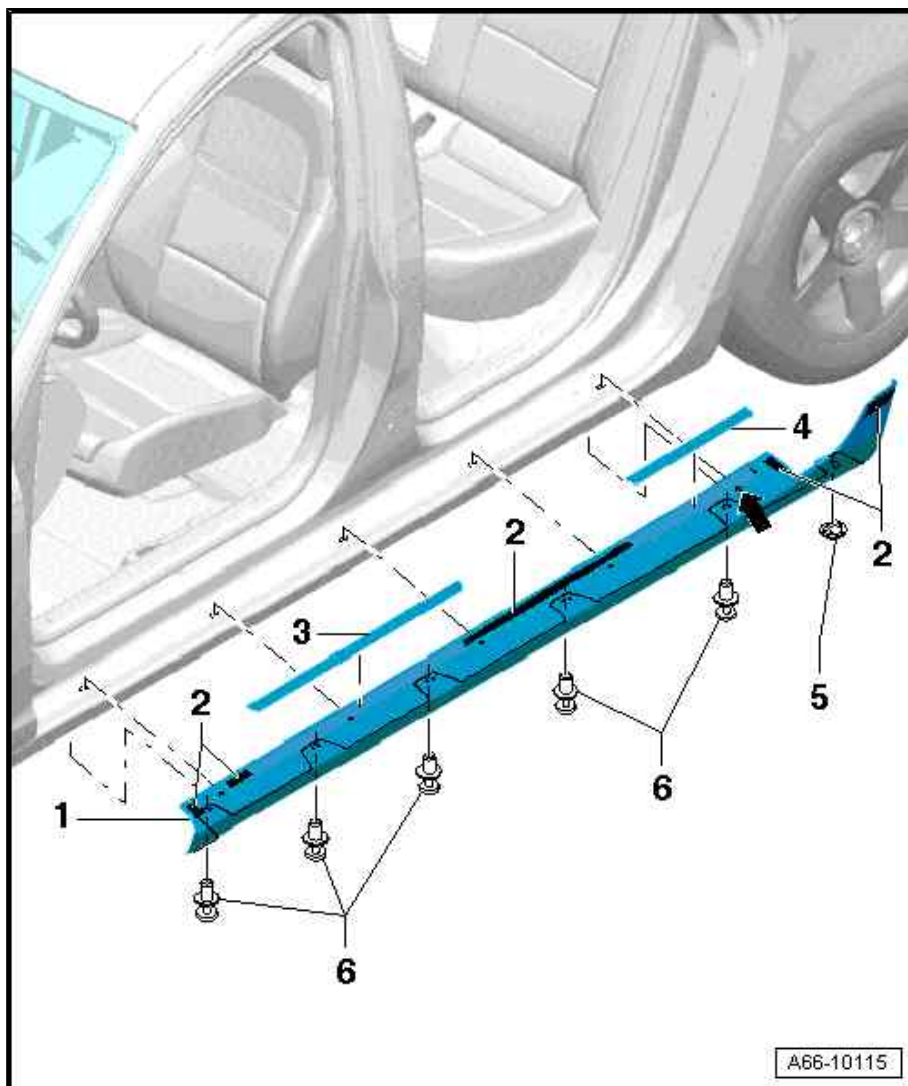


Caution

Bonding surfaces on side member must be free from dust and grease.

❑ Installing

- To install, secure in position in sill area using centring pin -arrow- and swivel downwards.
- Grasp tabs and remove protective film.
- Attach side member trim to side member by pressing down firmly on adhesive tapes.
- Press in grommet -5-, insert fasteners -6- and secure in place.



2 - Adhesive tape

- ❑ Peel off protective film before mounting.

3 - Trim strip (front)

- ❑ Fixed in position with double-sided adhesive strip

4 - Trim strip (rear)

- ❑ Fixed in position with double-sided adhesive strip

5 - Grommet

6 - Fastener

1.5 Removing and installing trim panel for B-pillar

1 - Cover

- ☐ To remove, pull off downwards

2 - Grommet

3 - Bolt

- ☐ 1.5 Nm

4 - Trim panel for B-pillar

Removing:

- ☐ Unclip cover -1-.
- ☐ Remove bolts -2- and detach trim panel outwards.

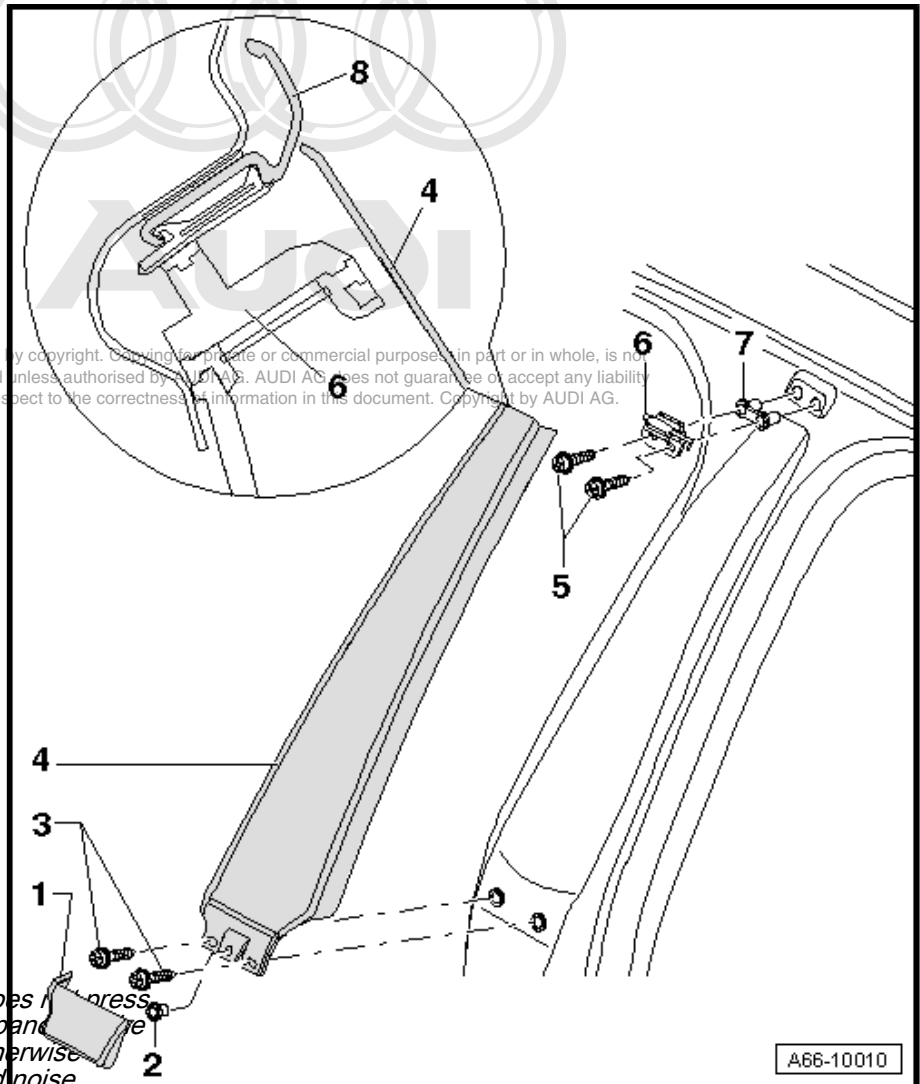
Installing:

- ☐ With rear door open, insert trim panel in retainer.
- ☐ With rear door closed, position trim panel at top and bottom, as shown in detail sections.
- ☐ Screw in front bolt -3-.
- ☐ The outer lip of the rear door window seal should make even contact all the way down the trim panel.



Note

Ensure that the seal does not press too hard onto the trim panel. The lip of the seal could otherwise project and cause wind noise.



A66-10010

- ☐ Screw in rear bolt -3- with door open.
- ☐ Press grommet -2- into trim panel.
- ☐ Push on cover -1- from below.

5 - Bolt with washer

- ☐ 5 Nm

6 - Retainer

7 - Clip

1.6 Panels for allroad



Note

- ◆ *The panels are destroyed when removed and cannot be re-installed (i.e. they must be renewed).*
- ◆ *Remove any remaining adhesive from the body.*
- ◆ *Clean bonding surfaces on body with cleaning solution - D 009 401 04-.*
- ◆ *Bonding surfaces must be free of dust and grease.*
- ◆ *Before bonding, heat body and panels in bonding area to approx. 40° C.*
- ◆ *When fitting panels, make sure that the position of the panel is matched exactly to the contour of the body (it is not possible to adjust the position after the panel makes contact).*

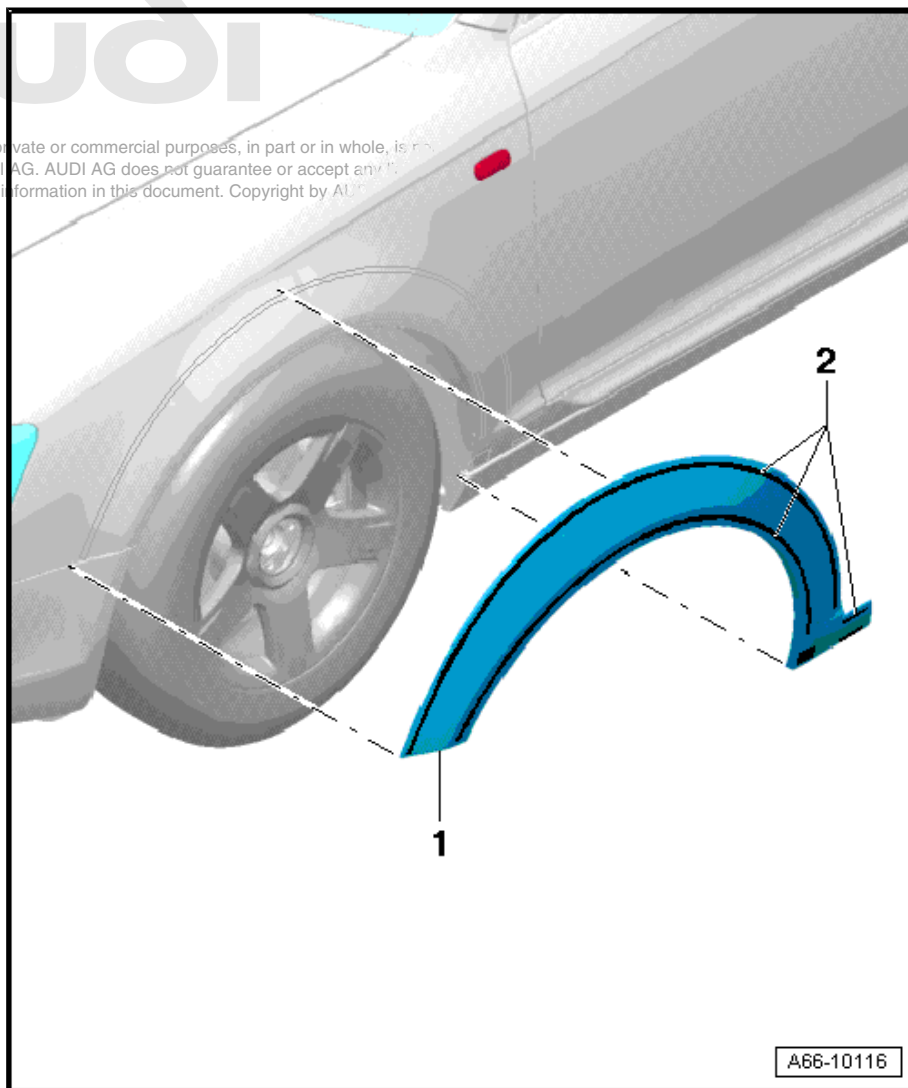
Renewing wing panel trim

1 - Trim

- ☐ To remove, heat bonding points with hot air blower and pull off trim in stages
- ☐ To install, match to exact contour of body and apply in stages by pressing on firmly by hand.

