

Audi A4 1995 ➤

General Body Assembly

Edition 04.1998



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List of Workshop Manual Repair GroupsList of Workshop Manual Repair Groups

Audi A4 1995 ➤

General Body Assembly

Repair Group

50 - Body front

55 - Bonnet, Flaps

57 - Front doors/Door components/Central locking system

58 - Rear doors/Door components

60 - Sliding/tilting roof

63 - Bumpers

64 - Glazing

66 - Exterior equipment



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

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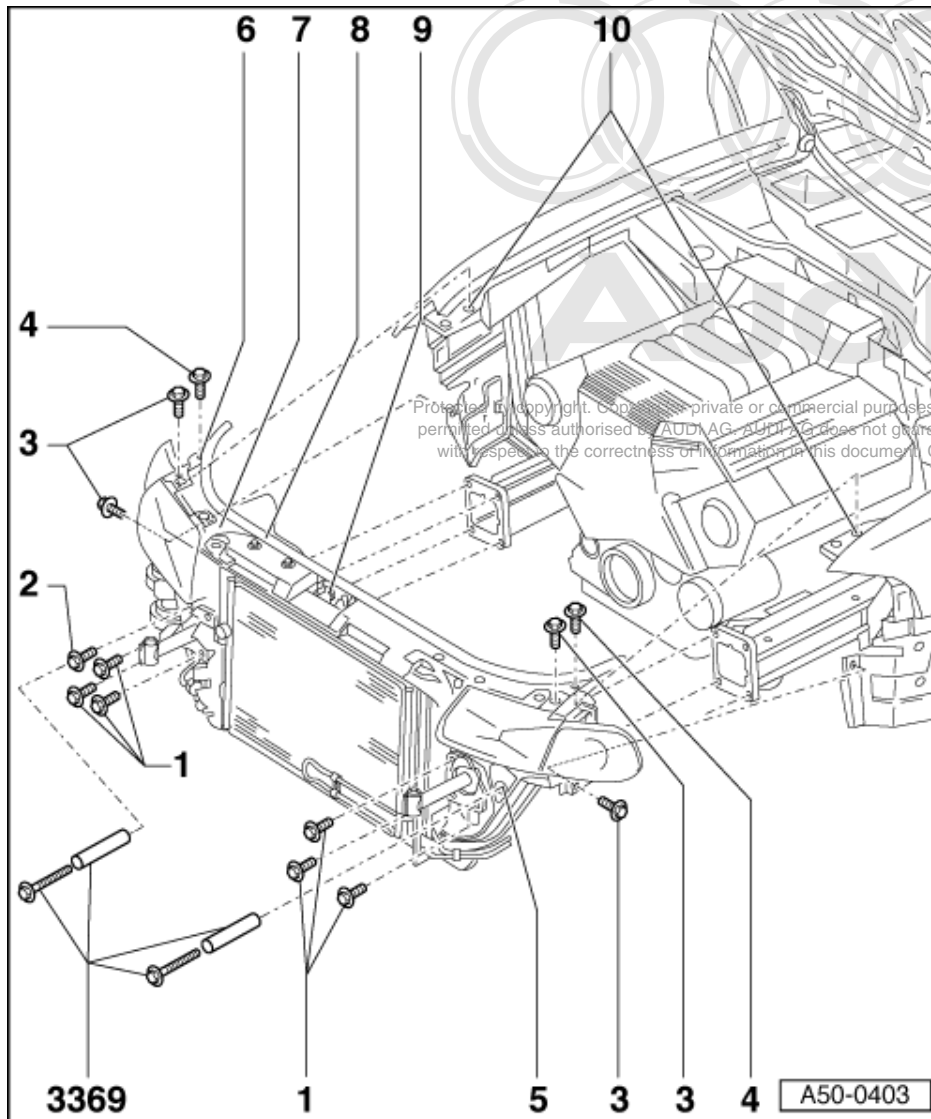
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50 - Body front

1 - Body front

1.1 - Body front



1.2 - Removing and installing lock carrier with ancillary components

- 1 Hexagon bolt (6x)
 - ♦ Tightening torque 45 Nm.
- 2 Hexagon bolt
 - ♦ Tightening torque 45 Nm.
- 3 Hexagon bolt (4x)
 - ♦ Tightening torque 10 Nm.
- 4 Hexagon bolt (2x)
 - ♦ Tightening torque 10 Nm.

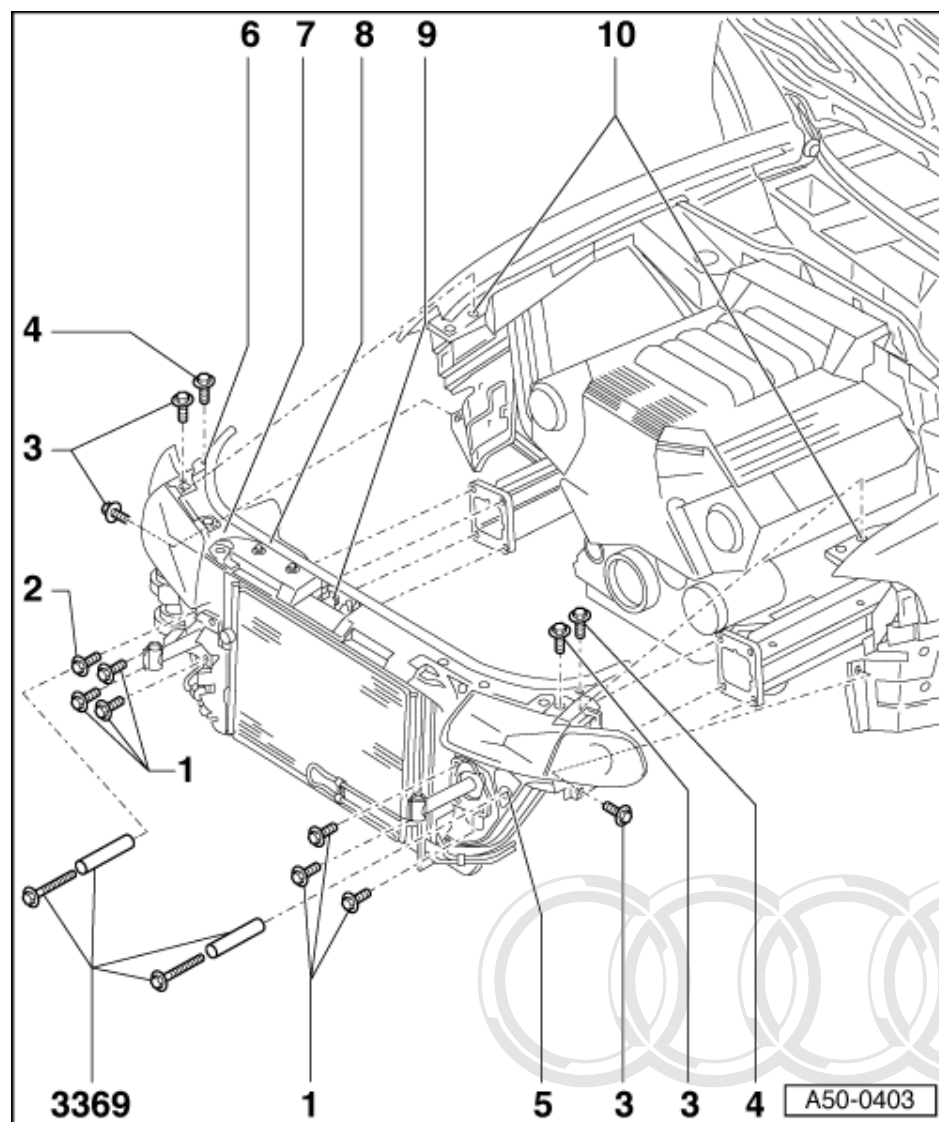


5 Hole for special tool

- ♦ For service position: fit special tool 3396 here.

6 Hole: Lock carrier

- ♦ Mount for service position.



7 Lock carrier

- ♦ Removal:

- Remove bumper: =>Page 161 .

- Remove noise insulation

=> Page 17 .

- Disengage Bowden cable for the bonnet lock=>Page 26

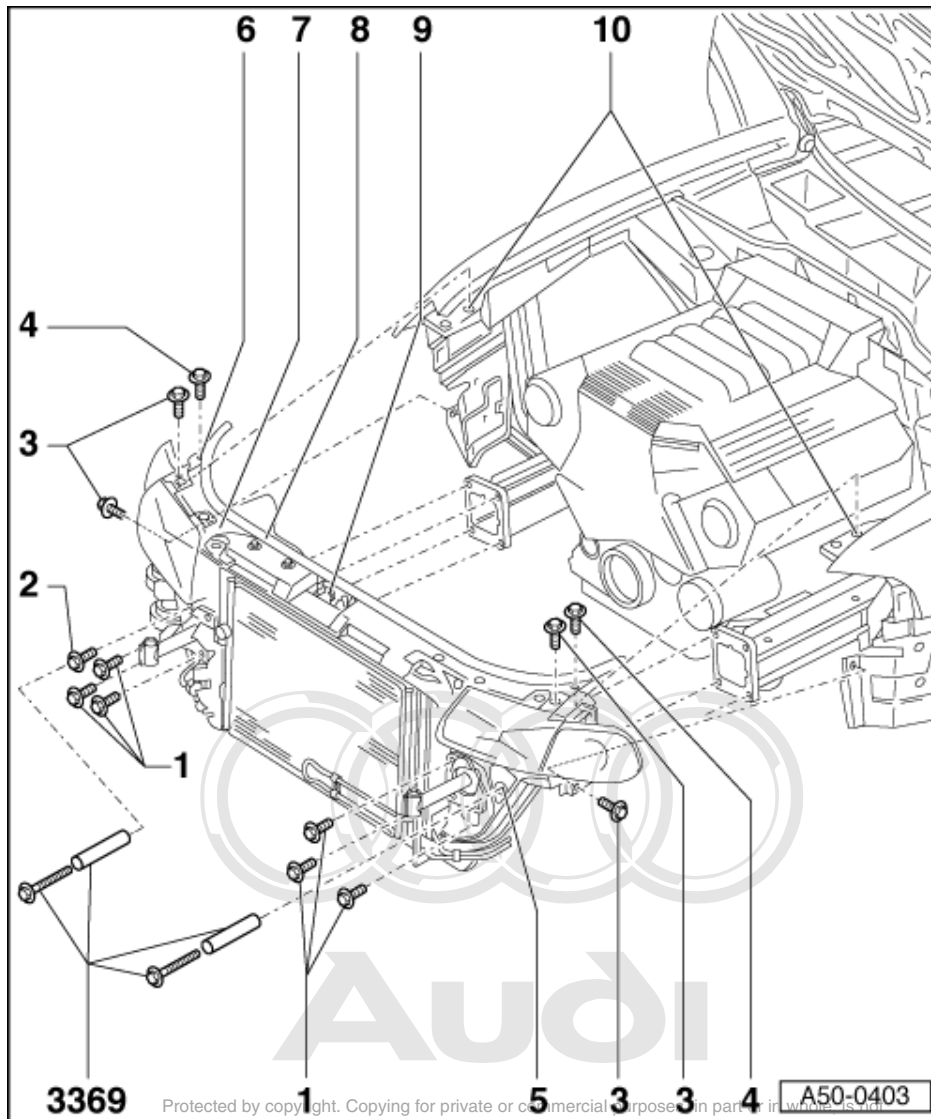
- Unbolt air duct between lock carrier and air cleaner (air duct is bolted to lock carrier).

- Detach electrical connectors.

- Drain coolant and disconnect coolant hoses =>Fig. 2 .

- Detach condenser from lock carrier only (do not disconnect lines) and secure with wire (e.g. at front wheel).

=> Heating, Air Conditioner; Repair group 87



Note:

Condenser must not be suspended by its lines.

Condenser lines must not be bent or kinked.

- ♦ Detach hydraulic fluid cooler => Fig. 1 (do not disconnect lines).

=> Running Gear; Repair group 48

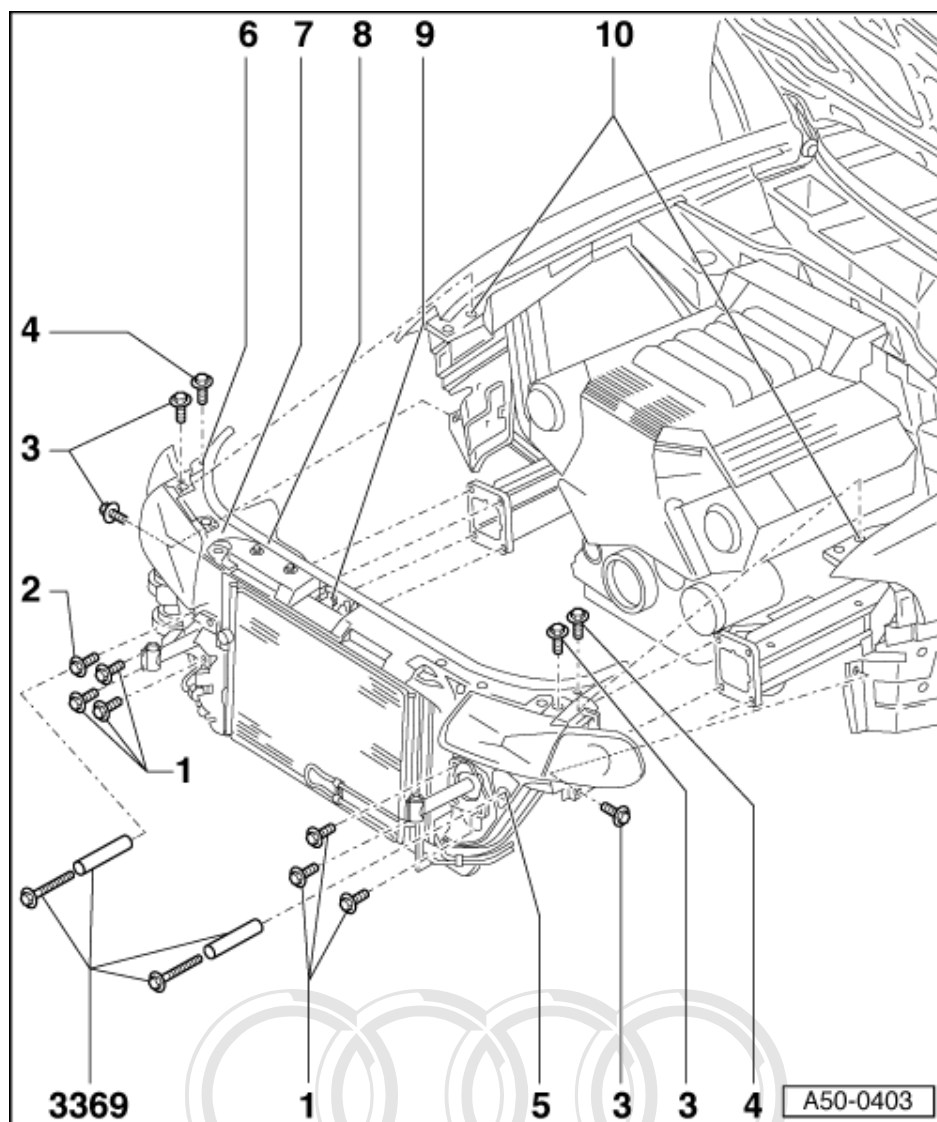
Note:

Hydraulic fluid cooler must not be suspended on its lines.

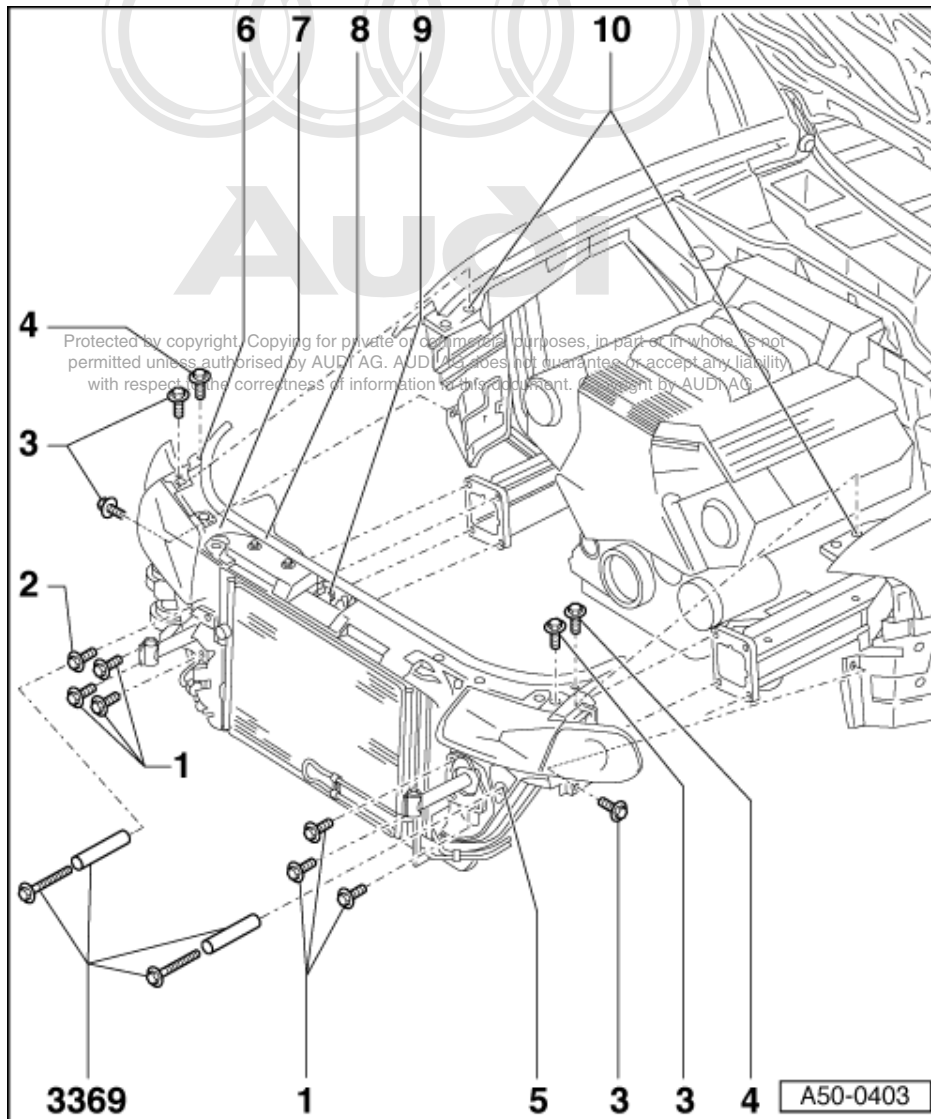
Lines leading to hydraulic fluid cooler must not be bent or kinked.

- On models with an automatic gearbox, disconnect lines from ATF cooler.

=> Automatic Gearbox; Repair group 37



- ◆ On vehicles with a charge air cooler, pull off air guide hose.
 - Detach left and right bonnet seals -8- at joint between wing and lock carrier -7-.
 - Remove bolts -3- and -4-.
 - A second mechanic is required to hold lock carrier -7-.
 - Remove bolts -1- and -2-.
 - ◆ Installation:
 - Install in reverse order.
 - Headlights must be readjusted.
 - ◆ Adjusting:
 - Lock carrier -7- must be centred between wings.
 - If the wings and bonnet are also being renewed, centre them in relation to one another before adjusting lock carrier.
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- 8 Bonnet seal
- 9 Bowden cable for bonnet
 - ♦ Detach => Page 26 .
- 10 Hole: Wing

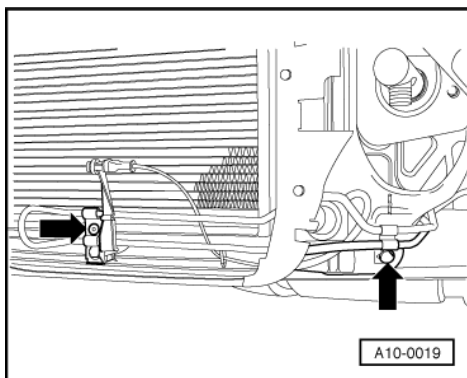


Fig.1 -> Disconnecting hydraulic fluid cooler

- Unscrew P.A. hydraulic line retainers from engine sub-frame and gearbox.

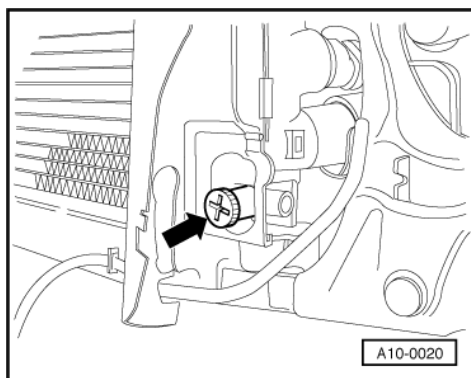


Fig.2 -> Disconnecting coolant hose

- Drain coolant from radiator.
- Pull out retainer for coolant hose connecting flange at the bottom of the radiator and pull off the connecting flange.
- Bleeding coolant system.

=> Engine Mechanical Components; Repair group 19

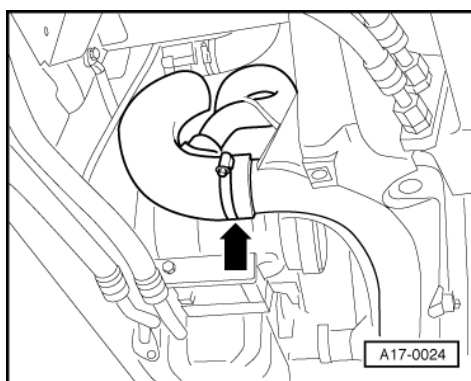
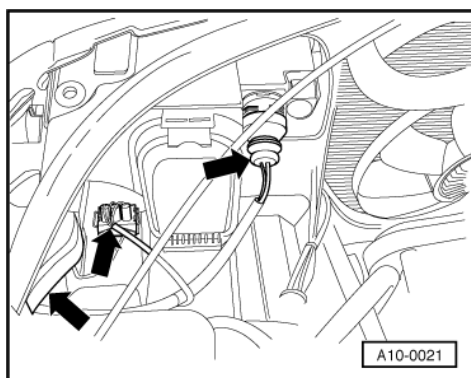


Fig.3 -> Disconnecting charge air cooler hose

- On vehicles with charge air cooling, slacken bolt on hose clamp -arrow-.
- Detach hose.

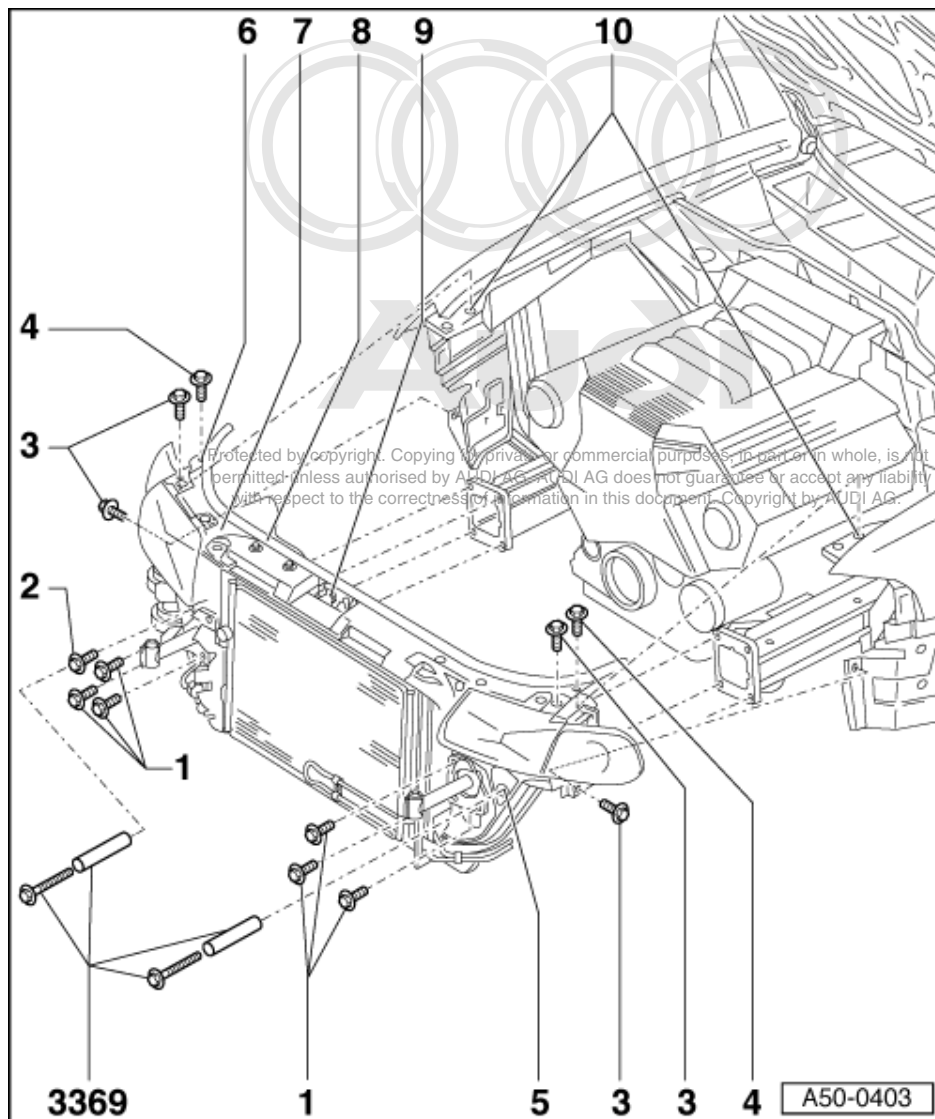
- Disconnect air duct to air cleaner at lock carrier and lift out.



- -> Unplug connectors for headlights, headlight height adjustment and indicators.
- Unplug connector for radiator fan temperature sender in area of lower coolant hose on left of radiator.



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1 Lock carrier

- ◆ For service position
- Unbolt air duct between lock carrier and air cleaner (air duct is bolted to lock carrier).
- On the right-hand side, unscrew securing bolt -2- and fit special tool 3369.
- On the left-hand side, fit special tool 3369 into the threaded hole -5- => Fig. 1
- Securing bolts -1- unscrew left and right.
- Remove securing bolts -3- and -4- and pull lock carrier -7- forwards.
- Set lock carrier => Fig. 2.

Note:

After installing lock carrier, check headlight settings and adjust, if necessary.

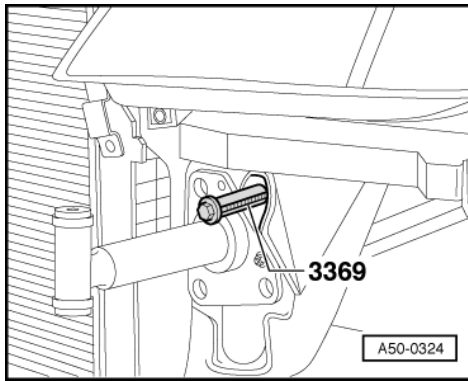


Fig.1 -> Inserting special tool 3369

- Screw in special tool 3369 on left and right as shown.
- Pull lock carrier forward until rear hole in lock carrier aligns with front threaded hole in wing flange.

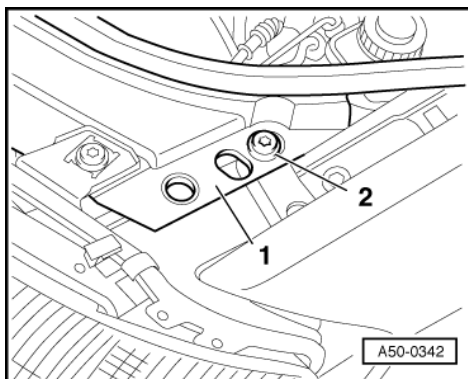


Fig.2 -> Securing lock carrier

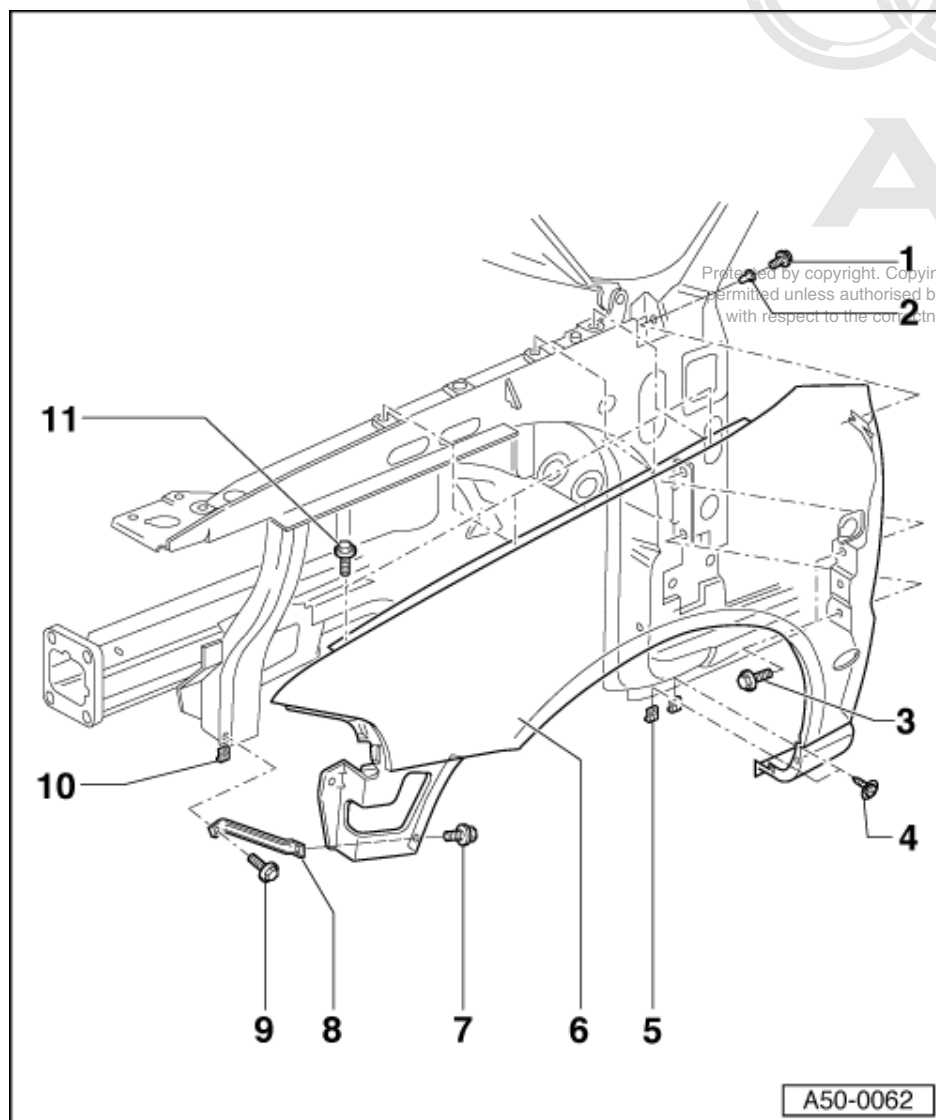
- Secure lock carrier in position on left and right using bolts as shown.



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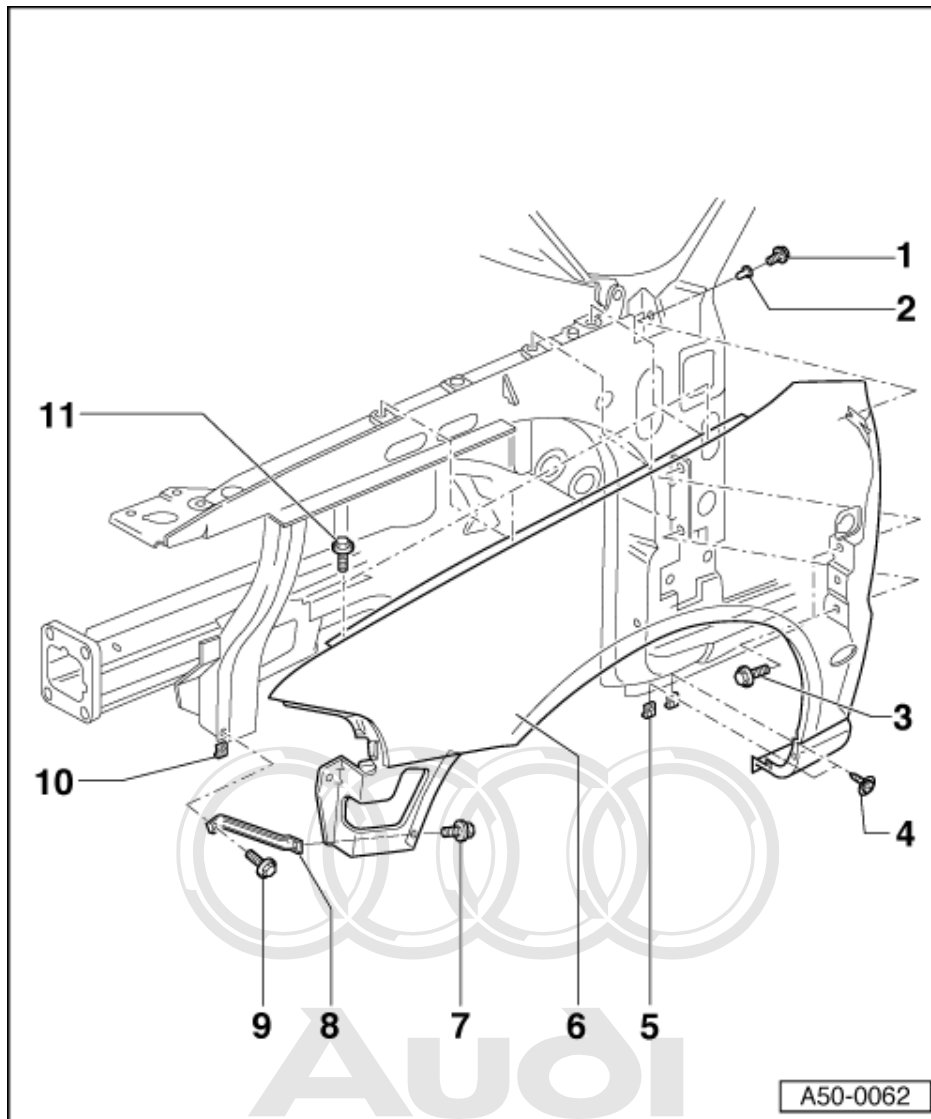


1.4 - Front wing (up to chassis number 8D XA 200 000)



Assembly overview

- 1 Combi bolt
 - ◆ 4.5 Nm
- 2 Threaded rivet
 - ◆ Fit threaded rivet using special tool V.A.G 1618 A.
- 3 Combi bolt (2x)
 - ◆ 7.5 Nm
- 4 Cross head screw
 - ◆ 4.5 Nm
- 5 Speed nut (2x)
- 6 Wings
 - ◆ Remove bumper: =>Page 161 .
 - ◆ Remove wheel housing liner
=>Page 248 .
 - ◆ Remove locking part =>Fig. 1 .



- ♦ Remove headlights => Workshop Manual, Electrical System.
- ♦ Unplug electrical connectors for side turn signals.
- Unscrew bolts -1-, -3-, -4-, -7- and -11-

- 7 Combi bolt**
 - ♦ 7.5 Nm
- 8 Bracket**
- 9 Combi bolt**
 - ♦ 7.5 Nm
- 10 Speed nut**
- 11 Combi bolt**
 - ♦ 7.5 Nm

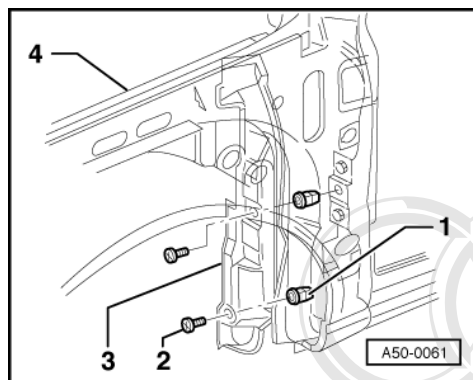
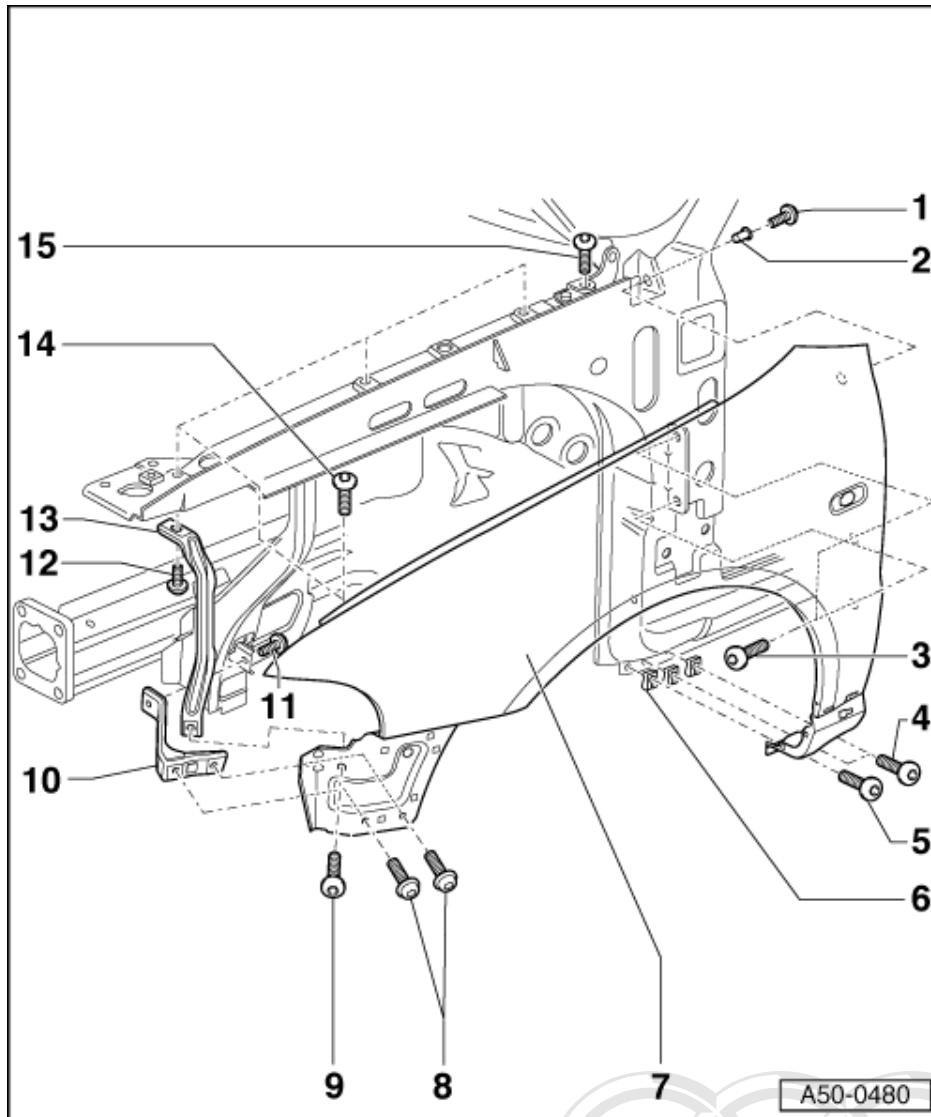


Fig.1-> Removing and installing end piece

- Front wheel removed.
 - Removing front wheel housing liner => Page 248 .
 - Unscrew bolts -2- (2x).
Tightening torque 2.5 Nm.
 - Remove locking element -3- from wing -4-.
 - Spreader clip -1- (2x).
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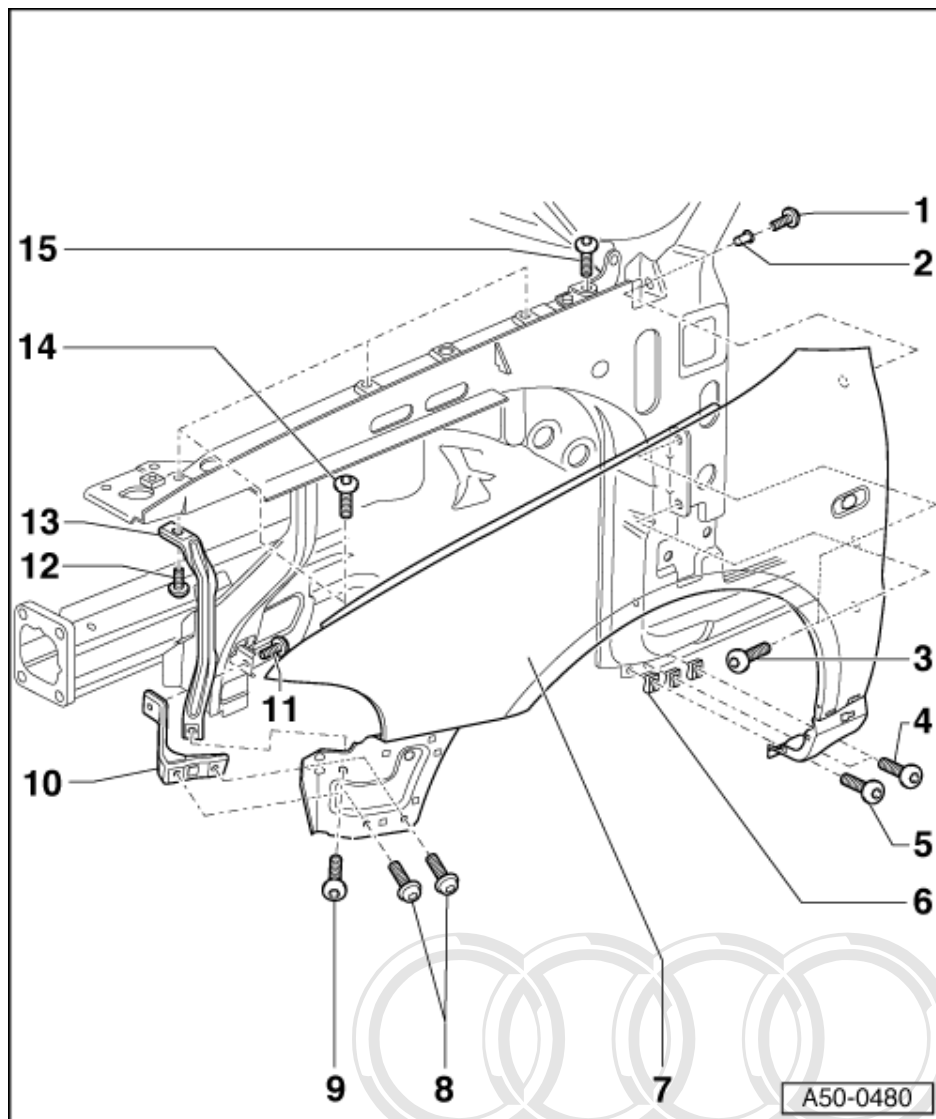
1.5 - Front wing (from chassis number 8D XA 200 001 and S4)



Assembly overview

- 1 **Combi bolt**
 - ◆ 4.5 Nm
- 2 **Threaded rivet**
 - ◆ Fit threaded rivet using special tool V.A.G 1618 A.
- 3 **Combi bolt (2x)**
 - ◆ 7.5 Nm.
- 4 **Cross head screw**
 - ◆ 4.5 Nm
- 5 **Cross head screw**
 - ◆ Only fitted on S4.
 - ◆ 4.5 Nm

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6 Snap nut

- ♦ Only fitted on S4.

7 Wings

- ♦ On S4 wings, make additional holes underneath => Fig. 1.

♦ Removal:

- Removing bumper => Page 161.

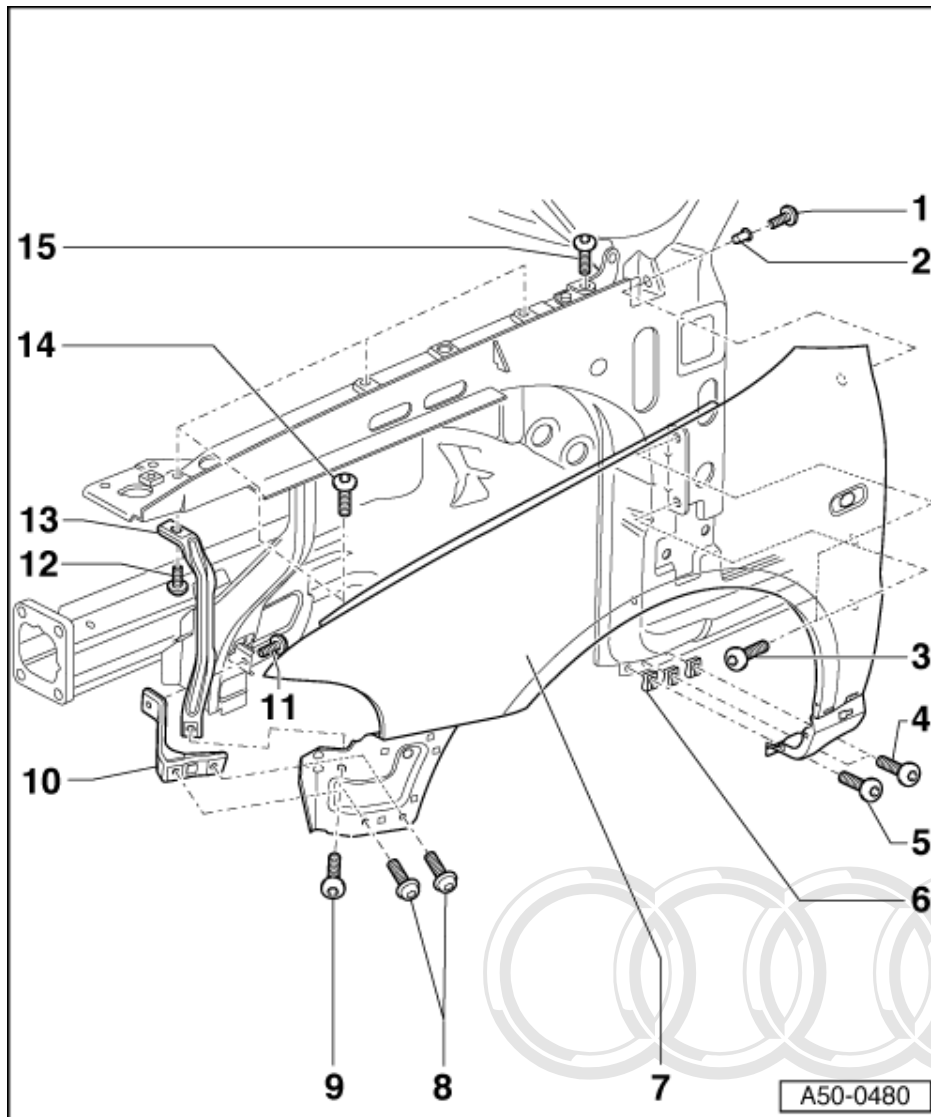
- Remove wheel housing liner => Page 248.

- Remove headlights

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=> Electrical System; Repair group 94; Servicing headlights; Removing and installing headlights Servicing headlights Removing and installing headlights

- Unplug connector for side indicators.
- Remove end plate => Page 12.
- Remove screws -1-; -3-; -4-; (screw -5- only on S4); -8-; -9-; and -14-.



- 8 Self-tapping screw**
 - ◆ 7.5 Nm
- 9 Self-tapping screw**
 - ◆ 7.5 Nm
- 10 Strut**
- 11 Self-tapping screw**
 - ◆ 7.5 Nm
- 12 Self-tapping screw**
 - ◆ 7.5 Nm
- 13 Strut**
- 14 Combi bolt**
 - ◆ 10 Nm
- 15 Combi bolt**
 - ◆ 7.5 Nm

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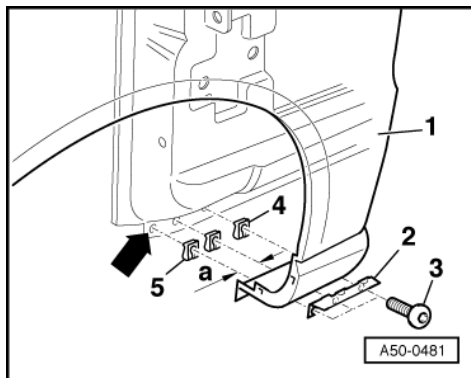


Fig.1 -> Making holes for S4 wings

Note:

With replacement body parts, you must make the holes before spraying.