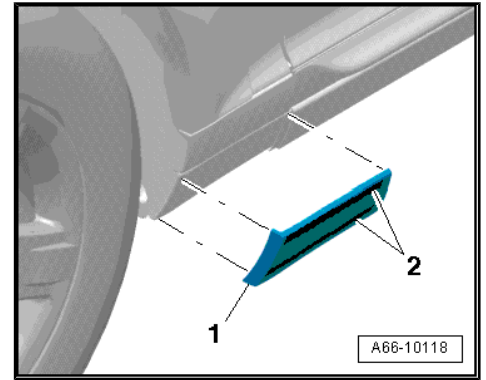
2 - Adhesive tape

- ☐ Peel off protective film before mounting.



Renewing trim panel for A-pillar (bottom)

- To remove, heat bonding points with hot air blower and pull off trim panel.
- Peel protective film off adhesive tape -2-.
- To install, match trim panel -1- to exact contour of body and apply in stages by pressing on firmly by hand.



Renewing side panel trim

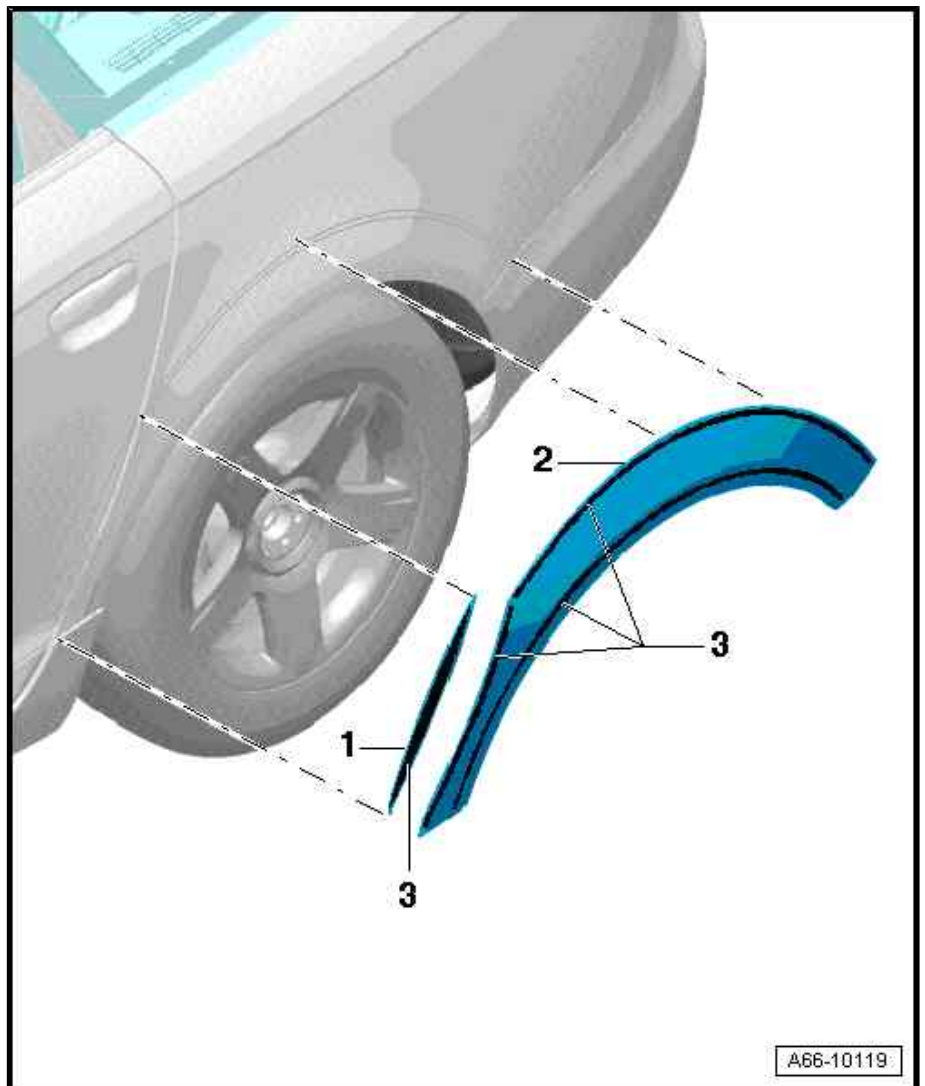
1 - Trim for rear door

- ☐ To remove, heat bonding points with hot air blower and pull off trim in stages.
- ☐ To install, match to exact contour of body and apply in stages by pressing on firmly by hand.

2 - Trim for side panel

3 - Adhesive tape

- ☐ Peel off protective film before mounting.



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1.7 Removing and installing trim strip for side window

Overview

1 - Trim strip for side window



Note

Mask side panel and D-pillar with fabric adhesive tape in area of trim strip to protect paint from damage.

- Start by levering trim strip at C-pillar out of clips -2-.
- Lever roof trim strip -3- slightly out of retaining clips in area of side window.
- Pull trim strip -1- downwards out of roof trim strip -3-.

2 - Retaining clips

- 3x on side panel

3 - Roof trim strip

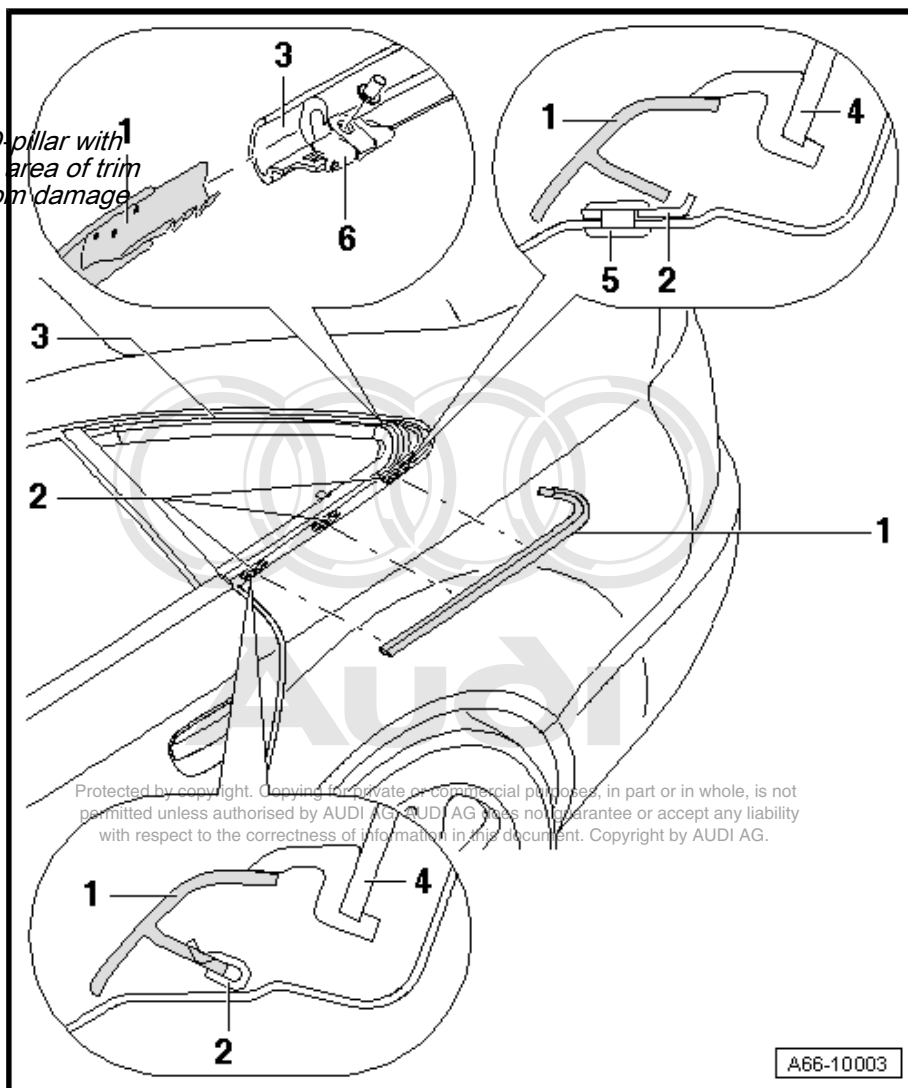
- Fastened to roof frame with 4 retaining clips in area of side window

4 - Side window

5 - Pop rivet

6 - Retaining clip

- 4x, riveted to D-pillar



A66-10003

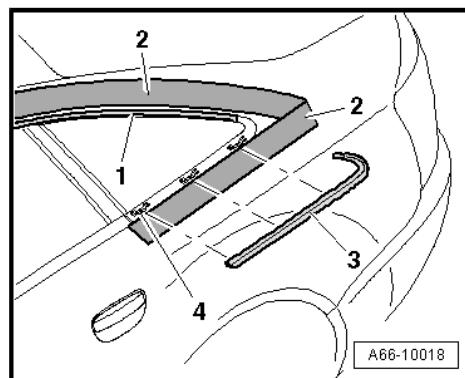
Removing trim strip



Note

Mask D-pillar in area of roof trim strip -1- and side panel below trim strip -3- using fabric adhesive tape -2-.

- Carefully lever trim strip out of retaining clips -4- on side panel first.
- Pull trim strip -3- in longitudinal direction out of roof trim strip -1-.



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1.8 Renewing outer sill panel trim



Note

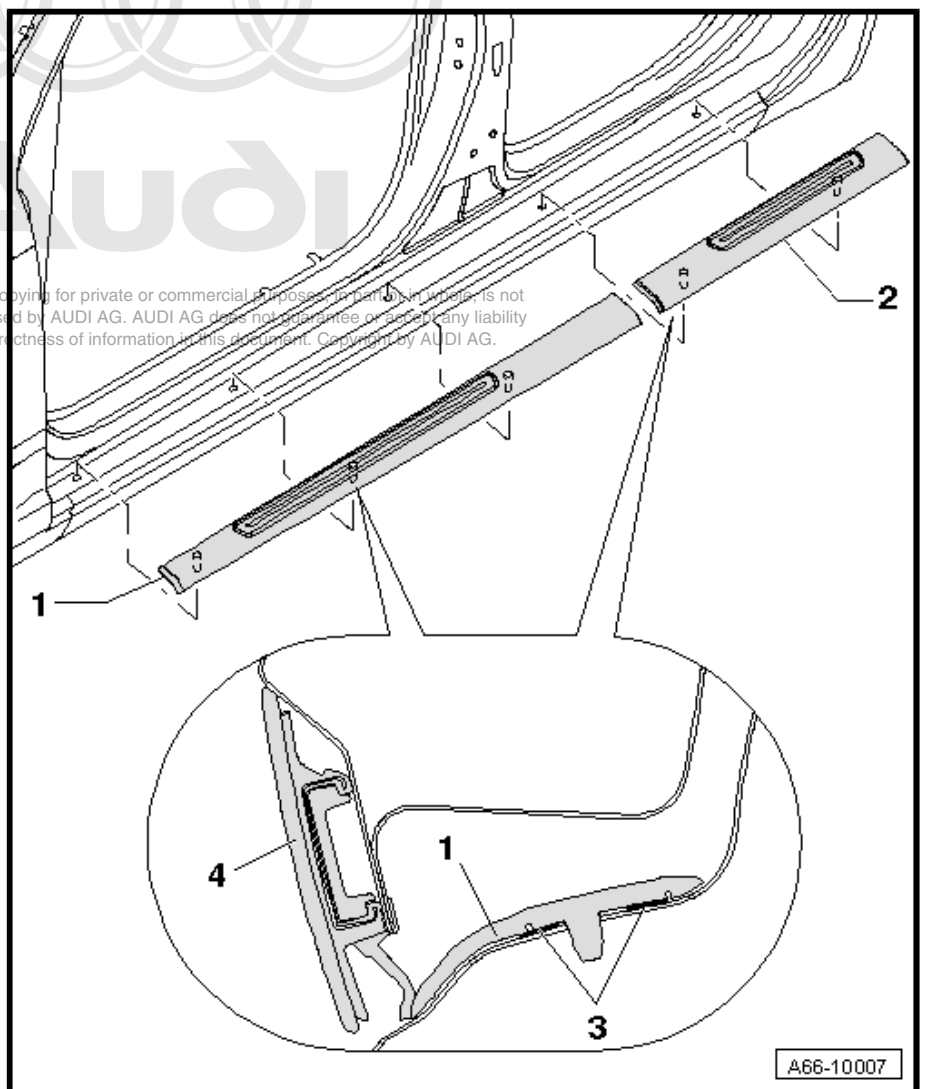
- ◆ Outer sill panel trim cannot be removed without damaging it irreparably.
- ◆ Bond on sill panel trim at ambient temperature only.
- ◆ Allow vehicle and sill panel trim to adjust to ambient temperature for at least 2 hours prior to performing work.
- ◆ Once the protective film has been removed, the protective strip must be fitted on the vehicle within 90 minutes.
- ◆ Vehicle must be kept at ambient temperature for 4 hours after bonding on trim strip.