- Make the hole with a $\varnothing$ of 7 mm at distance -a- = 22 mm and at distance -b- = 8 mm in the wing.
- Replace the corrosion protection on the edges of the hole.

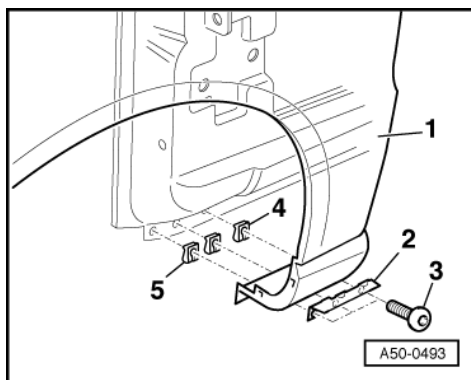
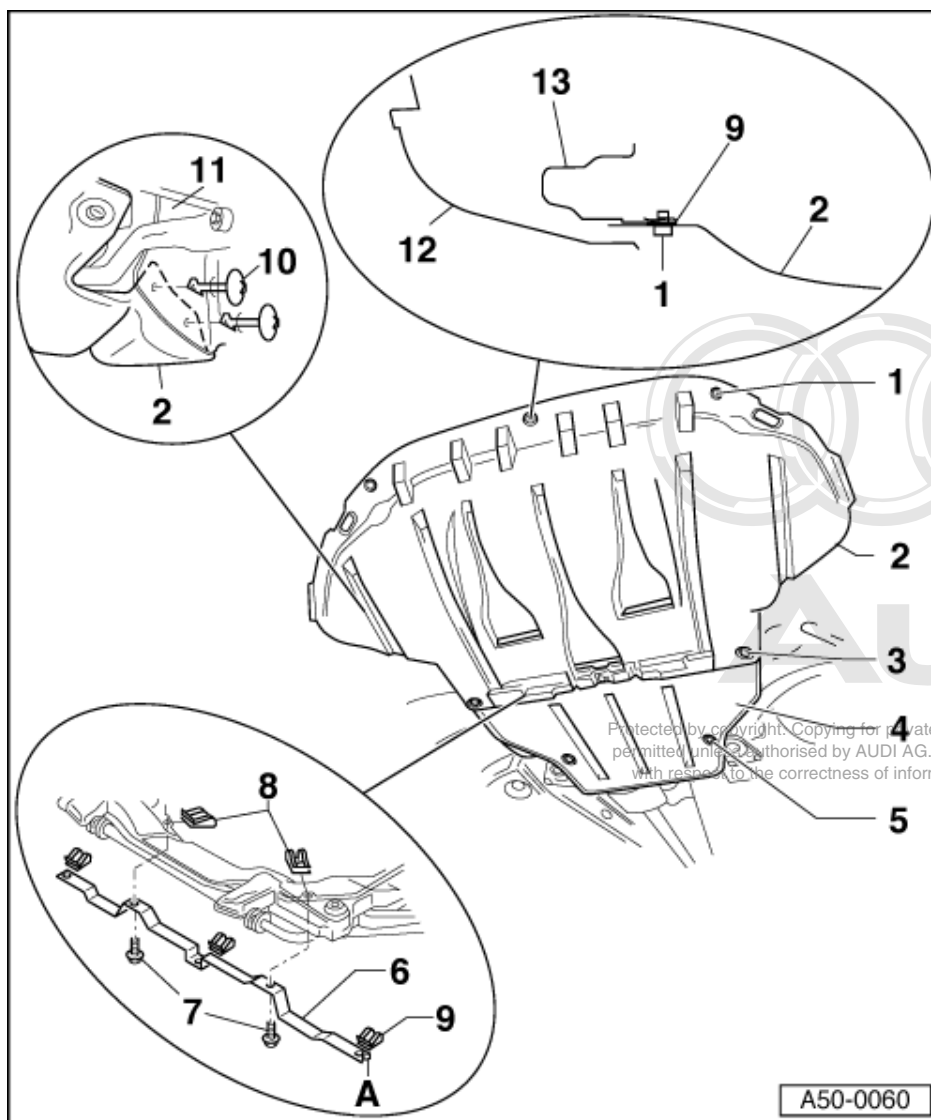


Fig.2 -> Fastening lower wing (S4)

- Push snap nut -4- from below onto sill panel.
- Snap nut -5- only on S4.
- Fasten the wing -1- underneath with the re-enforcement bracket -2- and the screws -3-.

1.6 - Noise insulation - Exploded view



1 Quick release bolt

- ◆ To move lock carrier to service position, unscrew only these quick release bolts.
- ◆ 3x
- ◆ 2 Nm

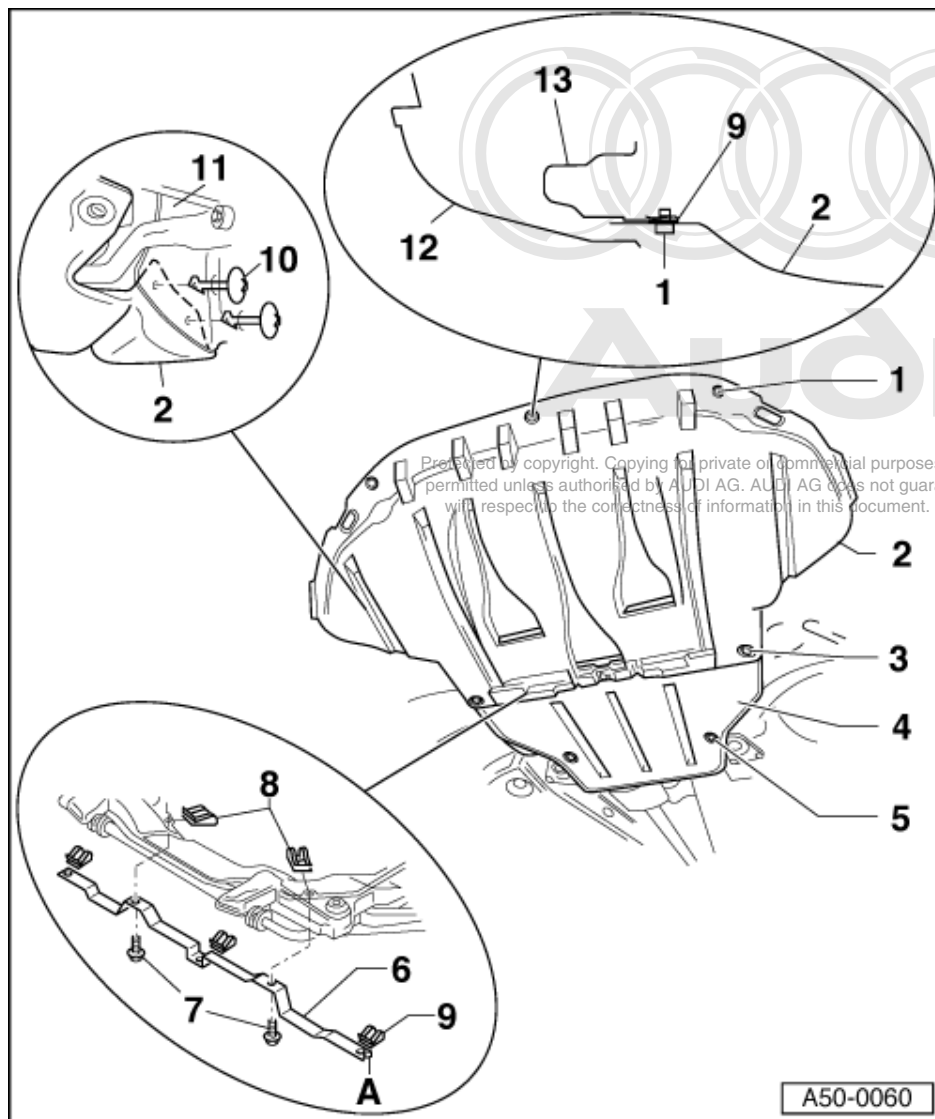
2 Front noise insulation

3 Quick release bolt

- ◆ 3x
- ◆ If rear noise insulation - 4 - is also installed, longer quick release bolts must be used
- ◆ 2 Nm

4 Rear noise insulation

- ◆ Only installed with certain engine versions.
- ◆ Fitted above noise insulation -2-.



5 Quick release bolt

- ◆ 2x
- ◆ 2 Nm

6 Noise insulation mounting

- ◆ -9- must point towards left side of vehicle.

7 Bolt

- ◆ 2x
- ◆ 7.5 Nm

8 Snap nut

- ◆ 2x

9 Snap nut

- ◆ 3x

10 Clamping pin

- ◆ 2x

11 Wheel housing liner

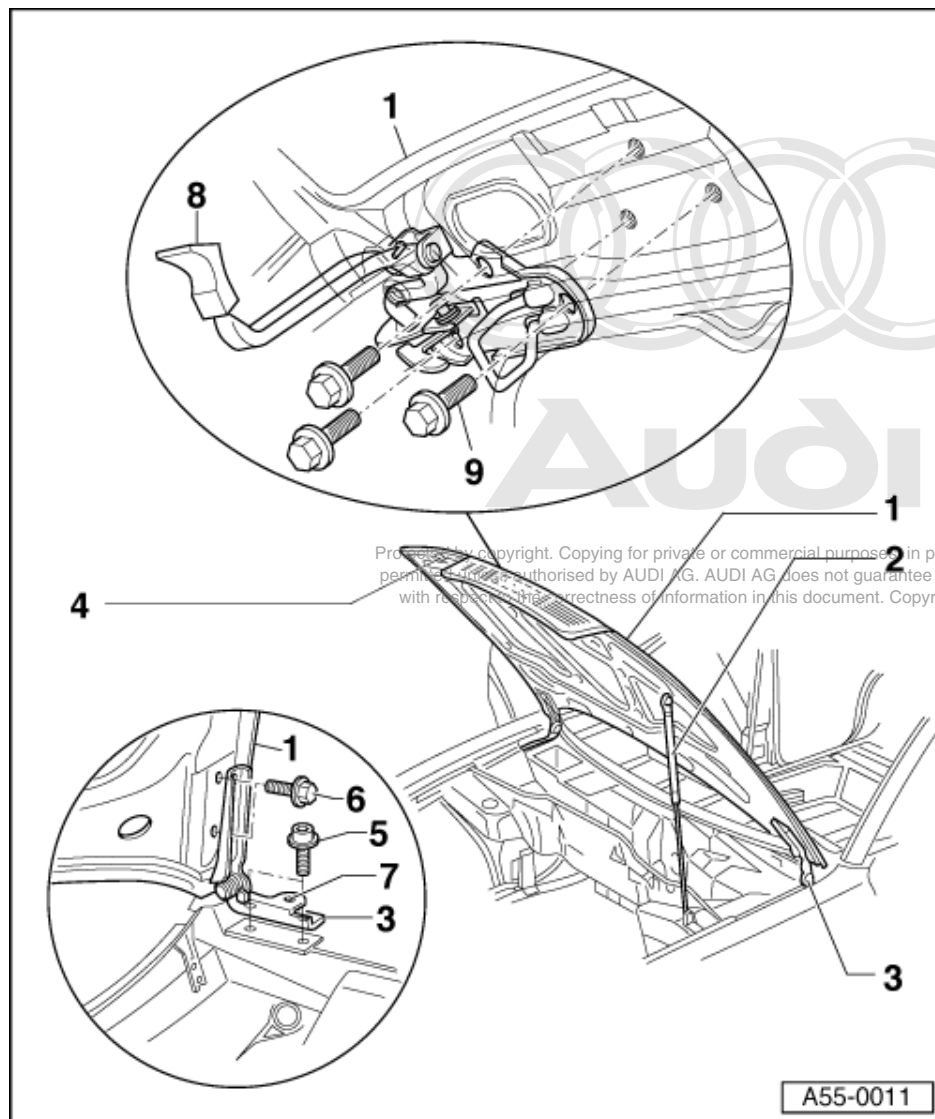
12 Bumper

13 Lock carrier with attaching parts

55 - Bonnet, Flaps

1 - Bonnet

1.1 - Bonnet

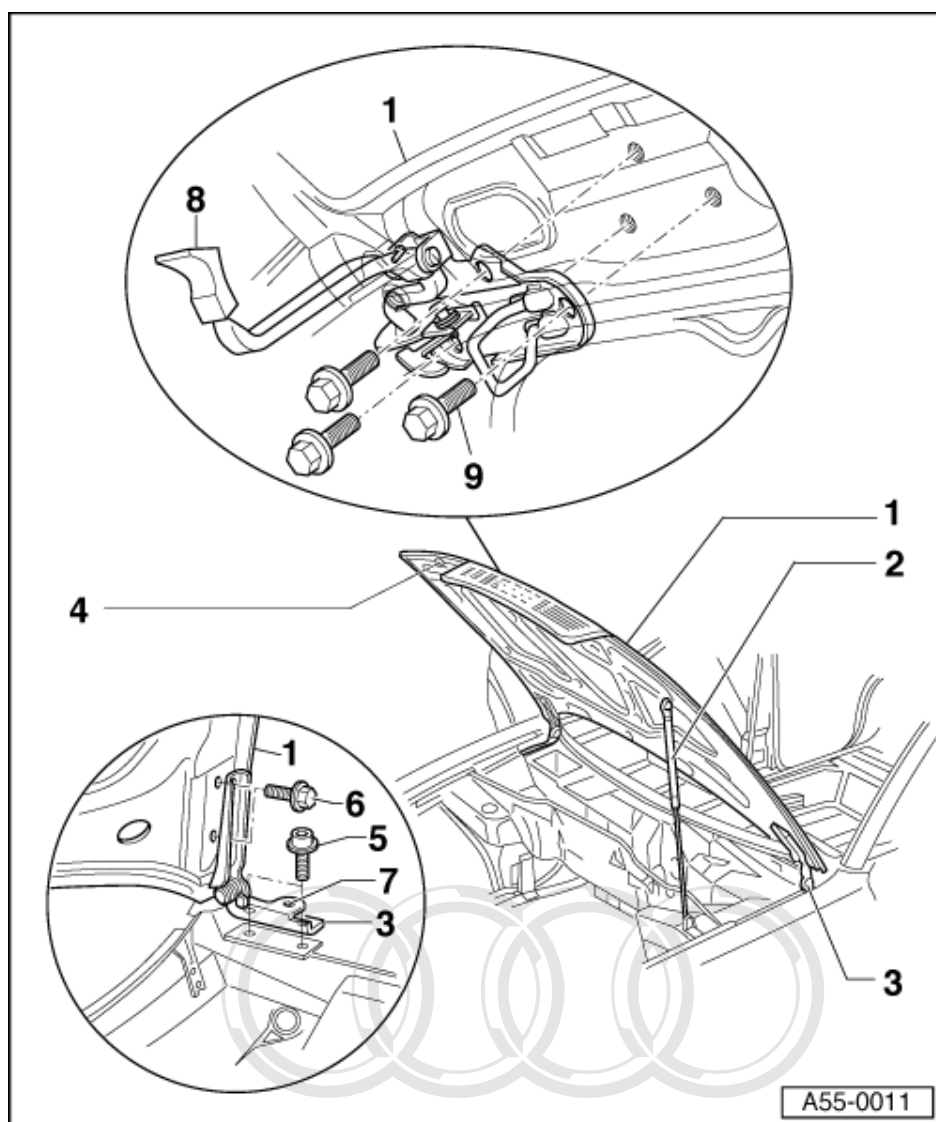


1.2 - Removing, installing and adjusting bonnet

1 Bonnet

- ◆ Removing:
 - Disconnect and unclip wiring and hoses for windscreen washers.
 - A second person is required to support and lift bonnet slightly.
 - Remove gas-filled strut -2- from bonnet -1-.
 - Unscrew bolts -6-.
 - Remove bonnet.
- ◆ Installing:

- Install in reverse order.



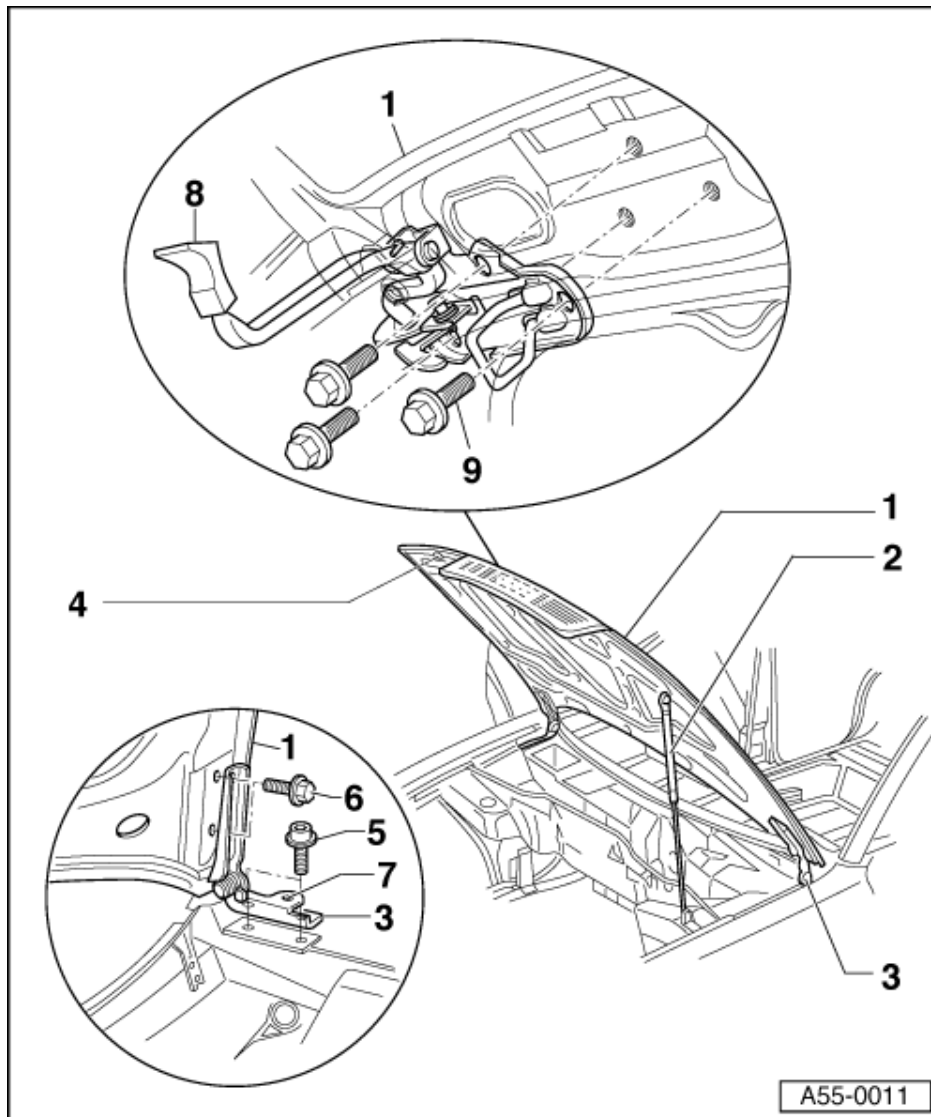
- ♦ Adjusting:
 - Align bonnet -1- between the wings.
 - Adjust height of bonnet by adjustment of bonnet lock => Fig. 4
 - The bonnet can be adjusted for height relative to wings using stop buffers -4- =>Fig. 2 .
 - Panel joint dimensions =>Fig. 5 .

2 Gas-filled strut

- ♦ Removing => Page 22
- ♦ To install, press gas-filled strut onto ball stud.
- ♦ Tube end of strut goes towards body of vehicle.
- ♦ Releasing gas => Page 23 .

3 Bonnet hinge

- ♦ Bonnet -1- must be removed or propped up safely.
- ♦ Remove bolts -5-, -6- and -7-.



4 Stop buffer

- ♦ Adjusting =>Fig. 2

5 Bolt (2x)

- ♦ 21 Nm

6 Bolt (2x)

- ♦ 21 Nm

7 Bolt

- ♦ Tightening torque 7.5 Nm.

8 Arrester release mechanism

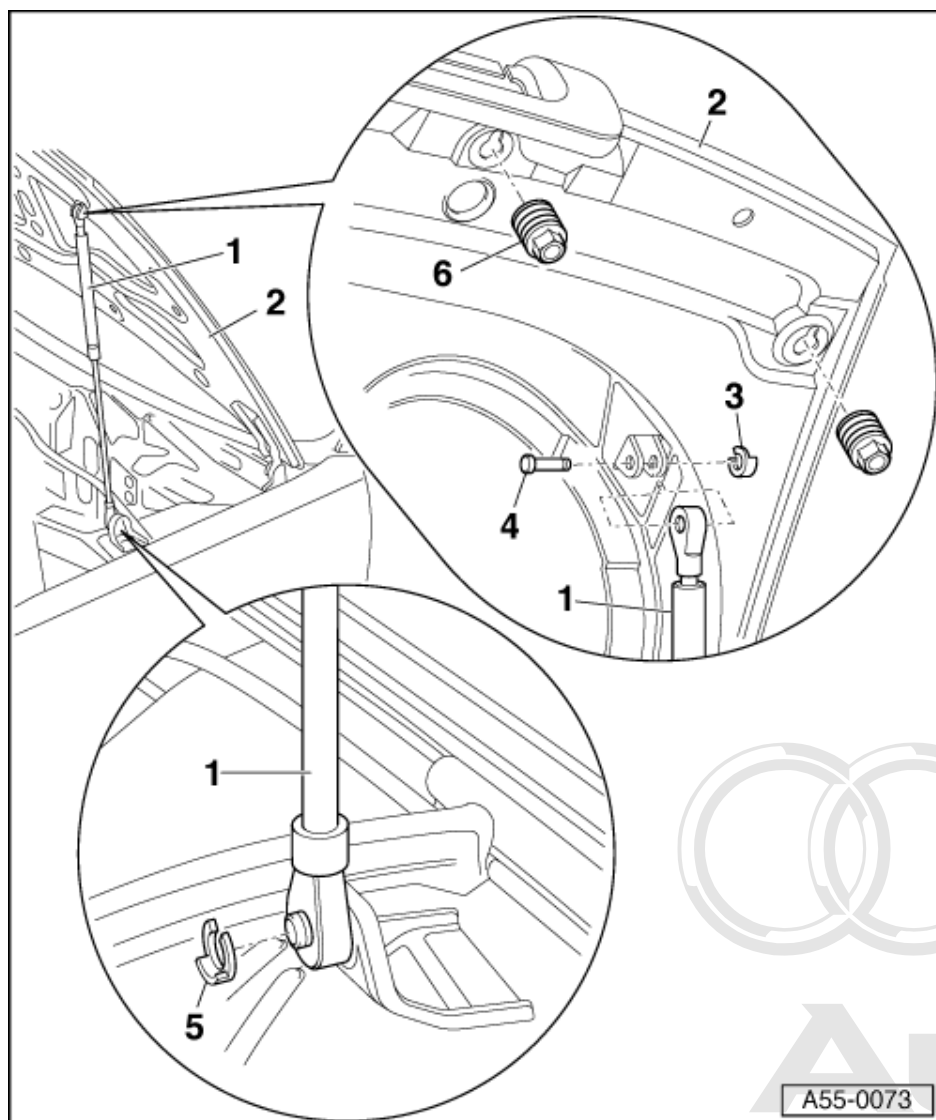
- ♦ To remove, unscrew screws -9-.
- ♦ Installing =>Fig. 3.
- ♦ Arrester release mechanism can only be adjusted in direction of travel.

9 Screw (3x)

- ♦ 8 Nm

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1.3 - Removing and installing gas-filled strut



1 Gas-filled strut

- ◆ Removing:
 - Support bonnet -2- or secure against falling closed
 - Pull off spring clip -5-.
 - Also clip -3-.
 - Lift bonnet slightly, pull out pin -4- and remove gas-filled strut.
- ◆ Installing:
 - The tube end of strut goes towards bonnet.

2 Bonnet

3 Securing clip

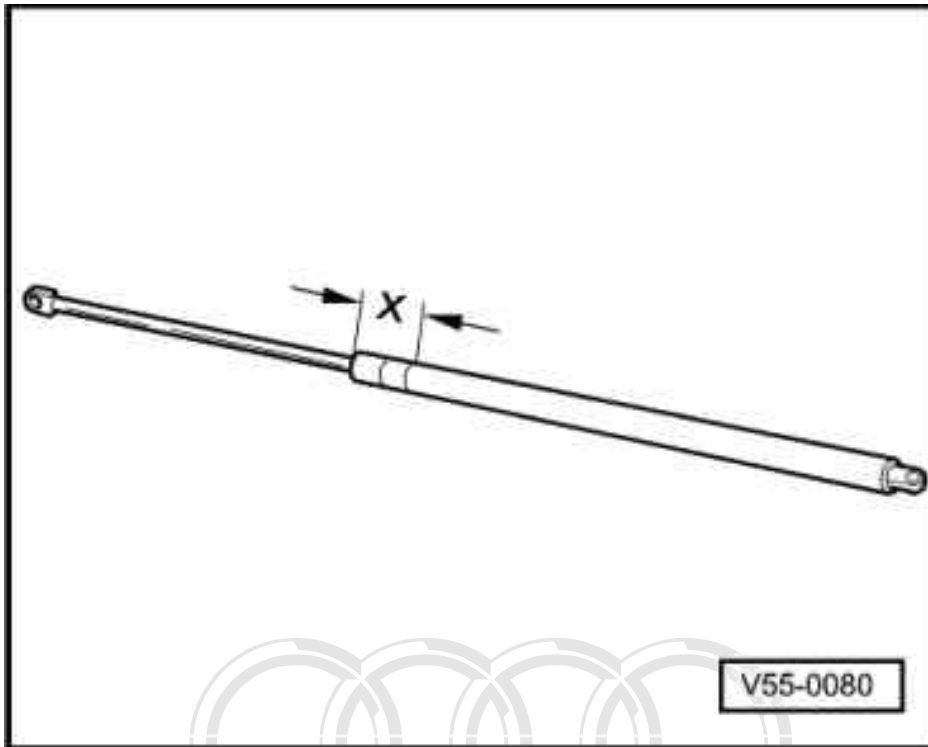
4 Pin

5 Securing clip

6 Stop buffer

- ◆ For adjusting height of bonnet => Fig. 2 .

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-> Fig.1 Releasing gas from gas-filled strut

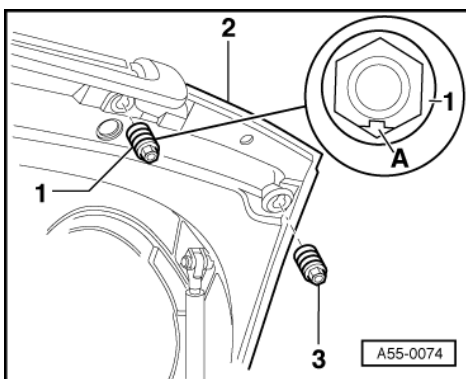
- Clamp gas-filled strut in vice in area x = 50 mm.
- Saw open cylinder of gas-filled strut in first third of overall cylinder length, starting from reference edge on piston-rod end.

Important
Only clamp the strut in this area. Otherwise there is risk of accident.

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Note:

Goggles must be worn during sawing. It is also appropriate to cover the area around the saw-cut with a cloth to catch any escaping fluid.



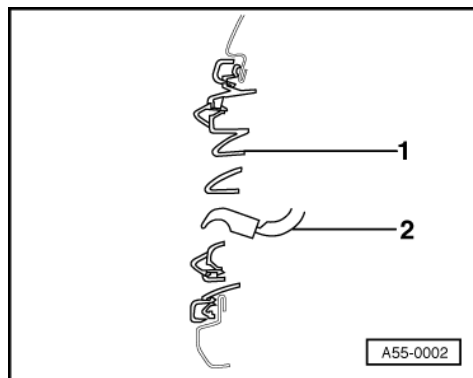
-> Fig. 2 Stop buffers for height adjustment

- Stop buffers -3- (2x outer) must rest lightly on lock carrier when bonnet is closed.

Note:

Stop buffers can be used for adjusting height of bonnet.

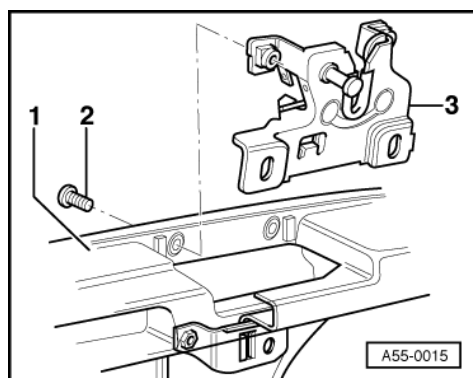
- Screw stop buffers -1- (2x inner) fully into bonnet -2-, then unscrew by half a turn. Mark -A- must point towards rear of vehicle.



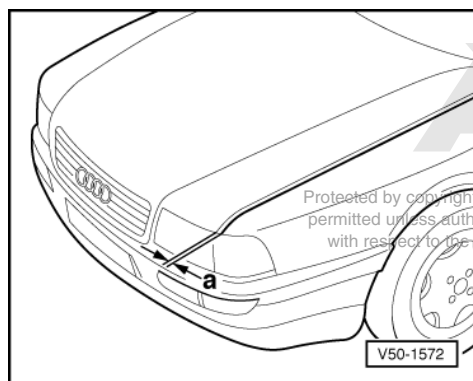
-> Fig. 3 Arrestor release mechanism

- Arrestor actuator -2- must be flush with radiator grille.
- Viewed from front towards radiator grille, arrestor actuator must be centred in radiator grille opening.

Fig.4 -> Removing and installing lower section of bonnet lock



- Disengage Bowden cable for the bonnet => Page 26 .
- Unscrew bolts -2- (4x). Tightening torque 10 Nm.
- Take out bottom part of lock -3-.
- Lock carrier -1-.
- To adjust bonnet, move lower section of lock up or down as required.

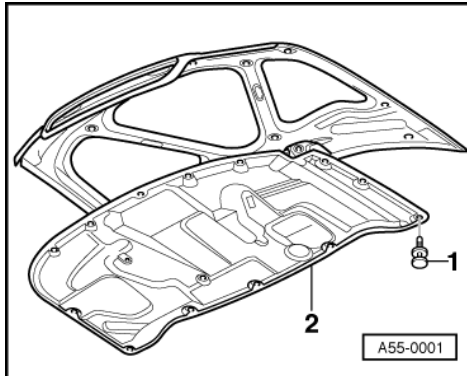


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-> Fig. 5 Joint dimensions

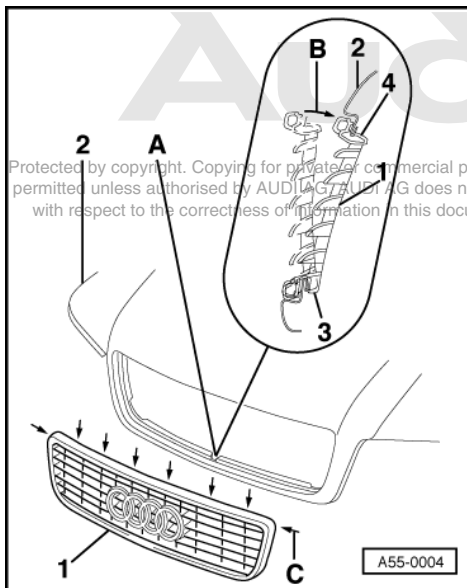
- Check adjustment with special tool 3371.
- $a = 3.0 \text{ mm}$

1.4 - Lining for bonnet



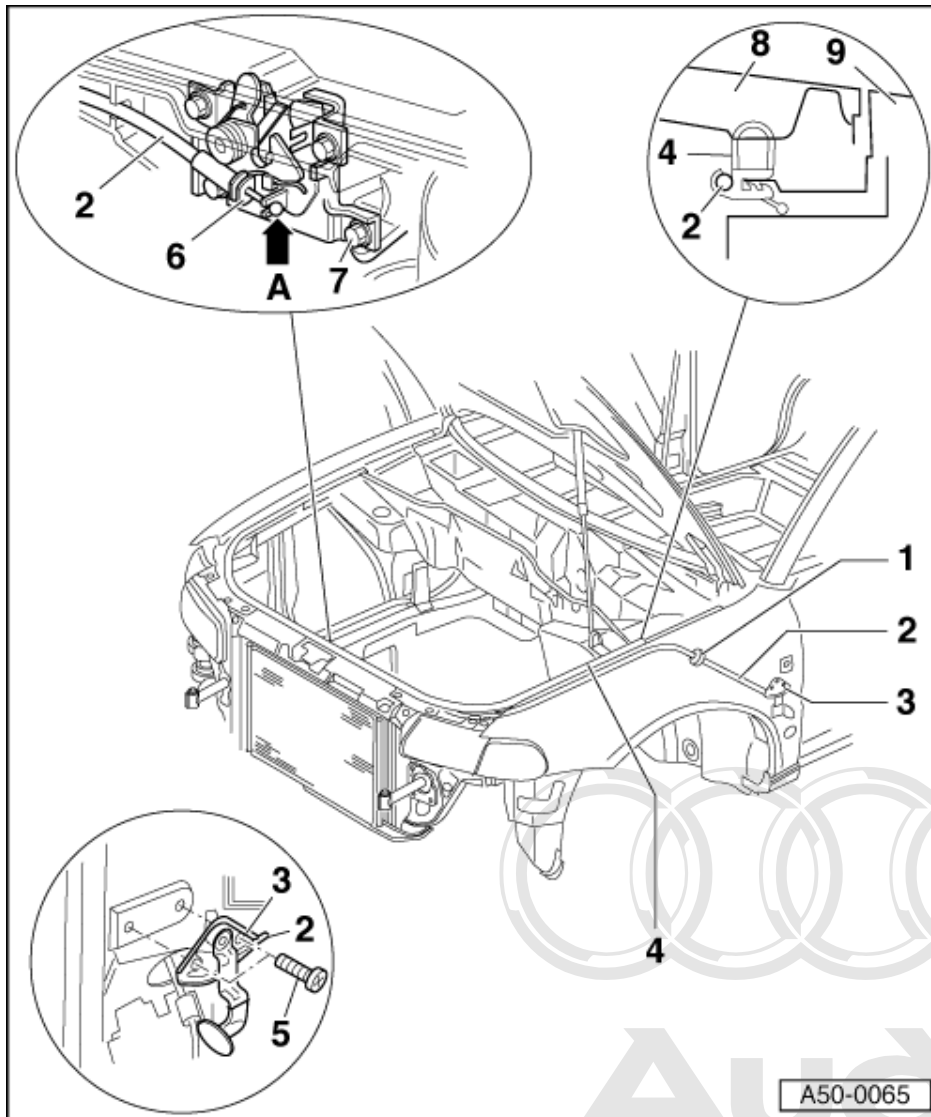
- Remove retaining clips -1- (17x).
- Remove lining -2-.

1.5 - Removing and installing radiator grille



- -> Item -A- centres radiator grille in bonnet.
- Engage radiator grille -1- at bottom in guide -3- and clip into bonnet -2- in direction of arrow -B-.
- Arrows -C- indicate all retaining tabs -4-, which must be unclipped individually during removal.

1.6 - Removing and installing bonnet lock cable



1 Grommet

2 Cable for bonnet

- ◆ Removal:
- Remove compartment on driver's side.

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=> General Body Assembly, Interior; Repair group 68; Trims/Covers Trims/Covers

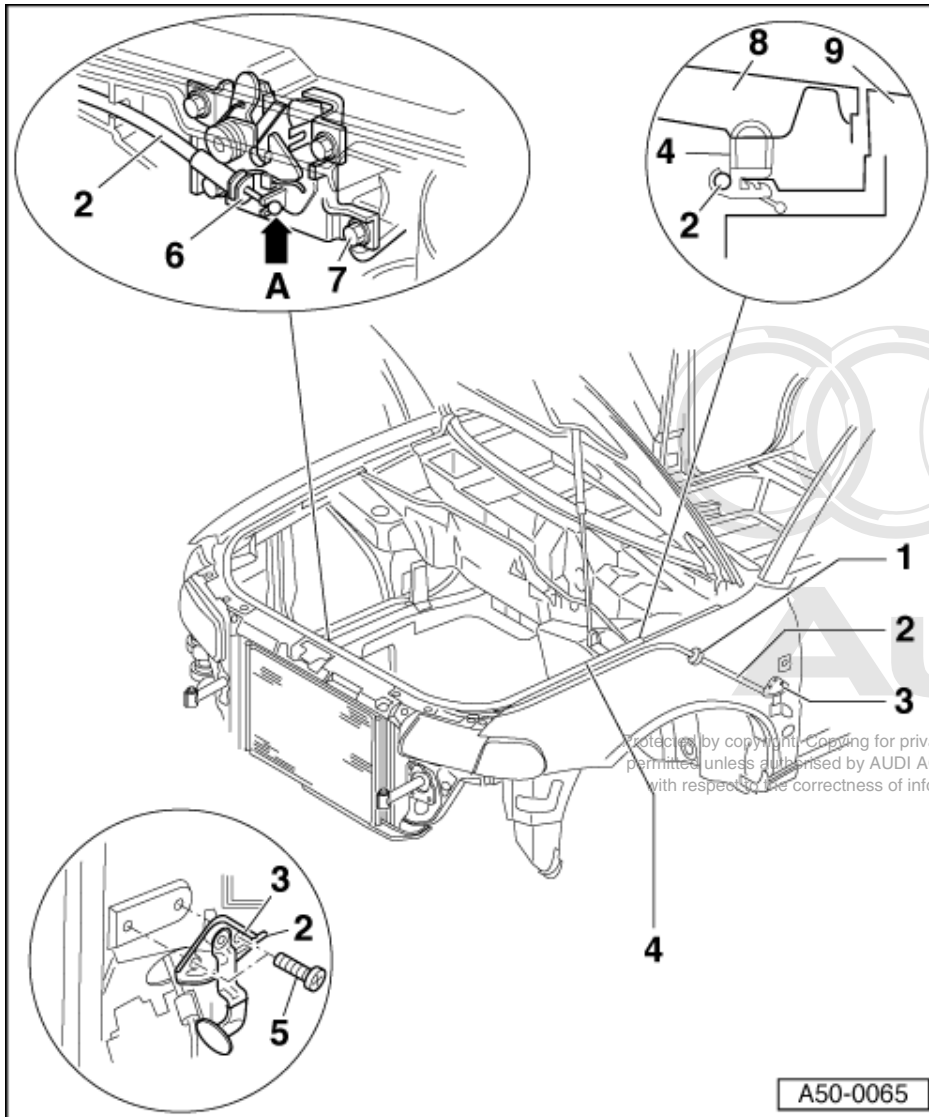
- Unscrew bolts -3-.
- Disengage cable -2- from support bracket -6- and item -A-.
- Remove cable -2- from guide slot of seal -4- and pull through towards passenger compartment.
- ◆ Installation:
- Install in reverse order.

3 Bonnet lock release

4 Gasket

5 Bolt

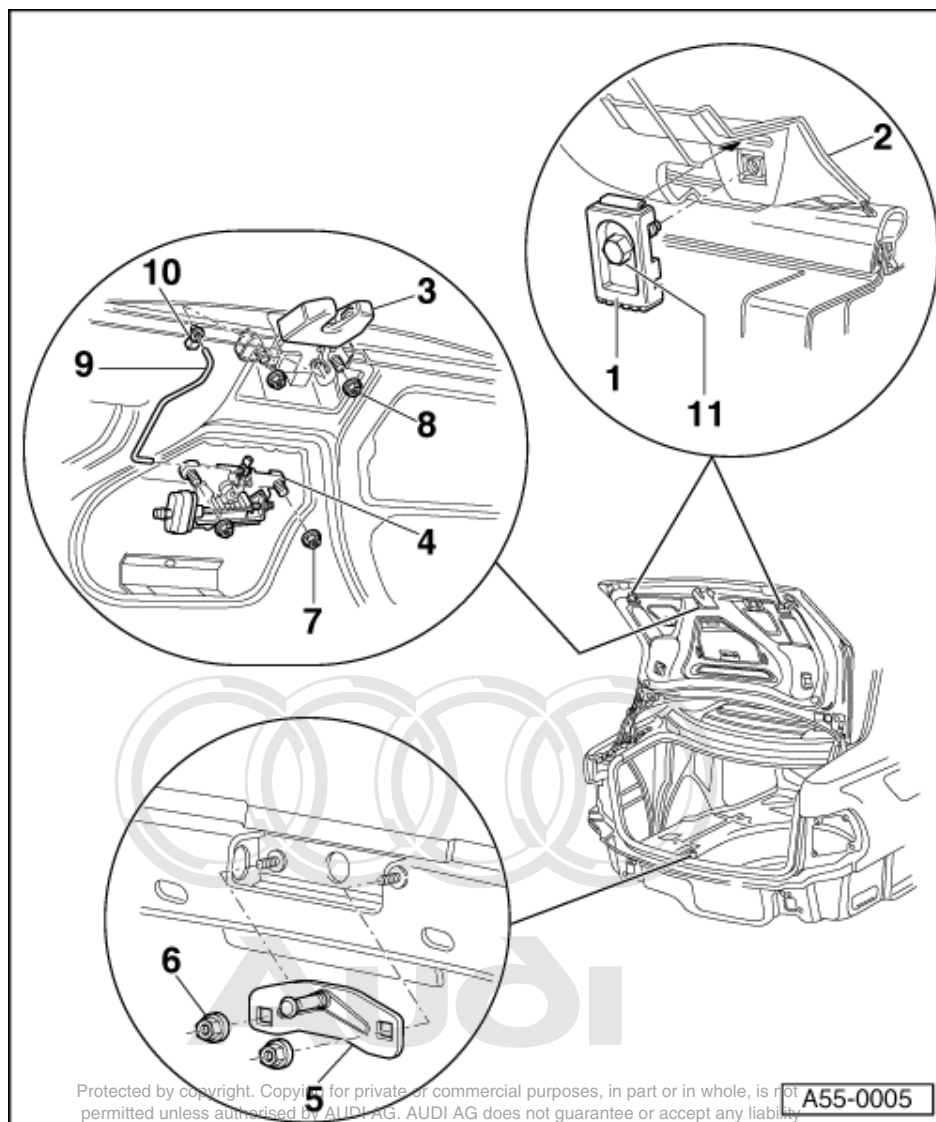
- ◆ 2x
- ◆ Tightening torque 4 Nm.



- 6 Cable support bracket
7 Bolt
♦ (4x)
♦ 10 Nm
8 Bonnet

2 - Boot lid >8D XA 200 000

2.1 - Boot lid >8D XA 200 000



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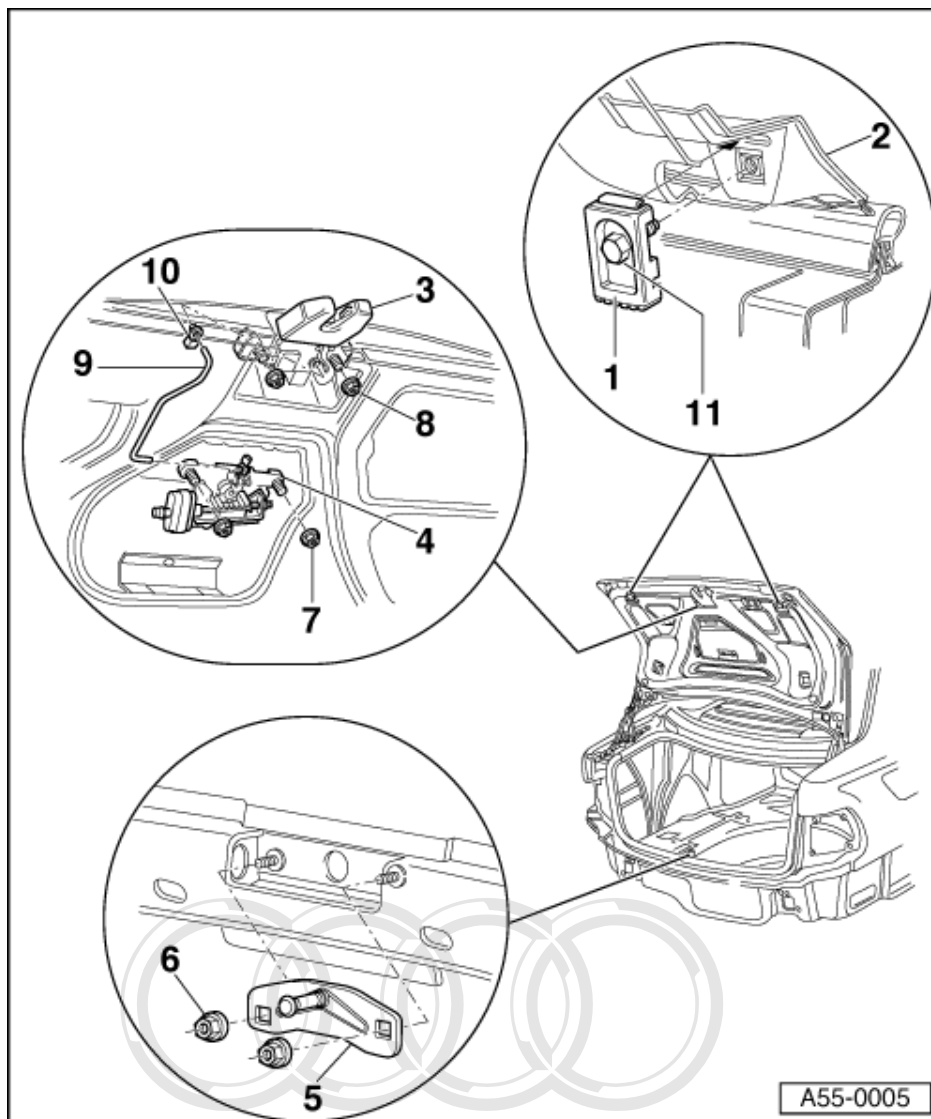
A55-0005

2.2 - Removing, installing and adjusting boot lid and boot lid lock

1 Stop buffer (2x)

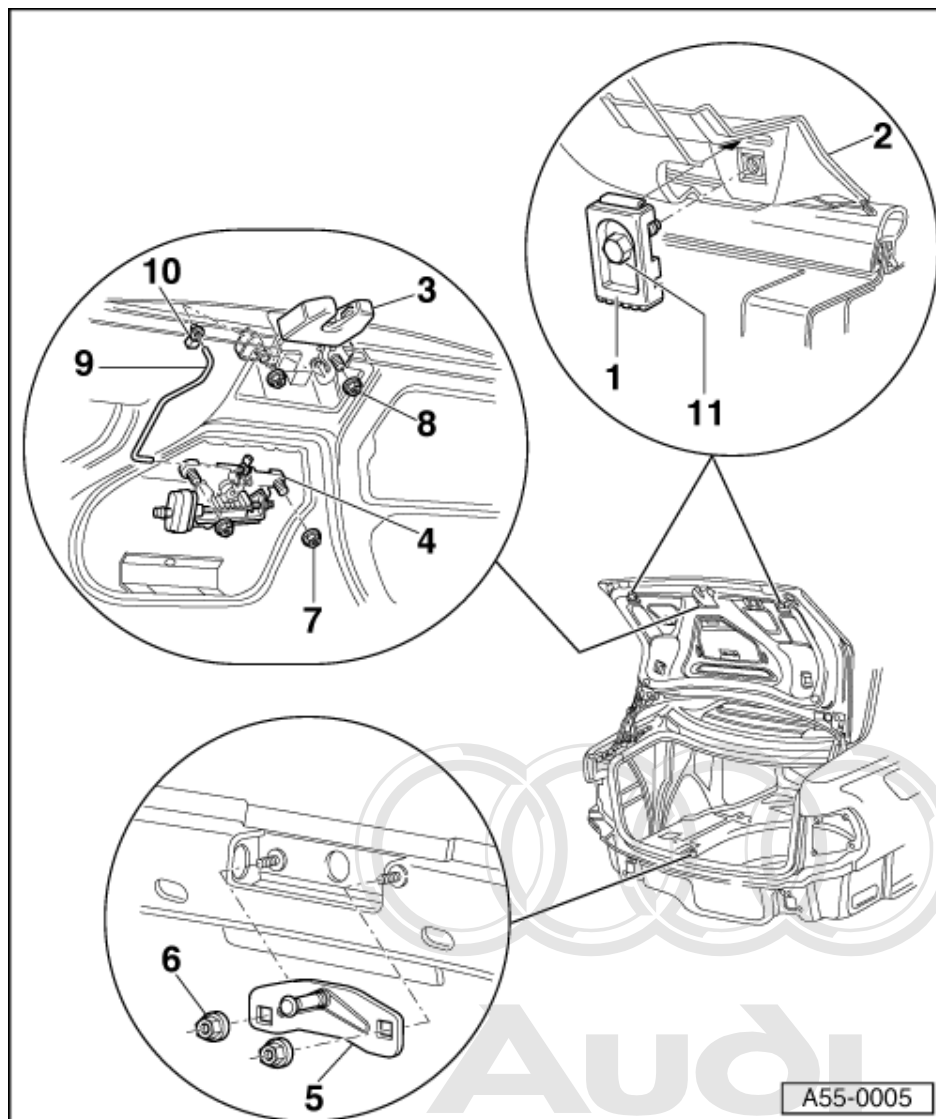
♦ Adjusting:

- Loosen bolt -11- and pull out stop buffer.
- Hand tighten bolts -11- (stop buffers must still be movable).
- Carefully close boot lid until it is flush with side panel at rear.
- Carefully open boot lid -3-.
- Pull out stop buffer -1- two retaining tabs (1mm pre-tension) and tighten bolt -2-. Tighten to 6 Nm $\pm$ 0.5.



2 Boot lid

- ◆ Removal:
 - Remove warning triangle with holder => Page 36 .
 - Remove boot lid lining.
 - Disconnect and unclip electrical wiring.
 - Disconnect line for central locking system.
 - A second person is required to lift off boot lid.
 - Unscrew nuts for connection of both boot lid hinges to boot lid => Page 33
- ◆ Installation:
 - Install in reverse order.
- ◆ Adjusting:
 - Height/axial adjustment of the boot lid is carried out at the boot lid hinge => Page 34 .
 - Adjust buffer stop -1-.
 - Adjust striker pin -5-.
 - Align boot lid centrally with panel joins => Page 36 .

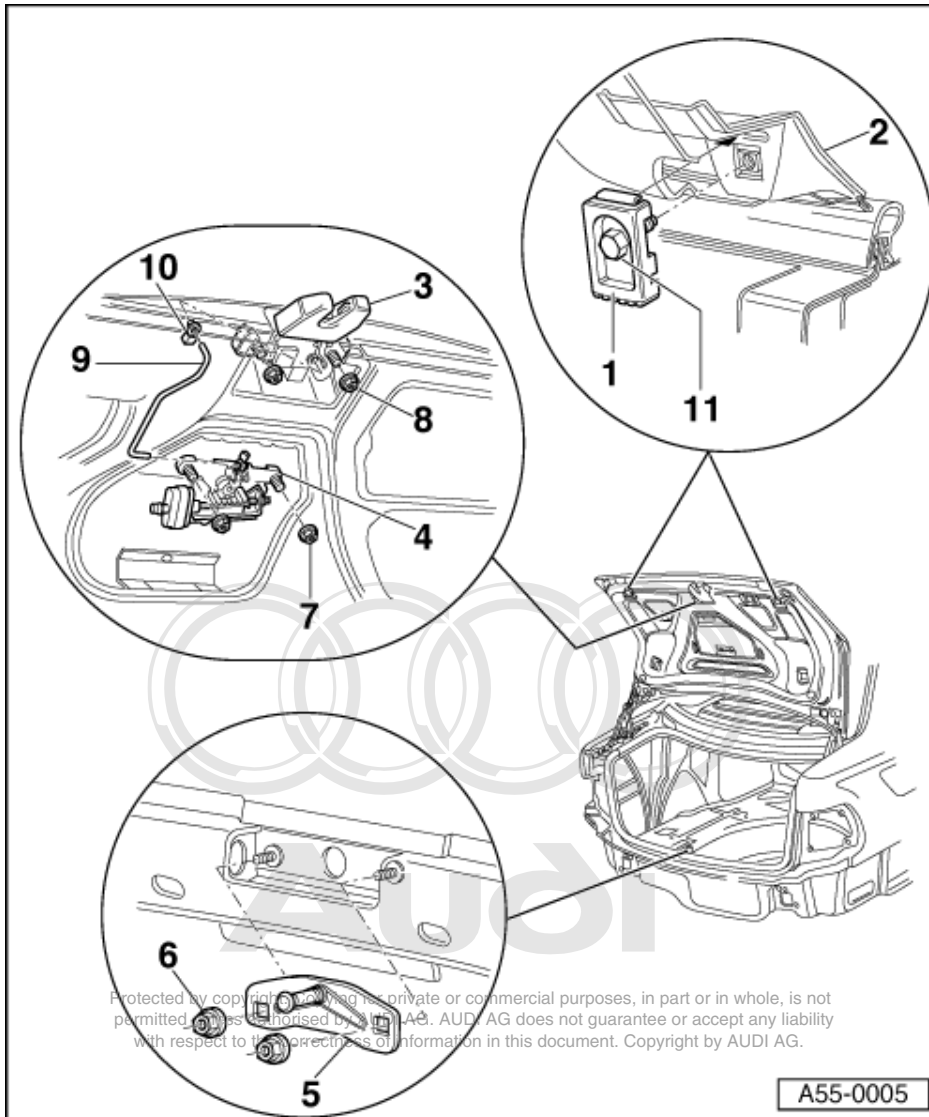


3 Boot lid lock

- Unclip operating rod -9-.
- Unscrew nuts -8-.

4 Lock cylinder

- Remove warning triangle with holder =>Page 36 .
- Remove boot lid lining.
- Disconnect line for central locking system.
- Disconnect electrical wiring.
- Unclip operating rod -9-.
- Unscrew bolts -7-.



5 Striker pin

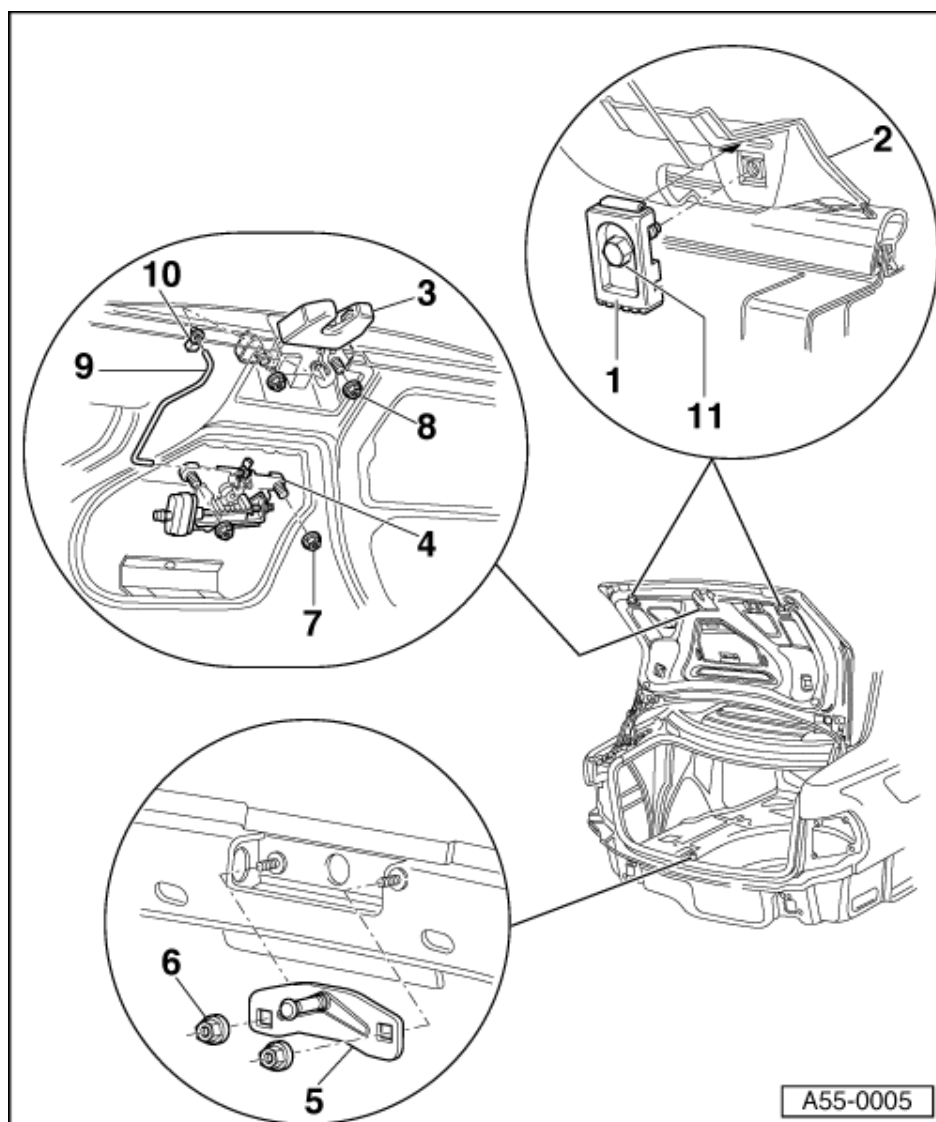
- Unscrew nuts -6-.
- ◆ Adjusting:
- Hand-tighten nuts -6- (striker pin must still be movable).
- Carefully close boot lid until it is flush with side panel at rear.
- Carefully open boot lid and tighten nuts -6-.

6 Hexagon nut

- ◆ 8 Nm

7 Hexagon nut

- ◆ 8 Nm

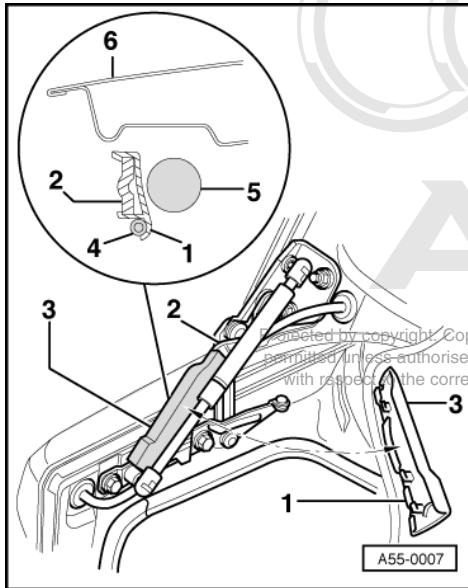


- 8 Hexagon nut
 - ♦ 6 Nm
- 9 Operating rod
- 10 Retaining clip
- 11 Hexagon bolt
 - ♦ 6 Nm



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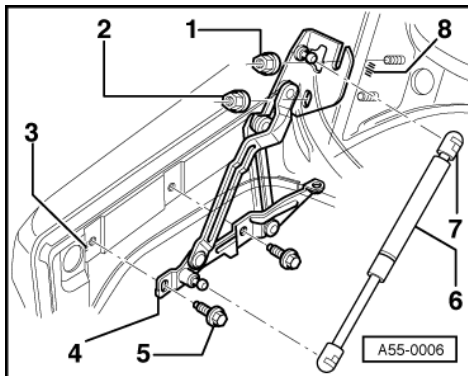
2.3 - Removing and installing boot lid hinge



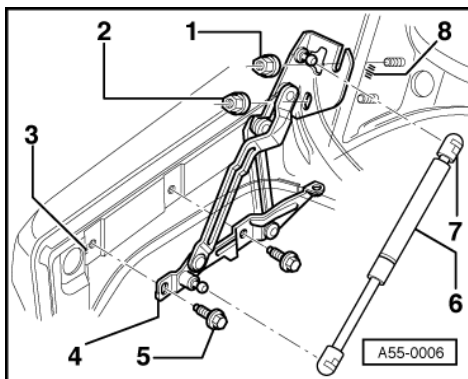
Cover for boot lid hinge

- -> Insert electrical wiring or line for central locking system -4- into lower retainer of cable guide on cover -1-.
- Attach cover -3- for boot lid hinge from below between gas-filled strut -5- and hinge lever, and clip onto hinge lever -2- at the top so it engages audibly.

Removing and installing boot lid hinge



- -> Loosen nut -1- on left and right.
Tightening torque 21 Nm.
- Unscrew nut -2- on left and right.
Tightening torque 21 Nm.
- Support boot lid using a second person or other suitable means.



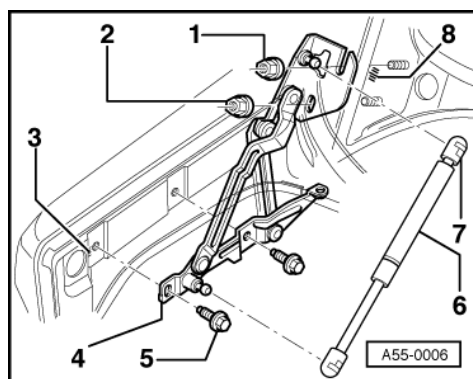


- Remove bolts -5- (2x).
Tightening torque 21 Nm.
- -> Lift boot lid slightly and remove hinge -4-.

Note:

The scales -3- and -8- facilitate boot lid hinge adjustment when adjusting the boot lid.

Removing and installing gas-filled strut



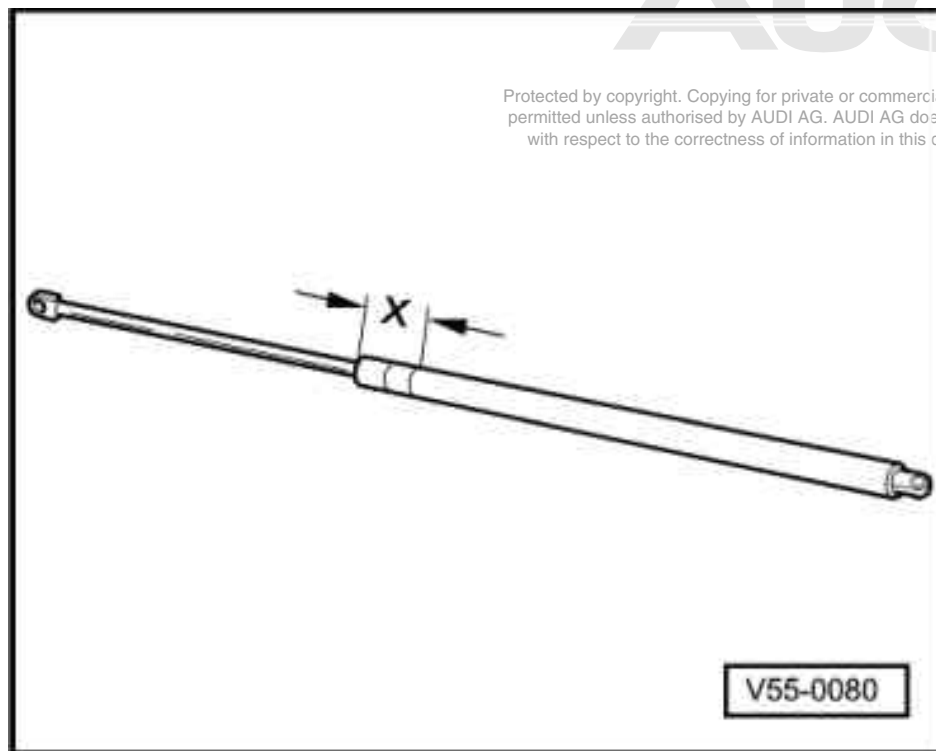
- -> Use screwdriver to slightly prise away spring catch -7- and unclip/clip in gas-filled strut.

Note:

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

Installation:

- Clip in gas-filled strut at bottom first, then at top.
- The tube end of strut goes towards boot lid.



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Releasing gas from gas-filled strut

- Clamp gas-filled strut in vice in area x = 50 mm.
- Saw open cylinder of gas-filled strut in first third of overall cylinder length, starting from reference edge on piston-rod end.

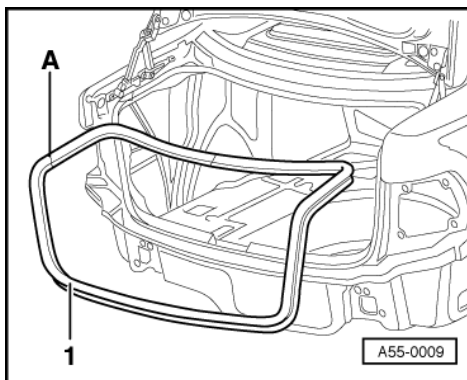
Important
Only clamp the strut in this area. Otherwise there is risk of accident.

Note:

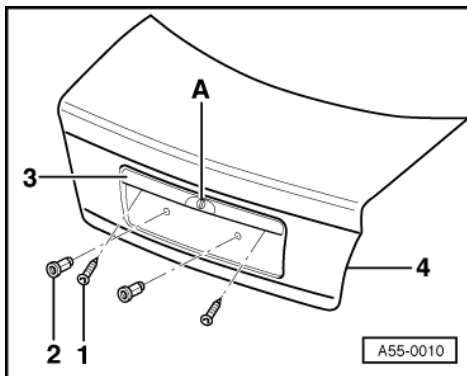
Goggles must be worn during sawing. It is also appropriate to cover the area around the saw-cut with a cloth to catch any escaping fluid.

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2.4 - Installing boot lid seal

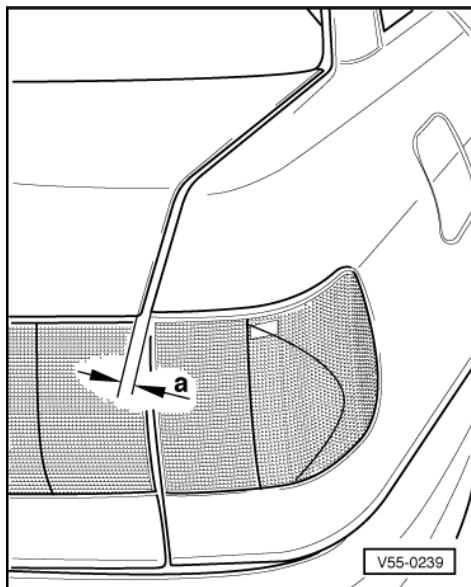


- -> The joint -item A- of the boot lid seal must be aligned with the ball socket of the left hinge.



Removing and installing grip panel for boot lid

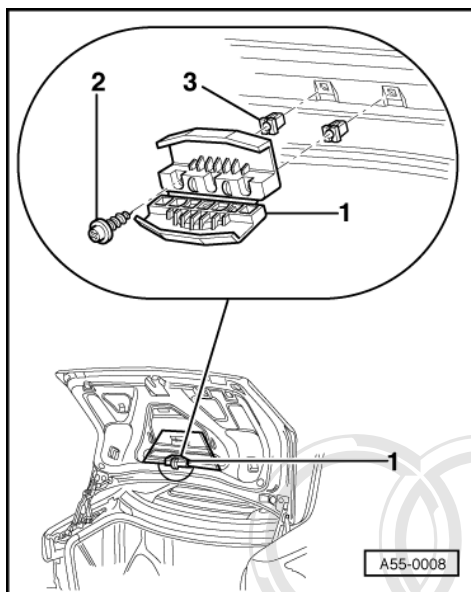
- -> Remove screws -1- (2x).
Tightening torque 2.5 Nm.
- Item -A; Unscrew nuts (2x) for lock cylinder on inside of boot lid.
Tightening torque 6 Nm.
- Pull out grip panel -3- until wiring for both number plate lights can be disconnected.



- Remove grip panel.
- Use special tool V.A.G 1618 A to fit threaded rivet nuts - 2- (2x).

Joint dimension

- $a = 3.0 \text{ mm}$

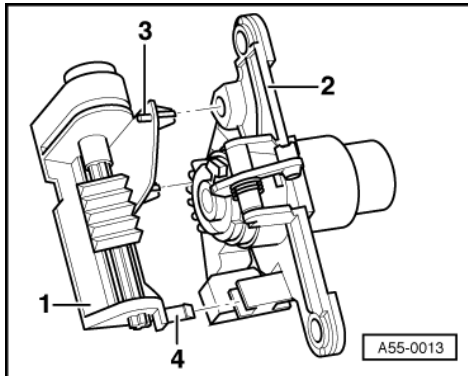


Removing and installing holder for warning triangle

- -> Take out warning triangle.
- Remove bolts -2- (2x).
Tightening torque 2 Nm.
- Holder -1-.
- Spreader clip -3- (2x).

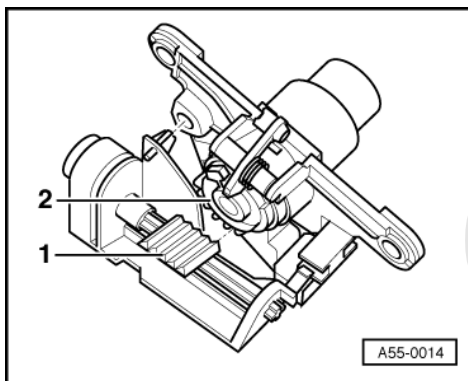
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2.5 - Removing and installing boot lid actuator



-> Removal:

- Remove lock cylinder => Page 30 .
- Press out retaining pins -3- (2x).
- Press back tab -4- and disengage.
- Prise out actuator -1-.

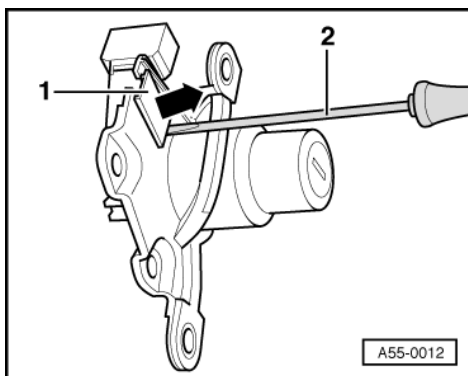


-> Installation:

- Set lock to open position.
- Press rack -1- to left. First tooth of rack -1- must engage in first tooth row of toothed segment -2-.

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2.6 - Removing microswitch for boot lid



- Remove lock cylinder => Page 30 .

- -> Disengage microswitch -1- in direction of arrow and carefully press out with screwdriver.

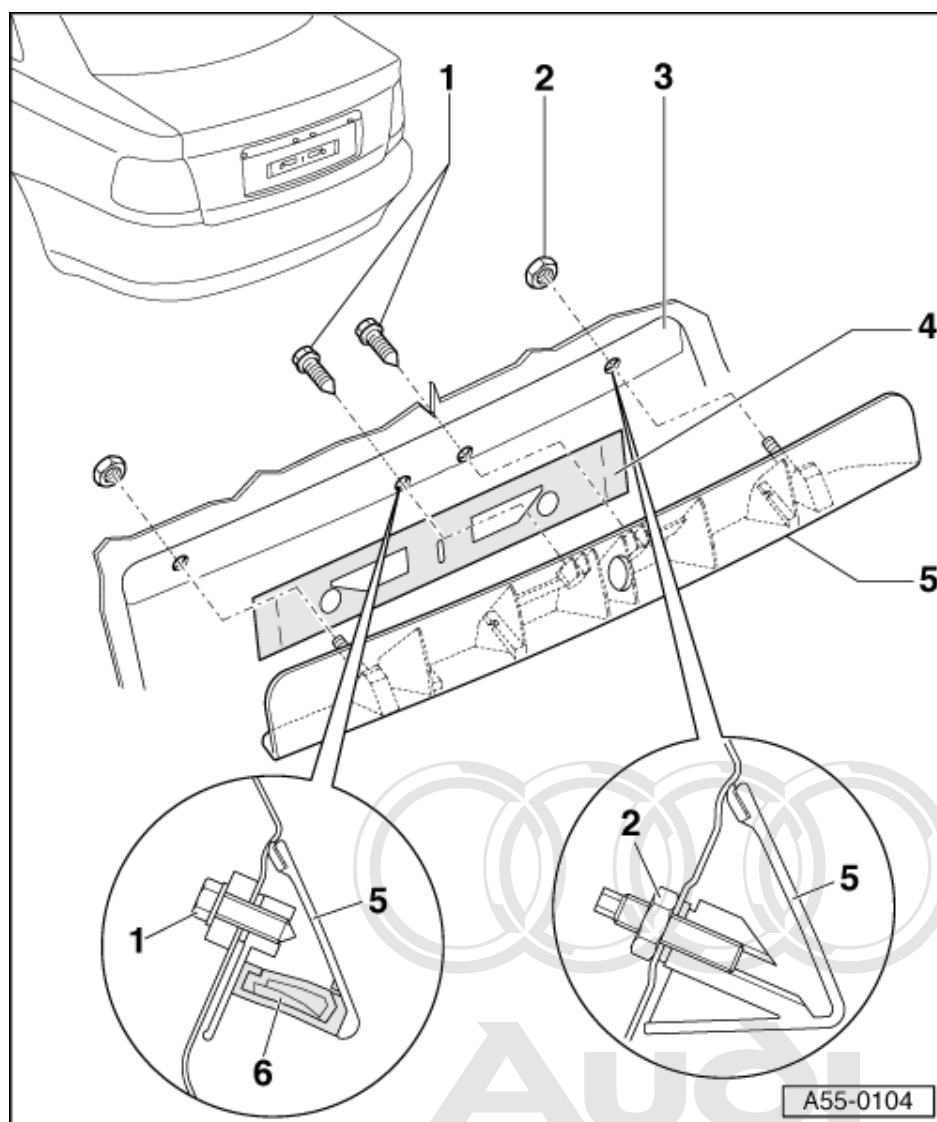
Note:

Lock cylinder cannot be switched to overall locking with workshop equipment.

To achieve one key operation, the lock cylinder must be ordered on the basis of the lock number.

3 - Boot lid 8D XA 200 001>

3.1 - Boot lid 8D XA 200 001>



Note:

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Only the steps that are different will be described; the other steps are performed as before.

3.2 - Removing and installing grip panel

12 Hexagon bolt

- ♦ 8 Nm

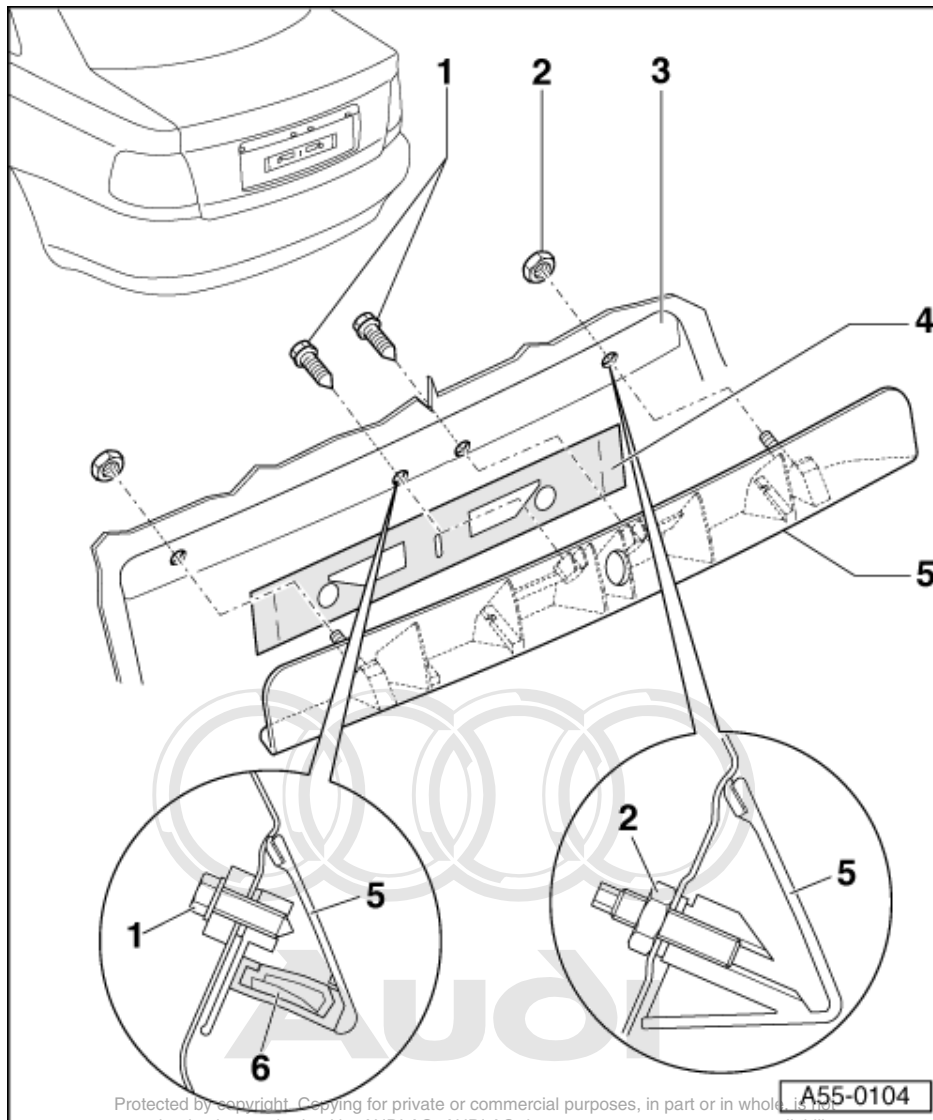
13 Hexagon nut

- ◆ 8 Nm

14 Boot lid

15 Gasket

- Unscrew the hexagon bolts -1- and the hexagon nuts -3-.



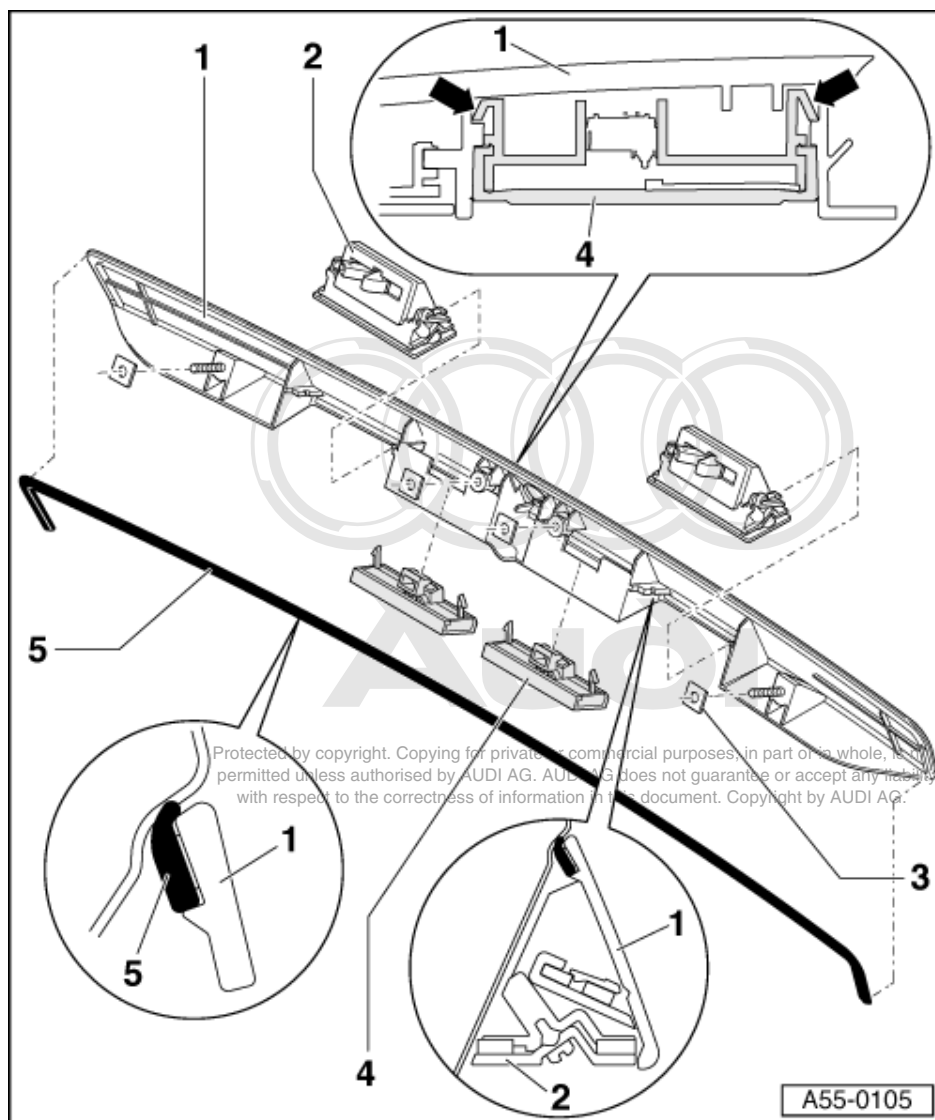
16 Grip panel

- ◆ Removal:
- Before removal, remove boot lid interior trim.

=> General Body Assembly, Interior; Repair group 70

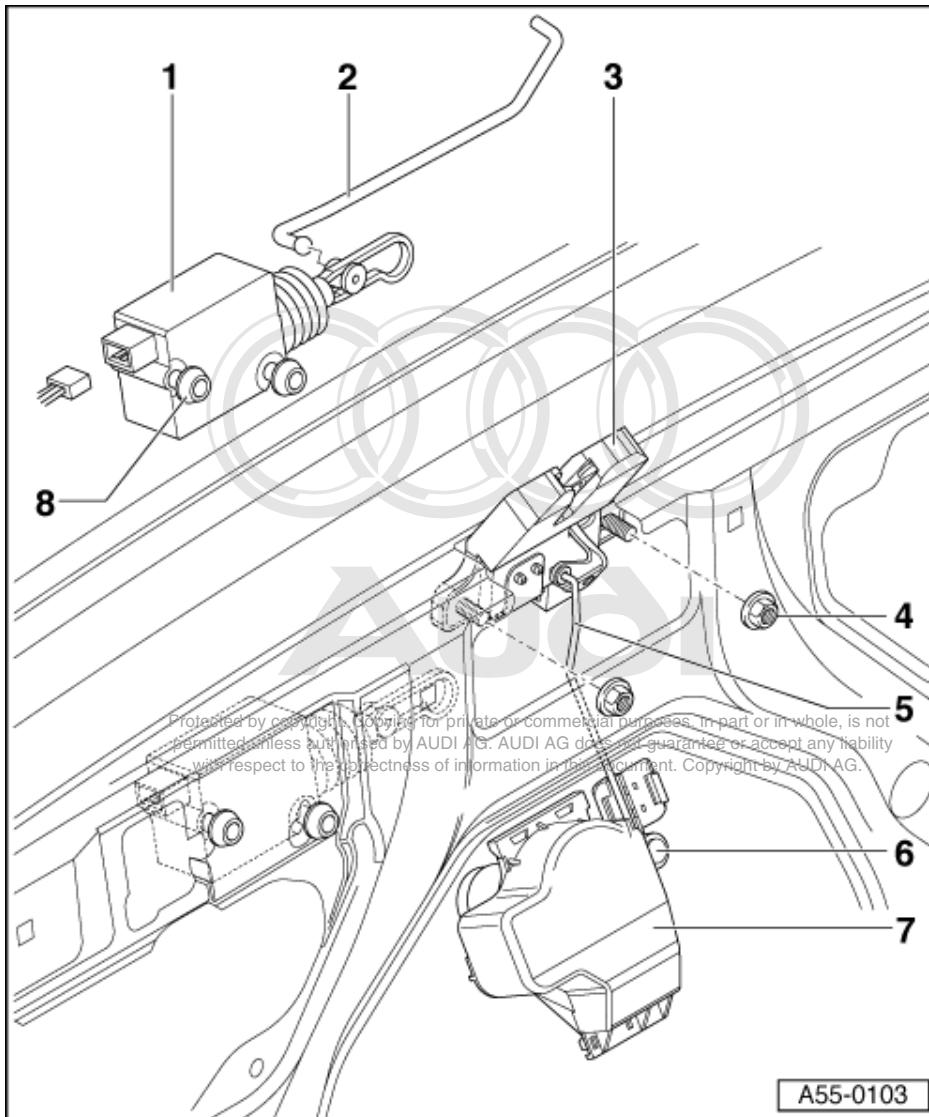
- Disconnect the electrical connectors for the number plate light and boot lid release switch.
- Remove the locking system from the boot lid from inside the luggage compartment.
- Pull the grip panel out of the boot lid.
- ◆ Installation:
- First tighten the two hexagon nuts -2- to 8 Nm.
- Then secure the locking system with the hexagon bolts -1- and tighten the bolts to 8 Nm.
- Reconnect electrical wiring.

3.3 - Installing and removing boot lid release mechanism microswitch



- 1 Grip panel
- 2 Number plate light
- 3 Sealing washer
- 4 Boot lid release mechanism microswitch
 - ◆ Detach electrical connectors.
 - ◆ Grip panel removed.
 - ◆ Release catch -arrows- and remove microswitch.
- 5 Gasket
 - ◆ Surface to be bonded must be clean and free from grease.
 - ◆ Detach self-adhesive protective strip before mounting and press on seal in the centre.

3.4 - Removing and installing boot lid lock



1 Boot lid release actuator

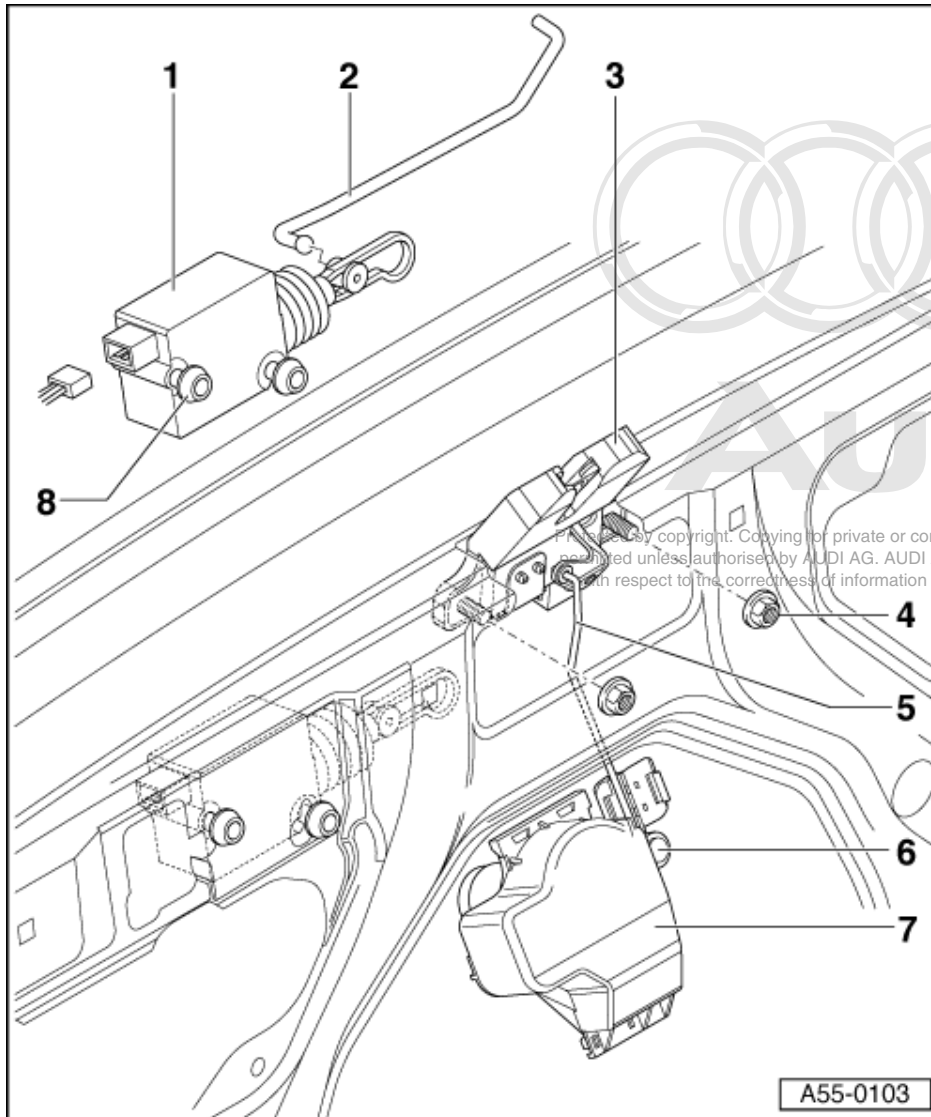
- ◆ Before removal first detach operating rod -2- from boot lid lock => Fig. 6 .
- Detach connector.
- ◆ Unscrew Torx bolts -8-.

2 Operating rod

- ◆ Attaching and detaching in boot lid lock => Fig. 6 .

3 Boot lid lock

- ◆ Removing
- Detach the operating rod -2- and the connecting rod -5- from the boot lid lock.
- Detach connector.
- Unscrew the hexagon nuts -4- and remove the boot lid lock.



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- 4 Hexagon nut**
 - ◆ 8 Nm
- 5 Connecting rod**
 - ◆ Clipping in and unclipping boot lid lock => Fig. 6
- 6 Hexagon nut**
 - ◆ 8 Nm
- 7 Locking system**
 - ◆ Removing => Page 43 .
- 8 Torx bolt**
 - ◆ 2.5 Nm

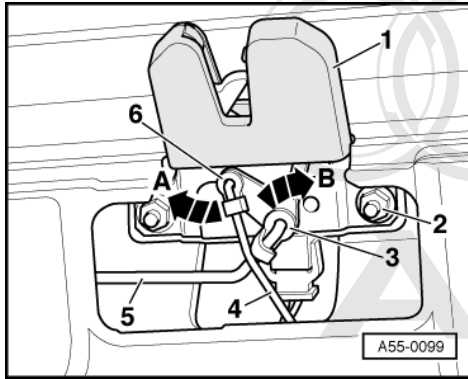
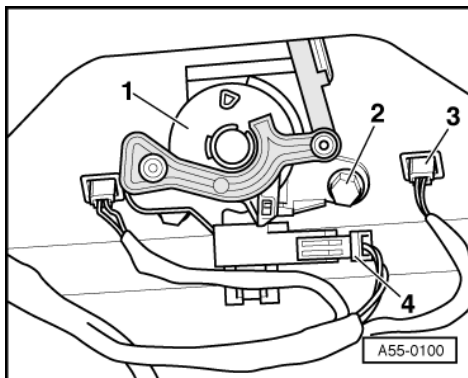


Fig.6-> Detaching and attaching operating rod and connecting rod

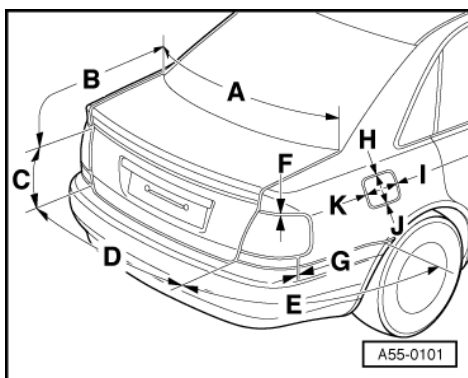
- Pivot hinged lever -6- in the direction of the arrow -A- and remove connecting rod -4-.
- Pivot the hinged lever -3- in the direction of the arrow -B- and remove operating rod -5-.
- To remove the boot lid lock -1- unscrew the hexagon bolts -2-.

3.5 - Removing and installing locking system



- Boot lid interior trim removed.
- Connecting rod detached from the boot lid lock.
- -> Unplug the connectors -3- from the microswitch and -4- from the locking system.
- Unscrew the hexagon bolts -2- and remove the locking system -1- from the boot lid.

3.6 - Boot lid joint dimensions

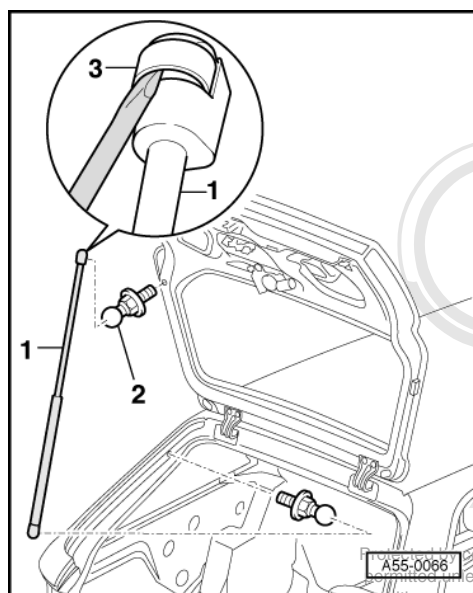


Letter	Clear joint width (mm)	Parallelism (mm)
A	4.7 +1.5	
B	2.9 +1	1
C	3.3 +1	
D	4.9 +1	1
E	3.5 +1	0.5
F	2.5 +0.5	0.5
G	1.5 +0.5	0.2
H	2.5±0.1	
I	3.3±0.1	
J	3.3±0.2	
K	3.0±0.4	

4 - Avant tailgate >8D XA 200 000

4.1 - Avant tailgate >8D XA 200 000

4.2 - Removing and installing tailgate



- Remove tailgate interior trim.

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

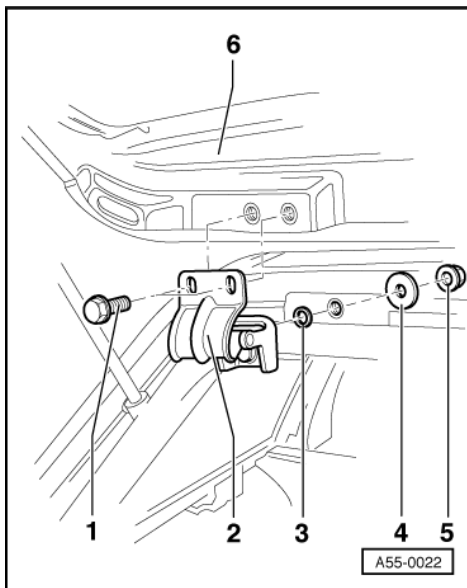
- Detach/unplug electrical connectors, hose for central locking system and hose for rear window washer system.
- Open and support the tailgate.
- -> Use screwdriver to prise away spring catch -3- as shown and detach gas-filled strut -1- from ball stud -2- at top.

Note:

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

Damping element must be attached on body end.

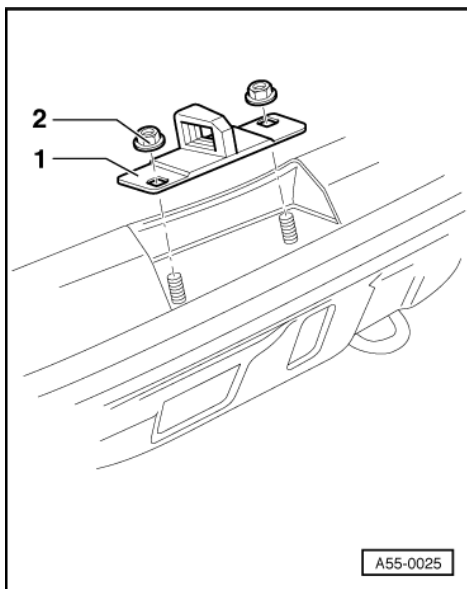
- To install, press gas-filled strut onto ball stud.
- Tightening torque for ball stud: 15 Nm-1 Nm.



- -> Unscrew hexagon bolt -1- (2*) from rear of tailgate -6-.
- Tightening torque on installation 21 Nm.