1 - Sill panel trim (front)

- Heat sill panel trim with hot air blower and carefully pull off upwards.
- Clean bonding surface with petrol, treat with silicone remover and rub dry.
- Heat areas to be bonded with a hot air blower to approx. 40 °C.
- Peel protective film off double-sided adhesive strip shortly before fitting.
- Clip in and press on sill panel trim.

2 - Sill panel trim (rear)

- Heat sill panel trim with hot air blower and carefully pull off upwards.
- Clean bonding surface with petrol, treat with silicone remover and rub dry.
- Heat areas to be bonded with a hot air blower to approx. 40 °C.
- Peel protective film off double-sided adhesive strip shortly before fitting.
- Clip in and press on sill panel trim.



1.9 Removing and installing side member trim (RS 6)

1 - Bolt

- 1.3 Nm

2 - Retainer (front)

3 - Clip

4 - Retainer (rear)

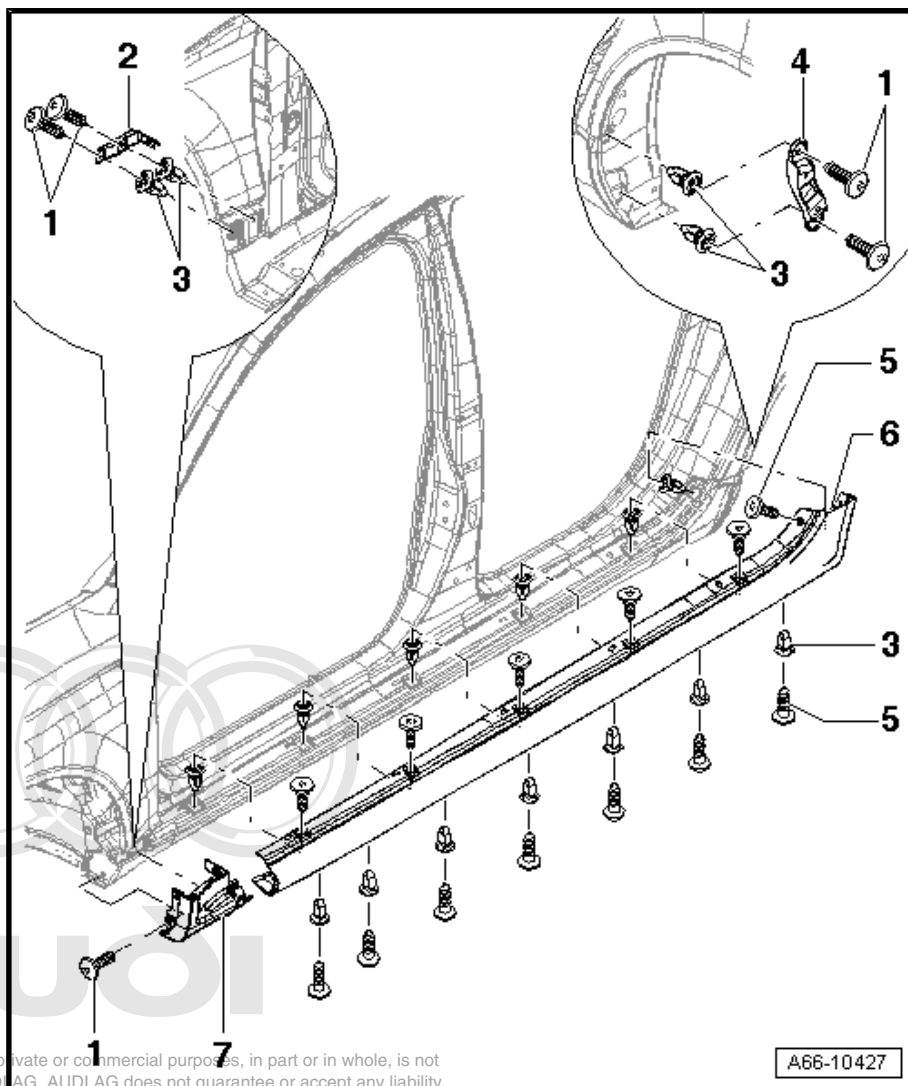
5 - Bolt

- 1.3 Nm

6 - Side member trim

- To detach, remove bolts (top and bottom) from trim and pull trim off side member towards side.
- Remove adhesive residue from side panel (bottom) and clean bonding surface with cleaning solution - D 009 401 04- .
- To install, peel protective film off double-sided adhesive tape and press tape firmly onto side panel (bottom).

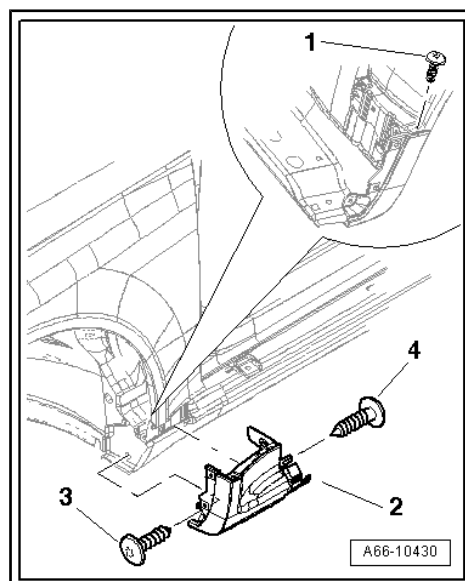
7 - End cap



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Removing end cap

- Unfasten wheel housing liner in area of bolt connection and fold back.
- Remove bolts from end cap and pull end cap off wing panel.
- To install end cap -2-, tighten bolts -1- and -4- to 2 Nm.
- Tighten bolt -3- to 1.3 Nm.



2 Roof rail

2.1 Removing and installing roof rail

Overview

1 - Roof rail

- ☐ Remove trim for A, B, C and D-pillars ⇒ Rep. gr. 70.
- ☐ Remove grab handles and sun visors, and lower headliner ⇒ Rep. gr. 70.

2 - Seal

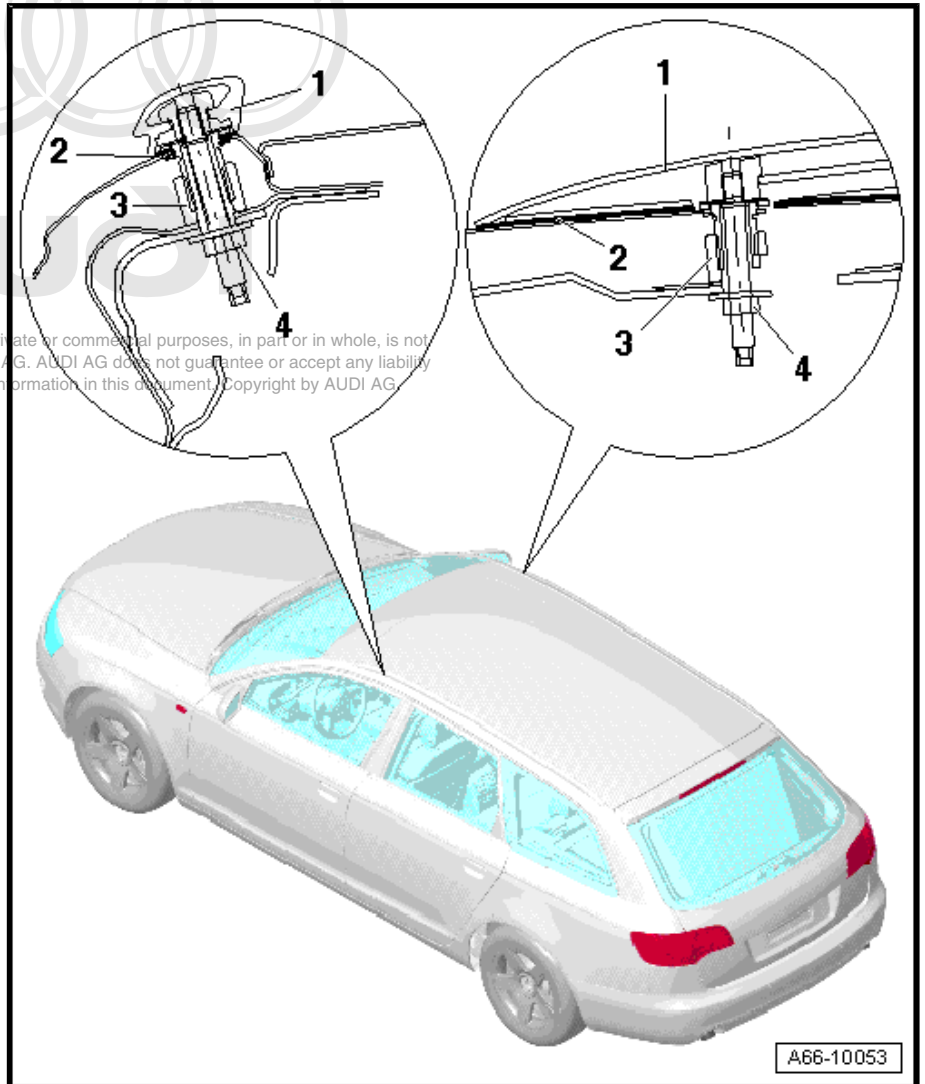
- ☐ Supplied with roof rail

3 - Adjuster element

- ☐ Insert in installation position before fitting roof rail.
- ☐ Must make contact with roof (with slight pre-tension).

4 - Hexagon nut

- ☐ Observe tightening sequence, working outwards.
- ☐ Tighten to 10 Nm.



Installing roof rail

1 - Roof rail

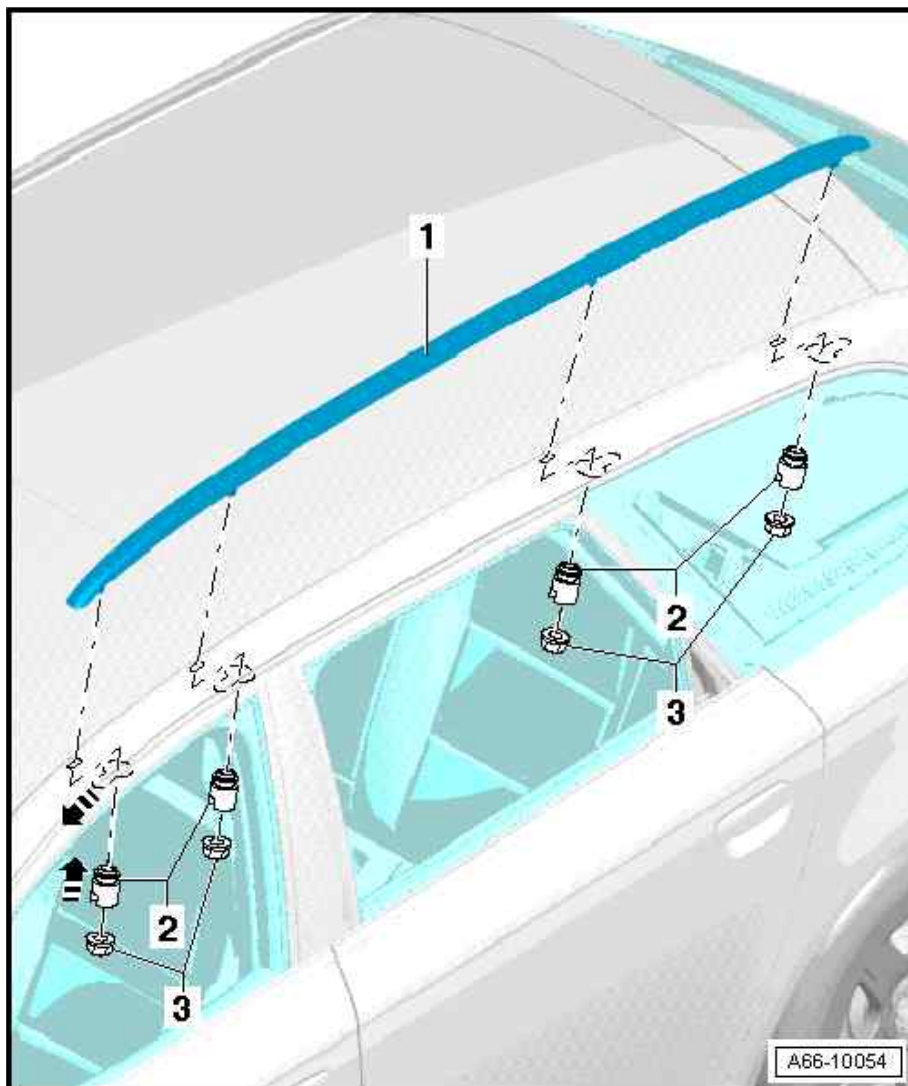
- Adjuster elements must be inserted in roof and be in the correct installation position.
- Position rail on roof and insert studs into adjuster elements.
- Tighten nuts in correct sequence to 10 Nm, working outwards.