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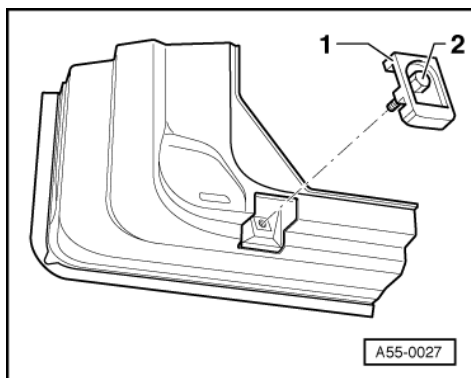
4.3 - Adjusting tailgate



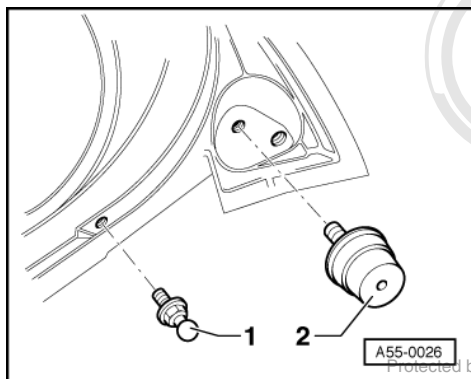
Note:

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

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



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

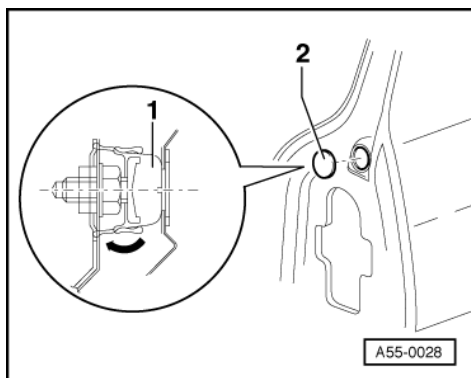


- -> Screw home upper adjusting stop -2-.
- Close tailgate and bring into alignment; rear lock and striker plate must engage.
- Open tailgate and tighten striker plate securing nuts to 8 Nm.
- Apply plasticine compound to upper adjuster.
- Close tailgate and open it again.
- Then check thickness of plasticine and loosen adjusting buffer accordingly.
- Now screw out adjuster a further 1.5 to 2 turns.

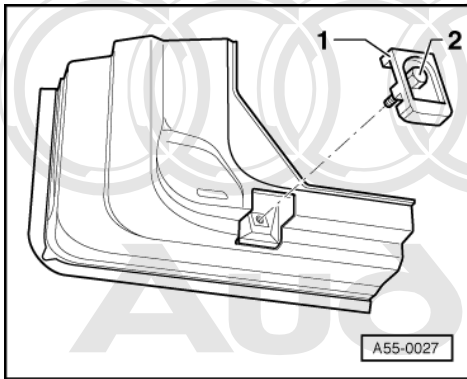
Note:

2 turns are equal to a pretension of 2.5 mm and correspond at gap -C- =>Page 50 to a shift in axial direction of 0.8 mm.

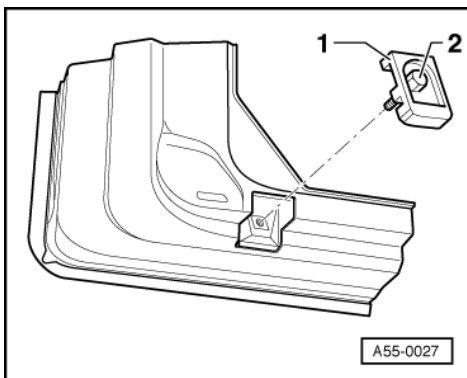
- Check overall visual impression on the basis of joint dimension table and ease of closing.



- -> Tighten upper adjuster -1- with lock nut to 21 Nm.
- Press sleeve at upper adjuster in direction of tailgate surface -arrow-.
- Protective foil -2-.



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- > Loosen hexagon bolt -2- and pull out lower adjuster -1- slightly.
 - Loosely fasten hexagon bolt -2- and close tailgate.
 - Use feeler gauge to set adjusting stop -1- from inside so that distance from rear cross panel trim is 1 mm.



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

- -> Open tailgate and tighten hexagon bolt -2- of lower adjuster to 8 Nm.
- Check joint dimensions with regard to correct alignment and joint positions => Page 50 .

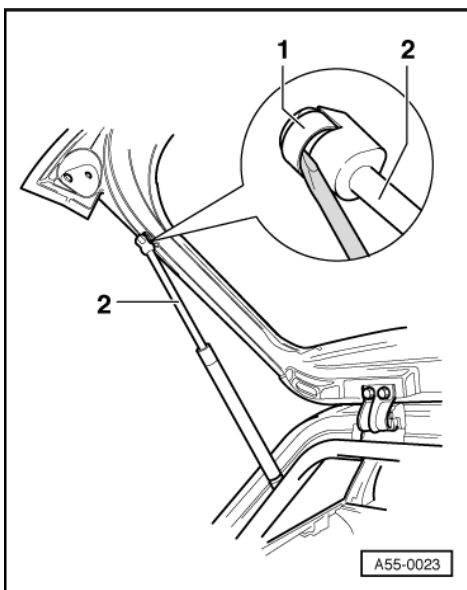




Fig.1-> Removing and installing gas filled strut.

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

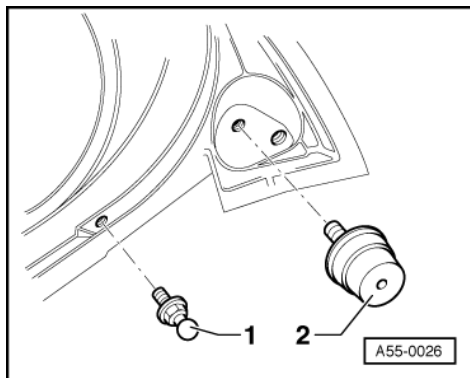
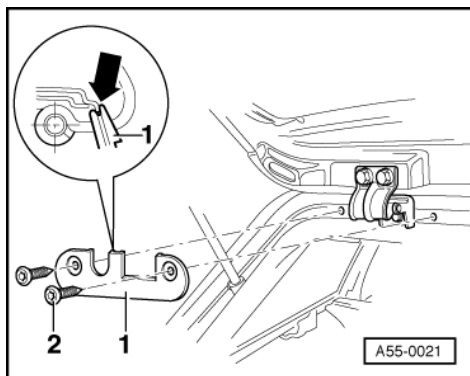


Fig.2 Removing and installing ball stud

- Unscrew ball stud -1- and remove with seal.
- On installation, tighten ball stud to 14 Nm.

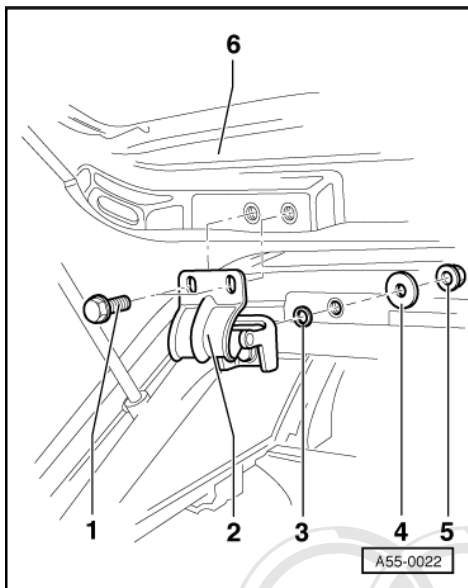


4.4 - Removing and installing tailgate hinge



- -> Unscrew self-tapping screws -2- and remove cover -1-.
- On installation, position cover -1- in top of roof flange using notches -arrow- and tighten screws -2- to 2.5 Nm.

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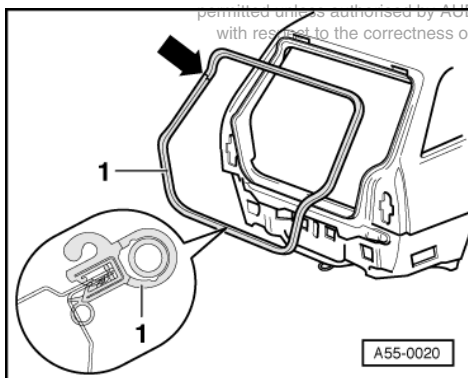
- -> Dismantle rear roof frame trim.

=> General Body Assembly; Repair group 70

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

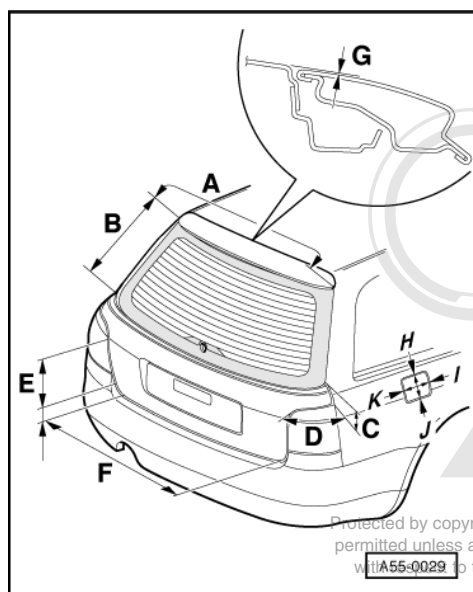
4.5 - Removing and installing tailgate seal

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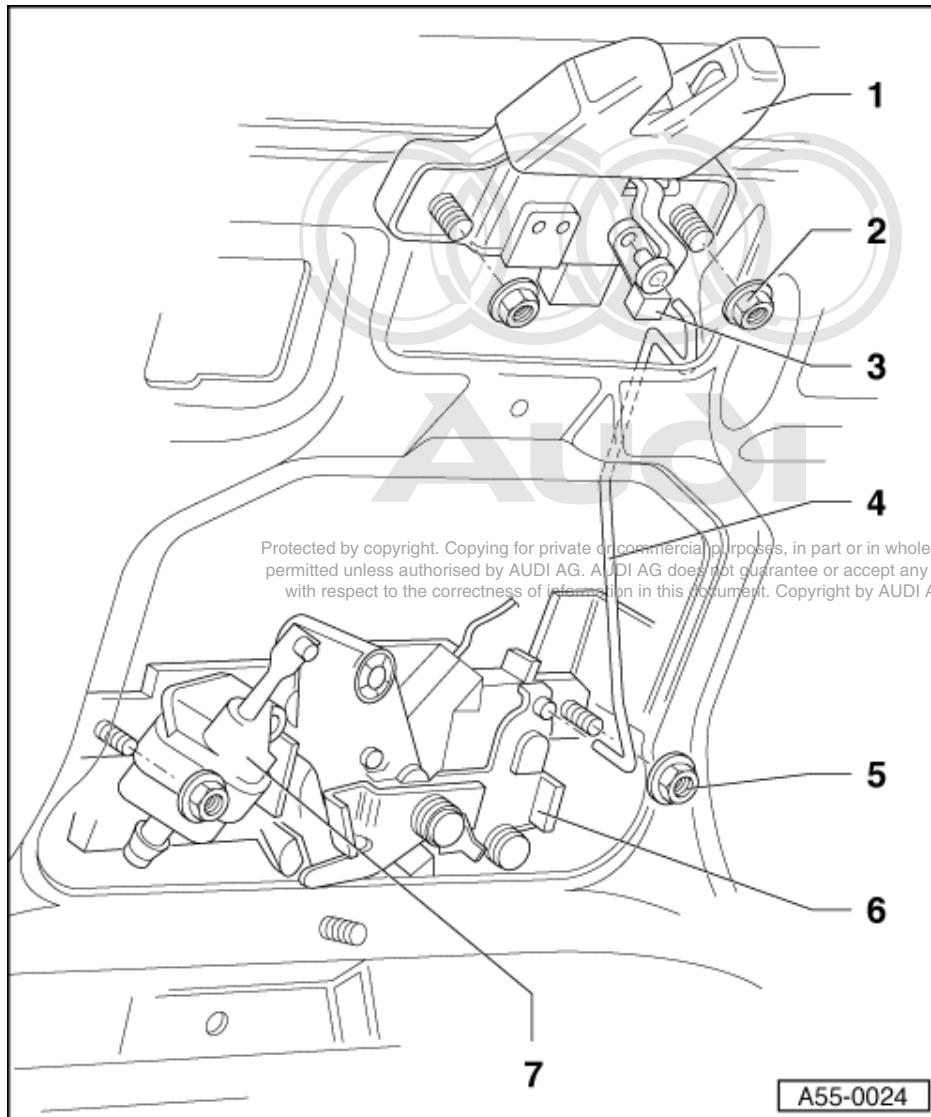
- -> Open tailgate and remove seal.
- On installation, vulcanised joint -arrow- of seal must be on a level with ball stud on body end.
- Press seal -1- onto body as shown.

4.6 - Tailgate joint dimensions



Letter	Clear joint width (mm)	Parallelism (mm)
A	4.0 +1	0.5
B	5.0 +1	1
C	4.0 +1	0.5
D	3.4 +1	0.5
E	3.4 +1	0.5
F	5.0 +1	
G	1.0	
H	2.5±0.1	
I	3.3±0.1	
J	3.3±0.2	
K	3.0±0.4	

4.7 - Removing and installing tailgate lock



1 Tailgate lock

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

2 Hexagon nut

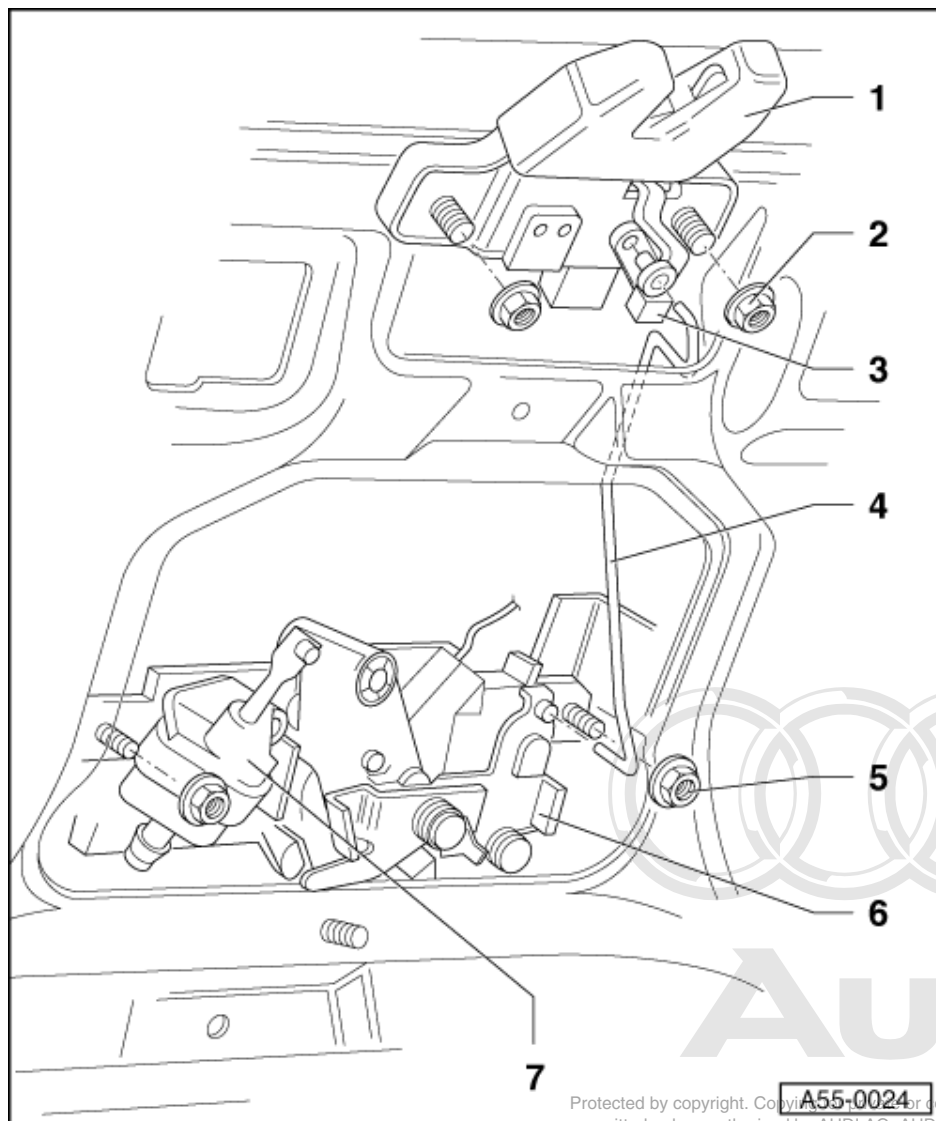
- ♦ 8 Nm.

3 Lever

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

4 Connecting rod

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



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5 Hexagon nut

- ♦ 8 Nm

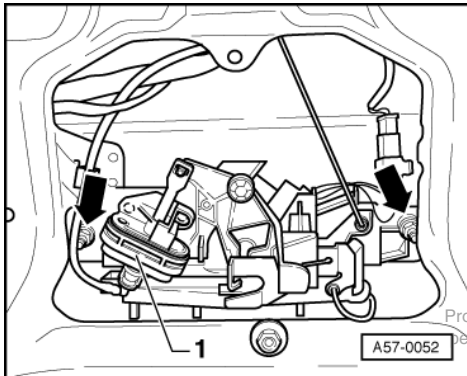
6 Locking system

- ♦ Removal => Page 53 .

7 Tailgate lock actuator

- ♦ Removal => Page 53 .

4.8 - Removing and installing locking system

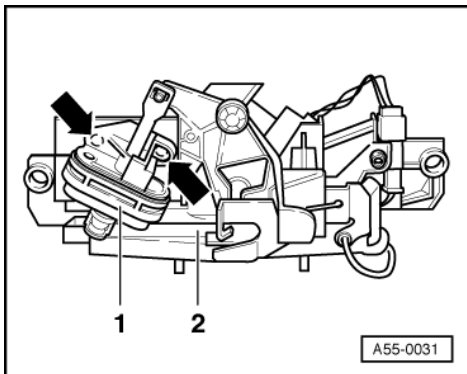


- -> Remove tailgate interior trim.

=> General Body Assembly; Repair group 70

- Unfasten catch at connector of vacuum line -1- and pull off actuator -2-.
- Unclip operating rod -3-.
- Unfasten catches at flaps and pulling out downwards =>Page 57 .
- Unscrew hexagon nuts -arrows- and remove locking system from tailgate.
- Tighten the hexagon nuts to 8 Nm.

4.9 - Removing and installing actuator

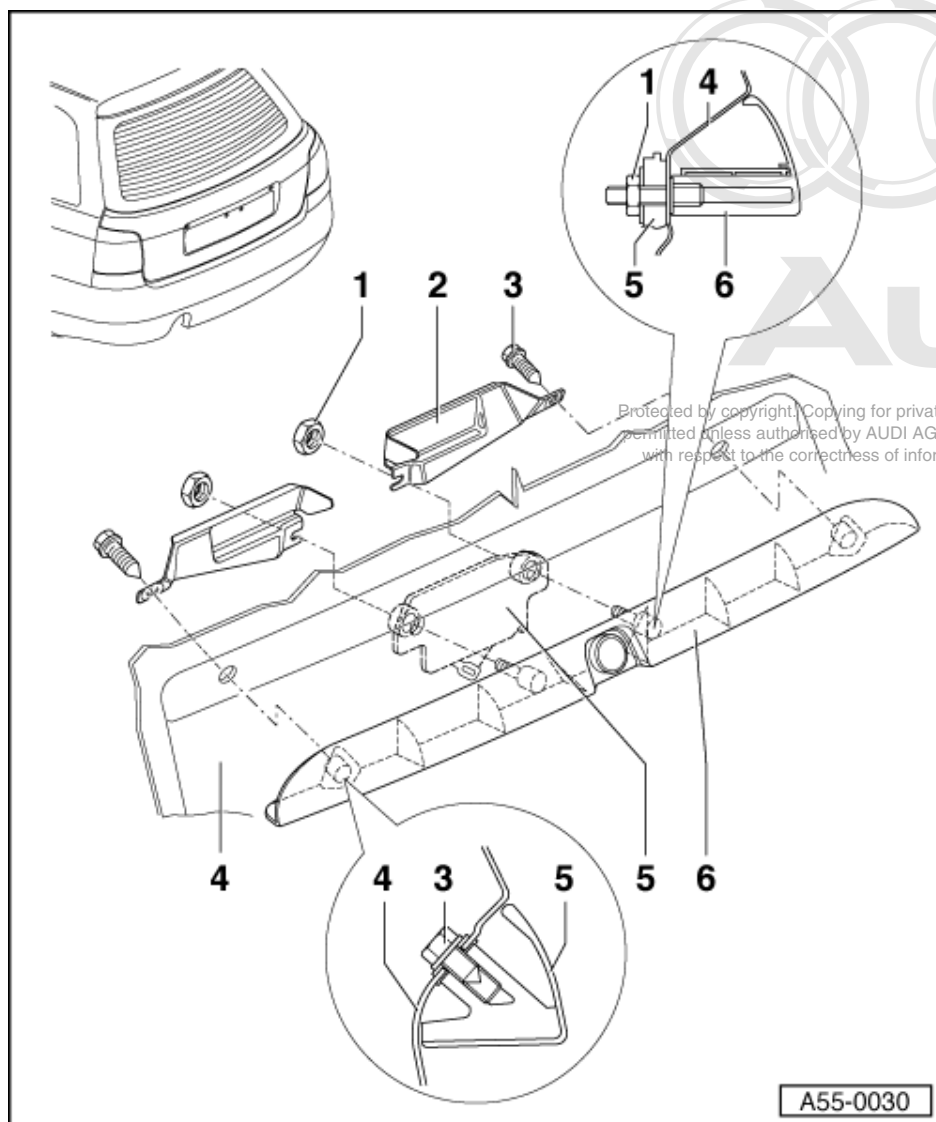


- -> Push out securing pins -arrow- and remove actuator -1- from lock -2-.
- On installation, clamping pins must be pressed back into expanding clips.
- Lever out with screwdriver if necessary.

Note:

The illustration shows the component already removed.

4.10 - Removing and installing grip panel

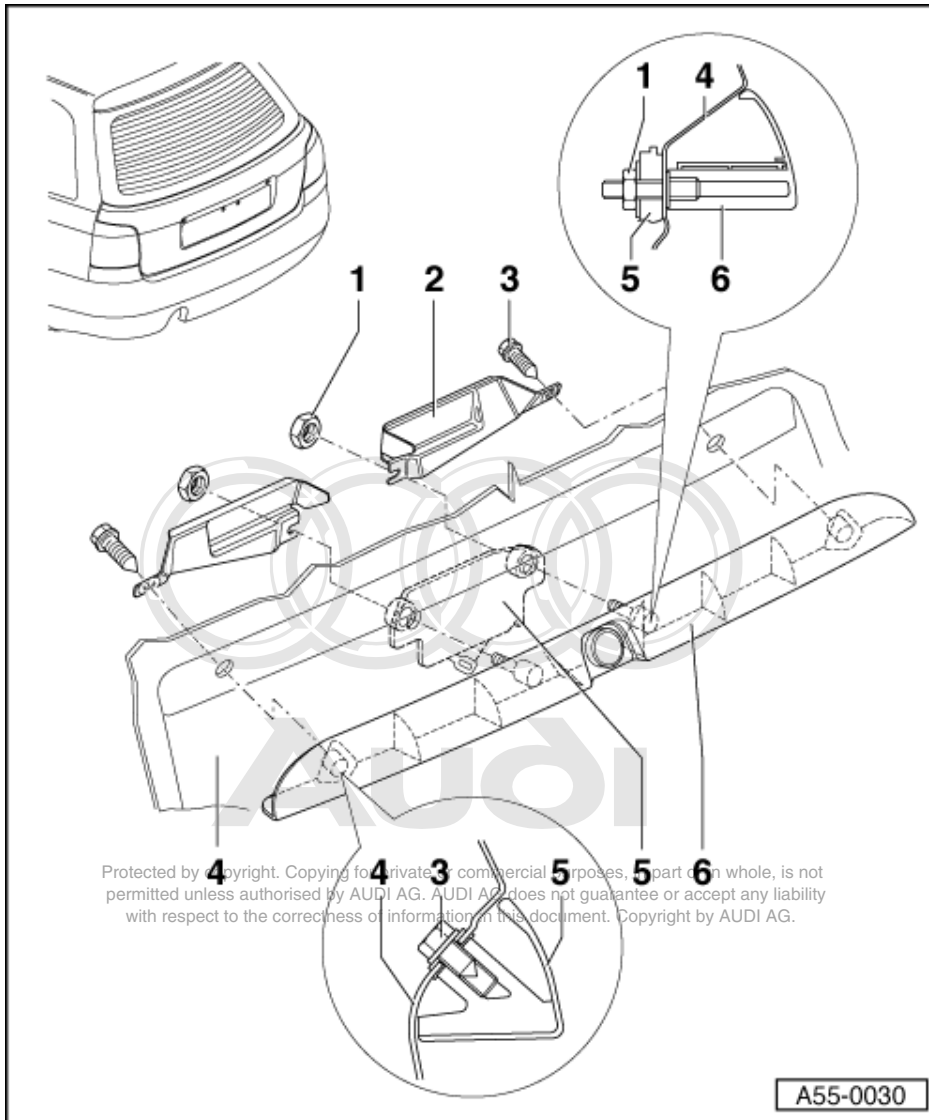


- 1 Hexagon nut**
 - ◆ 8 Nm
- 2 Bracket**
 - ◆ To remove unscrew hexagon nuts -1- and bolts -3-.

Note:

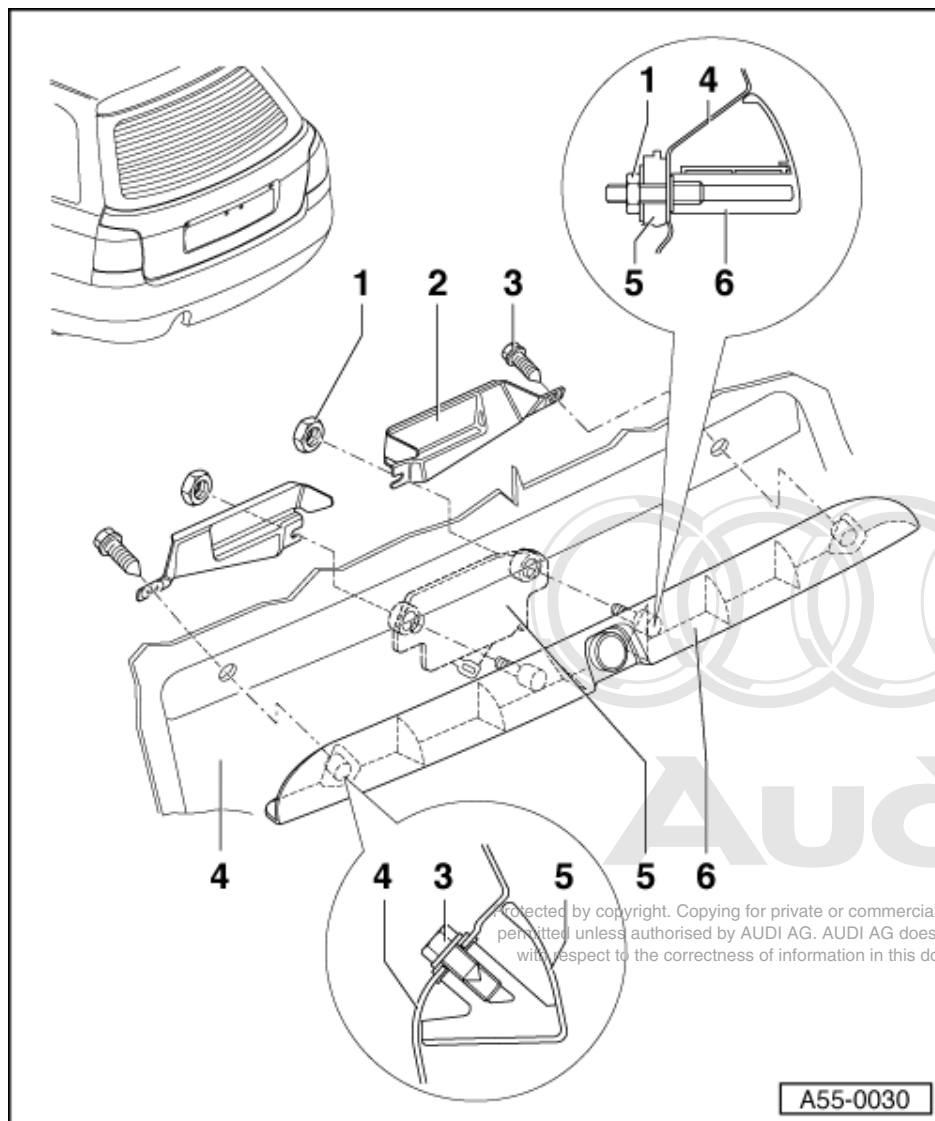
Component was discontinued shortly after start of series production.

- 3 Hexagon bolt**
 - ◆ 8 Nm
- 4 Tailgate**
 - ◆ Removing and installing
=>Page 44 .



5 Locking system

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



6 Grip panel

- ◆ Before removing, take off tailgate interior trim.

=> General Body Assembly; Repair group 70

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

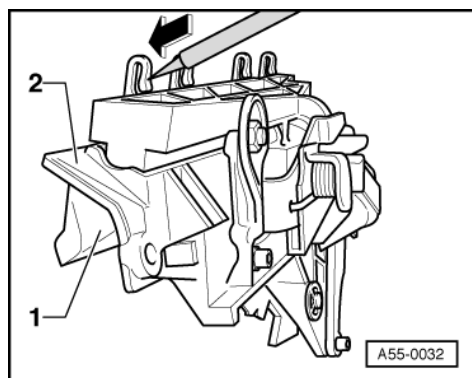
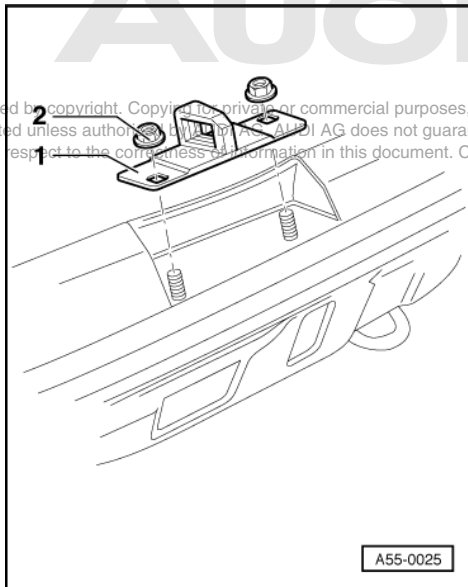


Fig.1 -> Removing and installing locking system

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

4.11 - Removing, installing and adjusting striker

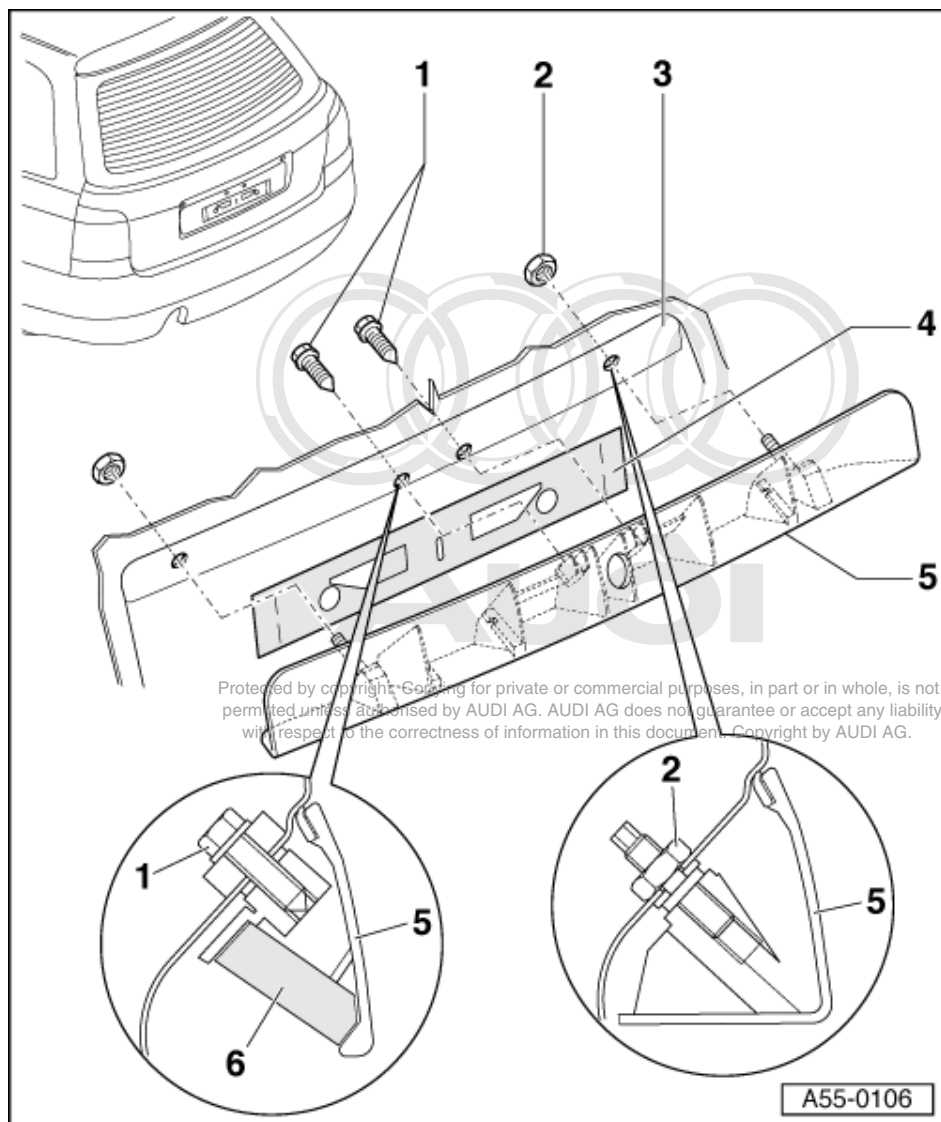
- Before removing striker, mark position with soft pencil.



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

5 - Avant tailgate >8D XA 200 000

5.1 - Avant tailgate >8D XA 200 000



Note:

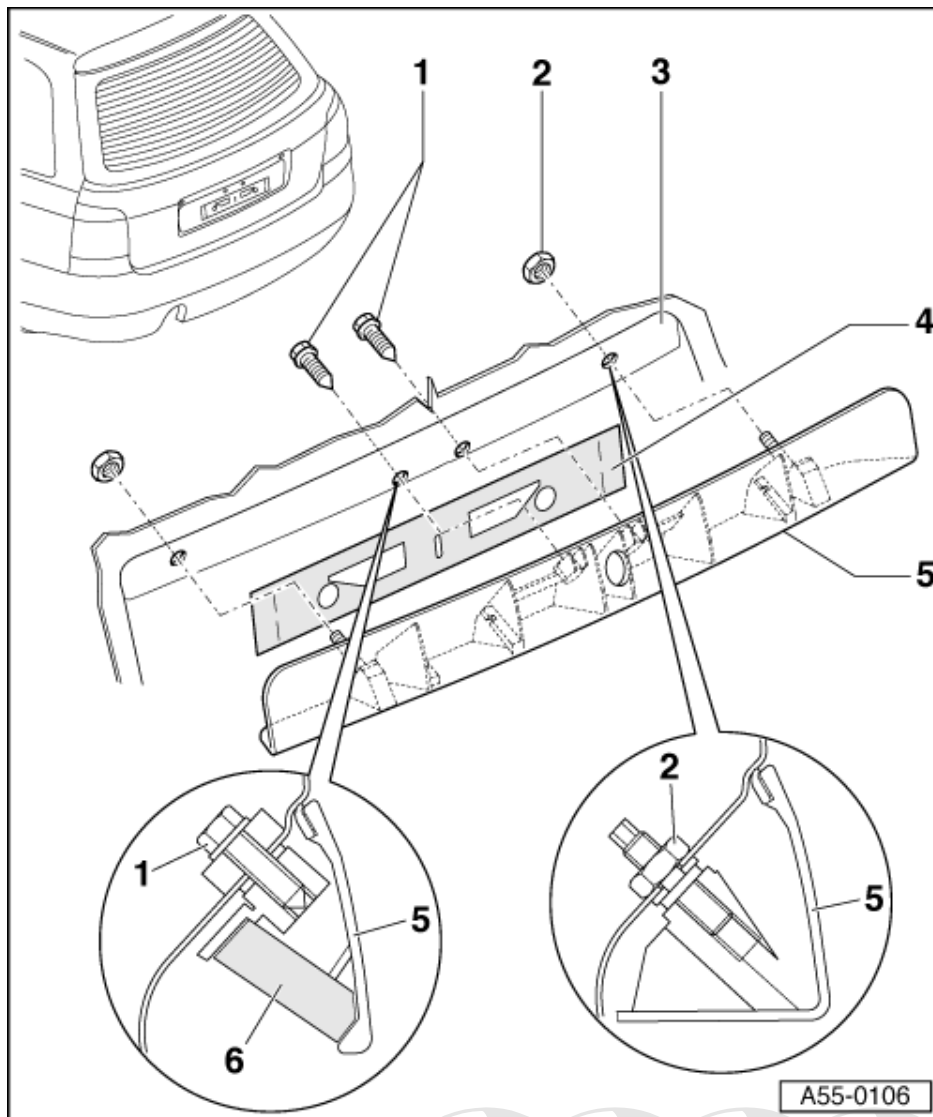
Only the steps that are different will be described; the other steps are performed as before.

5.2 - Removing and installing grip panel

- 1 Hexagon bolt
 - ♦ 8 Nm
- 2 Hexagon nut
 - ♦ 8 Nm
- 3 Tailgate
- 4 Gasket
- 5 Grip panel
 - ♦ Removal:

- Before removal, remove tailgate interior trim.

=> General Body Assembly, Interior; Repair group 70



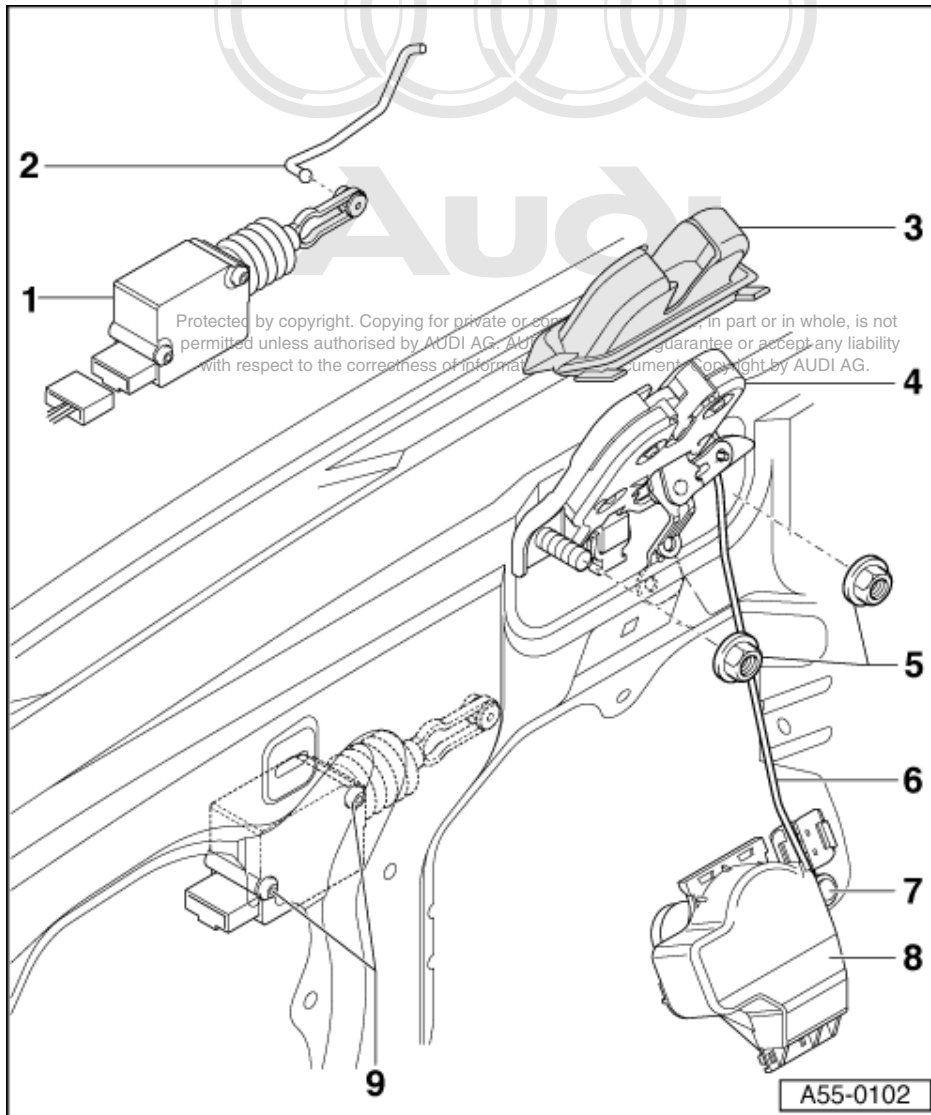
- Disconnect the electrical connectors for the number plate light and tailgate release switch.
- Unscrew the hexagon bolts -1- and the hexagon nuts -3-.
- Remove the locking system from inside the luggage compartment.
- Pull the grip panel out of the tailgate.
- ◆ Installation:
- Position the grip panel through the holes in the tailgate.
- First tighten the two hexagon nuts -2- to 8 Nm.
- Then secure the locking system with the hexagon bolts -1- and tighten the bolts to 8 Nm.

6 Tailgate release microswitch

- ◆ Removing => Page 40

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5.3 - Removing and installing tailgate lock



1 Tailgate release actuator

- ◆ Before removal first detach operating rod -2- from tailgate lock => Fig. 1 .
- ◆ Unscrew Torx bolts -9- and remove actuator.

2 Operating rod

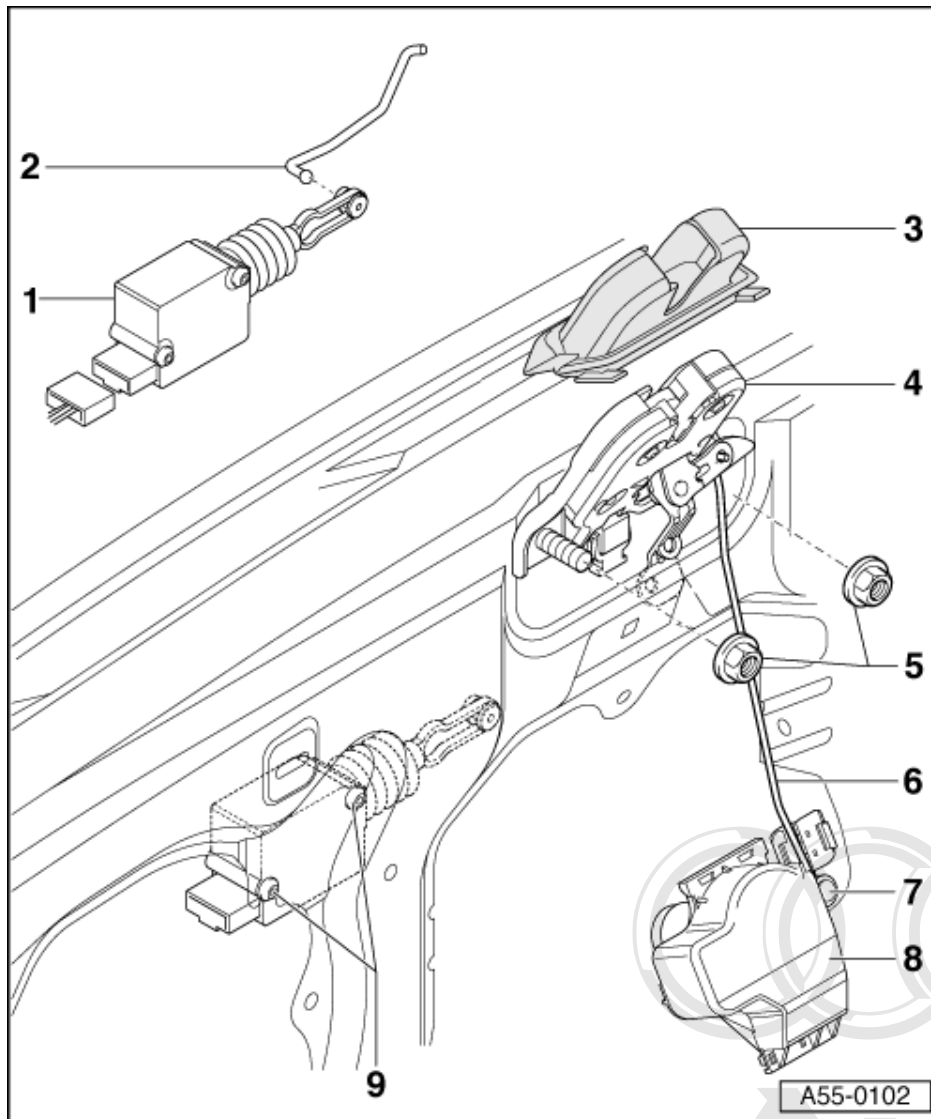
- ◆ Clipping in and unclipping tailgate lock => Fig. 1 .

3 Trim cap

- ◆ To remove from tailgate lock, unclip and disconnect => Page 63 .

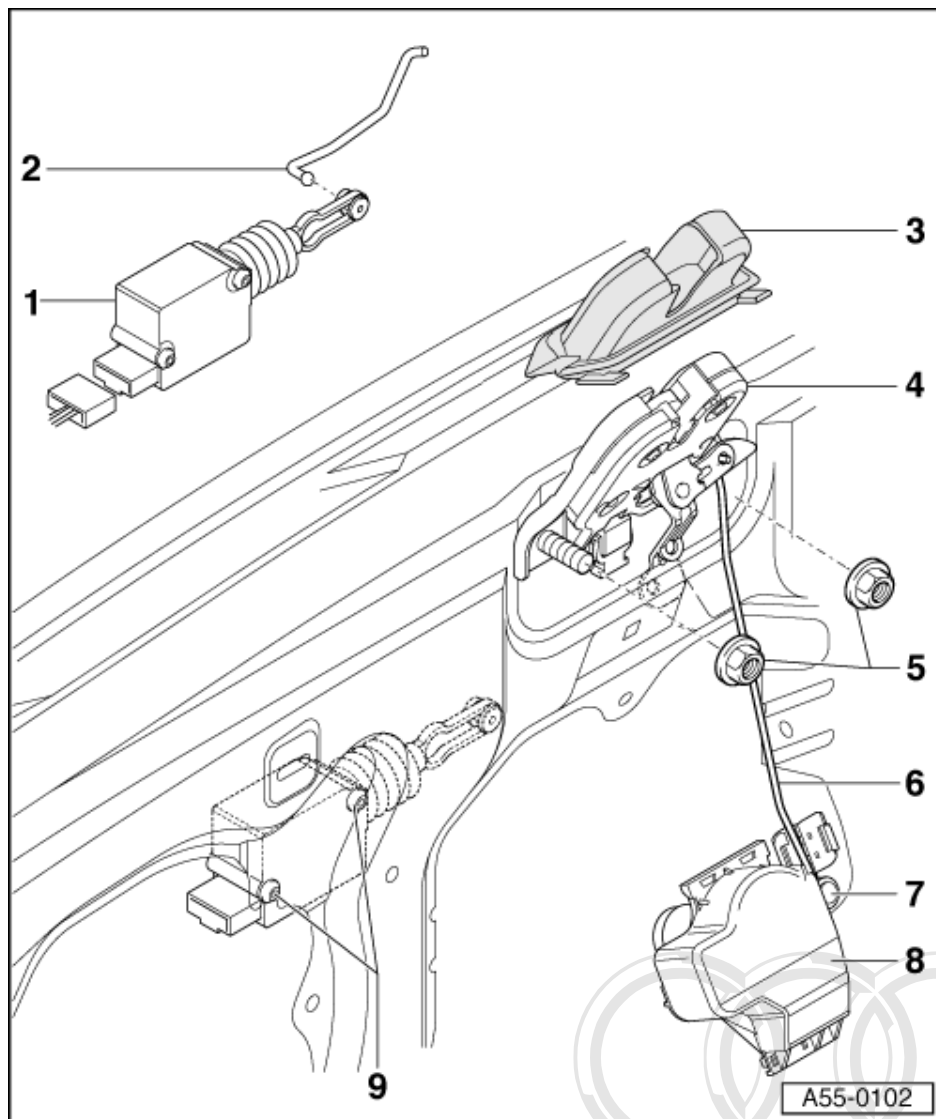
4 Tailgate lock

- ◆ Removal:
 - Detach the operating rod -2- and connecting rod -6- from the tailgate lock.
 - Unscrew the hexagon nuts -4- and remove the tailgate lock.