2 - Adjuster element

- ❑ Insert front adjuster elements into holes provided and push them forwards into installation position.
- ❑ Insert the rear adjusting elements into the holes provided and push them backwards into the installation position.
- ❑ Move adjustment element into contact with outer panel such that it is slightly pre-tensioned (0.3 Nm).

3 - Hexagon nut

- ❑ Observe tightening sequence, working outwards.
- ❑ 10 Nm



Roof rail for allroad



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1 - Roof rail

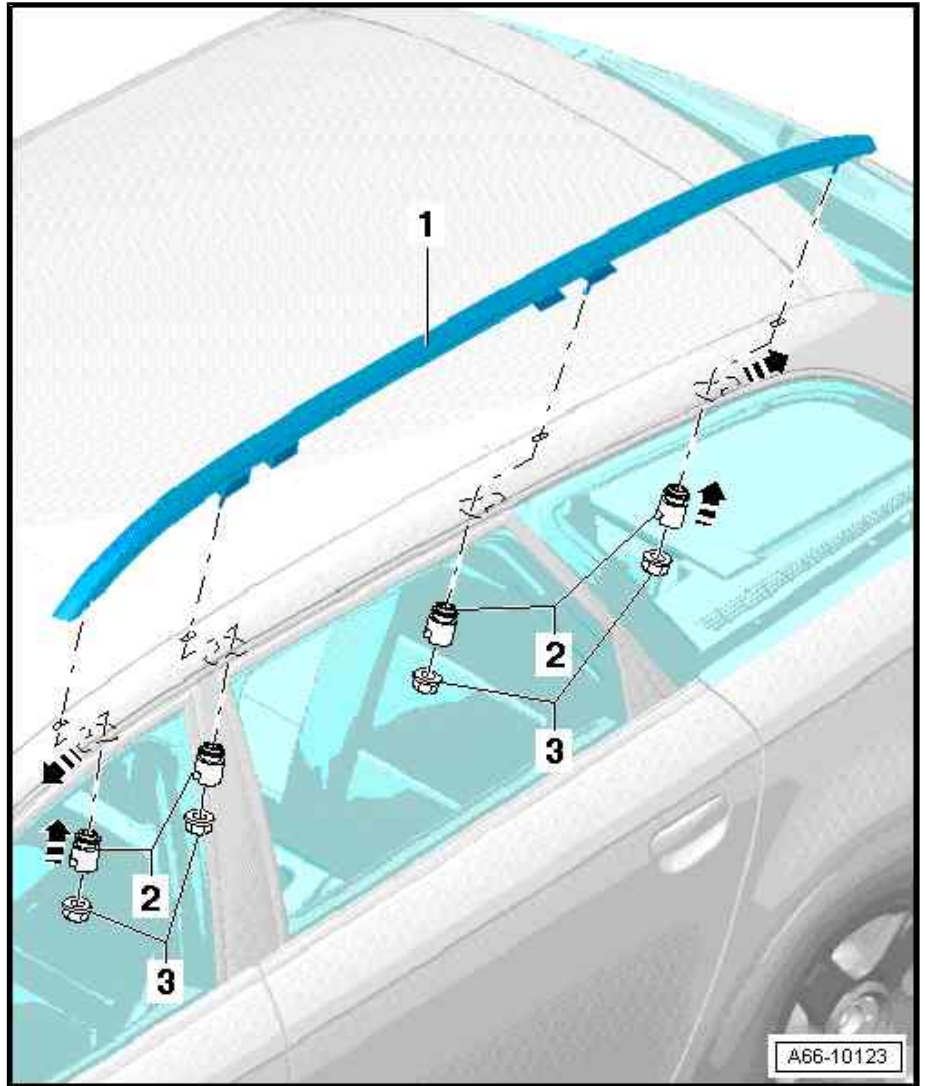
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3 Removing and installing spoiler for rear lid

Removing



WARNING

In addition to the adhesive strips, the spoiler must be bonded with 1-component MS adhesive - D 172 090 A2-.

If the rear lid has been repainted, the bonding surface for the rear spoiler must be cleaned with cleaning solution - D 009 401 04-.

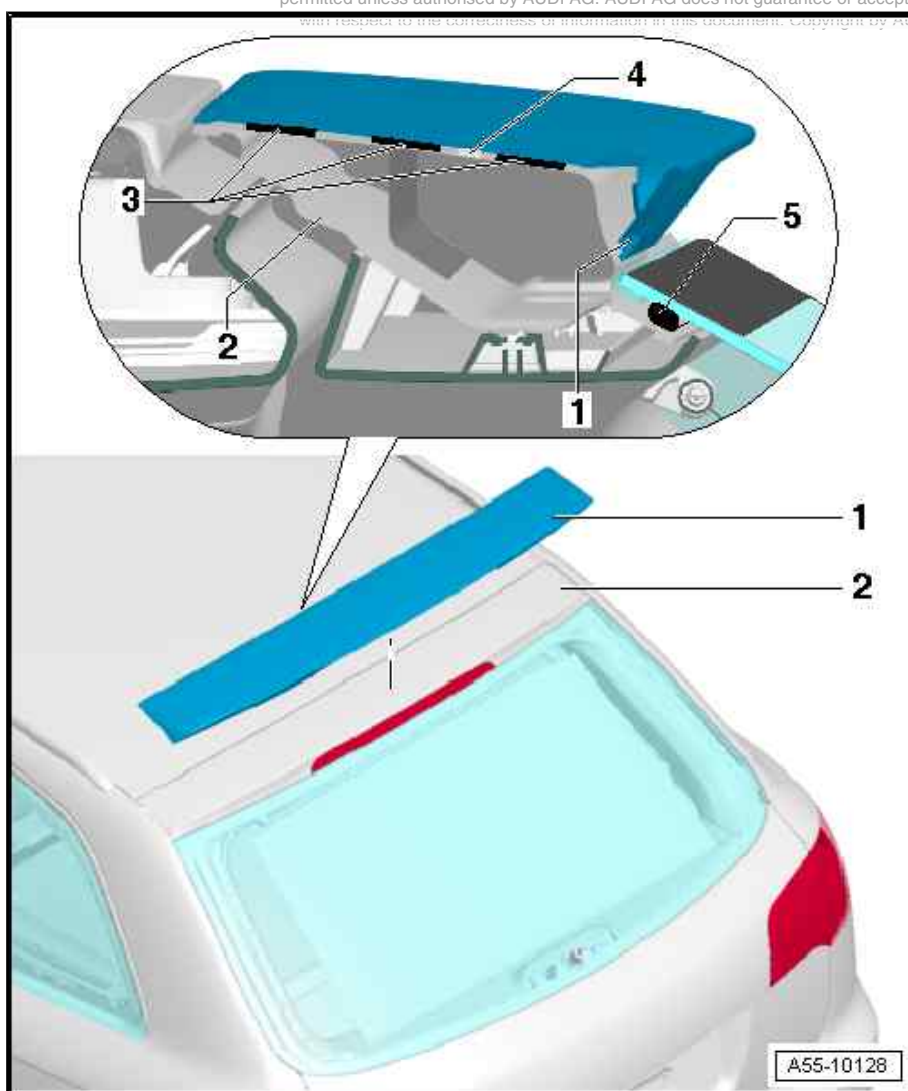
1 - Spoiler for rear lid



Caution

Entire bonding area on rear lid and spoiler must be free of dust and grease.

- ☐ When removing, protect adjoining paintwork on rear lid with fabric-reinforced adhesive tape.
- Remove rear lid trim (top).
- Remove high-level brake light.
- ☐ Insert wire for removal kit - VAS 6452/2- under spoiler at one side
⇒ [page 225](#).
- ☐ Heat bonding area on rear lid from inside using hot air blower - V.A.G 1416-.
- ☐ Cut spoiler clear using wire for removal kit - VAS 6452/2- (start at one side and work across to other side).
- ☐ Remove any adhesive tape residue completely from rear lid.
- ☐ Cut back adhesive bead residue between adhesive tapes on rear lid.
- ☐ Before fitting a new spoiler, clean bonding area for adhesive tapes on rear lid using »D 009 401 04«.
- ☐ Wipe the cleaned surface with a clean paper cloth.
- ☐ Apply 1-component MS adhesive - D 172 090 A2- between rear adhesive tapes across full width of spoiler.



2 - Rear lid

3 - Double-sided adhesive tape

- ☐ Peel off backing immediately prior to installation.

4 - Adhesive bead

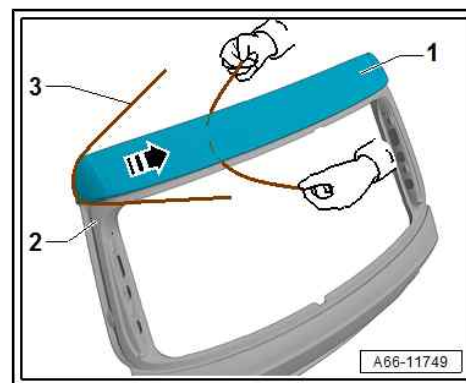
- ☐ Apply adhesive bead, Ø 3 mm.
- ☐ Trim the nozzle tip back to the required width.
- ☐ Adhesive is supplied with the spoiler.

Inserting cutting wire

- Position wire for removal kit - VAS 6452/2- -3- on one side between spoiler -1- and rear lid -2-.
- Starting on one side and working gradually towards opposite side, cut spoiler -1- clear and remove.

Installing a spoiler that has previously been removed

- Fully remove any residual adhesive of double-sided adhesive tape from spoiler.
- Trim down adhesive bead on spoiler.
- Clean bonding surface for double-sided adhesive tape.
- Prime bonding surface for double-sided adhesive tape with plastic primer - D 366 PR1 A1- and allow to flash off for 10 minutes.
- Peel protective film off one side of double-sided adhesive strip (⇒ ETKA) and press onto primed surface.
- The remaining installation steps are the same as for a new spoiler.



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Installing a new spoiler

1 - Spoiler for rear lid

2 - Double-sided adhesive tape

- ☐ Supplied with parts kit.
- ☐ Peel off backing immediately prior to installation.

3 - Adhesive bead

- ☐ Trim the nozzle tip back to an internal diameter of 3 mm.
- Clean surface between adhesive tapes using cleaning solution - D 009 401 04- .
- ☐ Apply 1-component MS adhesive - D 172 090 A2- between rear adhesive tapes across full width of spoiler with a diameter of 3 mm.
- Peel protective film off adhesive tape.
- ☐ Position spoiler as far forwards as it will go and align centrally with rear lid.
- ☐ Working outwards from centre, fit spoiler gradually by pressing on firmly.
- ☐ Fix spoiler in position with adhesive tape while adhesive is drying.