- Remove the locking system from the tailgate from inside the luggage compartment.
- Pull the grip panel out of the tailgate.
- ◆ Installation:
- First tighten the two hexagon nuts -2- to 8 Nm.
- Then secure the locking system with the hexagon bolts -1- and tighten the bolts to 8 Nm.

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- 5 Hexagon nut
 - ◆ 8 Nm
- 6 Connecting rod
 - ◆ Clipping in and unclipping tailgate lock => Fig. 1 .
- 7 Hexagon nut
 - ◆ 8 Nm
- 8 Locking system
 - ◆ Removing => Page 64
- 9 Torx bolt
 - ◆ 2.5 Nm

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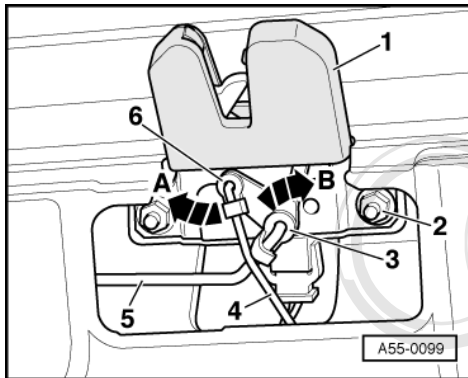


Fig.1-> Detaching and attaching operating rod and connecting rod

- Pivot hinged lever -6- in the direction of the arrow -A- and remove connecting rod -4-.
- Pivot the hinged lever -3- in the direction of the arrow -B- and remove operating rod -5-.
- To remove the tailgate lock -1- unscrew the hexagon nuts -2-.

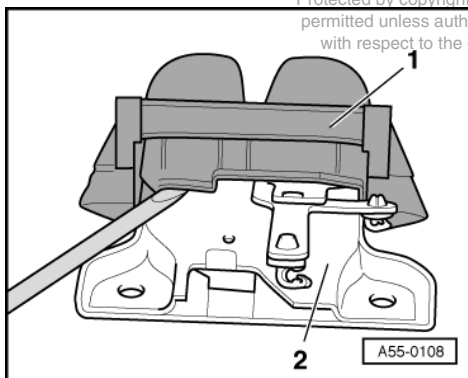


Fig.2 -> Removing tailgate lock trim cap

Note:

For ease of illustration, the part is shown removed.

- Before removing the trim cap, you must remove the tailgate interior trim.
- For removal release the catches-arrows- using a screwdriver and remove trim cap.

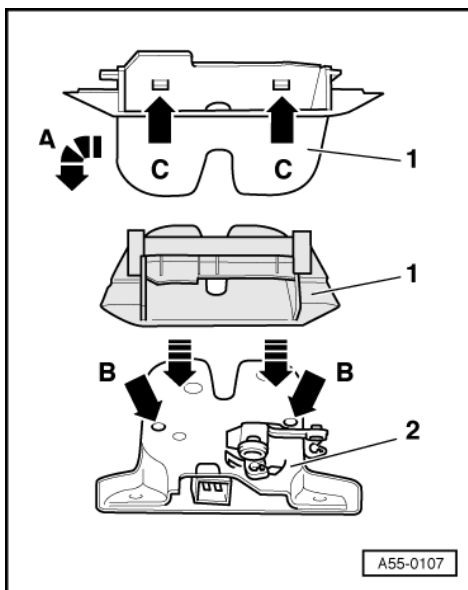
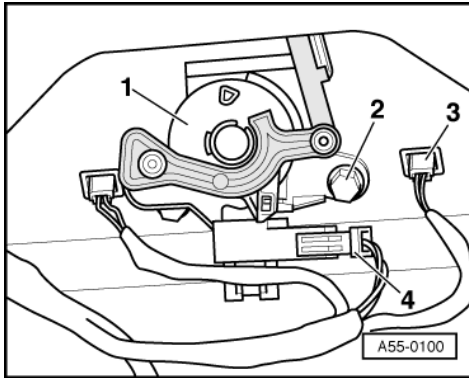


Fig.3 -> Fitting tailgate lock trim cap

- Tilt trim cap in direction of arrow -A- by 90°.
- Push the trim cap -1- onto the tailgate lock -2-, until the retaining lugs -arrows C- on both sides latch fully in the holes -arrows B-.
- Perform a functional check for the correct locking of the tailgate.

5.4 - Removing and installing locking system



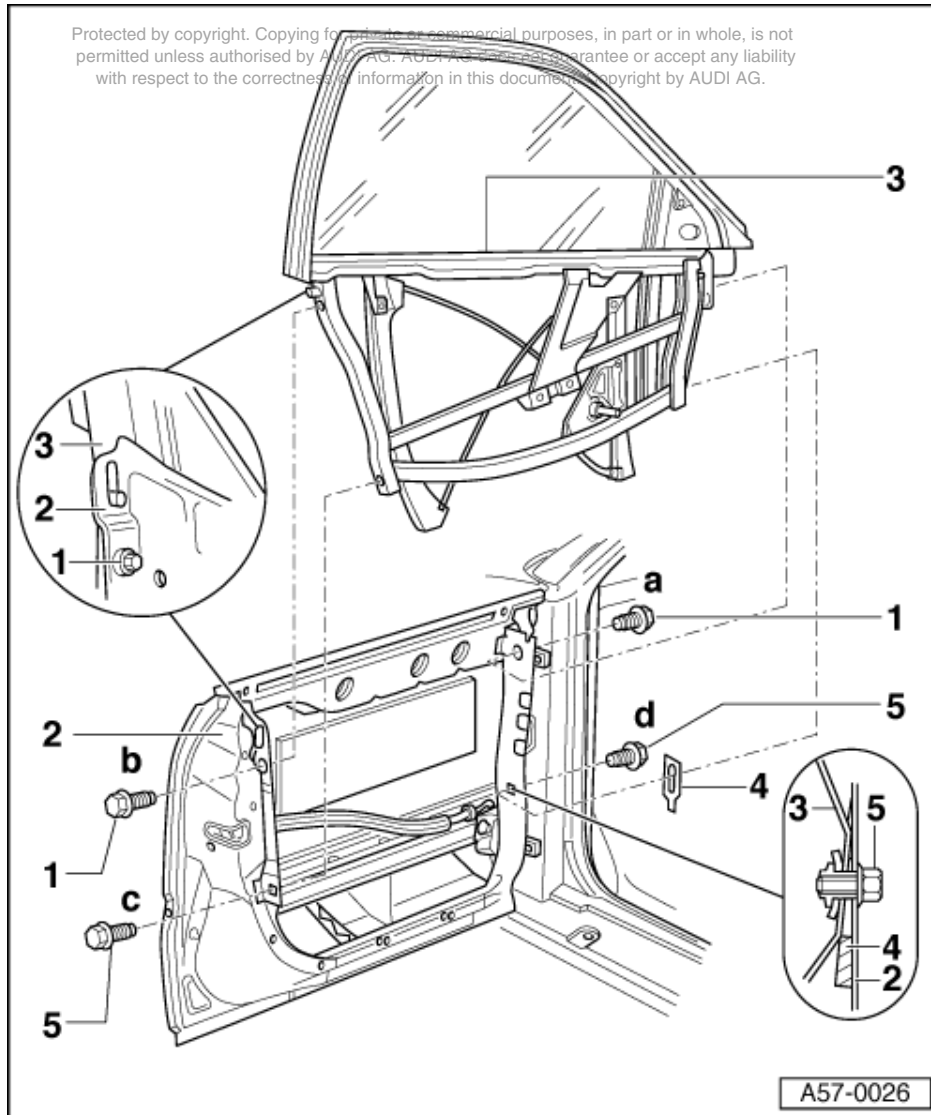
- Tailgate interior trim removed.
- Connecting rod detached from the tailgate lock.
- -> Unplug the connectors -3- from the microswitch and -4- from the locking system.
- Unscrew the hexagon bolts -2- and remove the locking system -1- from the tailgate.

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57 - Front doors/Door components/Central locking system

1 - Removing and installing door shell and door component carrier

1.1 - Removing and installing door shell and door component carrier



- 1 Hexagon bolt (2x)
 - ♦ Tightening torque 30 Nm.
- 2 Door shell

Note:

The door shell can also be removed without dismantling door component carrier.

- ♦ Removal:
 - Removing door trim.

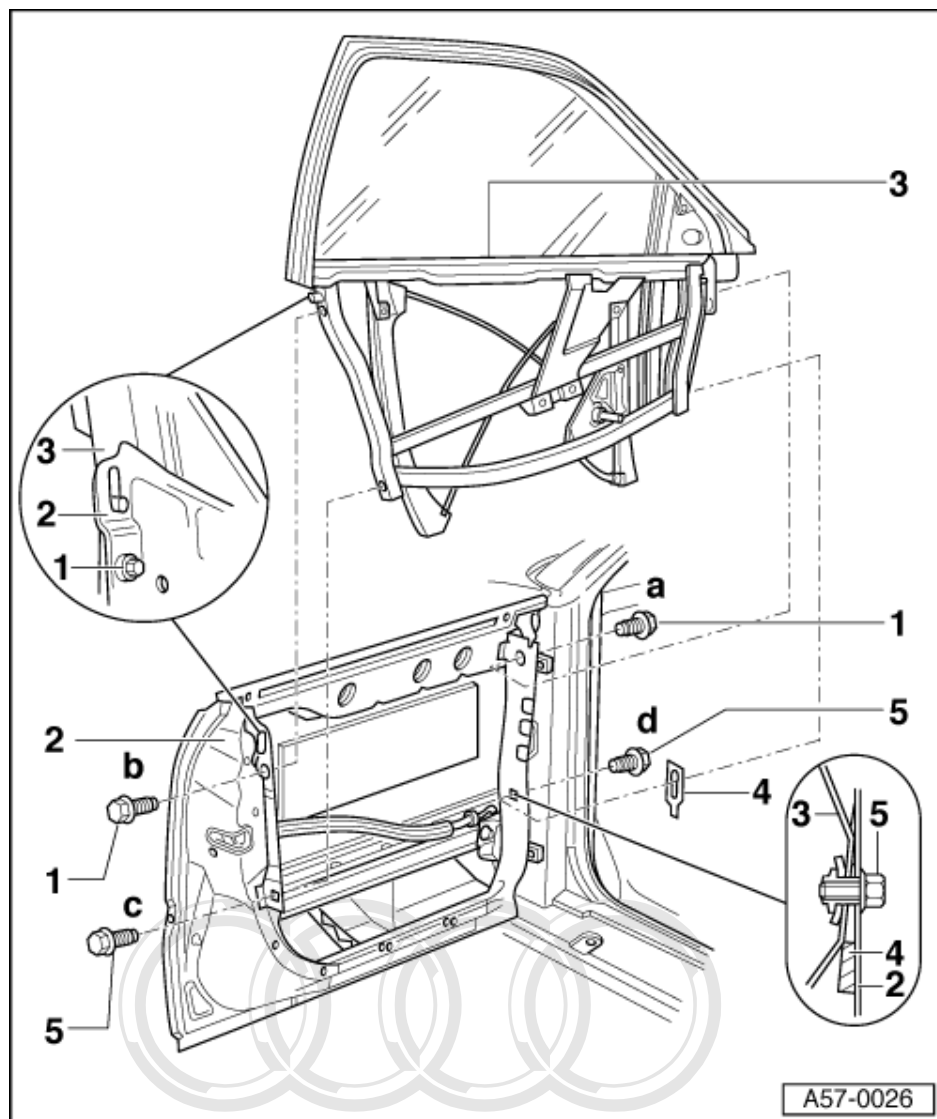
=> General Body Assembly; Repair group 70; Door trims Door trims



- Remove A-pillar trim at bottom .

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

- Disconnect electrical connectors from A-pillar connector point.
- Unclip bellows between door shell and A-pillar and pull both electrical wiring and central locking system hoses out from A-pillar.



- Remove door component carrier -3- .
- Remove bolts -1- and -5-.
- Unscrew bolts for top door hinge =>Fig. 2 .
- Unscrew bolts for bottom door hinge =>Fig. 3 .

♦ Installation:

- Install in reverse order.

♦ Adjusting:

- Adjusting =>Page 98

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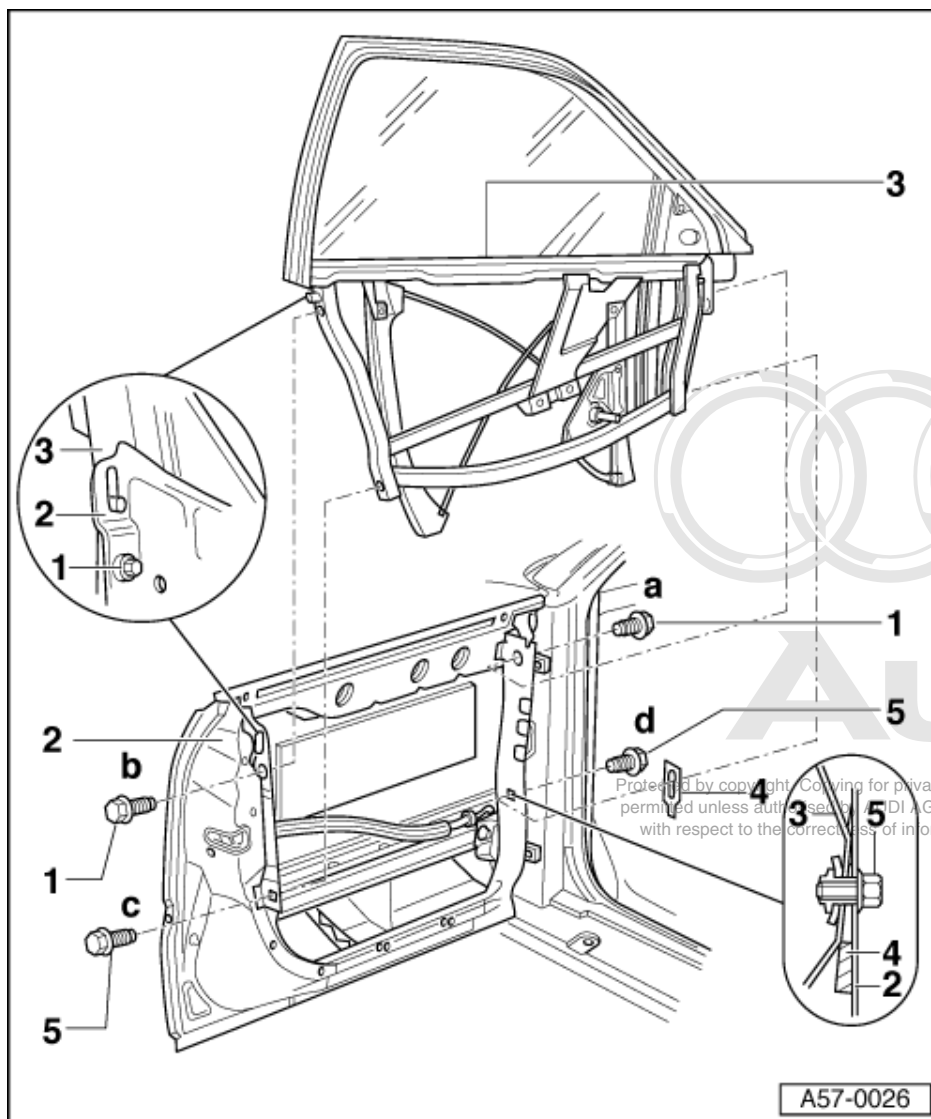
3 Door subframe

- ♦ Removal:
- Removing door trim.

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

- Disconnect electrical wiring from door component carrier and unclip.

- Unscrew bolts -1- and -5- and lift out door component carrier.



- ♦ Installation:
- Install in reverse order.

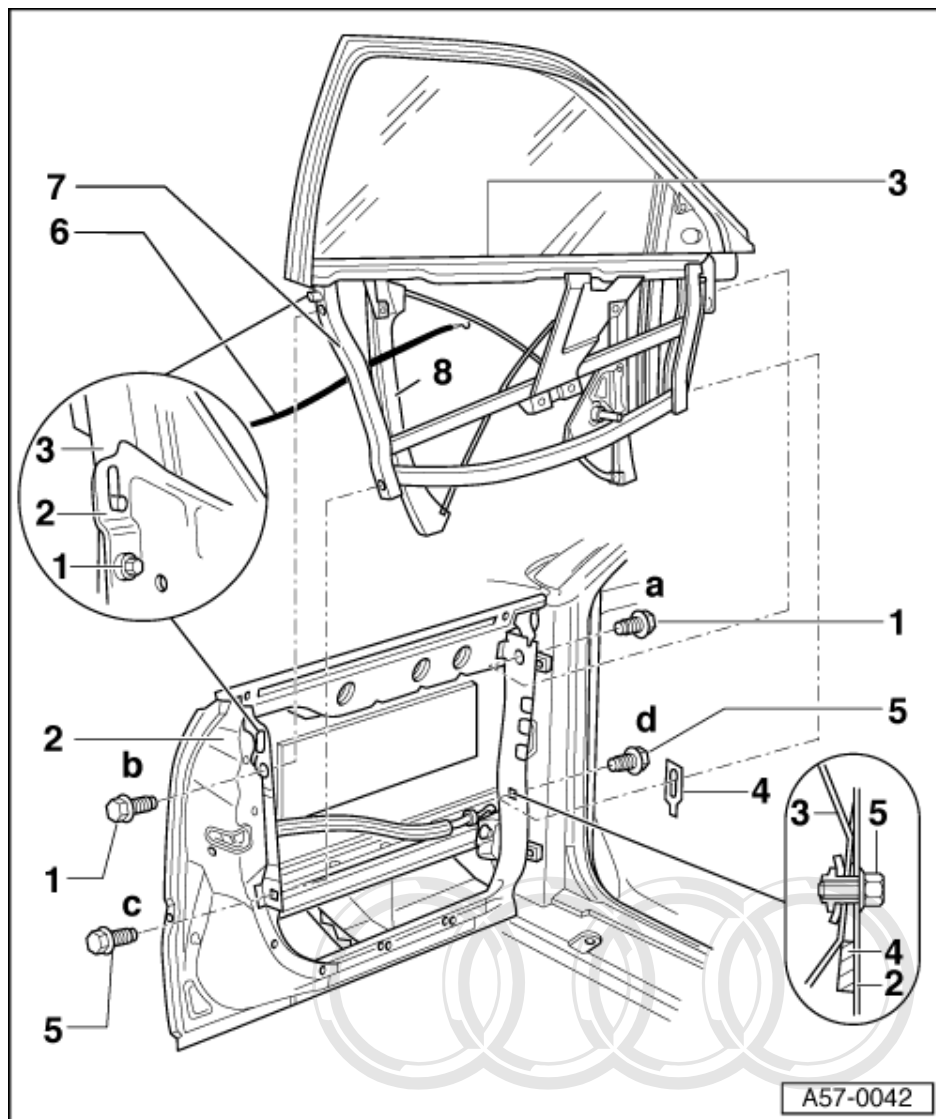
Important
Bolts -1- and -5- must be tightened in sequence a; b; c; d.

- ♦ Adjusting:
- Adjustment using adjusting wedge -4- =>Page 99 .
- Check dimensions =>Page 100 .

Note:

Rear door component carrier must be adjusted first or must be already adjusted.

Adjustment sequence: Rear door component carrier, B-pillar trim, front door component carrier.



4 Adjuster

Note:

Adjusting wedge must always be fitted.

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- ♦ Angle of door can be adjusted in B-pillar area by shifting adjusting wedge -4- =>Page 99 .

5 Bolt (2x)

- ♦ Tightening torque 30 Nm

6 Bowden cable

Note:

To prevent malfunction, always route Bowden cable -6- as shown (between support -7- and window guide -8-).

7 Mount

8 Window guide

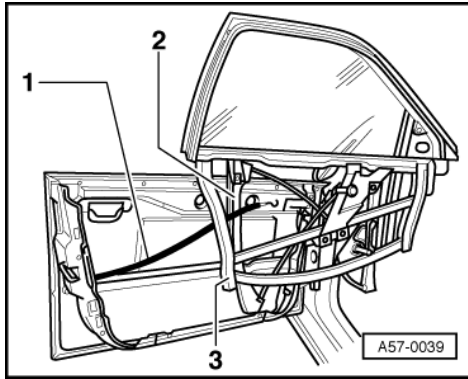


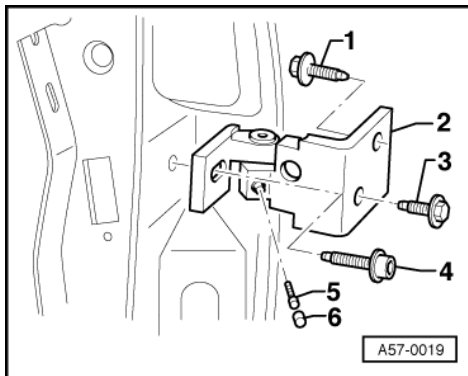
Fig.1 Malfunction

-> Bowden cable -1-, window guide -2-, support -3-

Note:

To prevent malfunction, always route Bowden cable -1- as shown (between support -3- and window guide -2-).

Fig.2 Upper door hinge



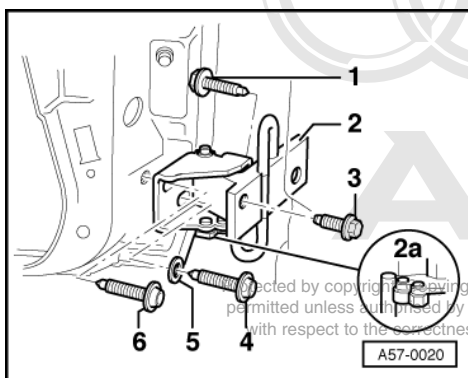
- -> To remove door shell, unscrew bolt -4-.
Tightening torque 30 Nm.

Note:

Door hinge -2- can also be separated via screw -5-. (Tightening torque 23 Nm).

- To remove door hinge -2-, also unscrew bolts -1- and -3-.
Tightening torque 30 Nm.

Fig.3 Lower door hinge

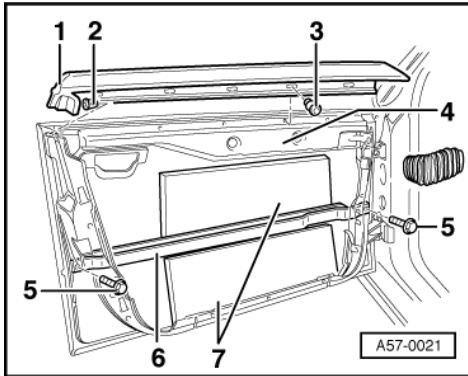


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- -> To remove door shell, unscrew bolts -4- and -6-.
Tightening torque 30 Nm.
- To remove door hinge -2-, also unscrew bolts -1- and -3-.
Tightening torque 30 Nm.
- Grease points -2a- grease G 000 150.

Removing and installing side impact bar



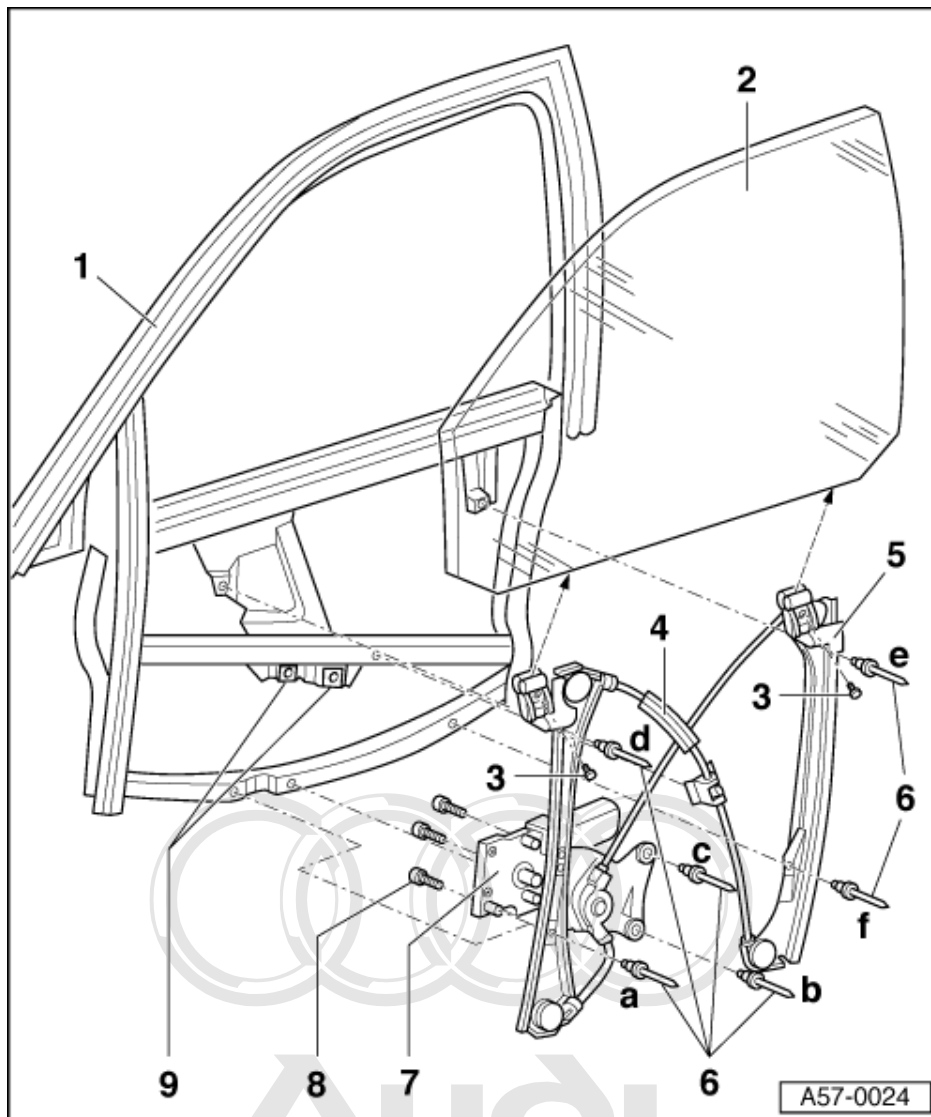
- -> To remove, unscrew bolts -5- (2x) and take out impact bar -6-.
Tightening torque 8 Nm.



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2 - Removing and installing window lifter and front side window

2.1 - Removing and installing window lifter and front side window

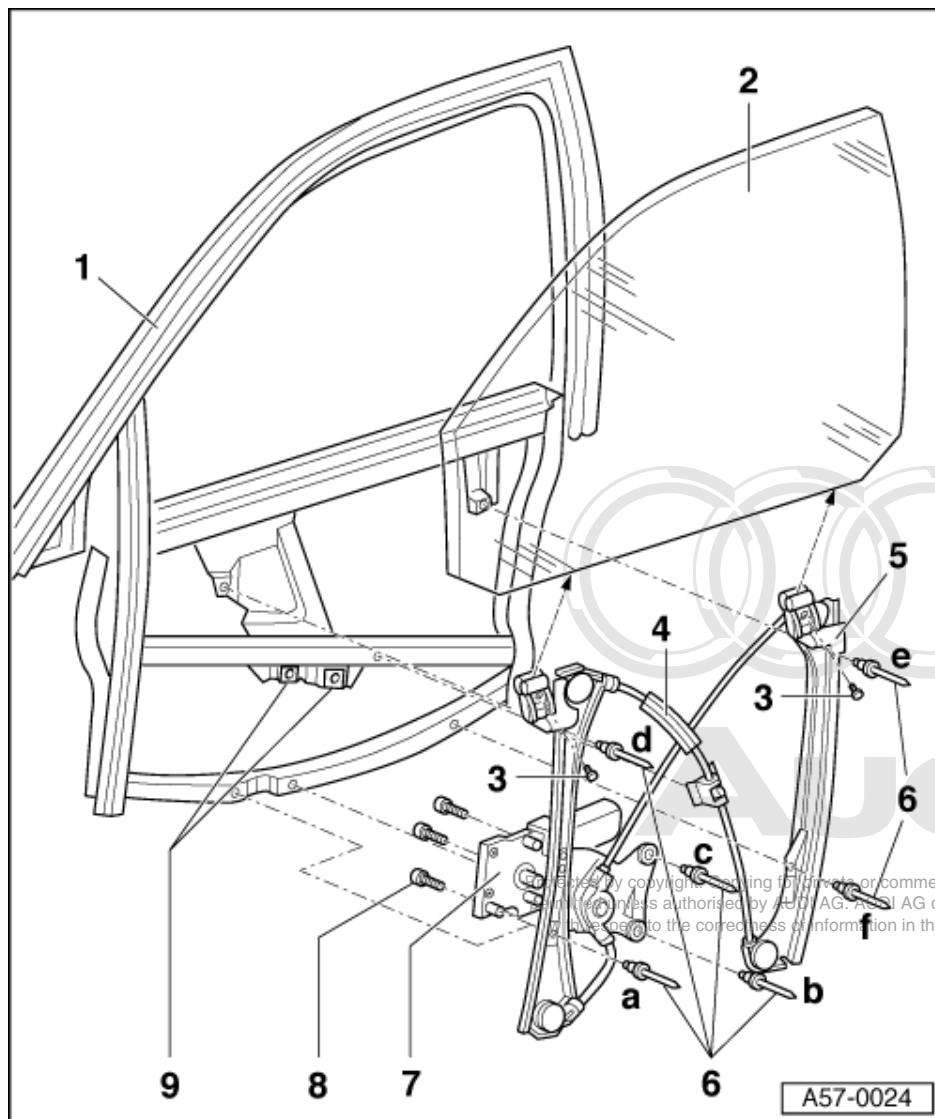


1 Door subframe

- ♦ Removing and installing =>Page 65 .

2 Window

- ♦ Removal:
 - Lower window.
 - Unscrew bolts -3-.
 - Lift window out of mount.
- ♦ Installation:
 - Install in reverse order.
 - ♦ Adjusting =>Page 74 .



3 Bolt (2x)

- ♦ Tightening torque 6.5 Nm.

4 Protective sleeve

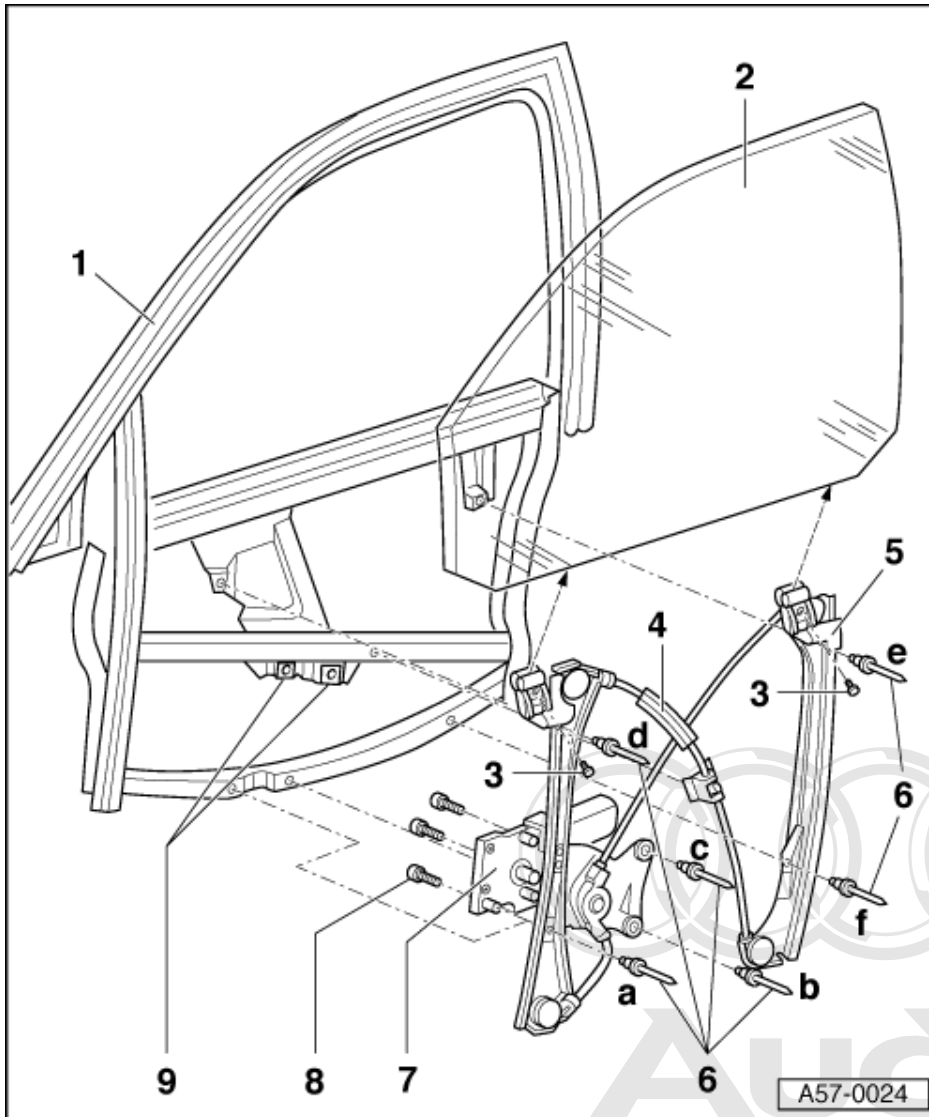
- ♦ Must always be in specified position to prevent abrasion of the two Bowden cables.

5 Window lifter

- ♦ Removal:
 - Remove door subframe =>Page 65
 - Drill out rivets -6-
- ♦ Installation:
 - Fit rivets -6-
 - To avoid noise, ensure Bowden cables do not make contact with impact bar.

Important

Bowden cable with protective sleeve -4- must always face door shell and not be turned through 180° towards door trim.



6 Rivet (6x)

- ♦ Fit using special tool V.A.G 1753.
- ♦ Installation sequence a; b; c; d; e; and f.

7 Window lifter motor

- ♦ Removing and installing .

=> Electrical Systems; Repair group 96

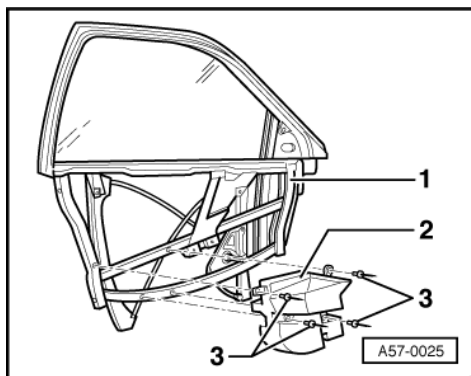
8 Bolts (3x)

- ♦ Tightening torque 6.5 Nm.

9 Snap nut (2x)

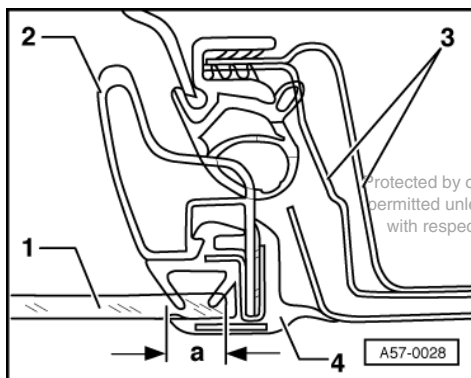
- ♦ Snap nut must be fitted before installing window lifter.

2.2 - Removing and installing impact absorber from door component carrier



- -> To remove, drill out rivets -3- (4x) and detach impact absorber -2-.
- Use special tool V.A.G 1617 B to fit rivets.
- Door component carrier -1-.

2.3 - Adjusting front side window



- As a check, dimension a = 9 mm can be marked on window in length of B-pillar with a water soluble pen.
- -> Adjust window in mount at window lifter.
- Raise window until shortly before stop.
- Window -1- and seal -4- for door component carrier must run parallel in roof and A-pillar area.
- Press window -1- towards B-pillar -3-.

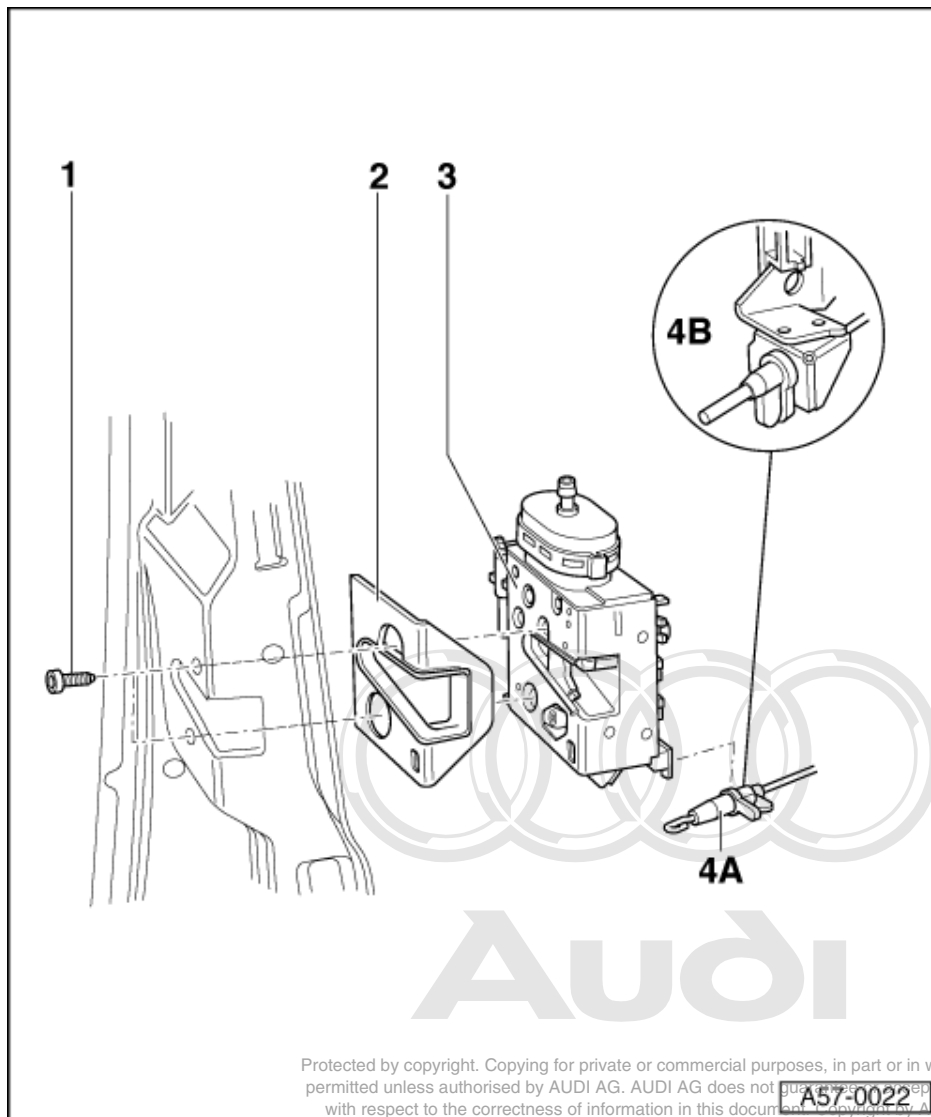
Note:

Window -1- must enter 9 mm-dimension a- into seal -4- for door subframe -3-.

- Tighten bolts on window lifter mounts.
Tightening torque 6.5 Nm.
- Raise window -1- as far as it will go.
- Check dimension -a- and erase pen mark.

3 - Removing and installing front door lock with operating elements

3.1 - Removing and installing front door lock with operating elements



1 Bolt (2x)

- ♦ Tightening torque 9.5 Nm.

2 Lock base plate

3 Door lock

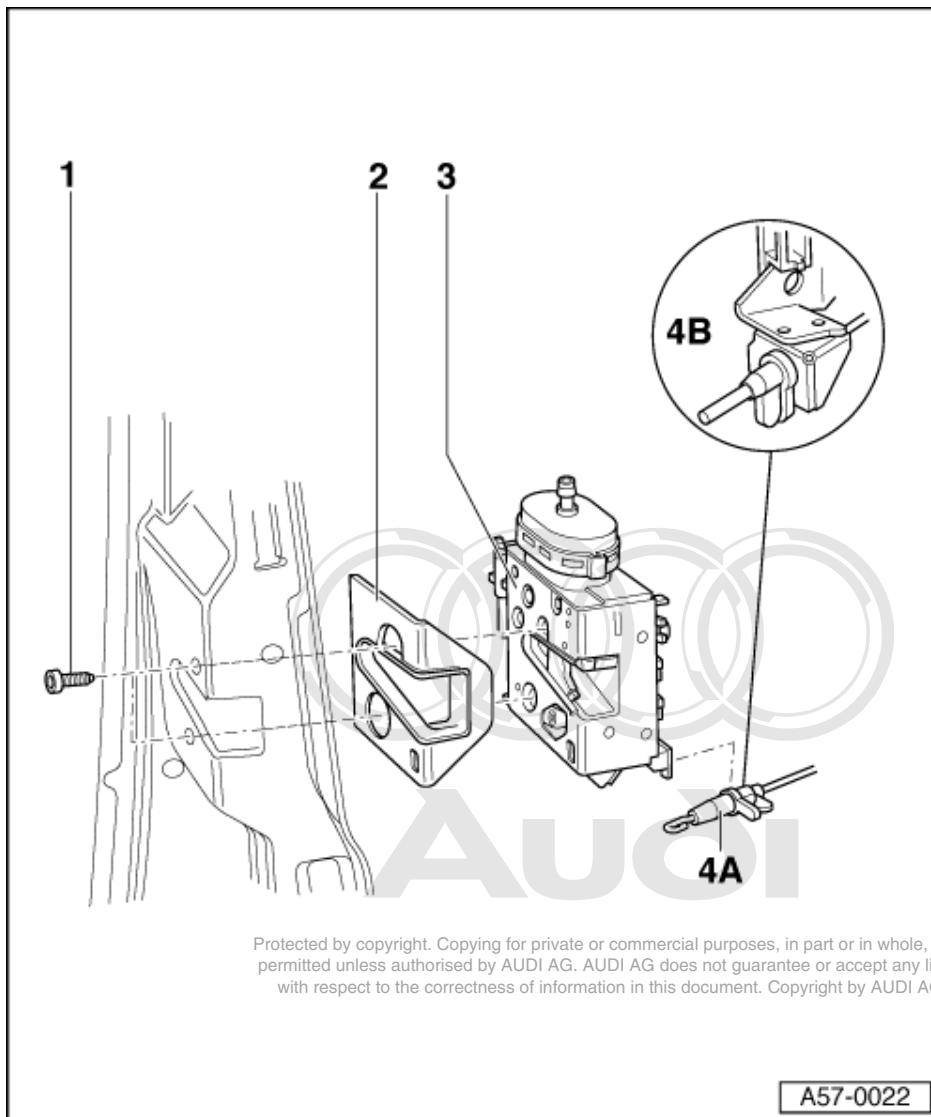
- ♦ Removal:
- Remove door component carrier =>Page 65 .

Note:

If the trim cap for door lock has not been fitted, door component carrier does not have to be removed to take out door lock.

- Remove cover for door lock =>Page 77 .
- Unclipping securing and operating rods =>Page 79 .
- Detach connecting hose from actuator for central locking system.
- Unscrew bolts -1-.

- Remove door lock and lock base plate -2-.

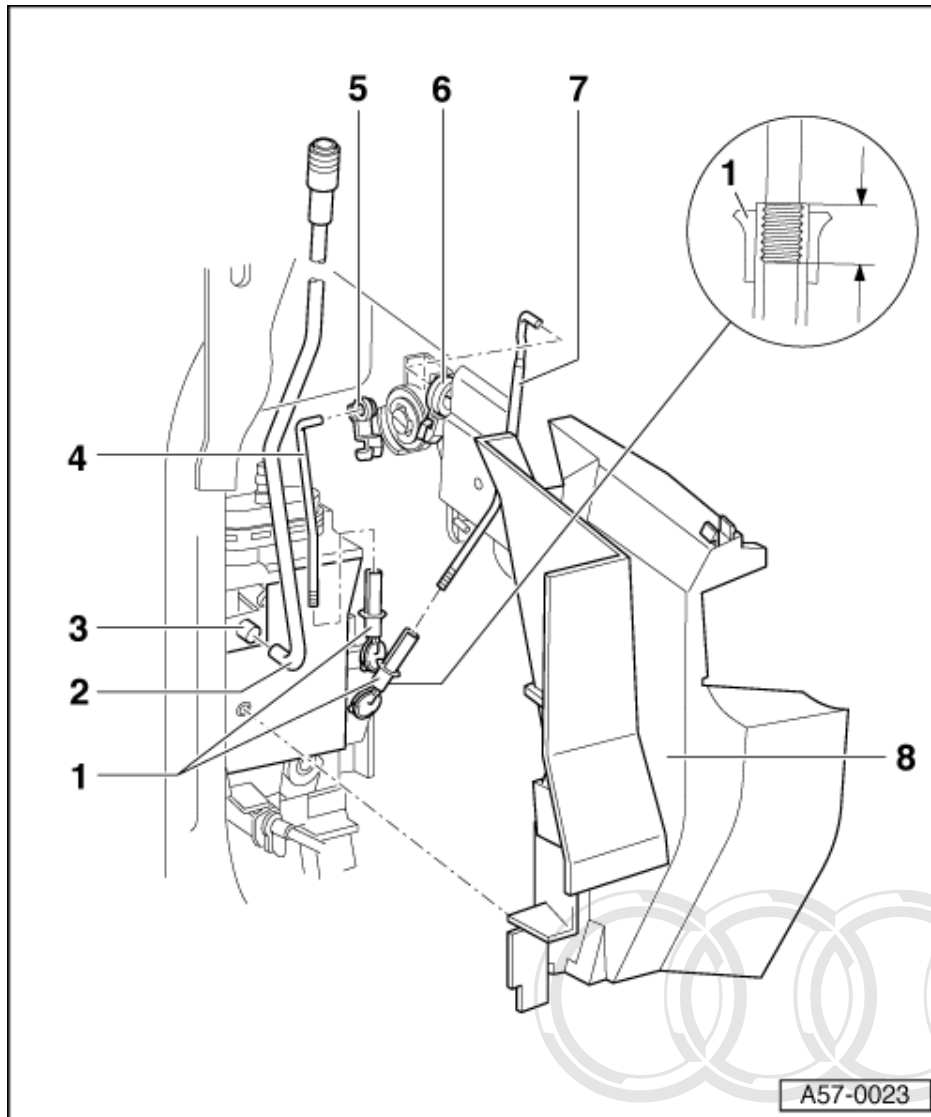


- ◆ Installation:
 - Install in reverse order.

4 Bowden cable for interior door handle.

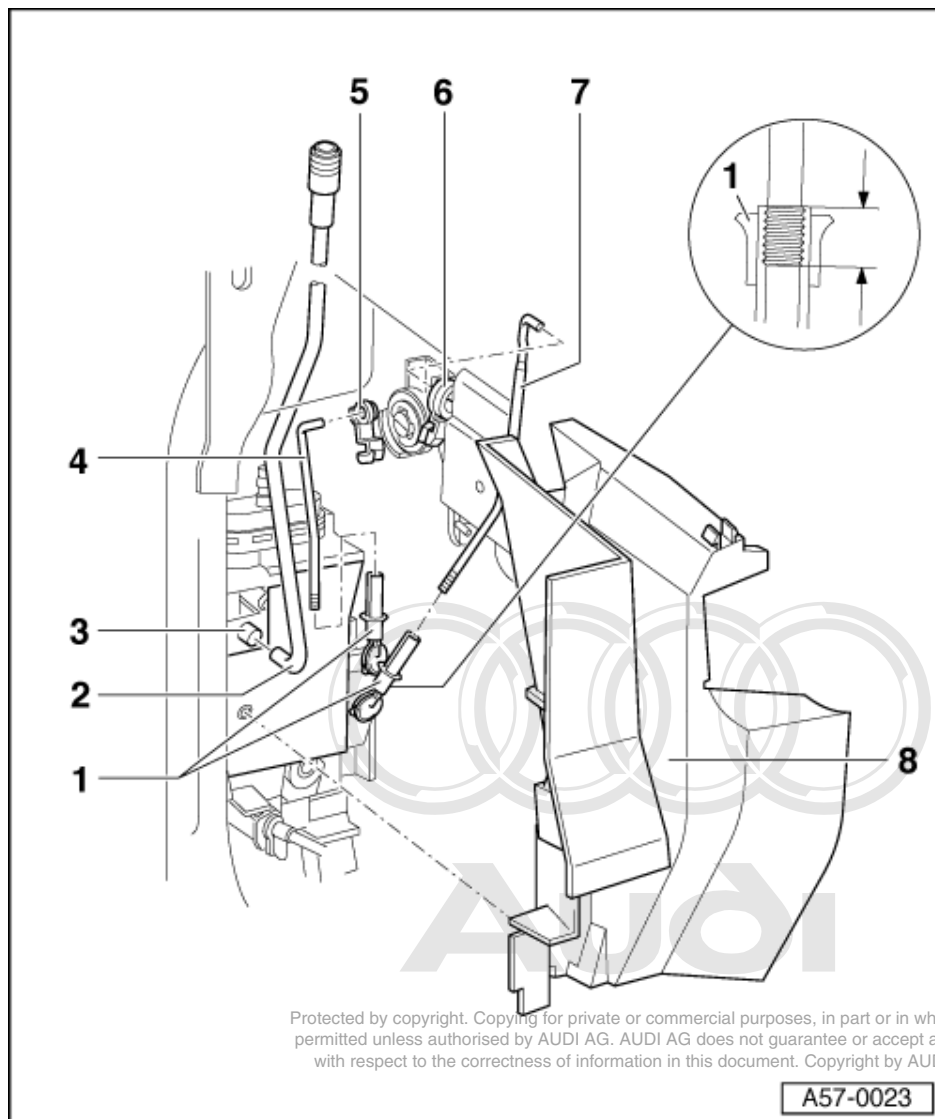
- ◆ Removal:
 - Remove door component carrier =>Page 65 .
 - Remove cover for door lock =>Page 77 .
 - Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
 - Install in reverse order.

3.2 - Removing and installing operating rods for front door lock



- 1 **Operating clip**
 - ♦ Installation =>Page 79
- 2 **Securing rod**
 - ♦ To remove, unclip at safety piece -3-.
- 3 **Fastener**
- 4 **Lock cylinder securing rod**
 - ♦ Installation =>Page 79 .
- 5 **Hinged bushing**
- 6 **Hinged bushing**

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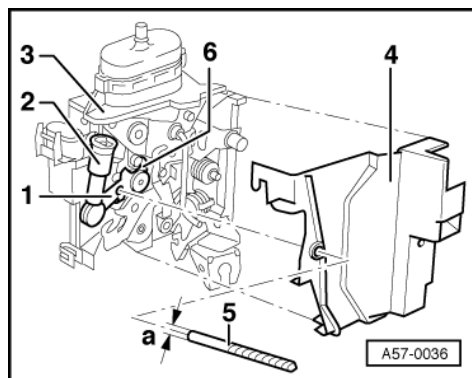
A57-0023

7 Door lock operating rod

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

8 Door lock cover

- ◆ Unclip trim cap to remove.
- ◆ Insert trim cap by gradually sliding into place.



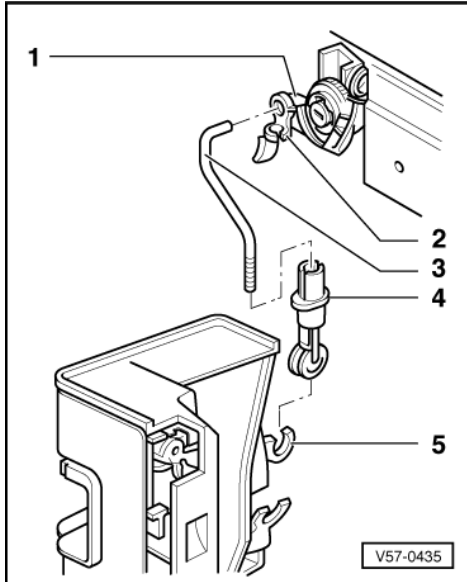
A57-0036

Installing lock cylinder securing rod

- -> Fix operating lever -1- in position with 4mm guide pin -5- (twist drill). This involves inserting guide pin through trim cap -4- into operating lever -1-.

Trim cap -4- is gradually being discontinued and replaced by a larger trim cap =>Page **77** .

- There must be a clearance of approx. 1 mm between guide lug -6- and stop for adjusting securing rod (guide pin -5- not needed).



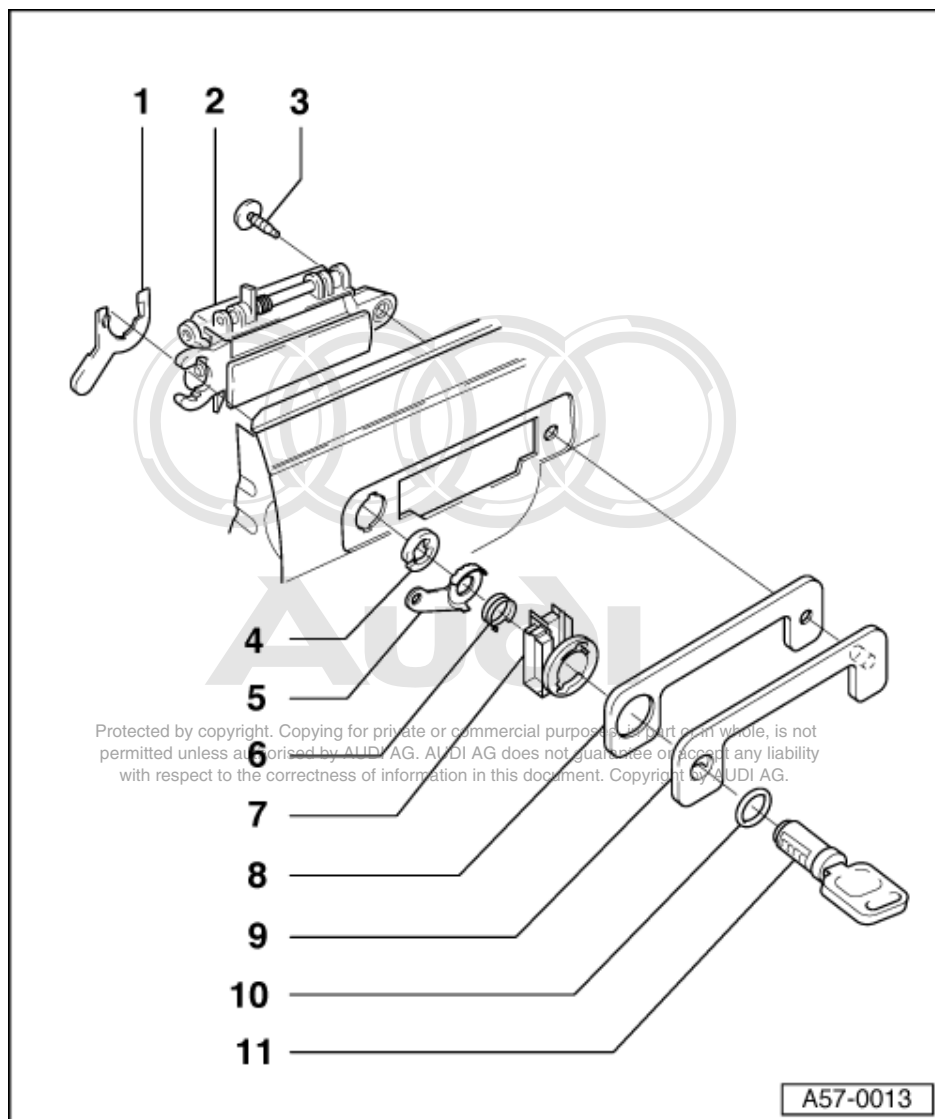
- -> Clip hinged bush -2- into release lever -1-.
- Enter securing rod -3- for locking cylinder into collar -2- and clip in.
- Swivel operating clip -4- through 90°, insert into door lock release lever -5- and swivel back upwards.
- Clip securing rod for lock cylinder -3- with no play into operating clip -4-, without straining door lock release lever -5- (max. play 1.5 mm).
- Push sleeve on operating clip -4- upwards.



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4 - Removing and installing front door handle

4.1 - Removing and installing front door handle



4.2 - >8D XA 200 000

1 Rotary clip

- ♦ Swivel rearwards (towards rear of vehicle) to release.

2 Door handle

- ♦ To detach, remove twist clamp -1- and unscrew combi bolt -3-.

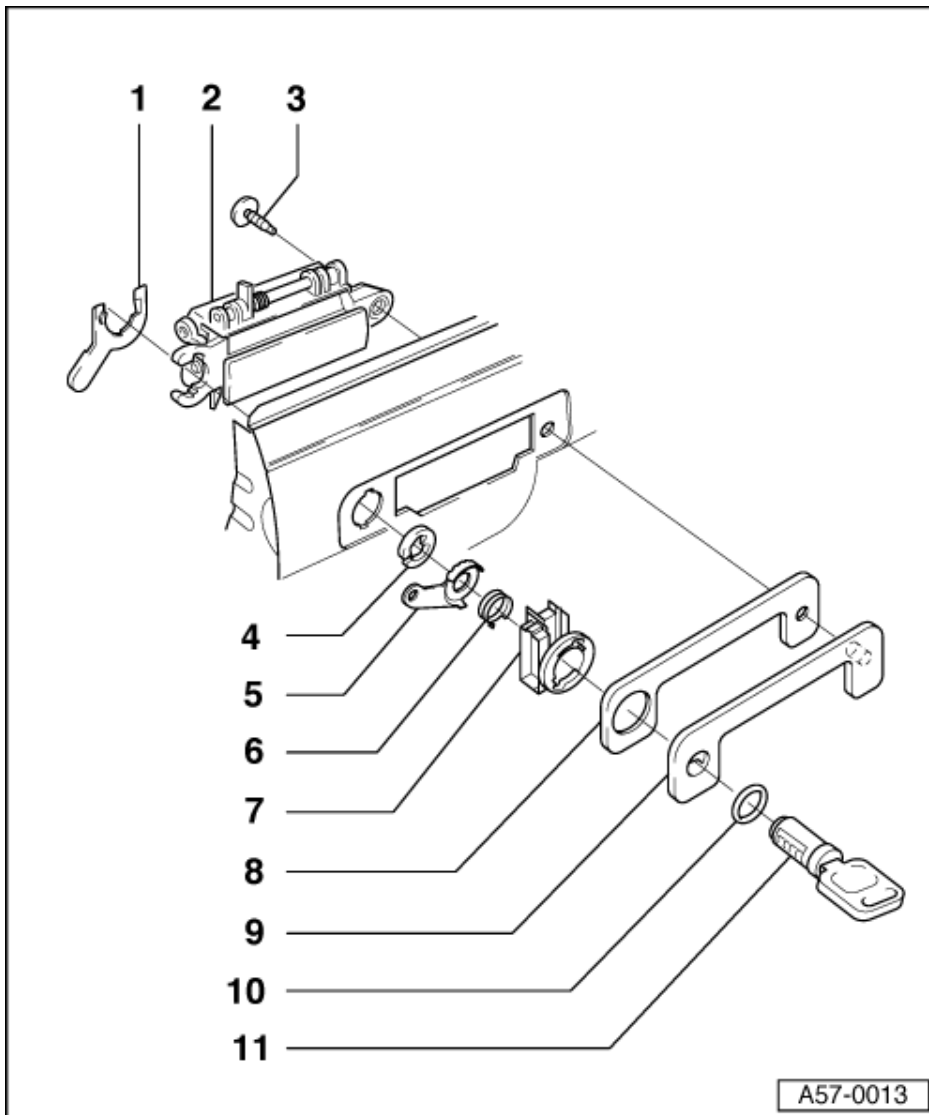
Note:

To avoid damage to paintwork on the handle cover, remove it before removing the door handle =>Fig. 1.

3 Combi bolt

- ♦ Tightening torque 5 Nm.

4 Circlip



5 Actuating arm

- ♦ Installation position =>Fig. 2 .

6 Spring

- ♦ When tensioned, ends of spring must be to the left and right of the operating lever.
- ♦ Operating lever and lock cylinder are constantly pushed into the centre position by the pre-loading.

7 Housing

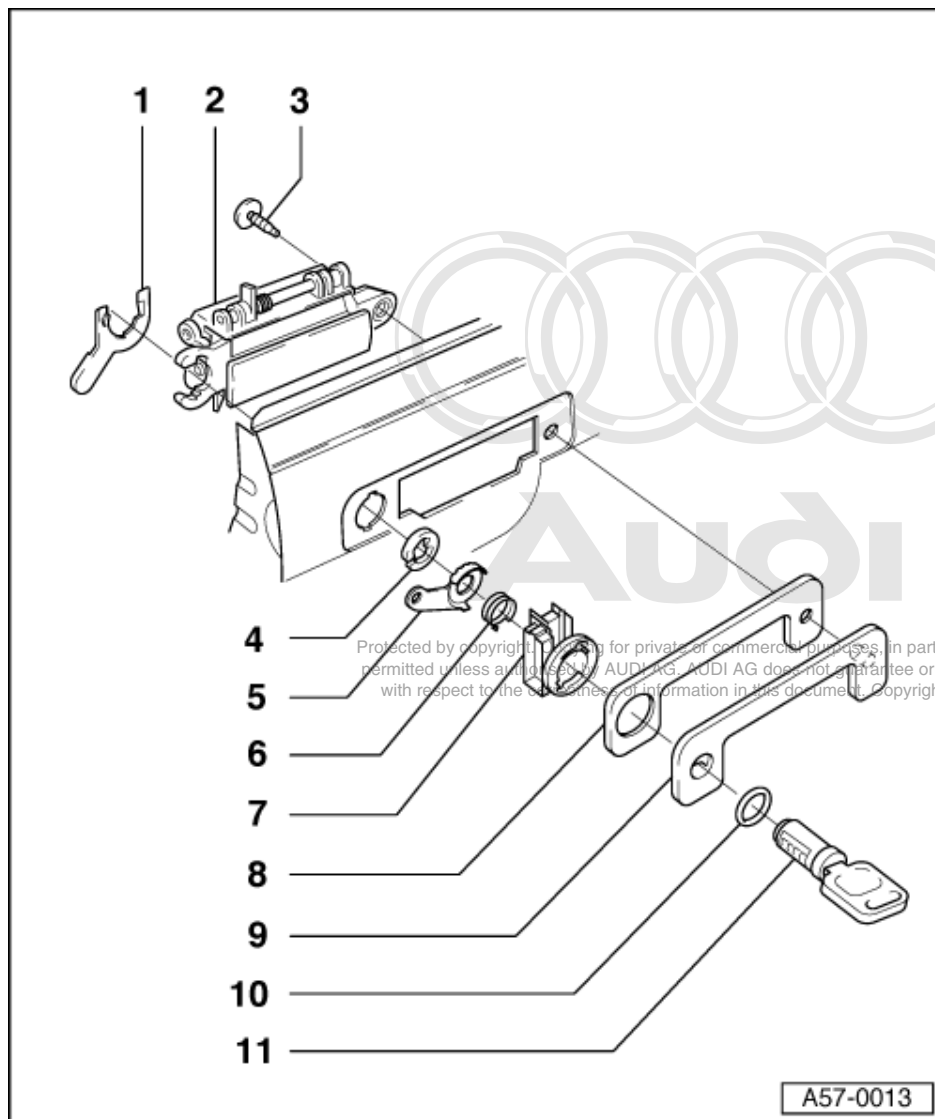
- ♦ To remove: Dismantle door handle -2- and lock cylinder -11-.

8 Shim plate

9 Panel

- ♦ Removing =>Fig. 1 .

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10 Sealing ring
11 Lock cylinder

Note:

Lock cylinder is removed and installed with key inserted.

- ◆ Door component carrier removed =>Page 65 .
- ◆ Lever circlip -4- out of groove of the lock cylinder.
- ◆ Detach driver -5- with spring -6-.
- ◆ Withdraw lock cylinder with key.

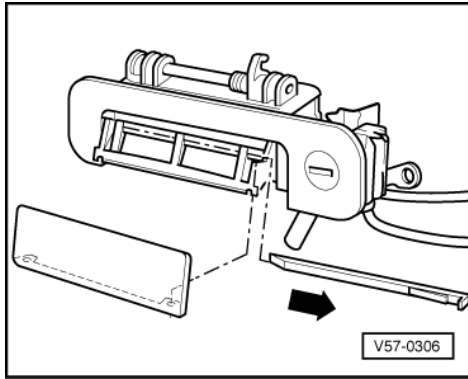


Fig.1 Removing cover for door handle

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

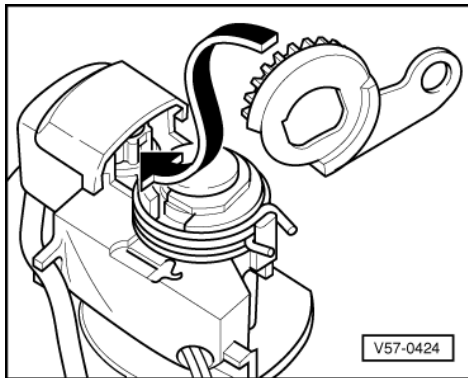
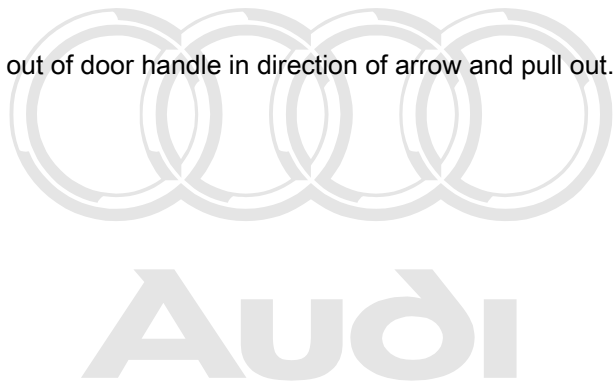


Fig.2 Driver installation position

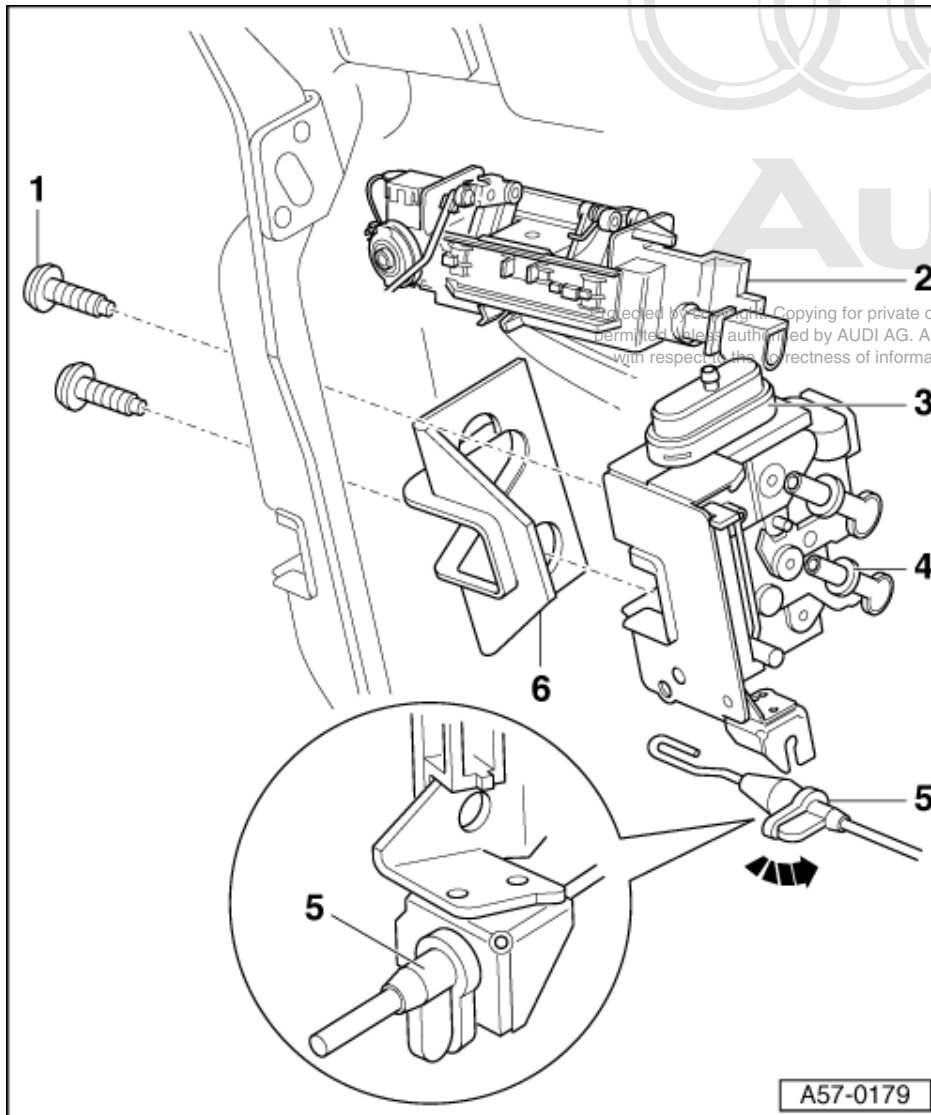
- -> To ensure operation of the central locking and anti-theft alarm system, the half-closed pitch of the driver must match the half tooth of the microswitch gearing.



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4.3 - 8D XA 200 001>

**1 Bolt (2x)**

- ♦ Tightening torque 9.5 Nm.

2 Door handle

- ♦ Removing and installing
=> Page 91 .

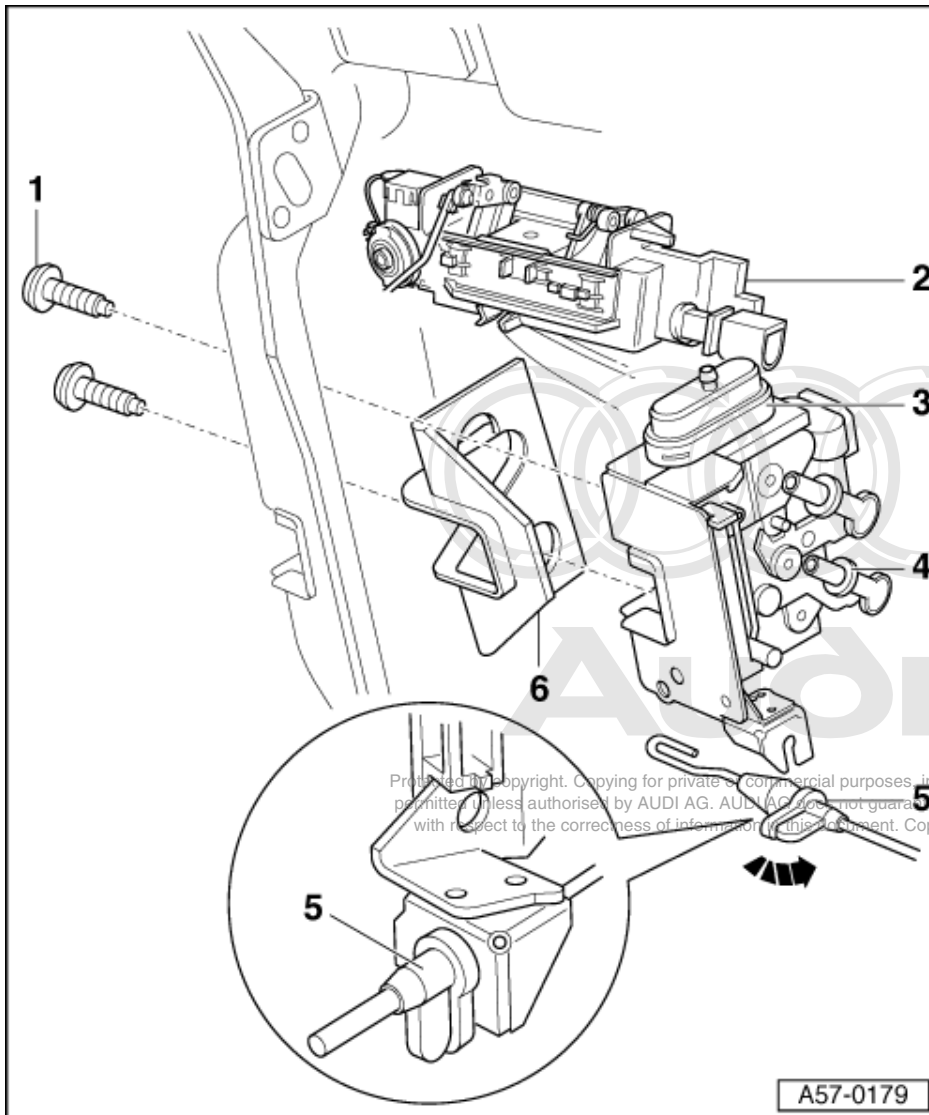
3 Door lock

- ♦ Removal:
- ♦ Remove door trim

=> General Body Assembly, Interior; Repair group 70

- Door subframe removed.
- Remove cover for door lock
=> Page 86 .
- Unclip securing and operating rods =>Page 89 .
- Detach connecting hose from actuator for central locking system.
- Unscrew bolts -1-.
- Remove door lock and lock base plate -2-
- ♦ Installation:

- Install in reverse order.



4 Operating clip

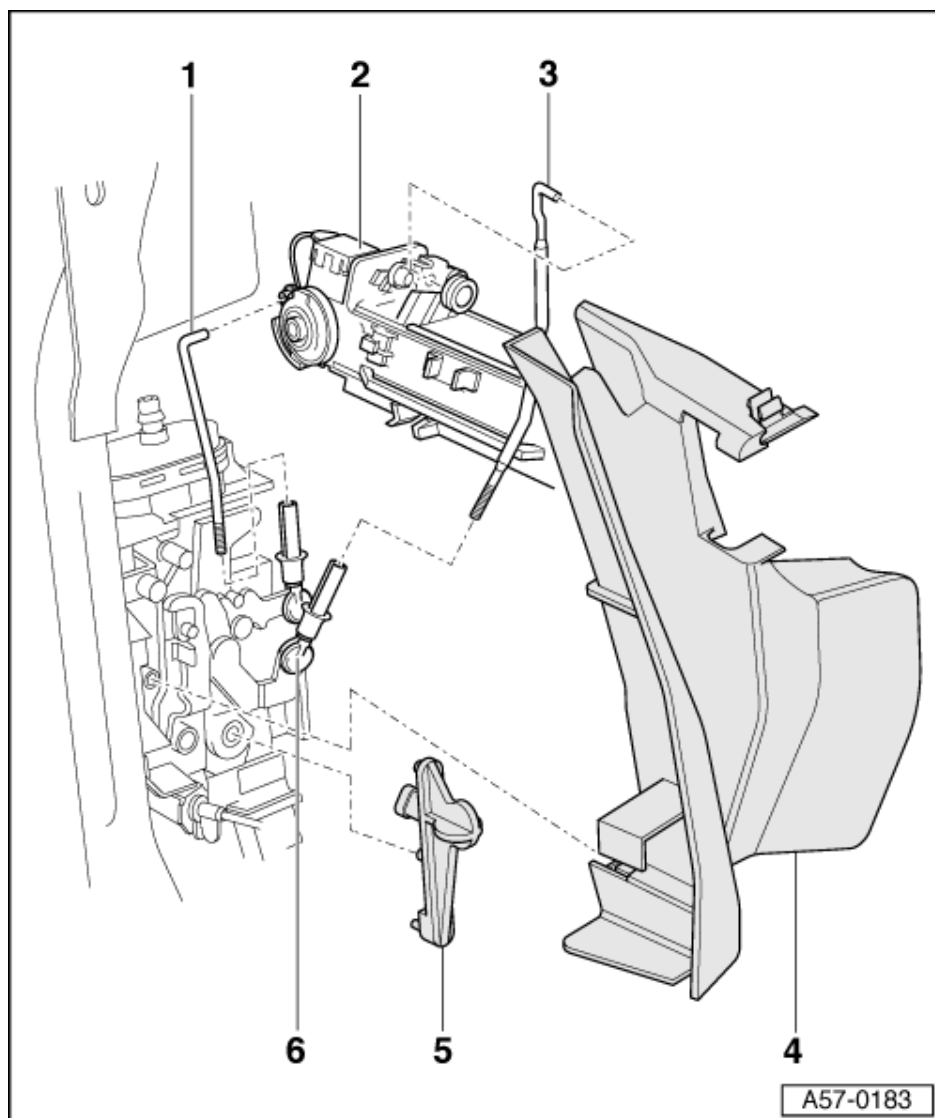
- ◆ Installing => Page 89 .

5 Bowden cable for interior door handle

- ◆ Removal:
 - Door sub-frame removed.
 - Remove cover for door lock => Page 86 .
 - Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
 - Install in reverse order.

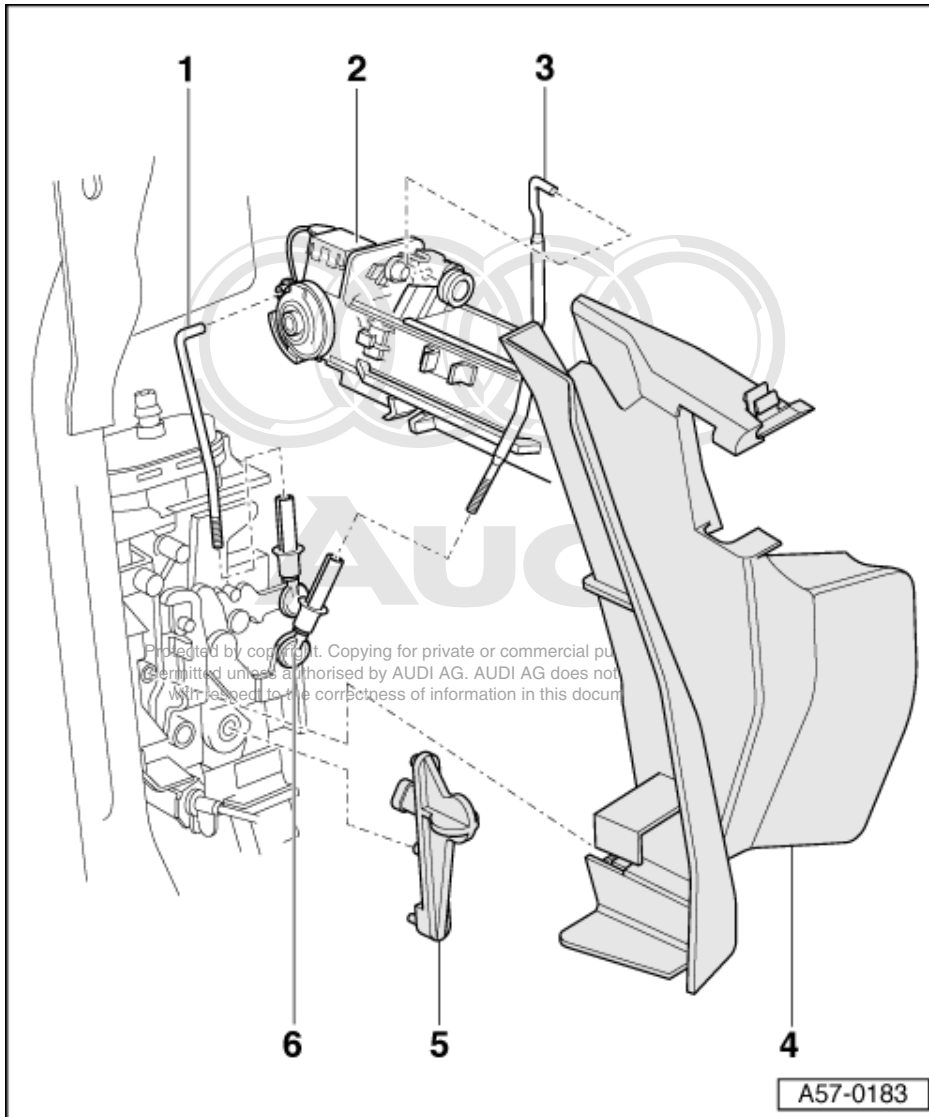
6 Lock base plate

4.4 - Removing and installing cover for door lock



- 1 **Lock cylinder securing rod**
 - ◆ Clip in bushing on release lever.
- 2 **Door handle**
 - ◆ Removing and installing => Page 91
- 3 **Door lock operating rod**
 - ◆ Installation as for securing rod -4-.
 - ◆ Clipping-in length -a- 13 ±3 mm.
- 4 **Door lock cover**
 - ◆ To remove, first unclip at top, then remove from door lock to rear at bottom.

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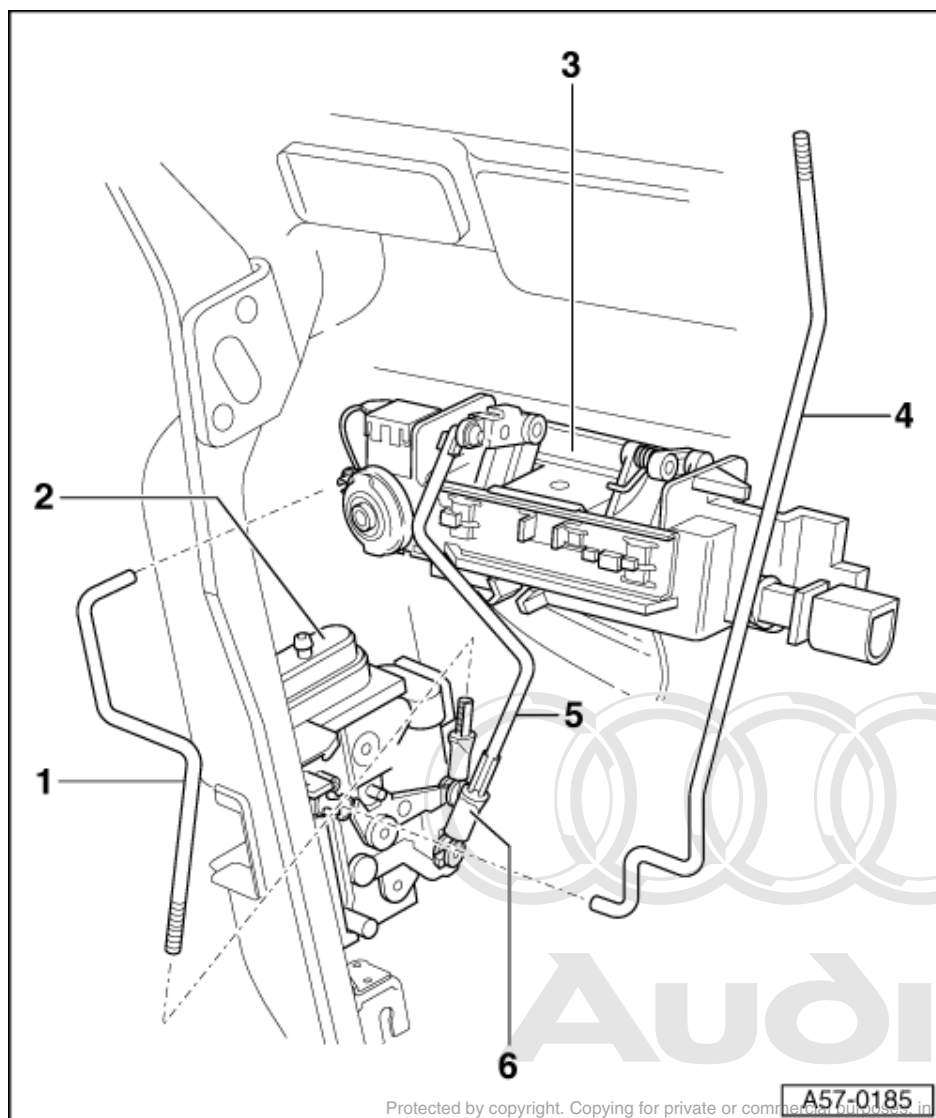
5 Installation pin

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

6 Operating clip

- ♦ Attaching in door lock => Page 89 .

4.5 - Removing and installing operating rods for front door lock



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A57-0185

1 Lock cylinder securing rod

- ♦ Installing => Page 89 .

2 Door lock

- ♦ Removing and installing => Page 75 .

3 Door handle

- ♦ When removing the door handle, the securing rod -1- and operating rod -5- must be detached from the door handle.

4 Operating rod

- ♦ Unclip from door lock to remove.

5 Operating clip

- ♦ Installing => Page 89 .

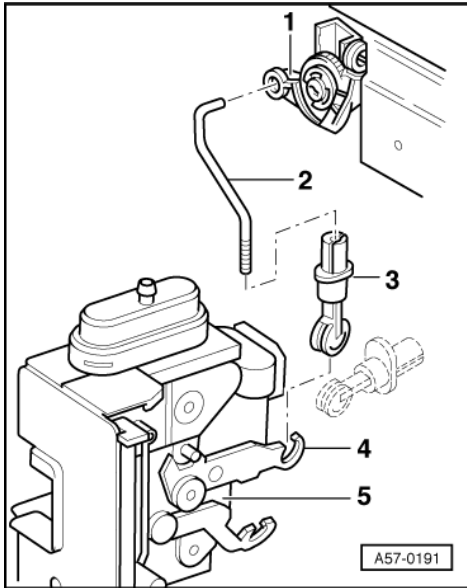


Fig.1 -> Removing and installing securing rod for lock cylinder

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

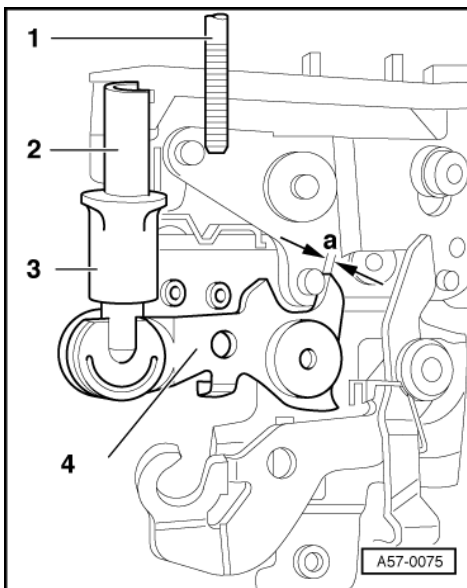


Fig.2 -> Adjusting play for locking lever

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



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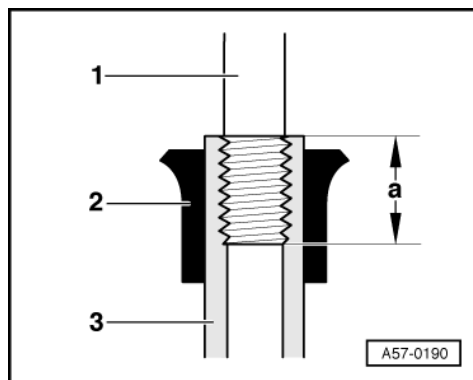
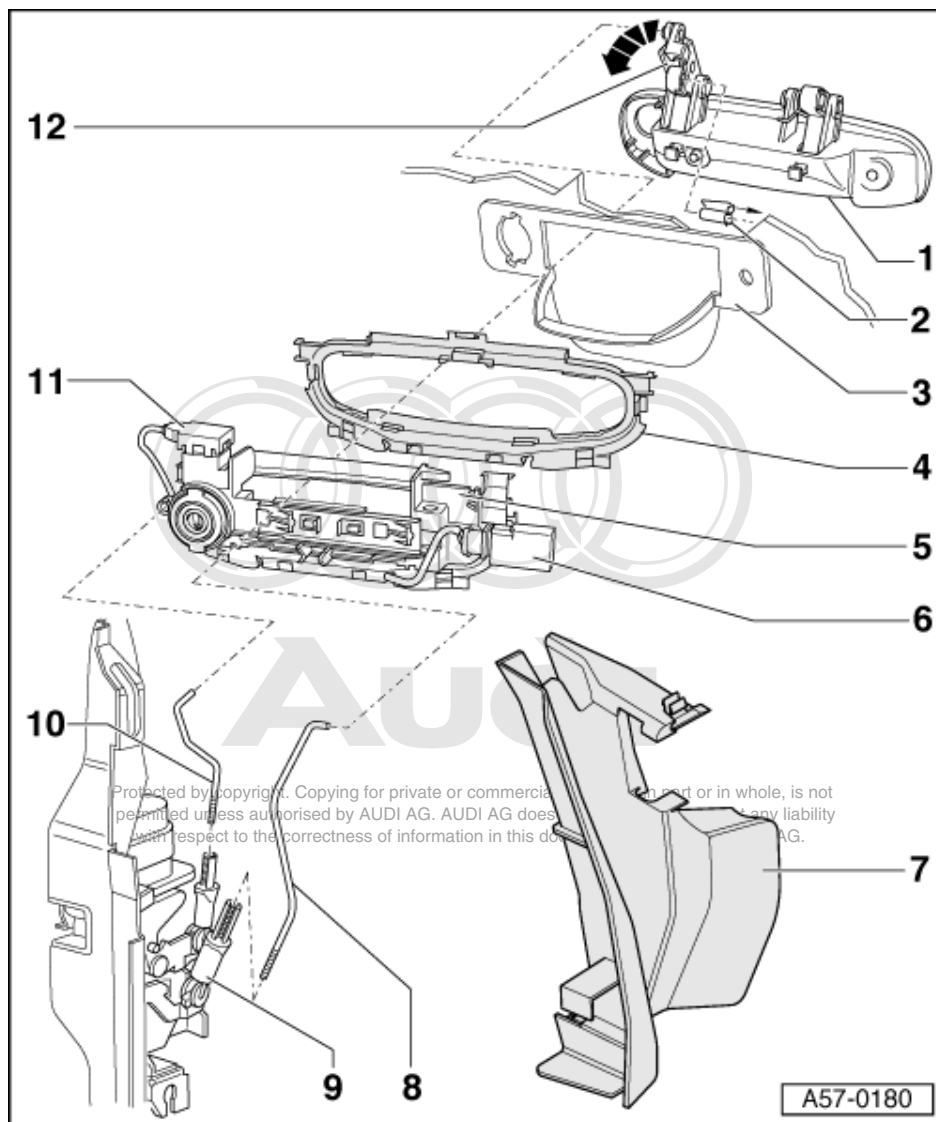


Fig.3 -> Adjustment depth for securing rod

- When correctly adjusted, dimension -a- of securing rod -1- must be $13\text{ mm} \pm 3\text{ mm}$.
- After adjustment is complete, push the sliding sleeve -2- upwards from actuation clip -3-.

4.6 - Front door handle - Assembly overview



1 Door handle

- ◆ Remove door trim.

=> General Body Assembly, Interior; Repair group 70

- ◆ Door sub-frame removed.
- ◆ Removal => Page 93 .

2 Locking pin

- ◆ When installing, the hinged lever must fully engage in spring catch.

3 Front door

4 Seal for door handle

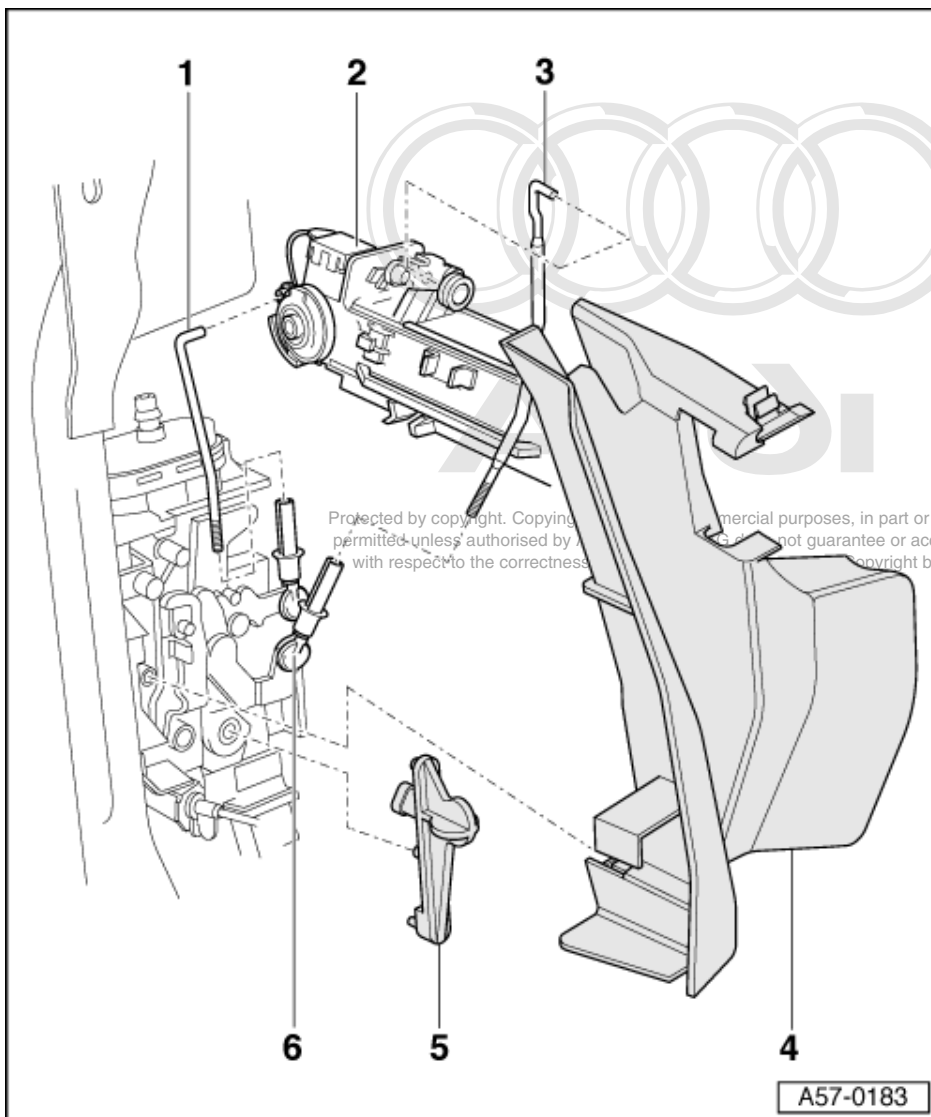
- ◆ Removing and installing => Fig. 2 .

5 Door handle mount

- ◆ Releasing => Page 94 .

6 Connector

- ◆ Vehicles with anti-theft alarm only.



7 Door lock cover

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

8 Operating rod

- ◆ Detach at clip -9- before removing door handle.

9 Operating clip

- ♦ Installation =>Page 89 .

10 Lock cylinder securing rod

- ♦ Installing => Page 89 .