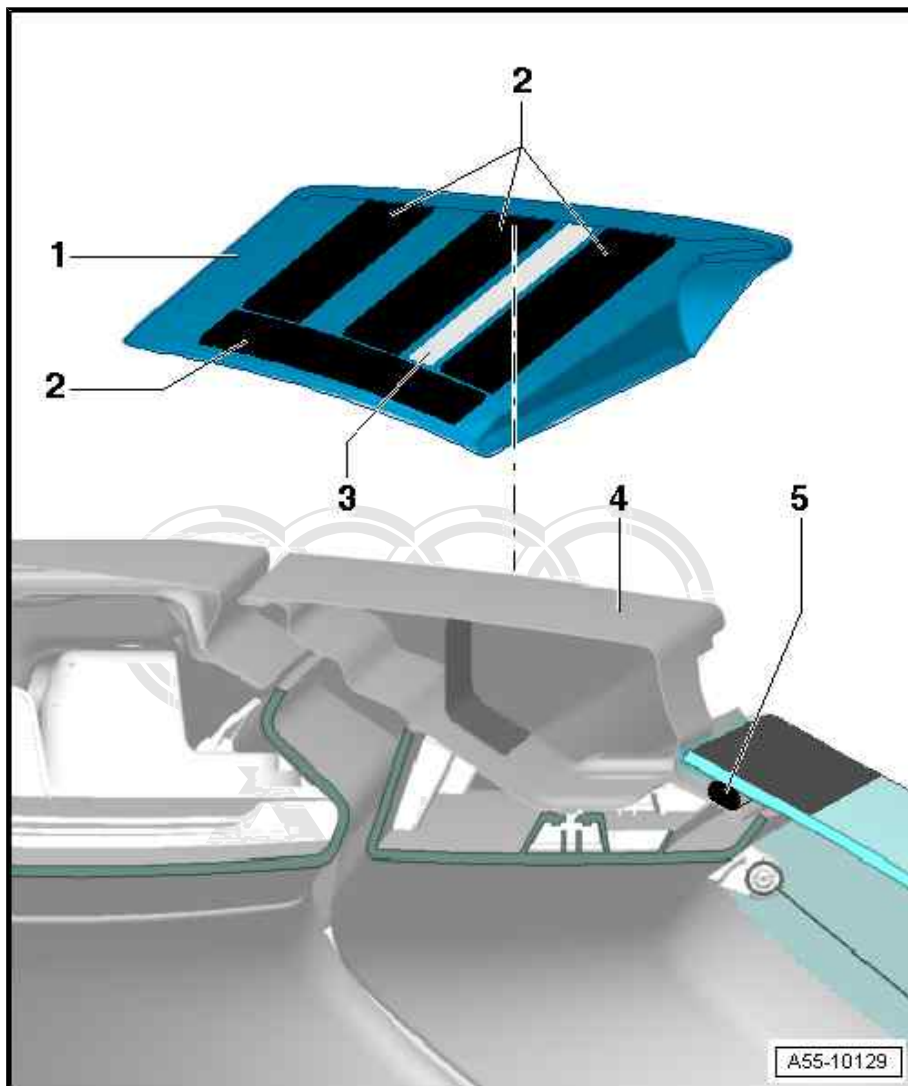


Caution

After fitting spoiler, vehicle must be left standing at room temperature for at least 4 hours.

4 - Rear lid

5 - Rear window

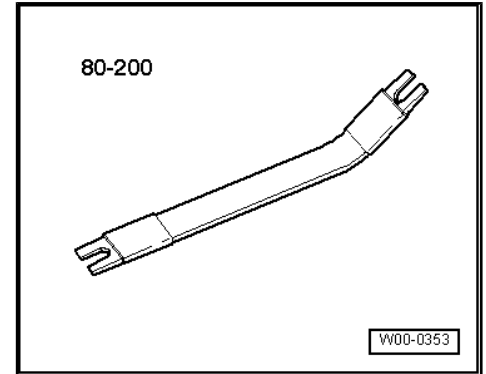


4 Exterior mirrors

4.1 Tools

Special tools and workshop equipment required

- ◆ Removal lever - 80-200-



4.2 Removing and installing exterior mirror

Exploded view

1 - Mirror housing

- Can be removed from door without dismantling entire exterior mirror ⇒ [page 229](#).

2 - Control motor

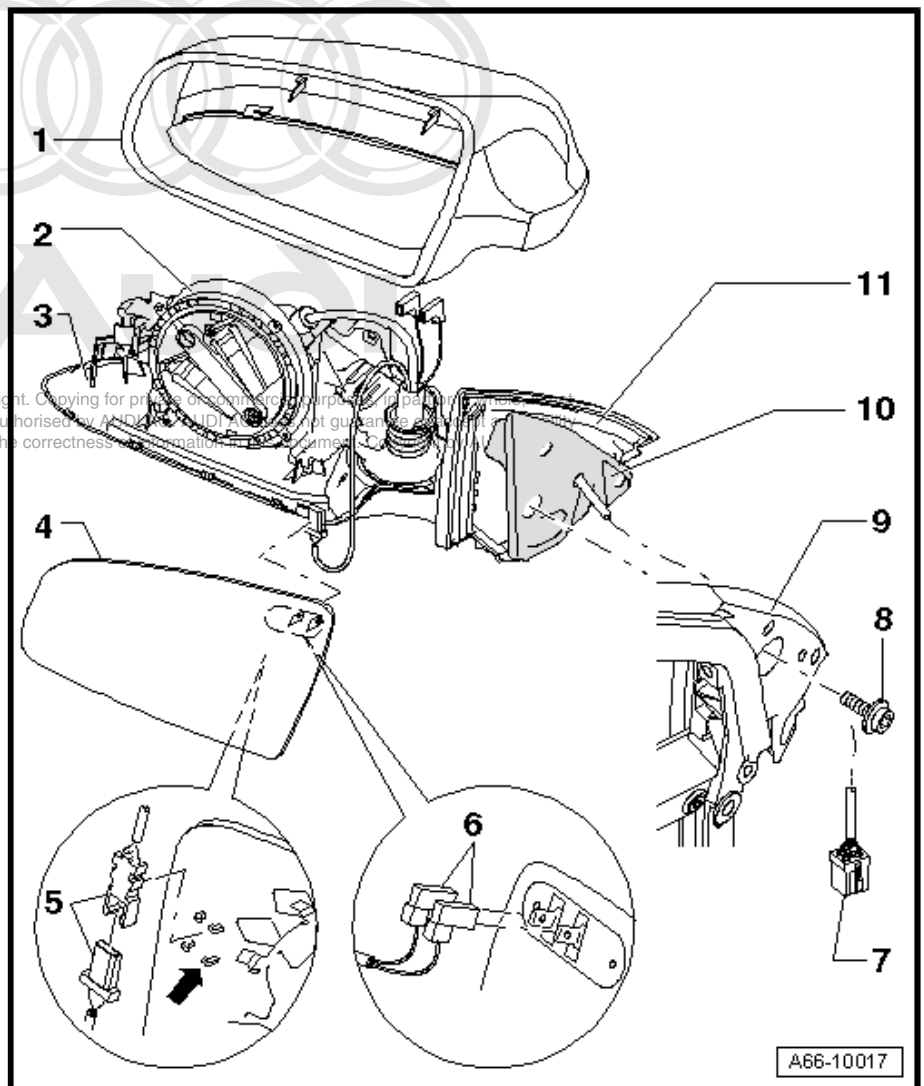
- Removing ⇒ [page 228](#)

3 - Mirror adjustment unit

- Before renewing, remove window frame.
- Detach exterior mirror from door before removing adjustment unit.
- To remove, prise off mirror glass, unplug connectors for mirror heating -6-, unscrew cross-head screws and take mirror adjustment unit out of mirror housing -1-.

4 - Mirror glass

- Use special tool 80-200 (removal lever) to unclip mirror glass.
- Use fabric-backed adhesive tape to protect mirror housing against damage at top and bottom.
- Press off mirror glass at bottom first and then at top.
- To install, insert mirror glass into guide stud



and friction finger into friction spring, then press on.

- ❑ Always use protective gloves, and only exert pressure at centre of glass.

5 - Connector

- ❑ Clip connector into retaining tabs -arrows- on back of mirror.

6 - Electrical connector for mirror heating

7 - Electrical connector

8 - Bolt with washer

- ❑ 12 Nm

9 - Front door

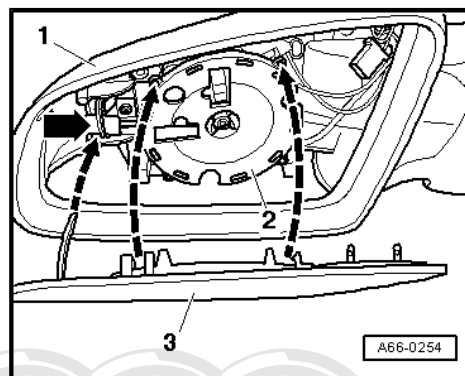
10 - Seal

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

11 - Mirror base

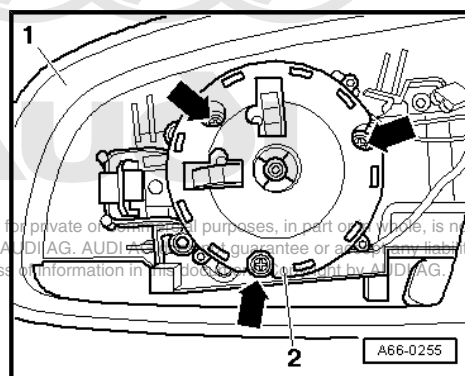
4.3 Installing mirror glass

- Position mirror glass -3- with catches in direction of -arrow- on base plate -2-.
- Friction finger must be inserted into friction spring -arrow- of housing -1-.
- Always use protective gloves, and only exert pressure at centre of glass.



4.4 Removing and installing mirror adjustment motor

- Mirror glass removed
- Unscrew bolts -arrows- from mirror adjustment unit.
- Remove motor -2- from mirror adjustment unit and unplug electrical connector.
- When installing, tighten bolts to 1 Nm.



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4.5 Removing and installing mirror housing

1 - Mirror housing

❑ Removing:

- Mirror glass removed
- Remove bolts -4- from trim cover -3- and detach it downwards.
- Release housing from retainers of mirror adjustment unit and lift housing off.

❑ Installing

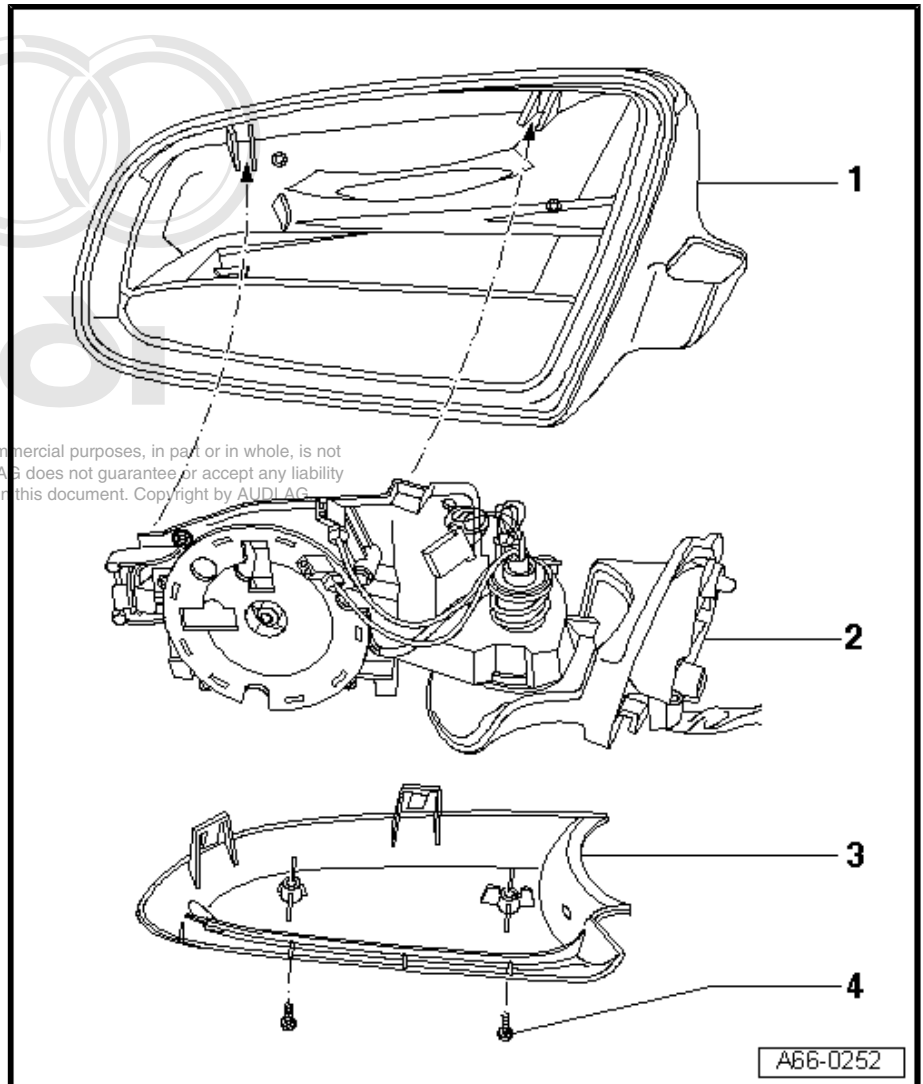
- Position mirror housing on mirror adjustment unit -2- from above.
- Retainers -arrows- must engage in mirror adjustment unit at top and bottom ⇒ [page 229](#).

2 - Mirror adjustment unit

3 - Cover (bottom)

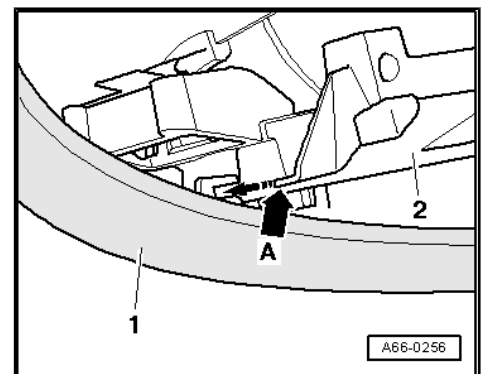
4 - Bolts with washers

- ❑ 1 Nm



Mirror locking element (bottom)

- When installing, retainer (arrow -A-) of mirror adjustment unit -2- must be inserted in retaining hooks of mirror housing -1- in direction of -arrow-.



5 Removing and installing wheel housing liner

5.1 Wheel housing liner (front)

1 - Wing

2 - Front section of wheel housing liner (front)

- ☐ Remove front wheel before detaching.
- ☐ To remove, release quick-release fasteners -4-.
- ☐ Remove bolts -3-.
- ☐ Disengage wheel housing liner from wing and pull it out downwards.

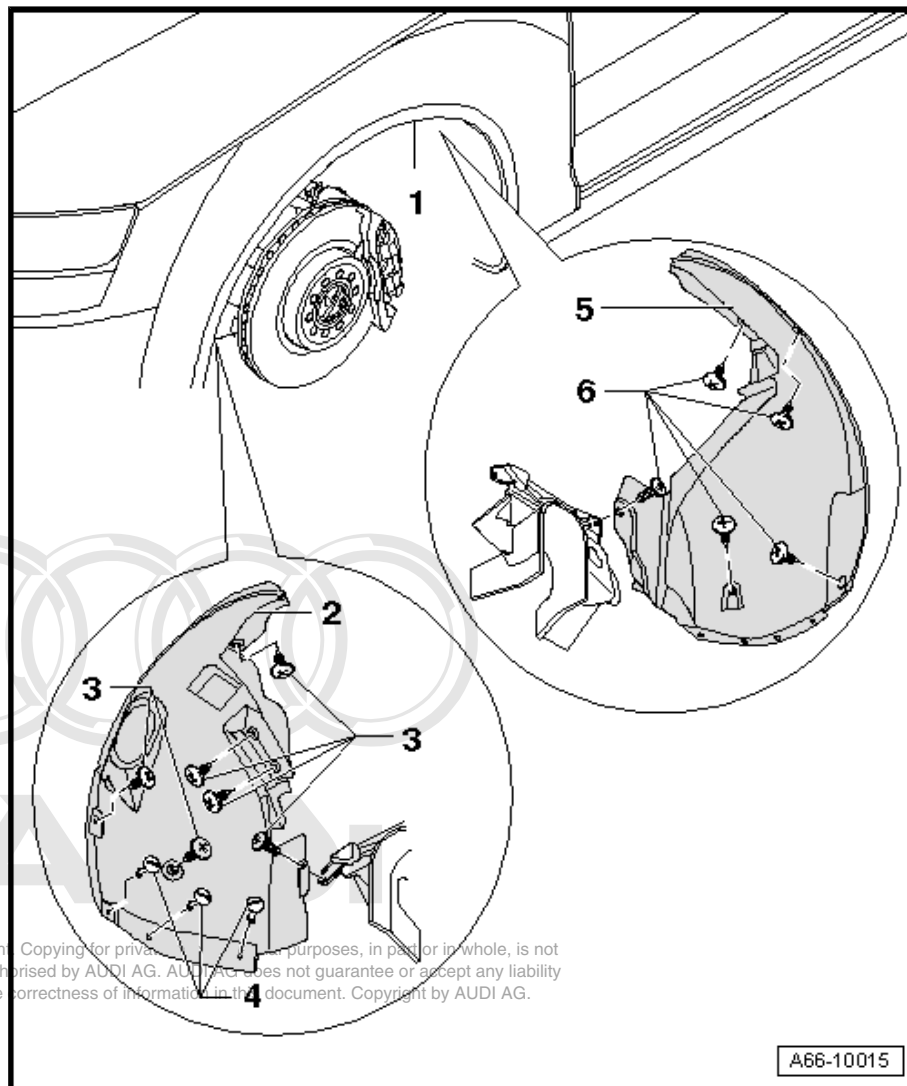
3 - Bolt

- ☐ 2.3 Nm

4 - Quick-release fastener

5 - Rear section of wheel housing liner (front)

- ☐ Remove bolts -6-.
- ☐ Disengage wheel housing liner from wing and pull it out downwards.



5.2 Wheel housing liner (rear)

Wheel housing liner (right-side)

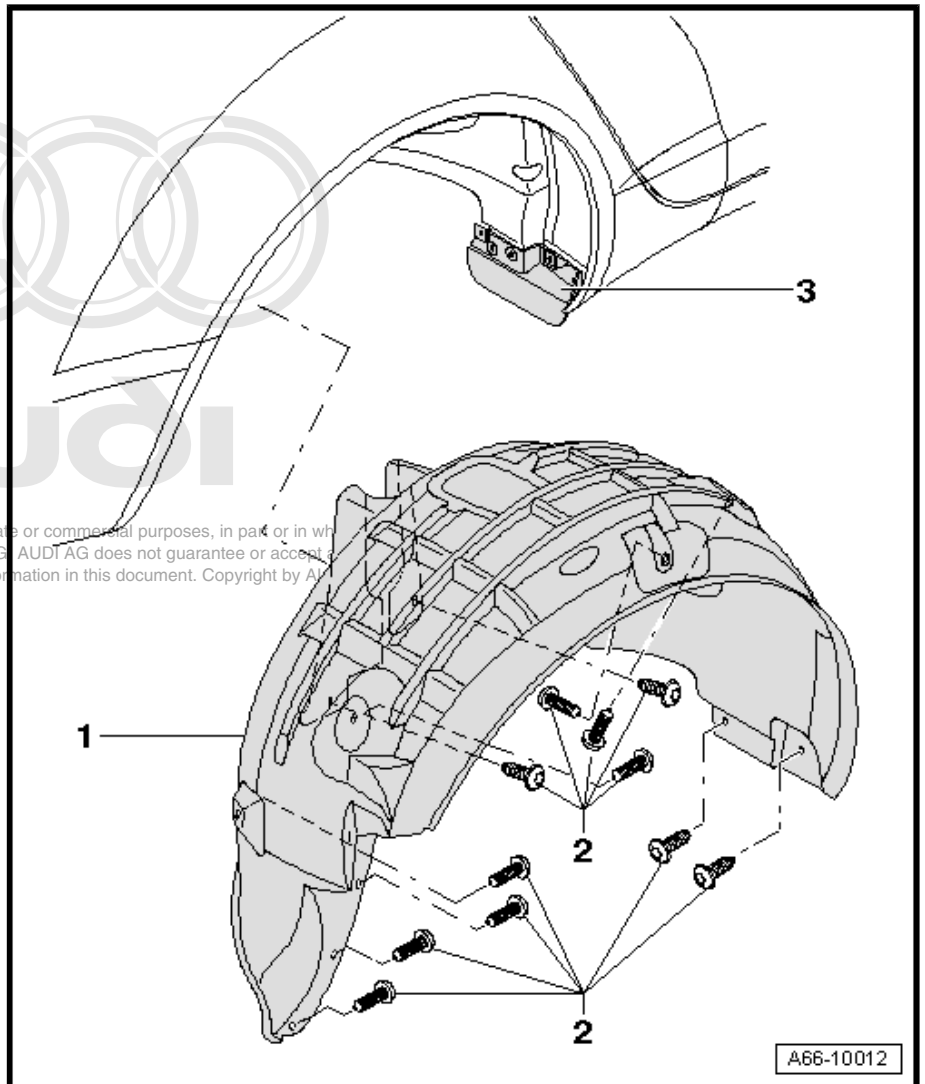
1 - Wheel housing liner (rear)

- ☐ Remove rear wheel before detaching.
- ☐ Remove bolts -2-.
- ☐ Detach wheel housing liner from wheel housing towards side and remove downwards.

2 - Bolt

- ☐ 1.5 Nm

3 - Wheel spoiler



Wheel housing liner (left-side)

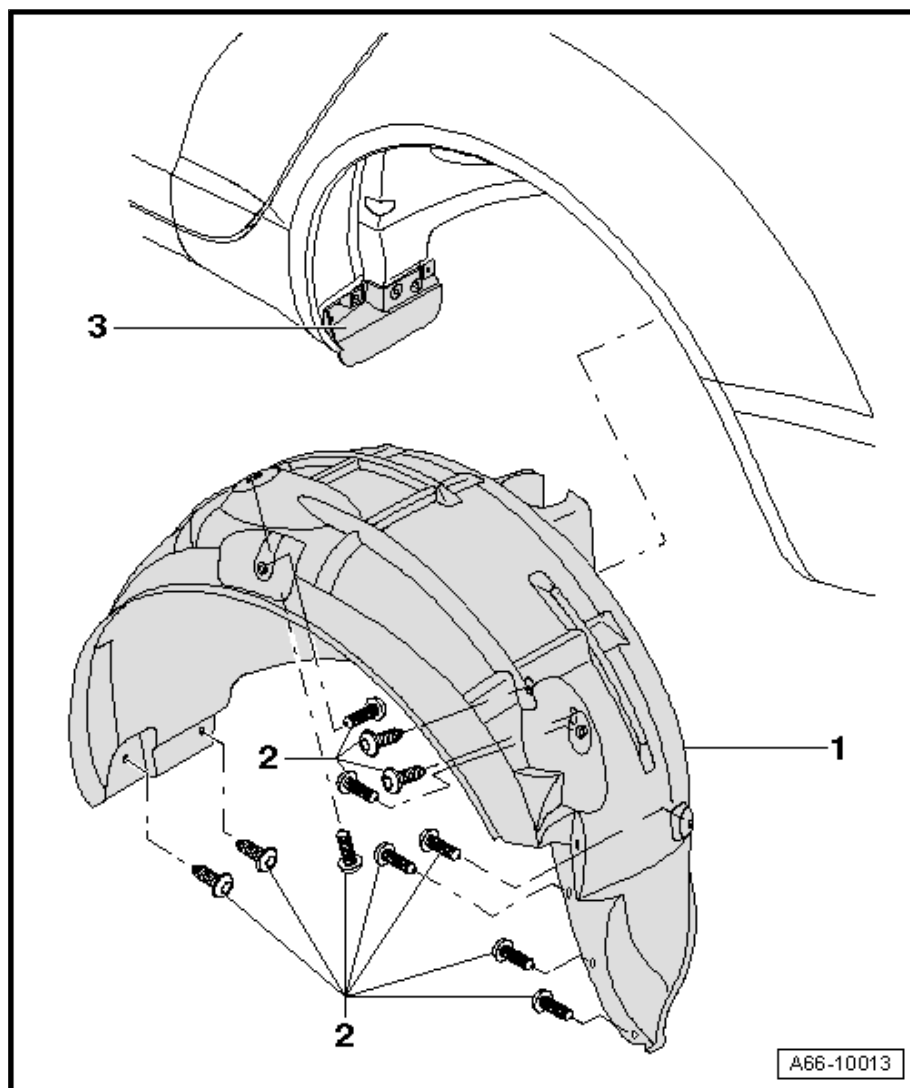
1 - Wheel housing liner (rear)

- ☐ Remove rear wheel before detaching.
- ☐ Remove bolts -2-.
- ☐ Detach wheel housing liner from wheel housing towards side and remove downwards.