11 Microswitch

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

12 Hinged lever

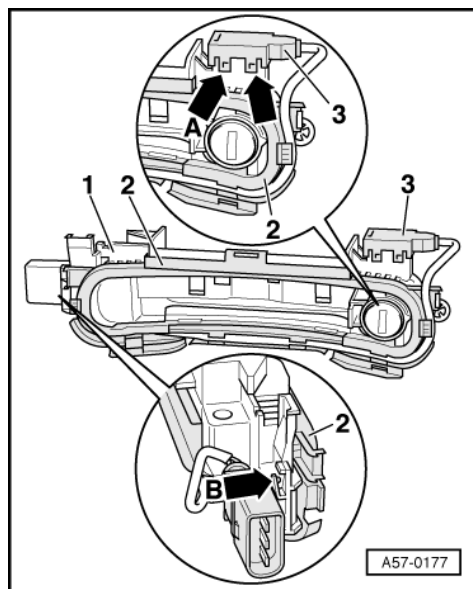


Fig.1 -> Removing and installing microswitch

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

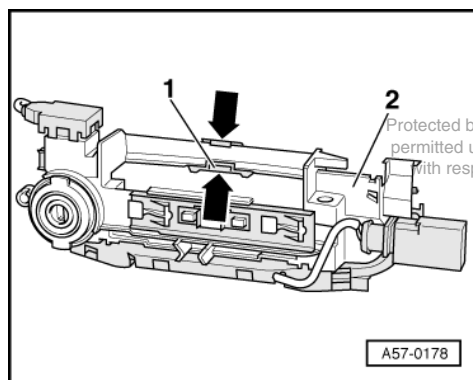


Fig.2 -> Removing and installing door handle seal

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

- door handle mount 11 using a screwdriver => Fig. 11.

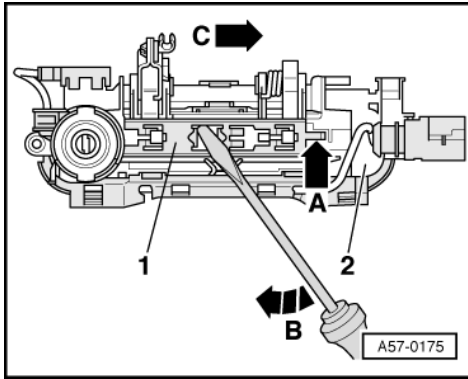


Fig.1 -> Releasing mount for door handle

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

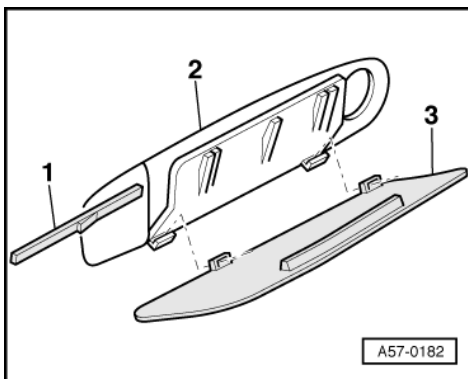
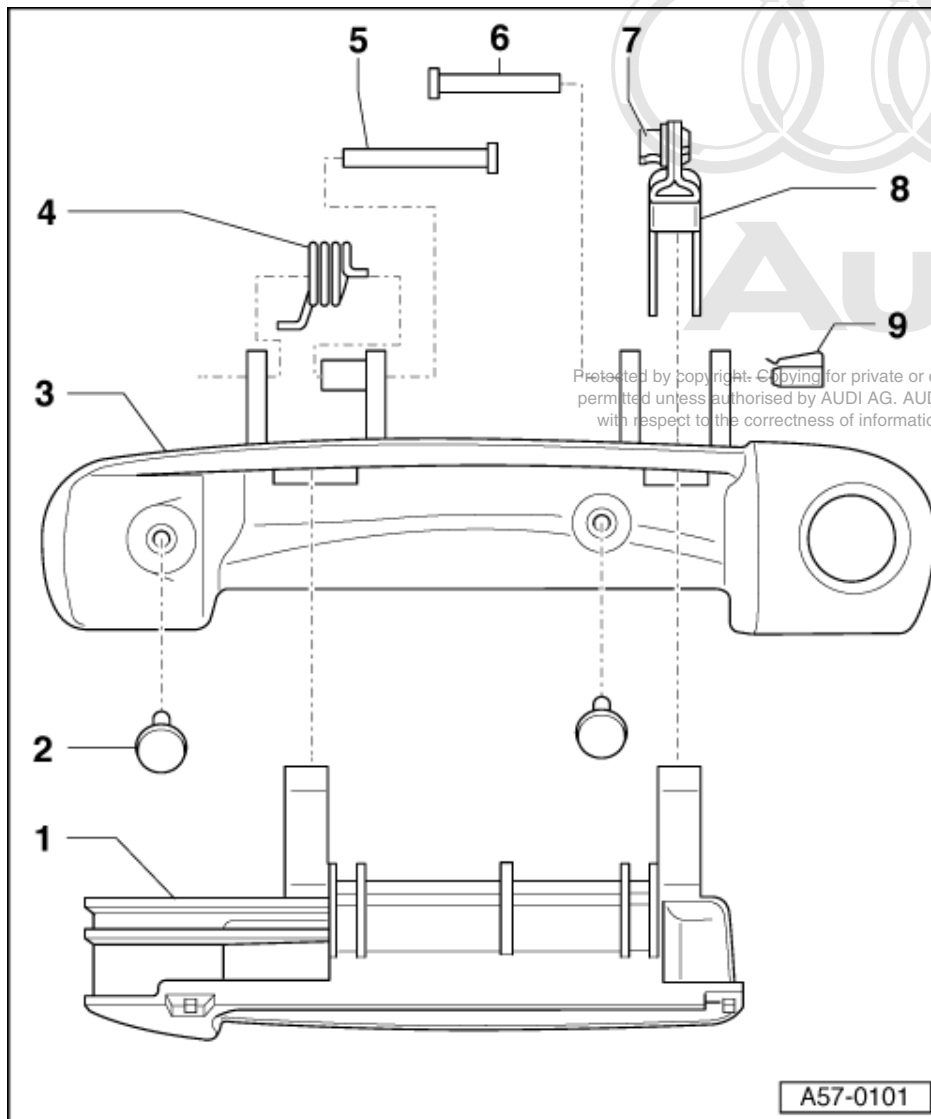


Fig.2 -> Removing cover

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

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4.8 - Front door handle pre-assembly



Note:

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

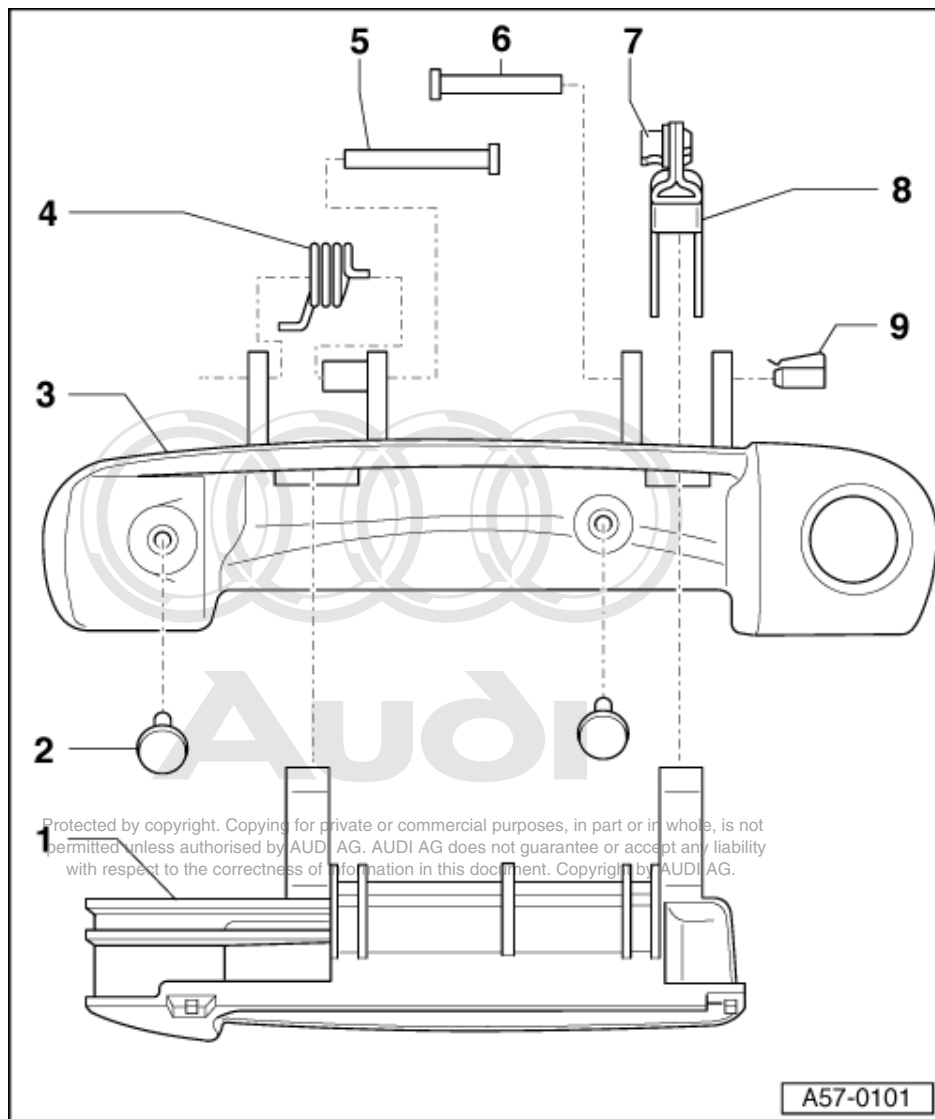
1 Door handle

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

2 Buffer

- ♦ Insert after painting.

3 Door handle mount



4 Spring

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

5 Pivot pin

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

6 Pivot pin

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

7 Clip

8 Hinged lever

9 Locking pin

- ♦ Assembly => Fig. 3 .

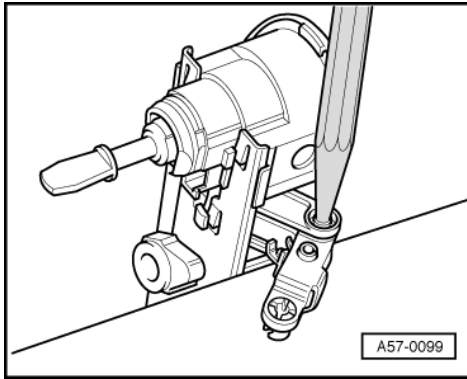


Fig.1 -> Caulking pivot pin

Note:

Before caulking pivot pins protect painted surfaces with fabric adhesive strip.

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

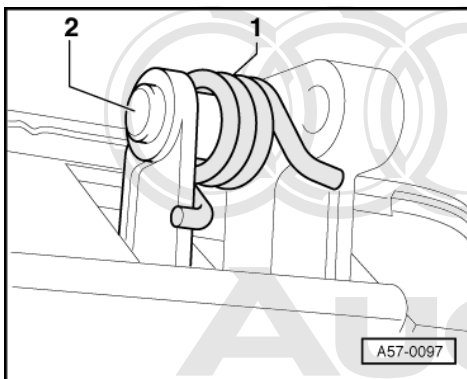


Fig.2 -> Installation position of spring

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

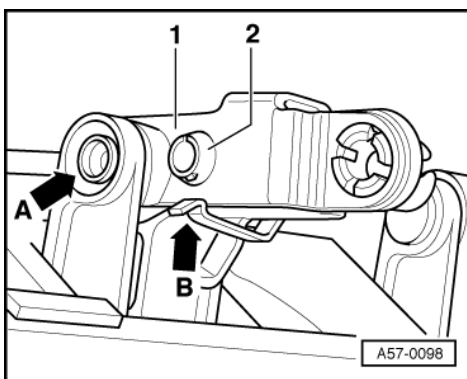


Fig.3 -> Installation of locking pin

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

- Arrow -A- = caulked pivot pin.

5 - Adjusting door - Adjustment sequence

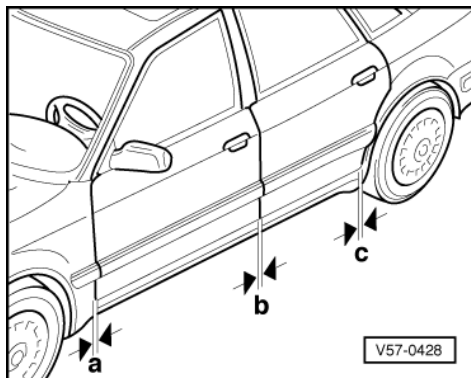
5.1 - Adjusting door - Adjustment sequence

5.2 - Adjusting door shell

Note:

Door shell at rear must be adjusted first or must be already adjusted.

Joint dimensions:



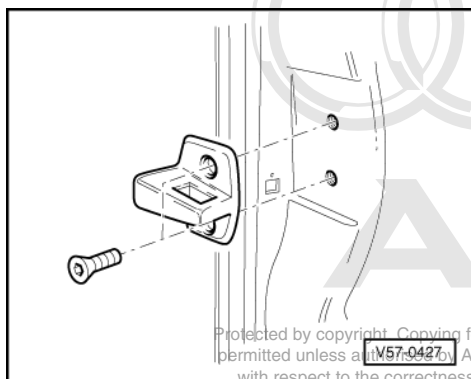
- -> The gaps are adjusted by loosening the hinge screws on the A-pillar and sliding the door (oversized drilled holes in hinge).
- $a = 4 \text{ mm} \pm 0.5$
- $b = 5 \text{ mm} \pm 0.5$
- $c = 3.5 \text{ mm} - 0.5 / +1$

Adjusting to body contour:

- The gaps are adjusted by releasing the hinge screws on door shell and sliding the door (oversized drilled holes in hinge).

Note:

Rear part of door is adjusted at striker plate (towards centre of vehicle) =>Fig. 1.



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Fig.1 Adjustment with striker wedge

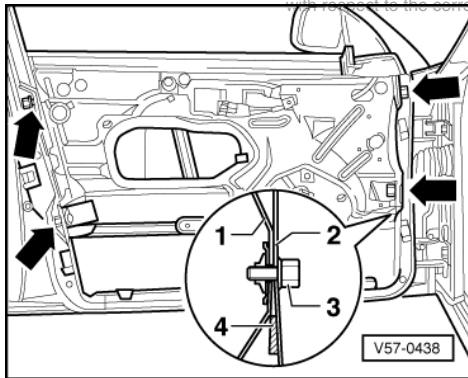
- -> Release bolts.
- Move striker plate until door shell is flush with body contour.
- Tighten bolts.
Tightening torque 20 Nm.

Note:

Adjustment can only be made towards centre of vehicle and not for height.

5.3 - Adjusting door subframe

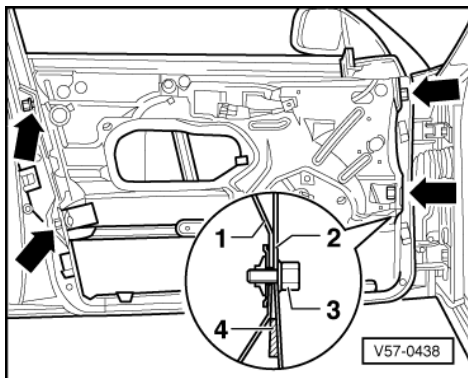
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Note:

Door shell must already be adjusted.

- -> Screw on bolts -3- so that door component carrier -1- can still be adjusted (bolt at adjuster -4- is only to be fitted but not tightened).
- Have second mechanic sit in vehicle
- Close door.



- -> Have second mechanic press door component carrier from inside against roof and A-pillar. Subframe must be forced slightly to allow for resilience of rubber seal.
- First mechanic checks correct positioning of door component carrier from outside.
- Push adjusting wedge -4- upwards, until it contacts the surfaces of the door shell -2- and the door component carrier -1-.

Important
Adjusting wedge -4- must always be installed.



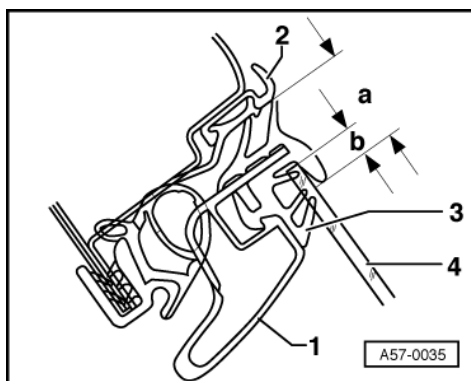
Angle of door can be adjusted in B-pillar area by shifting adjusting wedge -4-.

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

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

- Carefully open door and tighten bolts -3-.
Tightening torque 30 Nm.
- Close door and check adjustment of door component carrier.
- Procedure must be repeated if the adjustment of door component carrier is still not correct.

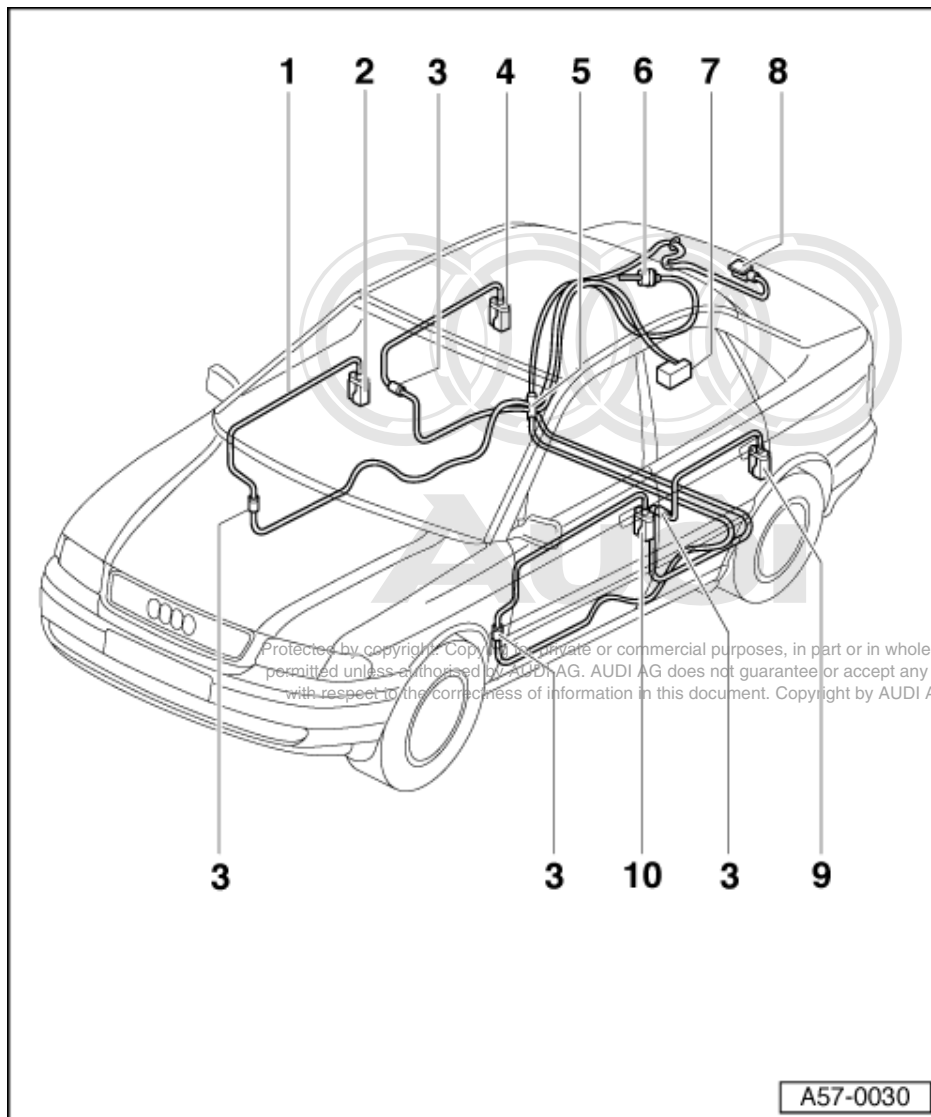
Check dimension for door subframe



- -> The outer sealing lip -3- must be flush along the A-pillar and roof trim strip -2-.
- Gap between bottom edge of roof trim strip -2- and bottom edge of seal -3- is 18.3 mm (dimension -a-).
- Window -4- enters 5 mm (dimension -b-) into seal for door component carrier -3-.

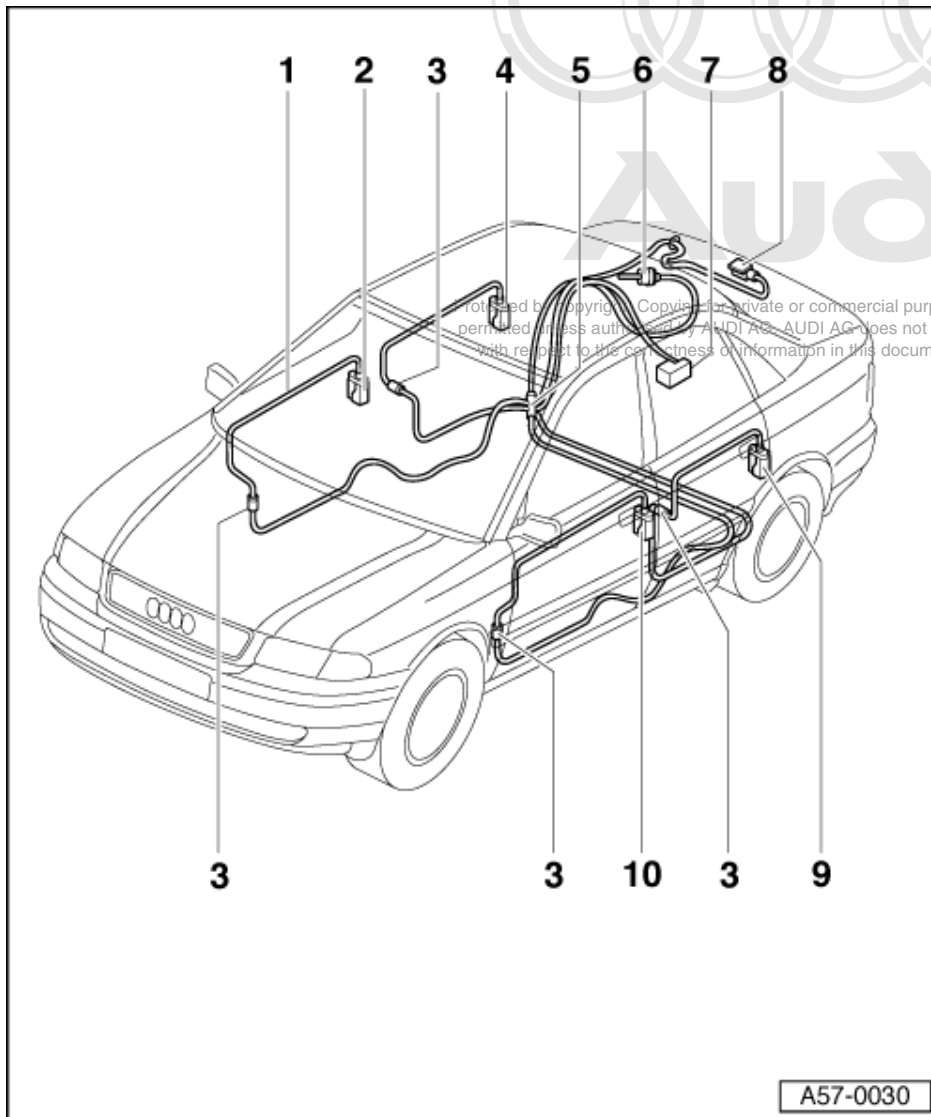
6 - Central locking

6.1 - Central locking



6.2 - Assembly overview

- 1 Vacuum line
- 2 Front right door actuator
 - ♦ Removing and installing
=>Page 75
- 3 Connectors
 - ♦ Detaching connector =>Page 103
 - ♦ Additional connectors are located at bottom of A-pillar and in bellows at B-pillar.
- 4 Rear right door actuator
 - ♦ Removing and installing Page 126 .



5 Fuel flap actuator

- ♦ Removing and installing => Page 105

6 Central locking system pump

- ♦ Removing and installing => Page 106

7 Junction

- ♦ Permanently connected to all lines except to tailgate.

8 Front left door actuator

- ♦ Removing and installing as for right door.

9 Tailgate lock actuator

- ♦ Removing and installing =>Page 105 .

10 Rear left door actuator

- ♦ Removing and installing as for right door.

Servicing central locking system

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

Note:

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

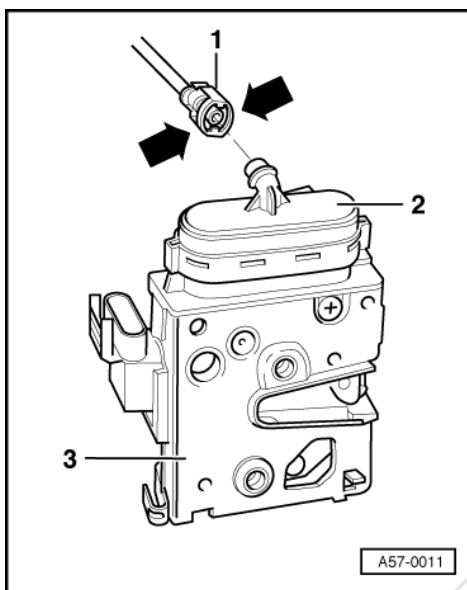
If the system is intact, all locks must be locked after approx. 2 seconds.

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

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

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

6.3 - Detaching connector



Note:

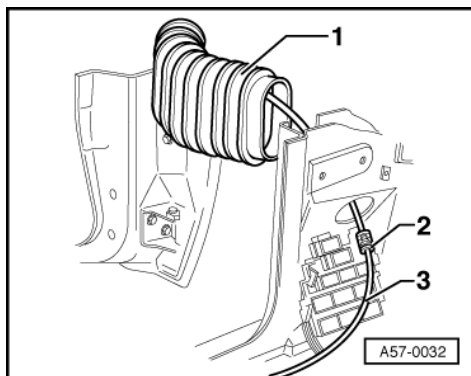
Do not simply pull the connectors off the actuators. The catches must be released first.

- -> Press connector together at arrows to release catch.
- Pull off connector.

6.4 - Repairing damaged line

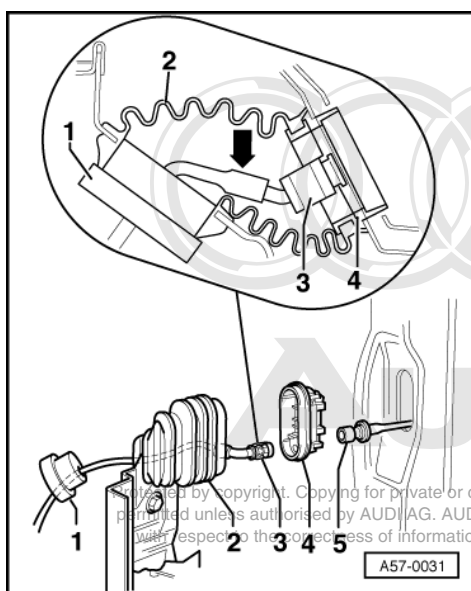
- Cut off damaged section with a knife.
- Cut connecting hose, e.g. Part No. 533 862 225 to appropriate length and push onto vacuum line.

6.5 - A- pillar connector



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

6.6 - B- pillar connector

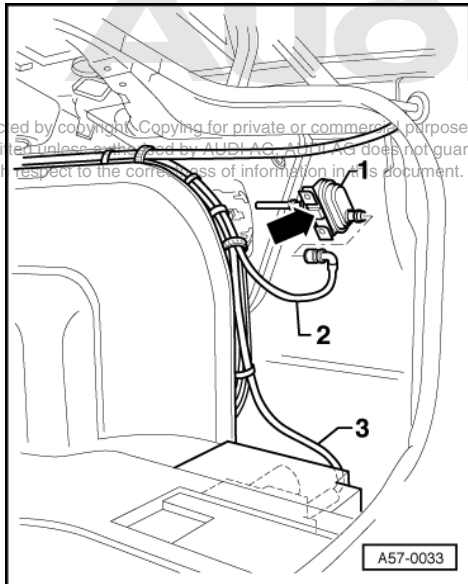


- -> Fit seal -1- with slit facing downwards.
- After pulling off bellows -2- connector -3- can be pulled off by releasing catch of line -5-.

Note:

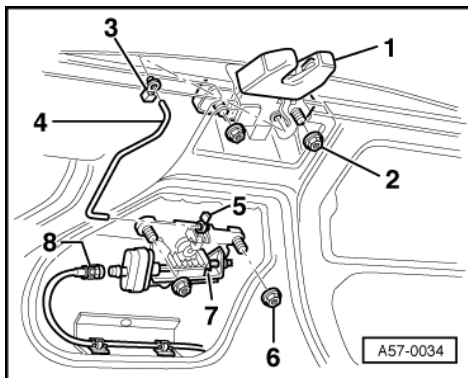
45°-connector -arrow- must face forwards in direction of travel.

6.7 - Removing and installing actuator for fuel tank flap



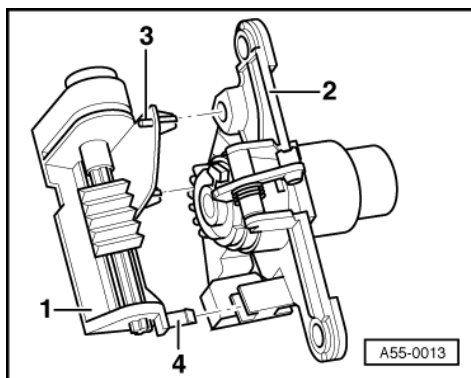
- -> Release catch of angle connector and detach vacuum line -2-.
- To remove, press in retainer tab -arrow- and pull out actuator -1- to rear
- Vacuum line -3- to central locking system pump.

6.8 - Removing and installing tailgate actuator



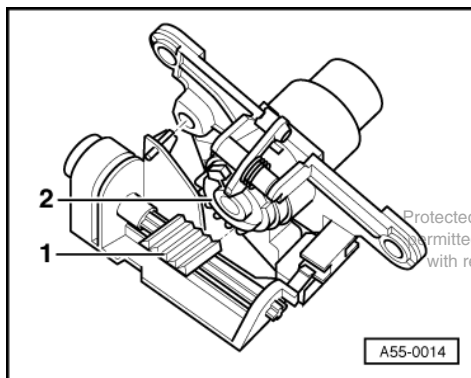
Removing:

- -> Unplug connector and detach vacuum line connection.
- Detach operating rod -4- from clip -3-.
- Unscrew hexagon nuts -6- and take out actuator -7- with tailgate lock.



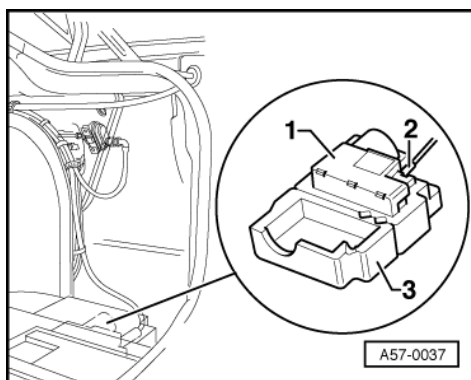
- -> Press out retaining pins -3- (2x) and pull out expanding clip.
- Press back and disengage catch -4-.
- Pull actuator -1- off tailgate lock.

Installing:

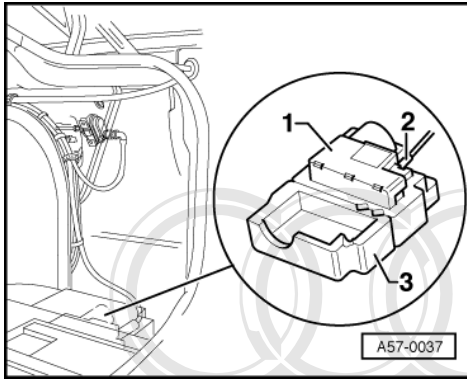


- Set lock to open position.
- -> Press rack -1- to left. First tooth of rack -1- must engage in first tooth row of toothed segment -2-.

6.9 - Removing and installing pump for central locking system



- The central locking pump is located at rear right of boot beneath boot trim.
- -> Raise boot trim-panel and remove insulation -3- with pump for central locking system -1-.
- Detach connecting hose -2- from pump.



- -> Open insulation, unplug connectors and detach vacuum line connection -2-.

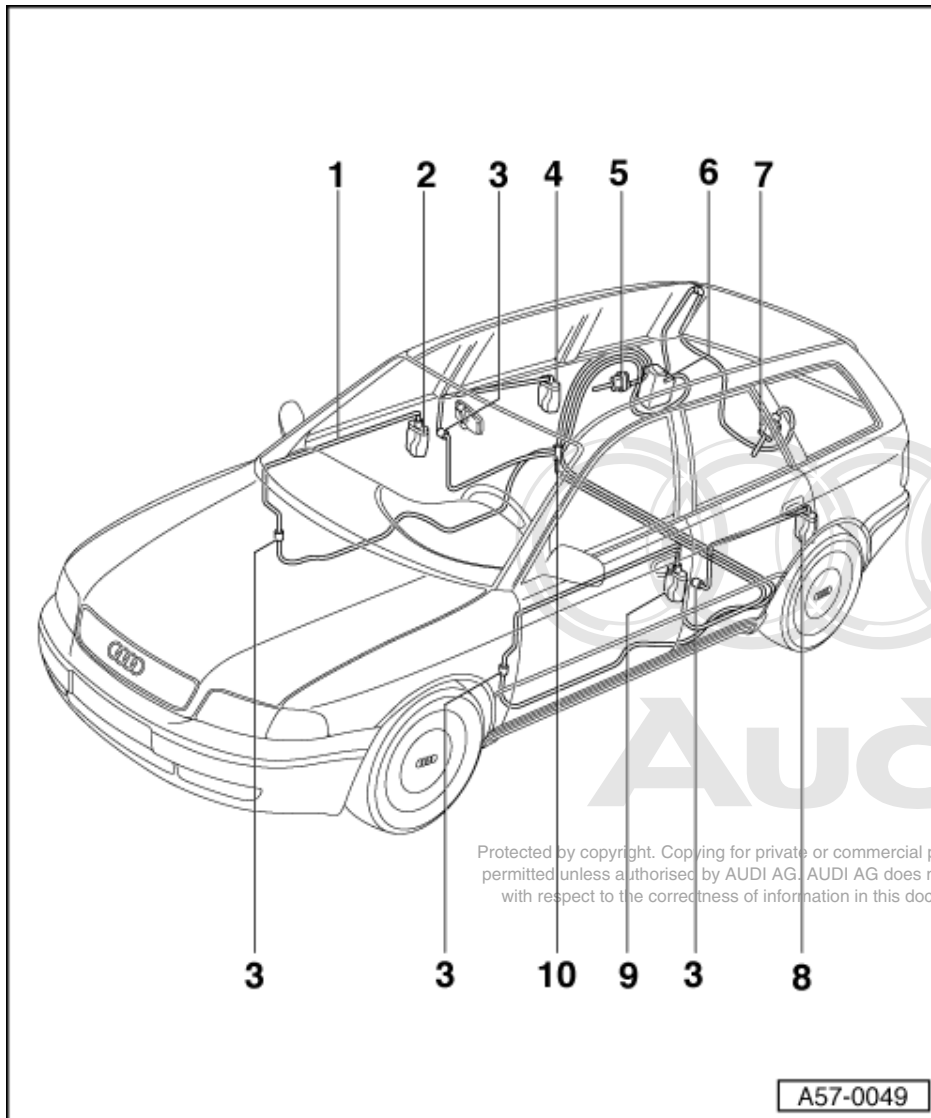
Important

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

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7 - Servicing central locking system Avant

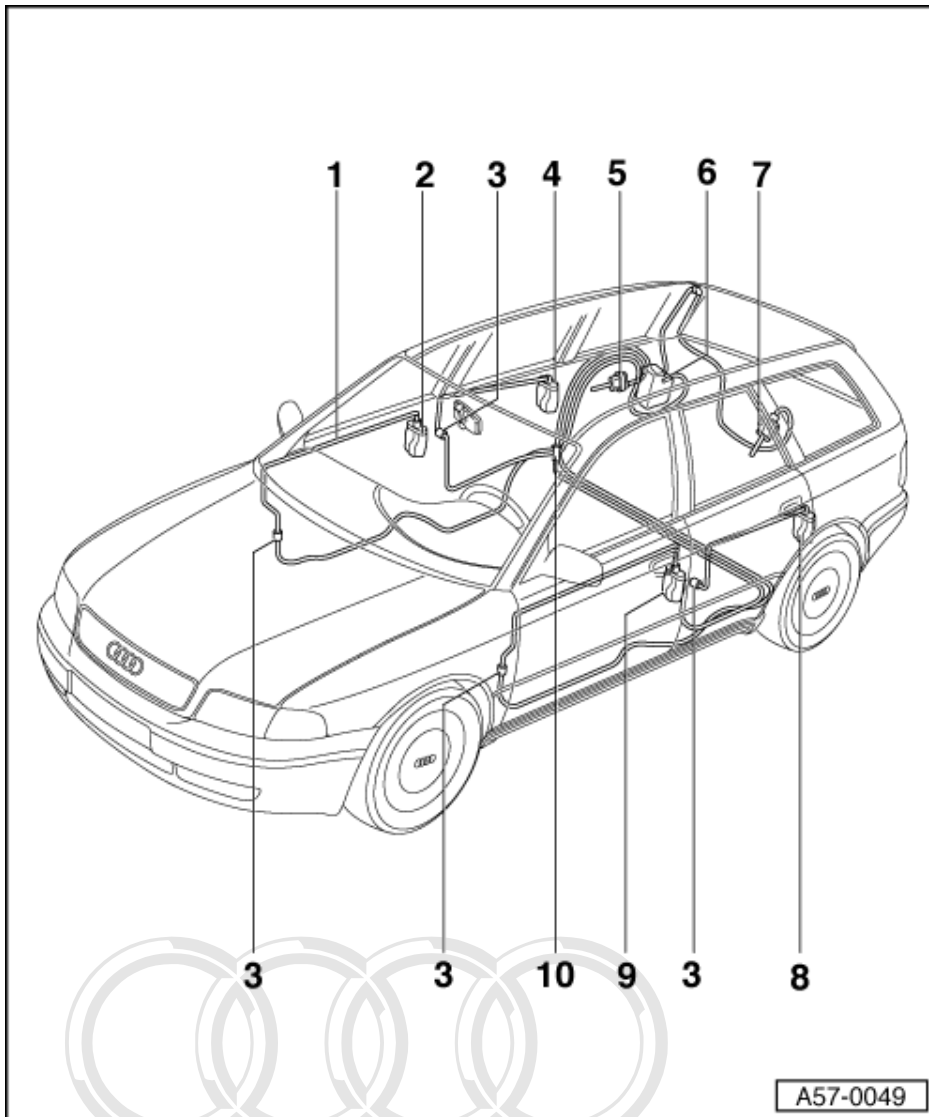
7.1 - Servicing central locking system Avant



7.2 - Assembly overview

- 1 Pressure/vacuum line
- 2 Front right door actuation valve
 - ♦ Removing and installing
=> Page 75 .
- 3 Connectors
 - ♦ Detaching connector =>Page 103 .
- 4 Rear right door actuation valve
 - ♦ Removing and installing
=> Page 126 .
- 5 Fuel flap actuator
 - ♦ Removing and installing

=>Page 110 .



6 Central locking system pump

- ♦ Removing and installing
=>Page 112 .

7 Tailgate lock actuator

- ♦ Removing and installing
=>Page 110 .

8 Rear left door actuating valve

- ♦ Removing and installing as for right door.

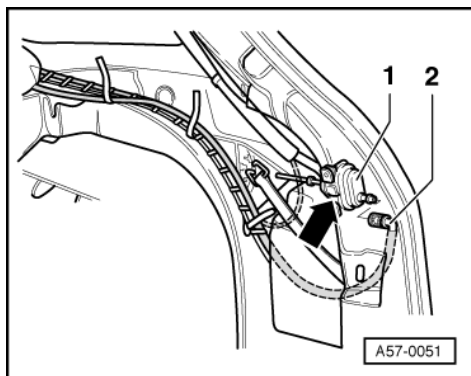
9 Front left door actuator

- ♦ Removing and installing as for right door.

10 Junction

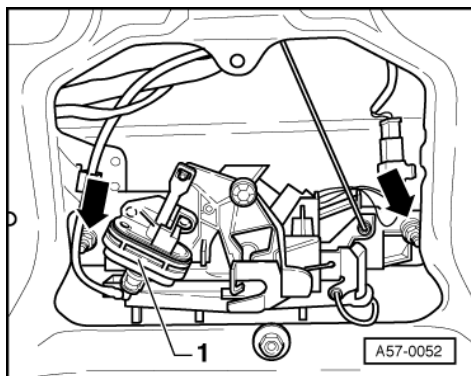
- ♦ Permanently connected to all hoses except to tailgate.

7.3 - Removing and installing actuator for fuel tank flap

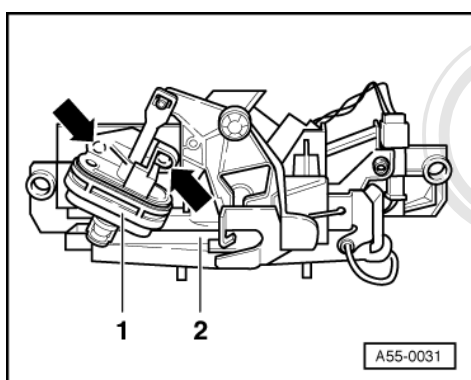


- -> Release catch of angle connector and detach vacuum line -2- from actuator -1-.
- Press in retainer tab -arrow- and pull out actuator -1- to rear out of holder.
- To install, press into holder until actuator engages.

7.4 - Removing and installing tailgate actuator



- -> Remove tailgate interior trim =>Fig. 1 .
- Unfasten catch at connector of vacuum line -1- and detach actuator -2-.



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

Note:

The illustration shows the component already removed.

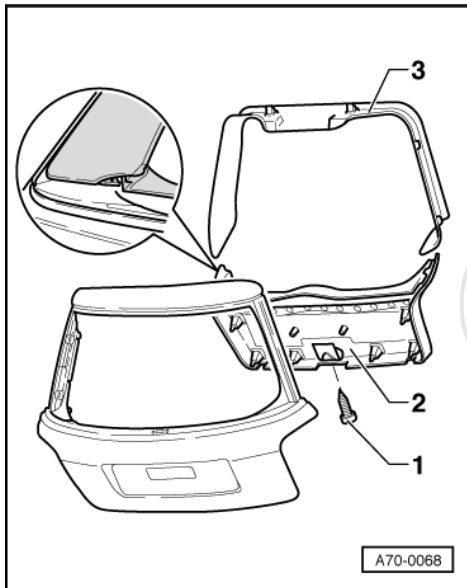


Fig.1 -> Removing and installing tailgate interior trim

- Screw bolt -1- out of recessed handle moulding.
- Torque: 1.5 Nm + 0.5 Nm
- Unclip lower tailgate trim -2-.
- Unclip upper tailgate trim -3-.

Note:

When fitting trim at bottom, insert it into upper trim with guide webs.

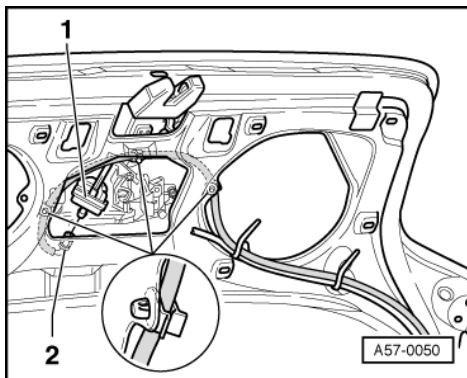
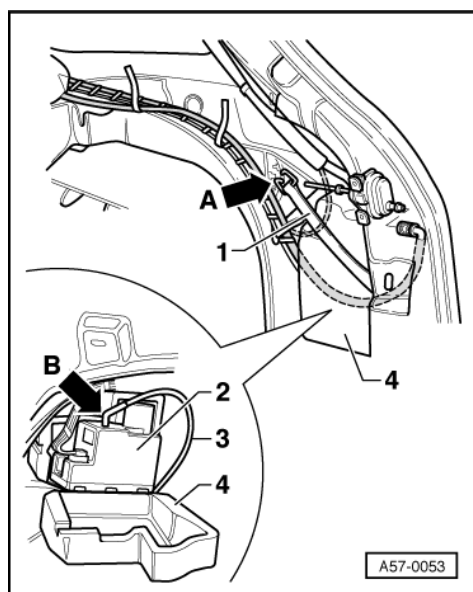


Fig2 -> Pipe routing

- Lay pressure/vacuum pipe in tie bands -4- as shown and engage in clips -3-.
- Engage connector -2- in actuator.

7.5 - Removing and installing pump for central locking system



- Detach cover at side trim.
- -> Unhook tensioner -1- at arrow -A-
- Remove insulation -4- with pump for central locking system -2- from side panel.
- Open insulation and take out pump.
- Detach electrical connectors and pull off angle connector -arrow B-

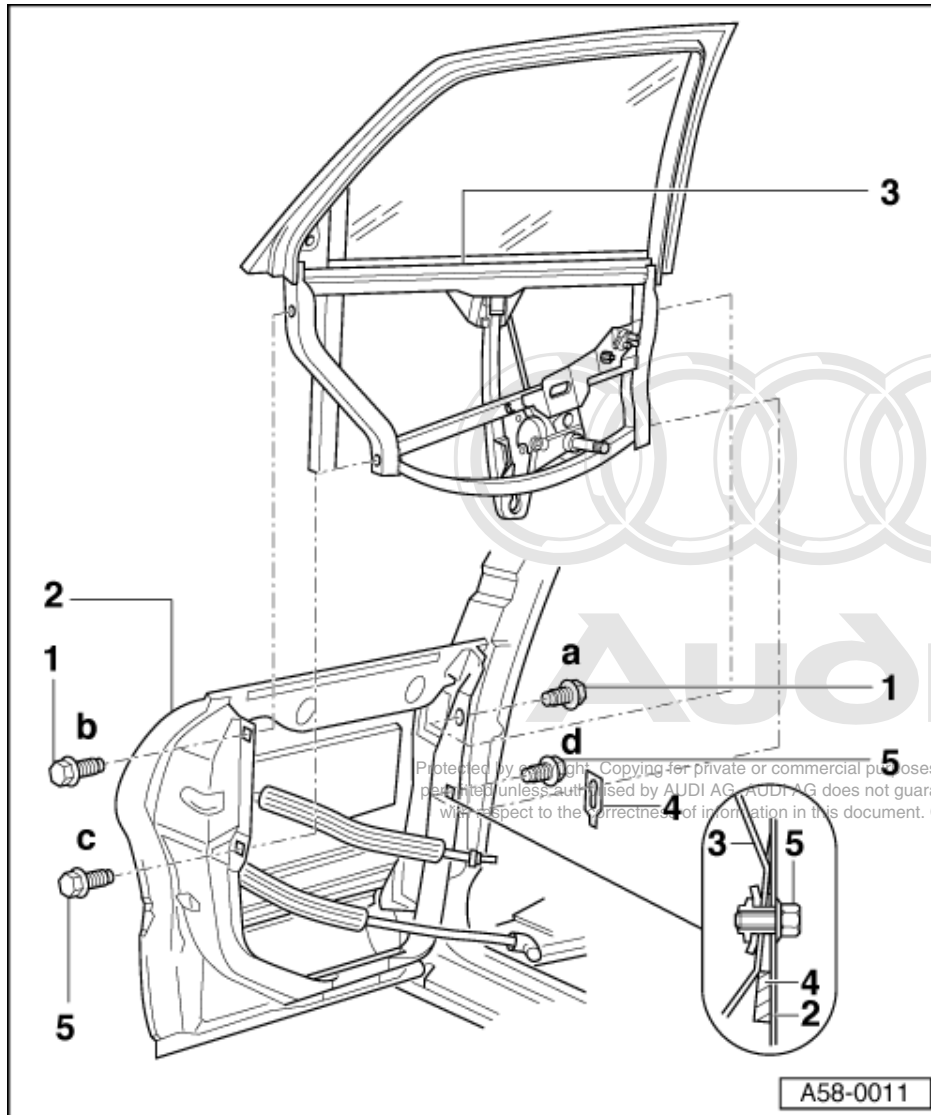
Important

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

58 - Rear doors/Door components

1 - Rear door

1.1 - Rear door



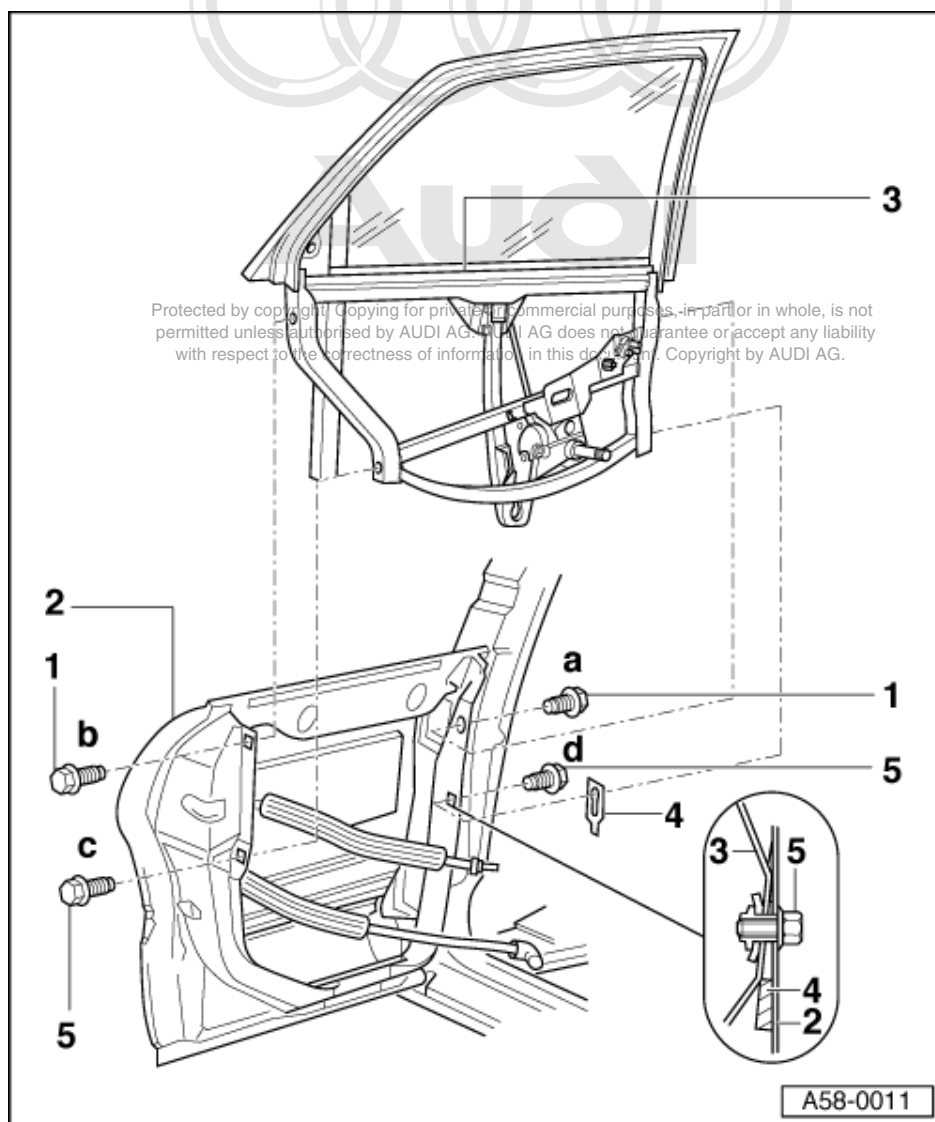
1.2 - Removing and installing rear door and door subframe

- 1 Bolt (2x)
 - ♦ Tightening torque 30 Nm.
- 2 Door shell

Note:

The door shell can also be removed without dismantling door component carrier.