2 - Bolt

- ☐ 1.5 Nm

3 - Wheel spoiler



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6 Model emblems

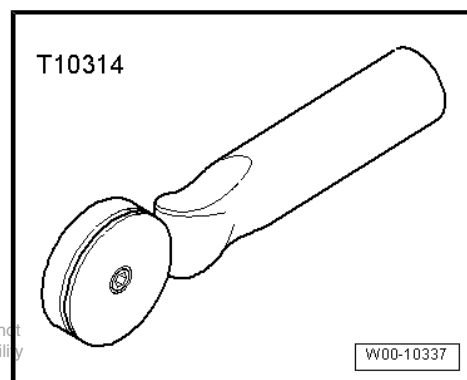


Caution

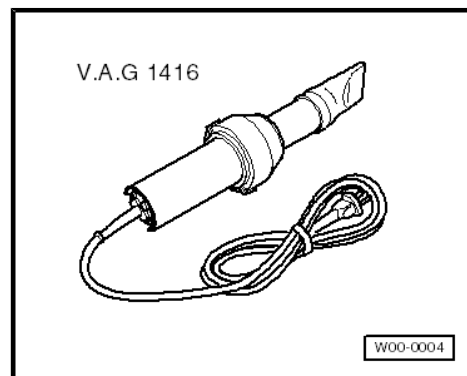
- ◆ *The bonding surfaces on the body must be free of dust and grease.*
- ◆ *Clean bonding surfaces with cleaning solution - D 009 401 04-.*
- ◆ *Heat the bonding surfaces and model emblems with a hot air blower to around 40°C.*
- ◆ *After attaching the model emblems, press them on firmly with roller - T10314-.*

Special tools and workshop equipment required

- ◆ Roller - T10314-

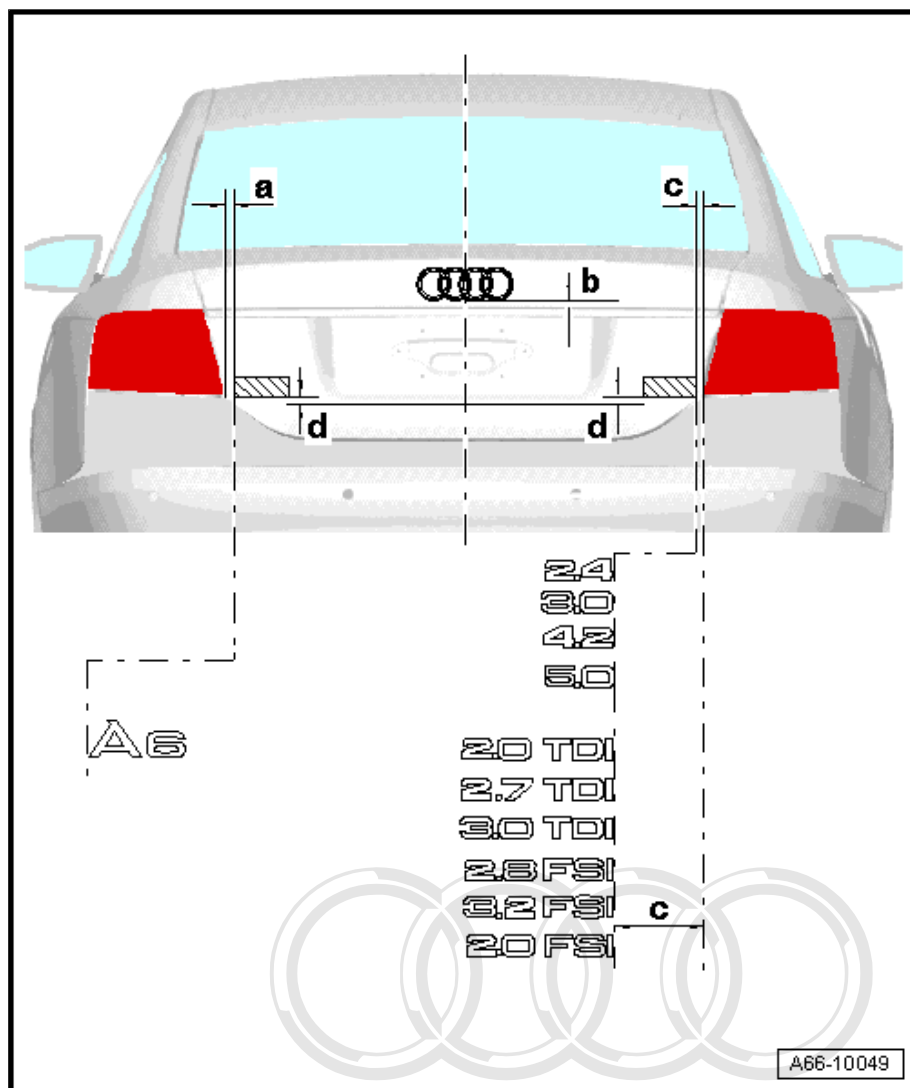


- ◆ Hot air blower - V.A.G 1416-



6.1 Saloon

Dimensions for vehicles with front-wheel drive

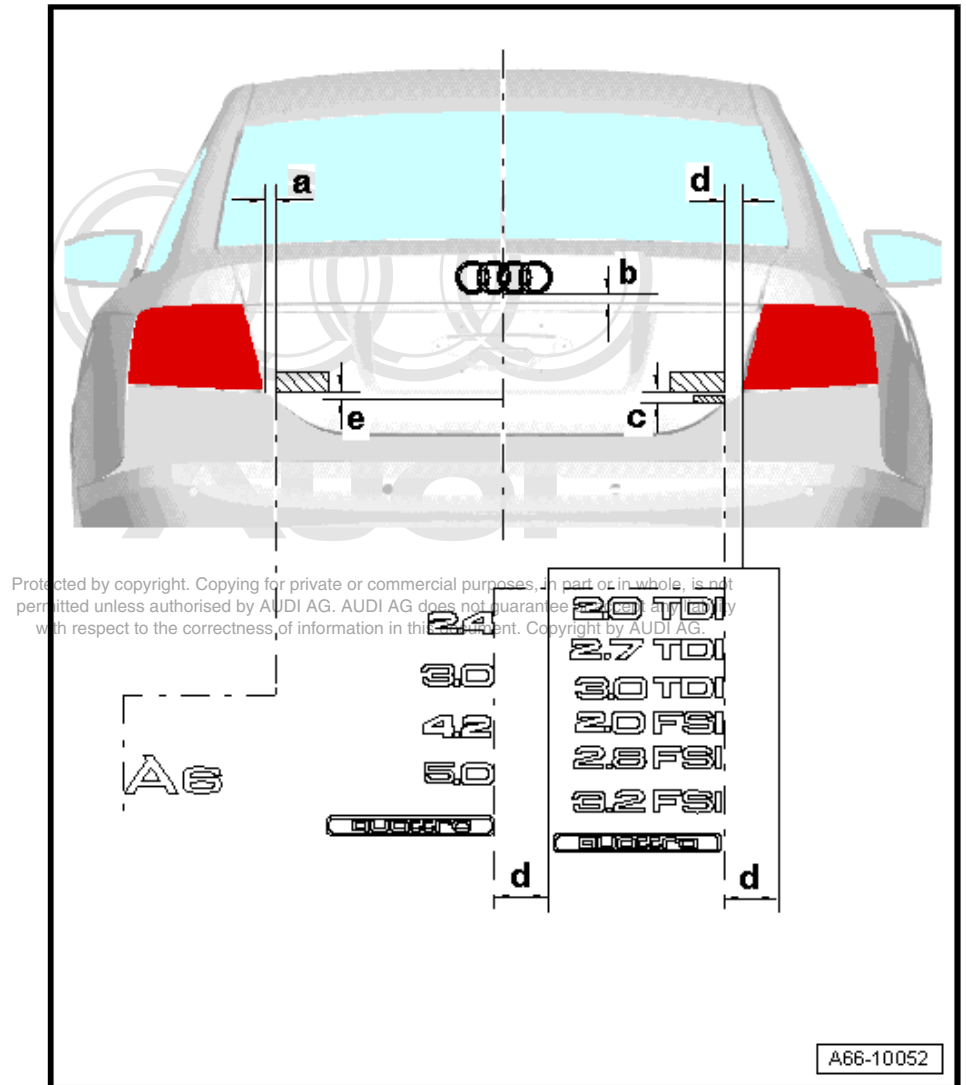


Note

The outside edges of rear lid and extensions of lower rear light lines are used as reference edges.

Dimensions for vehicles with four-wheel drive

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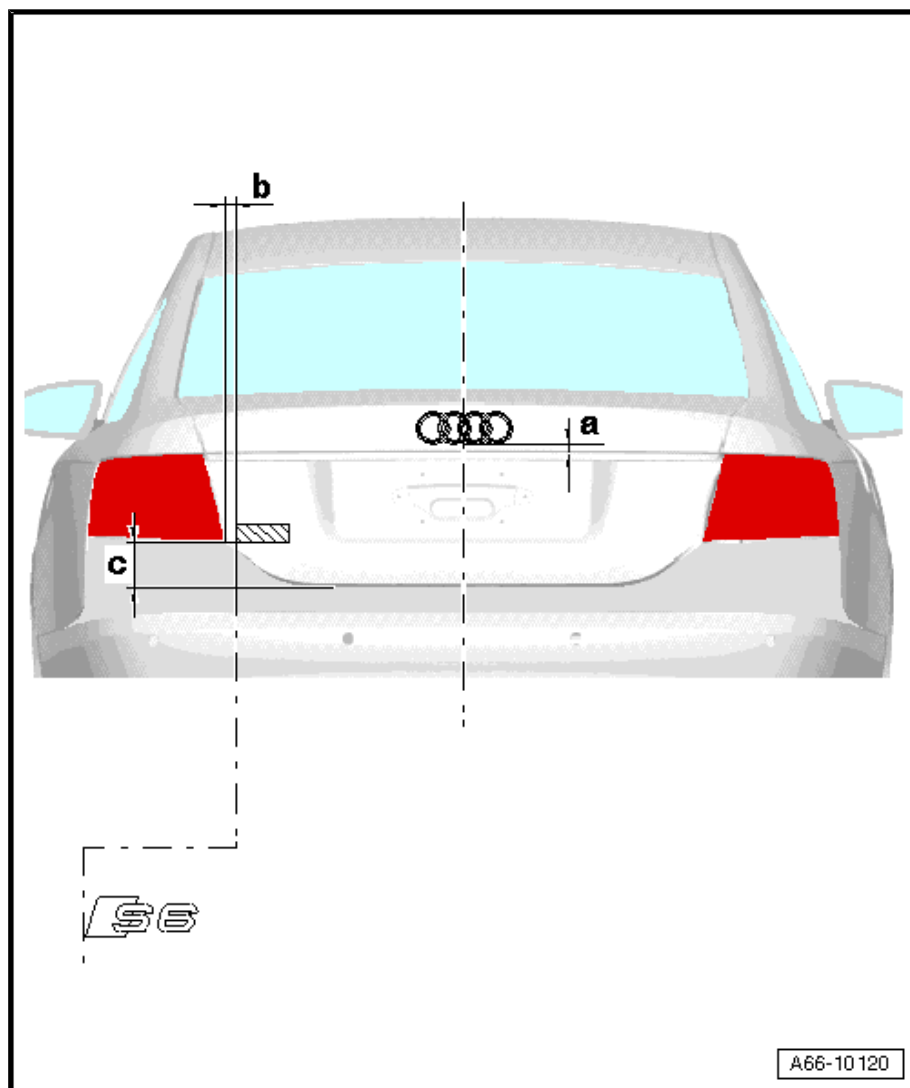


- Peel off protective film, attach model emblems in specified positions and press on firmly.

- ◆ a = 31 mm
- ◆ b = 19 mm
- ◆ c = 4 mm
- ◆ d = 36 mm
- ◆ e = 16 mm

- Dimension -e- must be measured upwards to extension of lower number plate embossment.

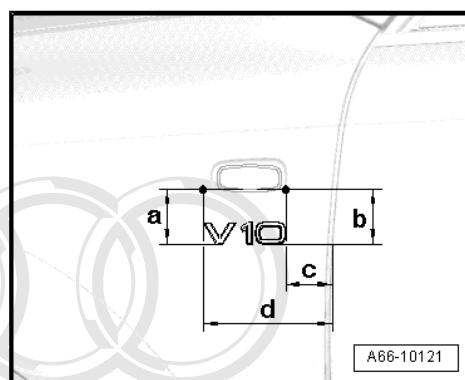
Dimensions for S6



Dimensions for model emblem on wing panel

- Peel off protective film, attach model emblems in specified positions and press on firmly.

- ◆ a = 56 mm
- ◆ b = 58 mm
- ◆ c = 33 mm
- ◆ d = 109 mm

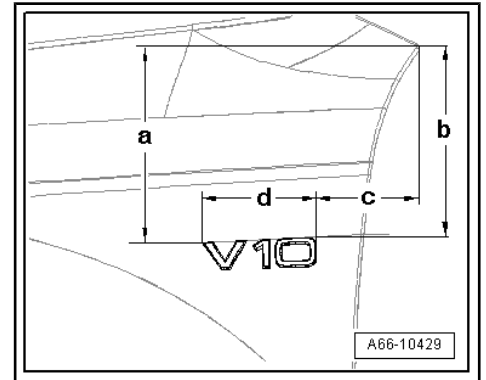


Audi

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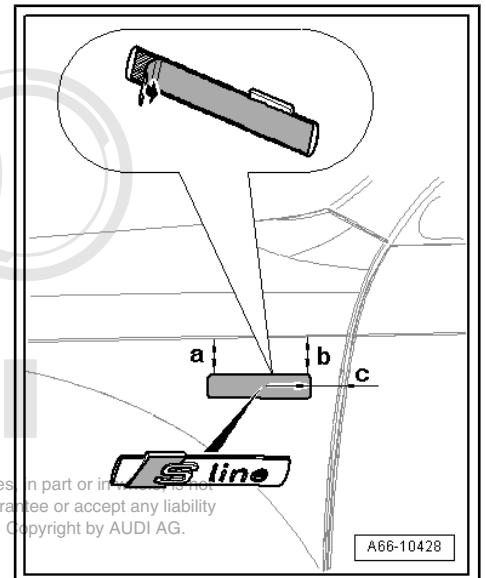
Vehicles without turn signal repeaters

- ◆ a = 148.5 mm
- ◆ b = 145 mm
- ◆ c = 87 mm
- ◆ d = 77 mm
- ◆ Peel off protective film, attach model emblems in specified positions and press on firmly.



Model emblem for S-line

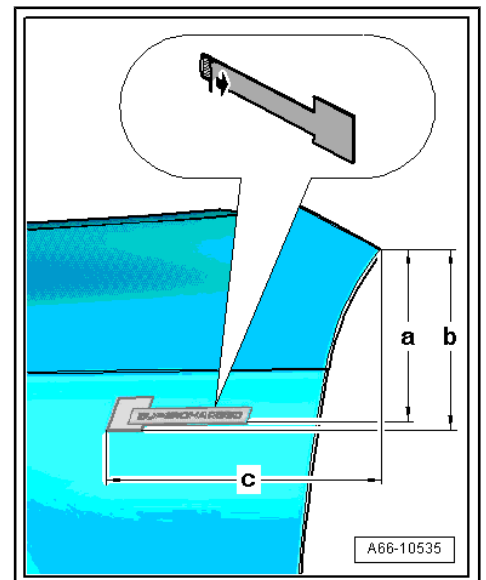
- ◆ a = 73 mm
- ◆ b = 74 mm
- ◆ c = 58 mm
- Peel off protective film, attach model emblems in specified positions and press on firmly.



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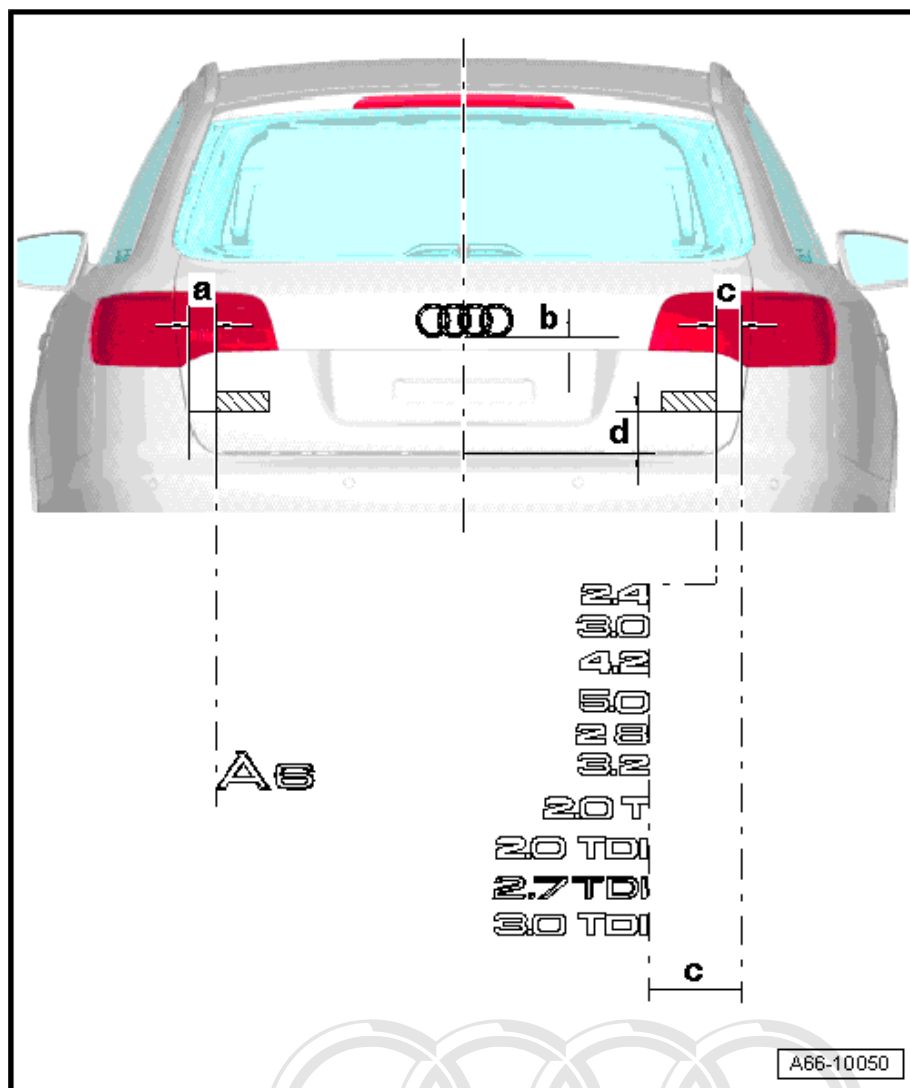
Emblem for supercharged version (country-specific version)

- ◆ a = 146 mm
- ◆ b = 151 mm
- ◆ c = 205 mm
- ◆ Peel off protective film, attach model emblems in specified positions and press on firmly.



6.2 Avant

Dimensions for vehicles with front-wheel drive



Note

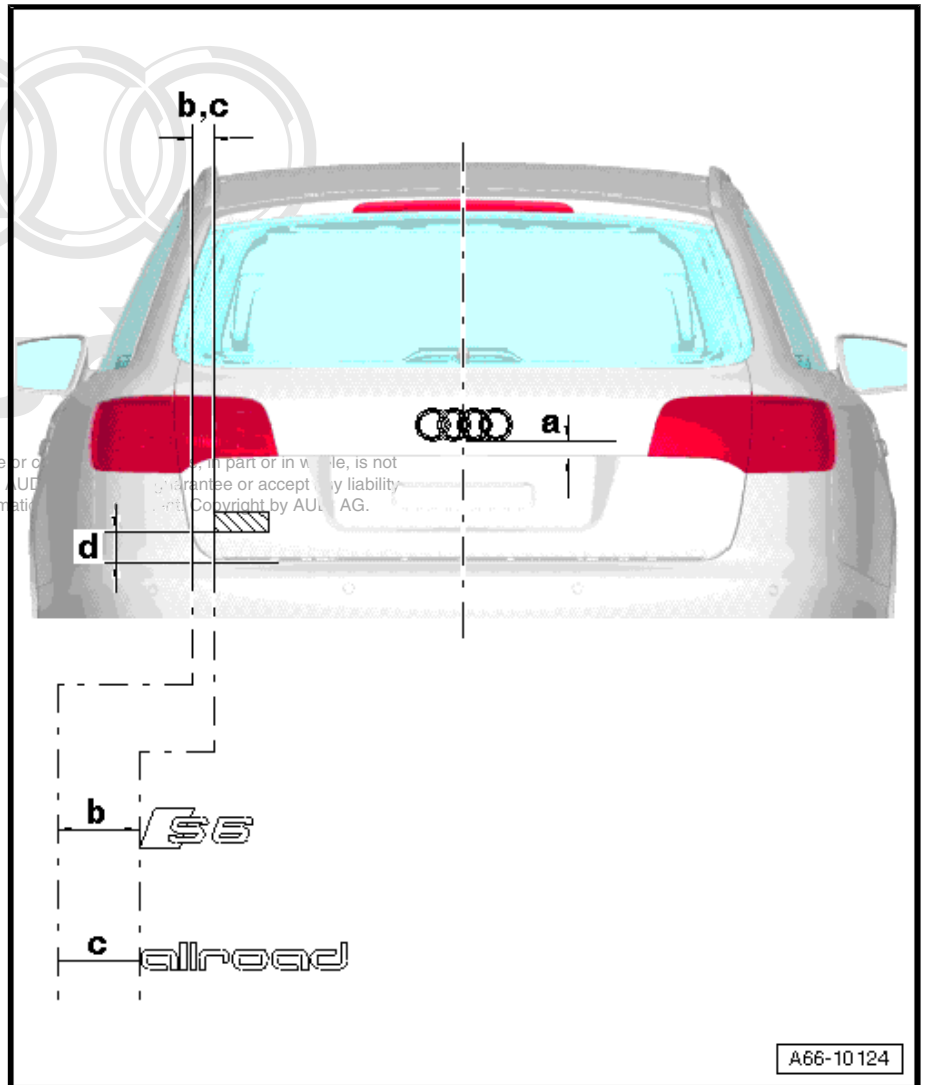
The outside edges of rear lid and extensions of lower rear light lines are used as reference edges.

- Peel off protective film, attach model emblems in specified positions and press on firmly.

Dimensions for vehicles with four-wheel drive

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- ◆ a = 38 mm
- ◆ b = 55 mm
- ◆ c = 55 mm
- ◆ d = 83 mm
- ◆ e = 4 mm
- ◆ f = 60 mm
- ◆ Peel off protective film, attach model emblems in specified positions and press on firmly.