- ◆ Removal:
- Remove door component carrier -3-.
- Unscrew bolts for top door hinge =>Fig. 1.
- Unscrew bolts for bottom door hinge =>Fig. 2.



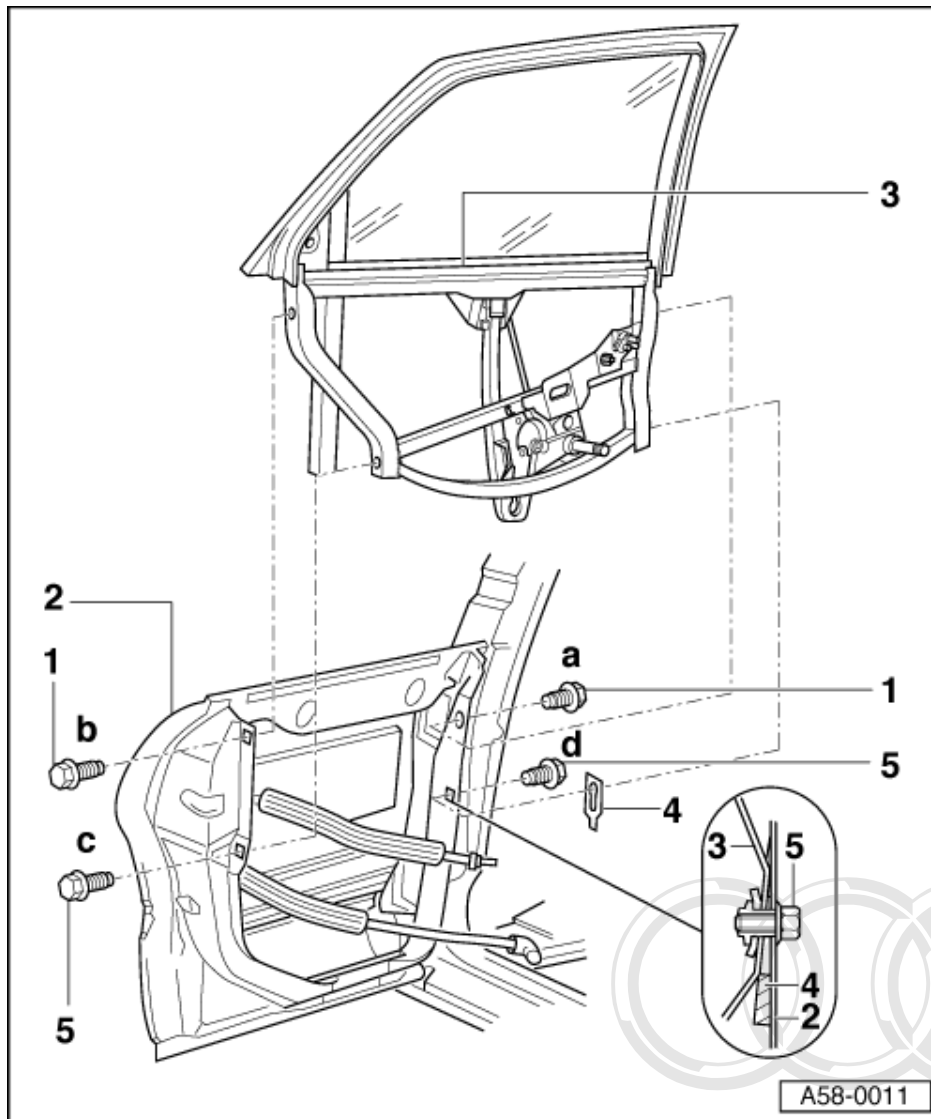
- ◆ Installation:
- Install in reverse order.
- ◆ Adjusting:
- Adjusting =>Page 136

3 Door subframe

- ◆ Removal:
- Removing door trim.

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

- Detach Bowden cable for door locking =>Fig. 3.
- Disengage bellows at B-pillar and disconnect electrical wiring and pneumatic pipes.
- Remove bolts -1- and -5-.
- Lift out door component carrier.



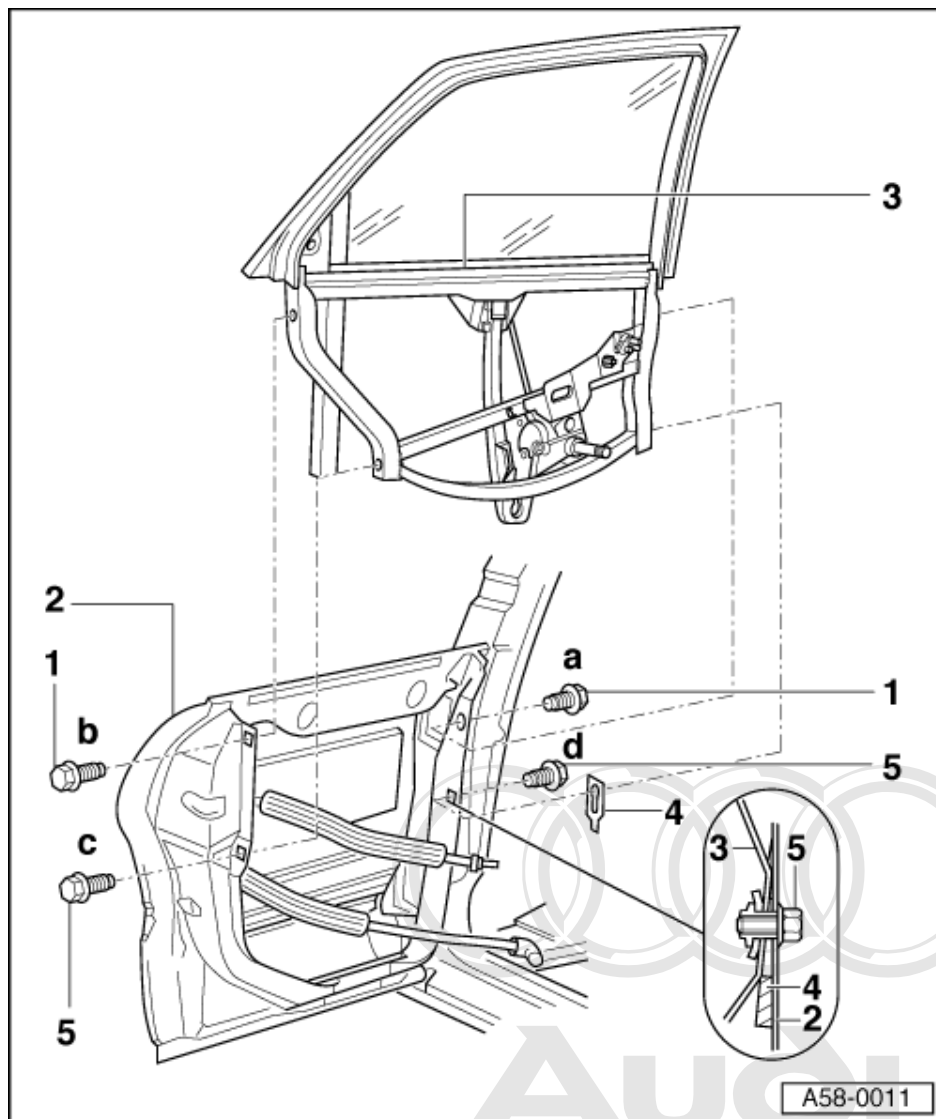
♦ Installation:

Note:

Door shell -2- must already be adjusted =>Page 136 .

- Install in reverse order.
- Insert door component carrier in door shell and screw on loosely with bolts -1- and -5- with adjusting wedge -4-.
- Bolts -1- and -5- must be tightened in sequence a; b; c; d.
- ♦ Adjusting:
- Adjusting =>Page 137 .

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4 Adjuster

Note:

Adjusting wedge must always be fitted.

- ♦ Angle of door can be adjusted in C-pillar area by shifting adjusting wedge -4- =>Page 137 .

5 Bolt (2x)

- ♦ Tightening torque 30 Nm.

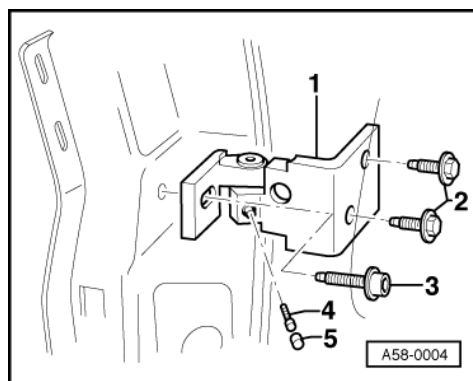


Fig.1 -> Upper door hinge

- To remove the door shell, unscrew bolt -3-.

Tightening torque 30 Nm.

Note:

Door hinge -2- can also be detached via stud bolt -4-.

(Tightening torque 23 Nm).

- Trim cap -5-.
- To remove door hinge -1-, also unscrew bolts -1- (2x).

Tightening torque 30 Nm.

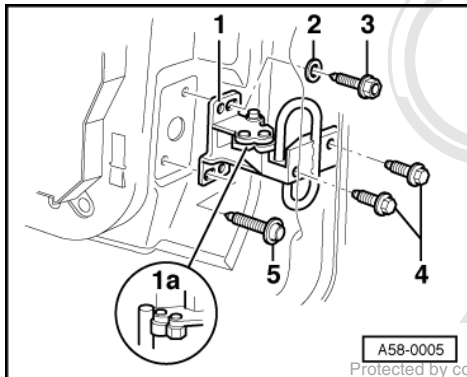
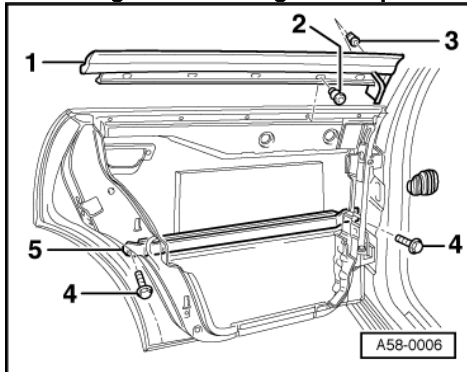


Fig.2 -> Lower door hinge

- To remove the door shell, unscrew bolt -3-.
- To remove door hinge -2-, also unscrew bolts -1- (2x).
- Grease points -1a- grease G 000 150.

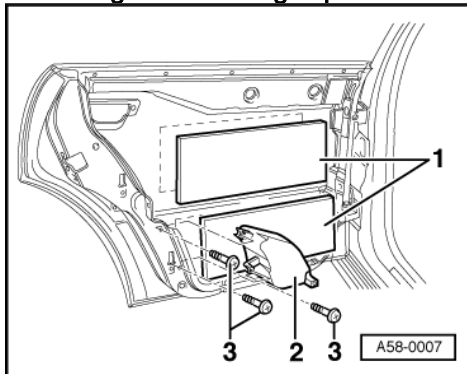
Removing and installing side impact bar



- -> To remove, unscrew bolts -4- (2x) and take out impact bar -5-.

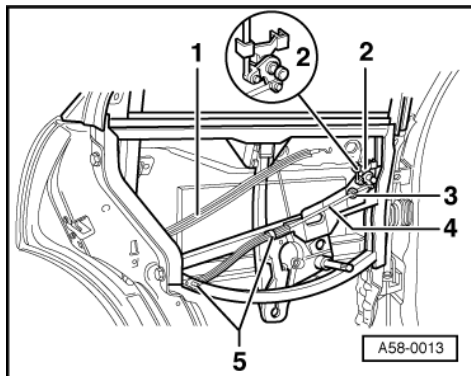
Tightening torque 8 Nm.

Removing and installing impact absorber for rear door



- -> To remove, unscrew bolts-3- (2x).
Tightening torque 3 Nm.
- Take out impact absorber -2-.
- Insulating mats -1- (2x).

Fig.3 Bowden cable for door locking



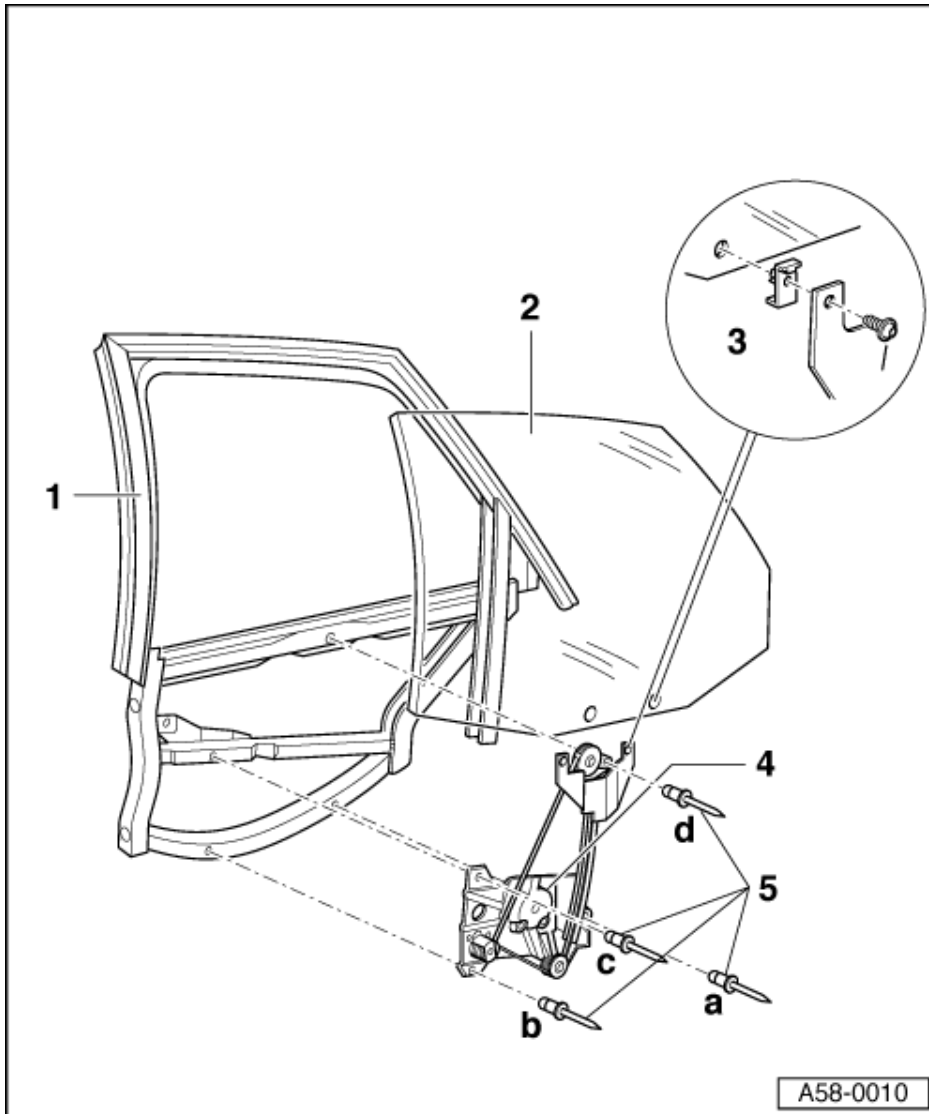
- Unfasten Bowden cable -4- from clips -5- and -3-.
- Screw plastic bolt out of hinged lever -2-.
- Unclip hinged lever -2- and disengage Bowden cable.
- Bowden cable -1- for inside door mechanism.



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

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



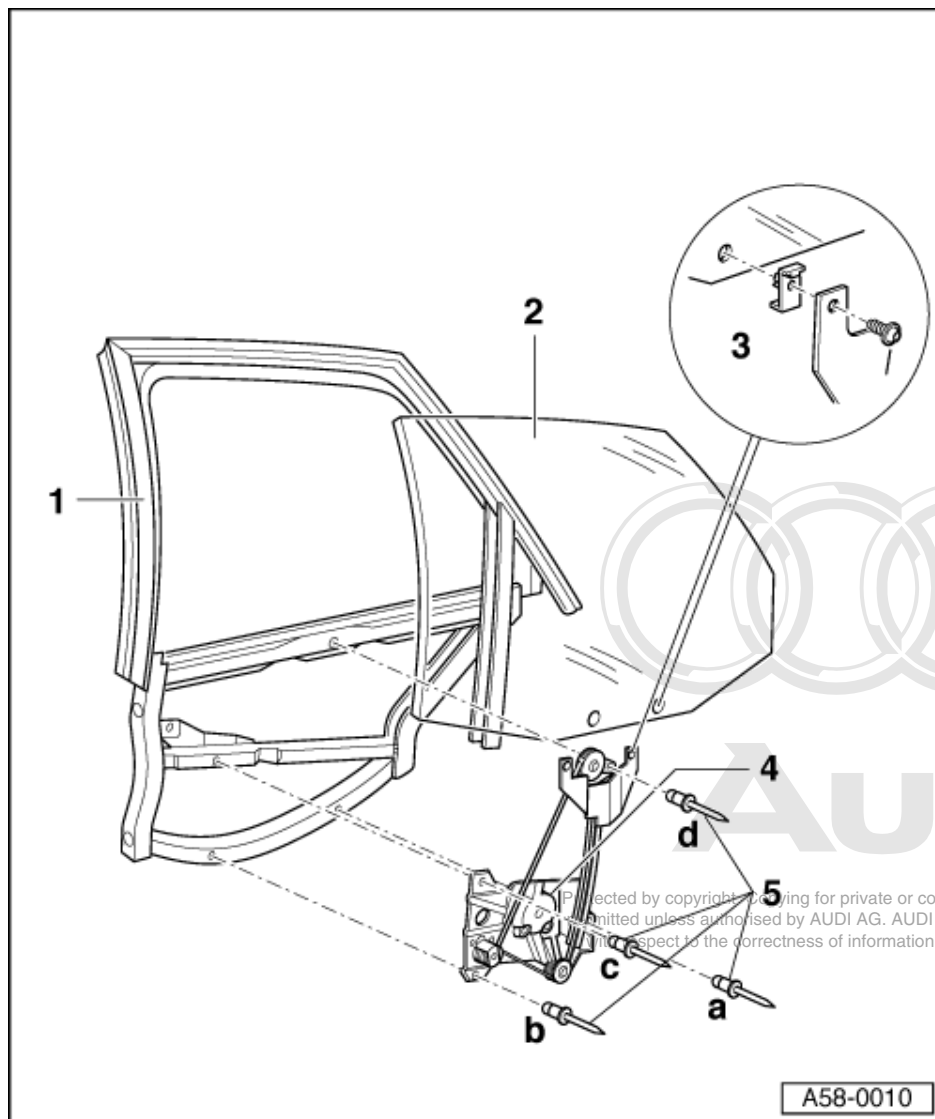
1 Door subframe

- ◆ Removing and installing => Page 114 .

2 Washer

- ◆ Removal:
 - Remove door subframe -1-.
 - Lower window lifter -4- fully.
 - Unscrew bolts -3-.
 - Unclip and take out window.
- ◆ Installing/adjusting
 - Clip in clip -3-.
 - Installing and adjusting =>Page 121 .

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3 Bolt (2x)

- ♦ Tightening torque 2.5 Nm.

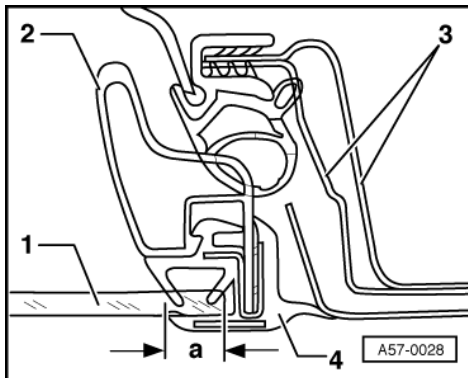
4 Window lifter

- ♦ Removal:
 - Remove door subframe -1-.
 - Unscrew bolts -3-.
 - Unclip and take out window.
 - Drill out rivets -5-
 - Take out window lifter.
- ♦ Installation:
 - Install in reverse order.

5 Rivets

- Fit rivets in sequence a; b; c, d.
- Fit using V.A.G 1753 B.

2.2 - Adjusting rear window



- As a check, dimension $a = 9 \text{ mm}$ can be marked on window in length of B-pillar with a water soluble pen.
- -> Position window at window lifter.
- Raise window until shortly before stop.
- Window -1- and seal -4- for door component carrier must run parallel in roof and C-pillar area.
- Press window -1- towards B-pillar -3-.

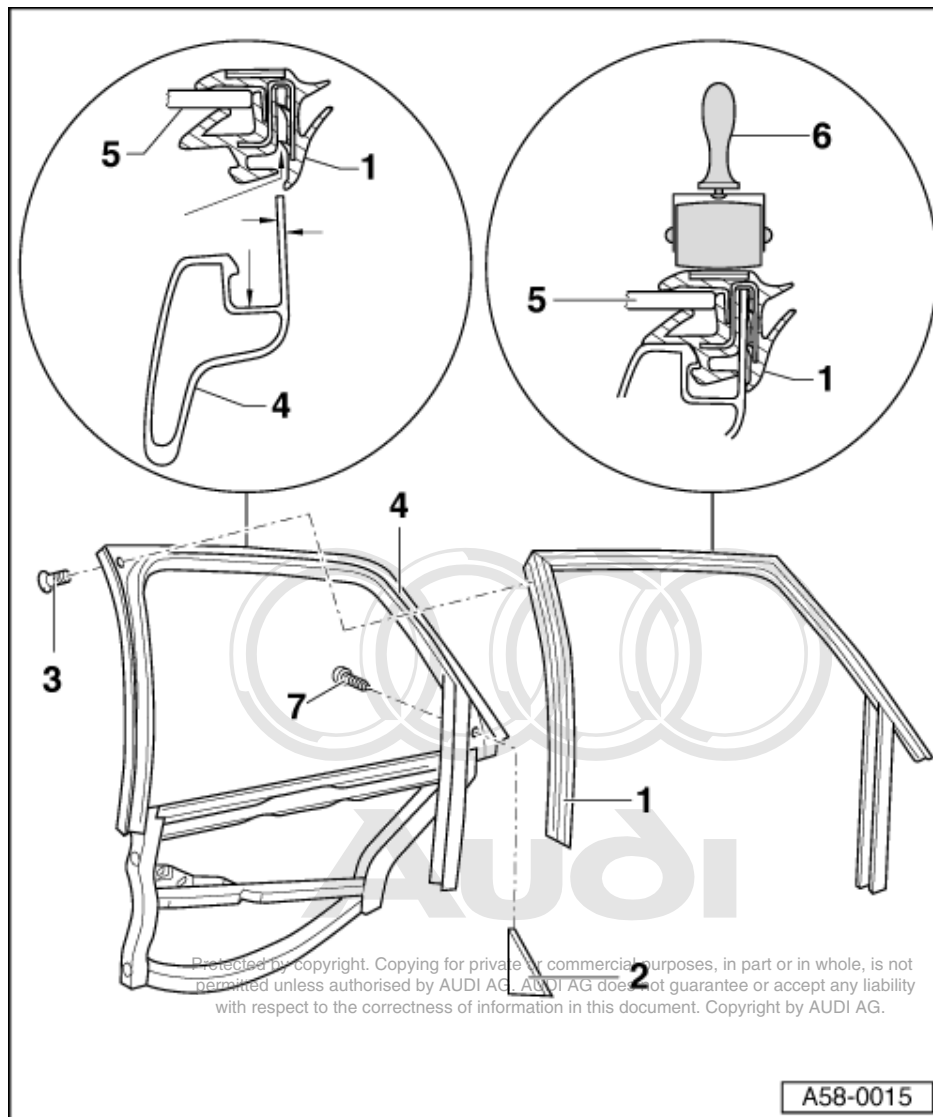
Note:

Window -1- must enter 9 mm-dimension a into seal -4- for door subframe -3-.

- Tighten bolts on window lifter mount.
Tightening torque 2.5 Nm.
- Raise window -1- as far as it will go.
- Check dimension -a- and erase pen mark.

3 - Removing and installing rear side window seal

3.1 - Removing and installing rear side window seal



- ◆ Door trim
- Removing and installing.

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

- ◆ Door subframe
- Removing and installing => Page 114
- ◆ Door window
- Removing and installing =>Page 119 .

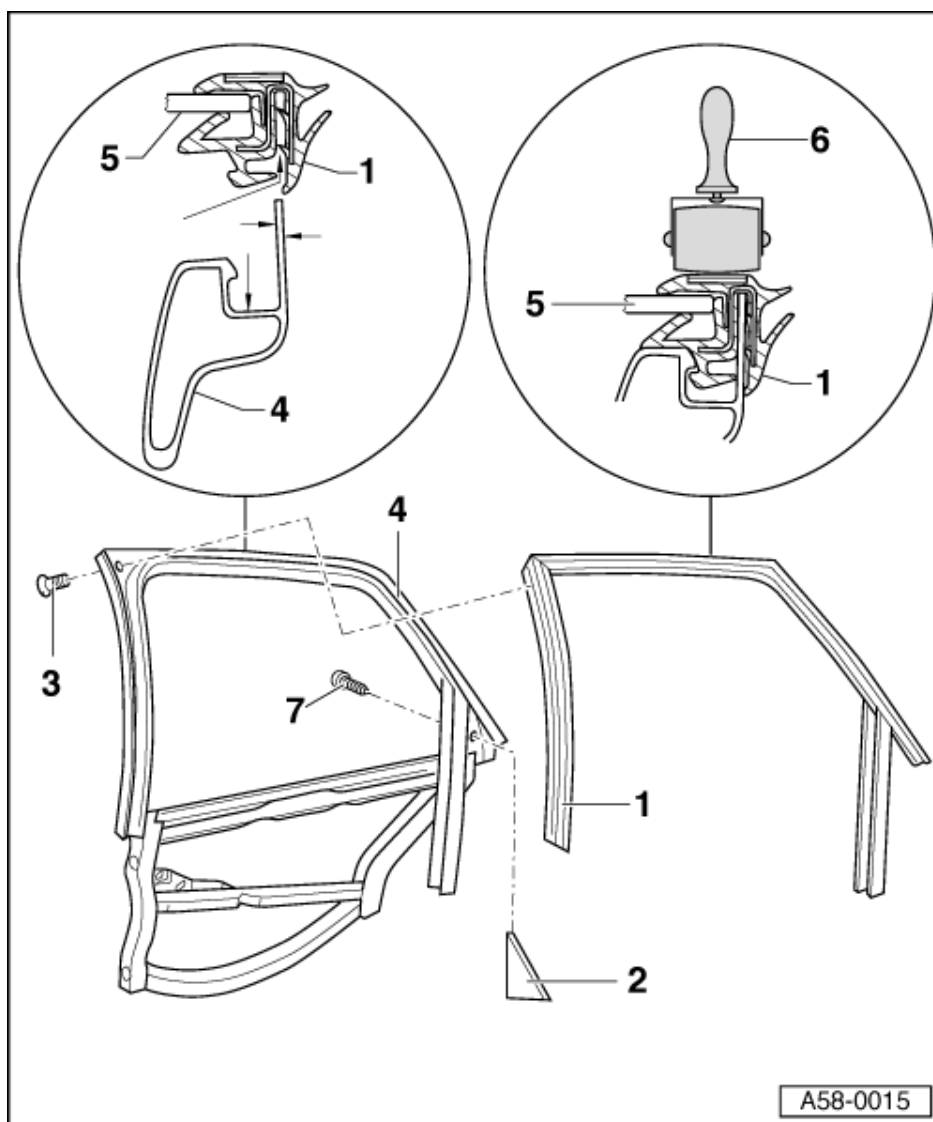
1 Door window seal

Removal:

- Unscrew bolt -7- and detach trim -2-.
- Dismantle window seal -1- from fastening pin -3- and pull off door component carrier -4-.

Note:

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

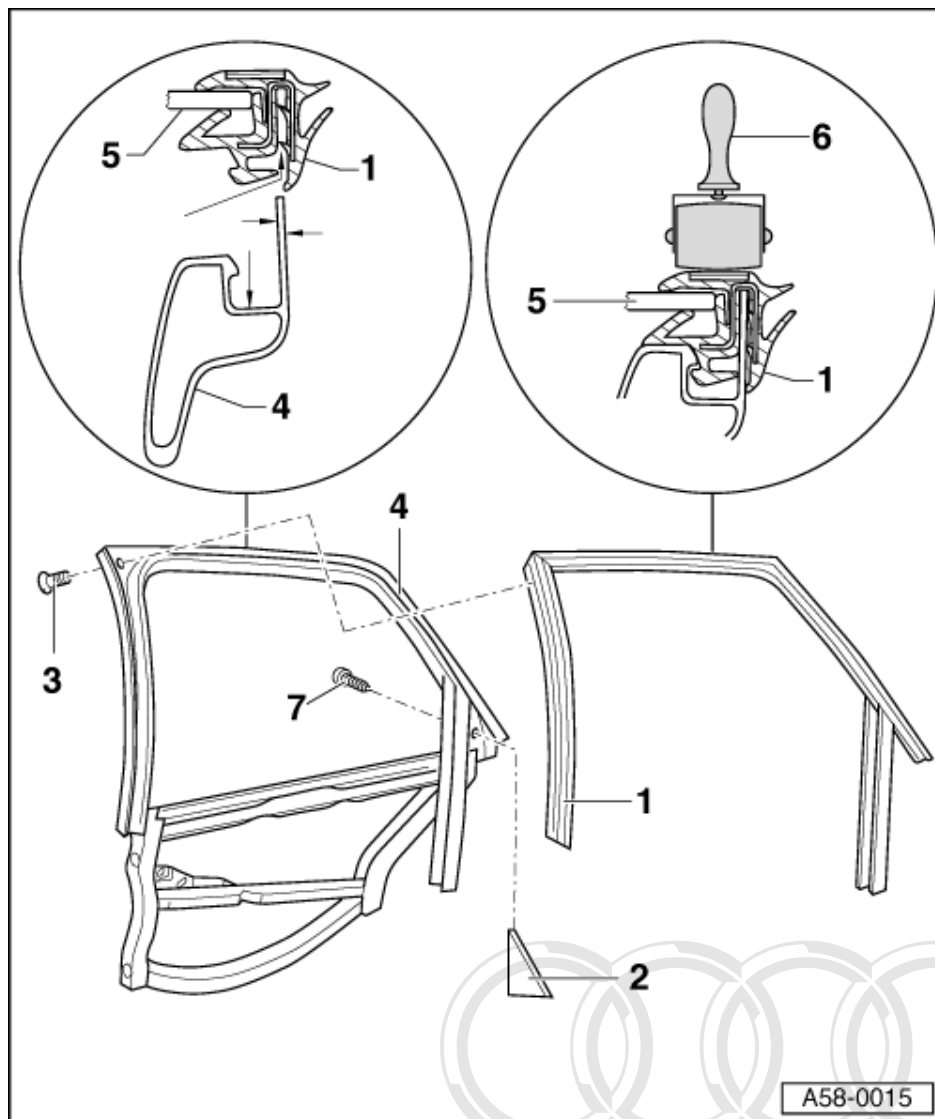


Installation:

- Brush over window seal -1- and door component carrier -4- at marked locations (arrows) with soap solution.
- Attach window seal -1- at bevelled corners and press on by hand.
- Install window -5-
- With window closed, roll gently over door seal -1- with wallpaper roller -6- (place door component carrier on firm surface).

Note:

Window guide -1- is not to be knocked into position, as this could lead to corrugations and subsequent damage.



2 Panel

- To remove, unscrew bolt -7- and unclip trim.

3 Securing pin

- Dismantling: Simply press off seal in corner.
- Fit: Press in fastening pin with plastic wedge whilst providing support at seal.

4 Door subframe

5 Door window

6 Wallpaper roller

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4 - Removing and installing inner door seal

4.1 - Removing and installing inner door seal

Removing and installing lower A pillar trim

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

Removing and installing upper B-pillar trim.

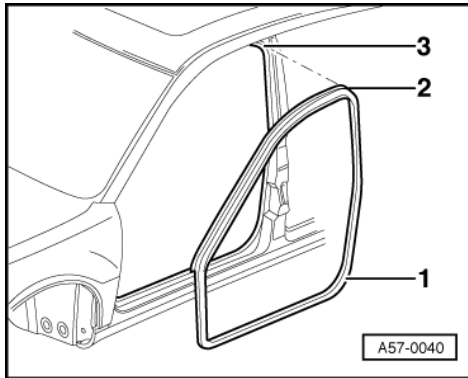
=> General Body Assembly; Repair group 70; Trims

Removing and installing lower B-pillar trim.

=> General Body Assembly; Repair group 70; Trims

Remove inner sill panel trim.

Installation:



- -> Position door seal -1- with end of PVC lip -2- at mark -3- in side panel frame.

Note:

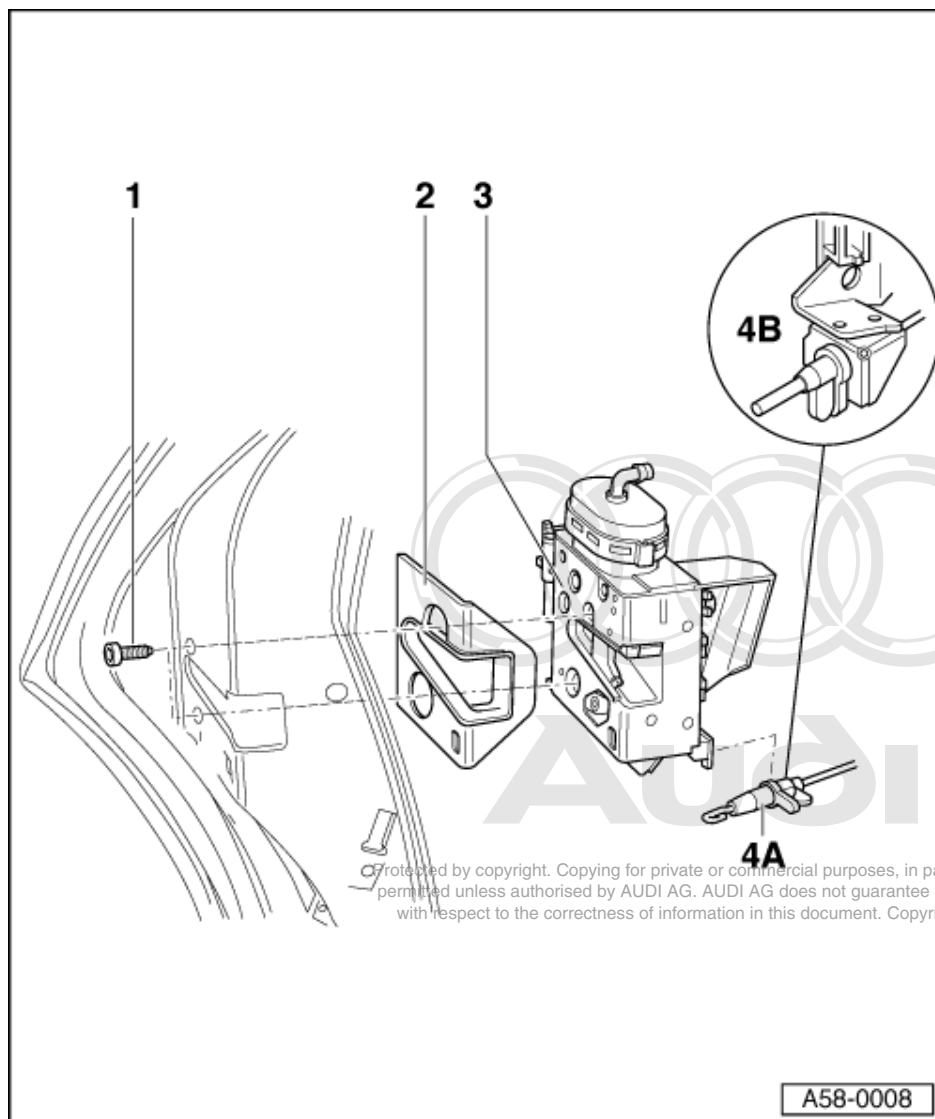
Compress excess seal length in area of B-pillar and sill panel flange.

- Use plastic-headed hammer to carefully attach inner door seal to flange.

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5 - Removing and installing rear door lock with operating elements

5.1 - Removing and installing rear door lock with operating elements



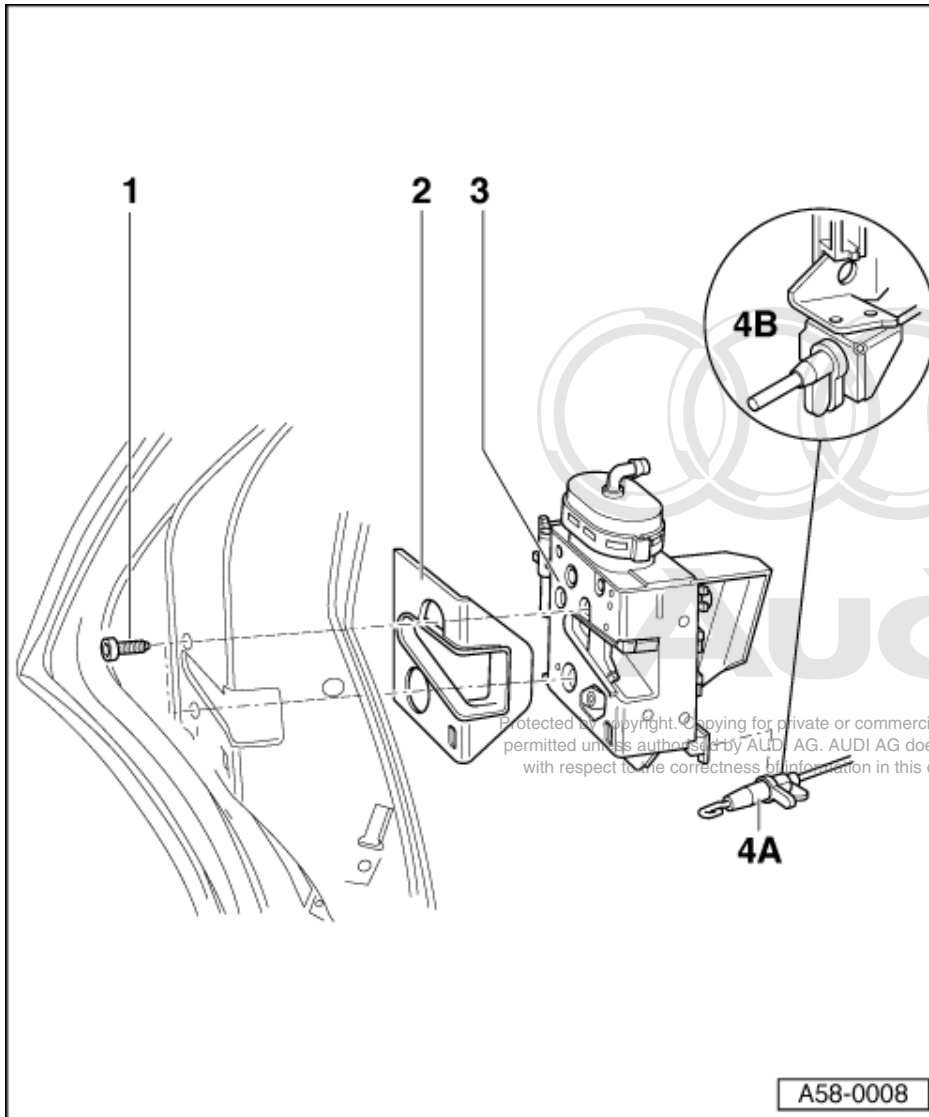
1 Bolt (2x)

- ◆ Tightening torque 9.5 Nm.

2 Lock base plate

3 Door lock

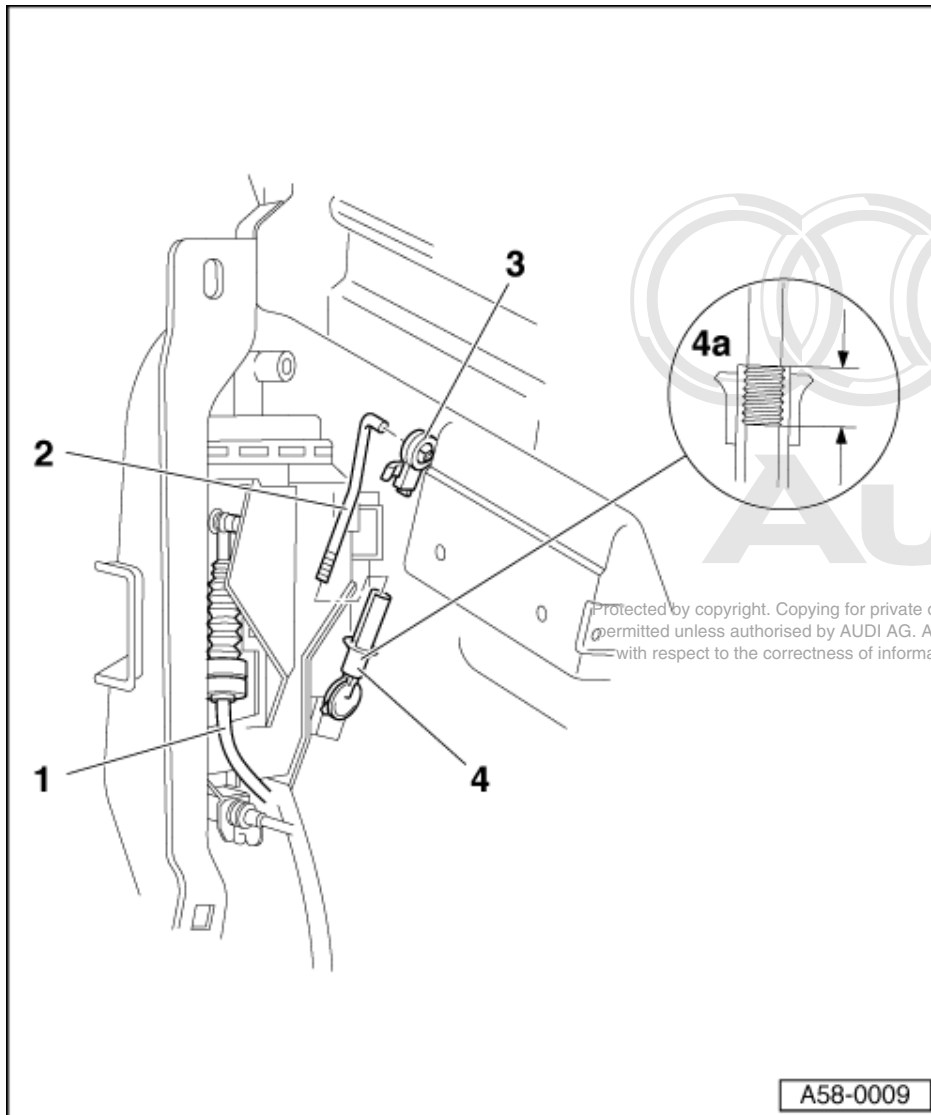
- ◆ Removal:
 - Remove door subframe =>Page 114
 - Unclip Bowden cable -4- for inside door mechanism.
 - Unclip pipe for central locking system.
 - Unclip operating rods.
 - Unscrew bolts -1- and take out lock to inside.
- ◆ Installation:
 - Install in reverse order.



4 Bowden cable for interior door handle

- ◆ Removal:
 - Remove door subframe =>Page 114
 - Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
 - Install in reverse order.

5.2 - Removing and installing operating rods for rear door lock



1 Bowden cable for door locking

- ♦ Removing and installing =>Fig. 4 .

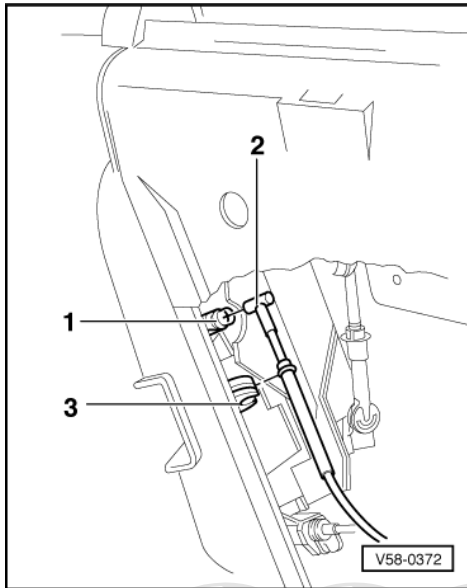
2 Operating rod

- ♦ Adjusting:
 - Insert operating rod in hinged bushing -3-.
 - Clip operating rod into operating clips -4- without straining door lock release lever (max. play 1.5 mm).
 - Push sleeve onto operating clip -4-.
 - Clipping-in length -4a- 13 ± 3 mm.

3 Hinged bushing

4 Operating clip

Fig.4 Bowden cable for door locking

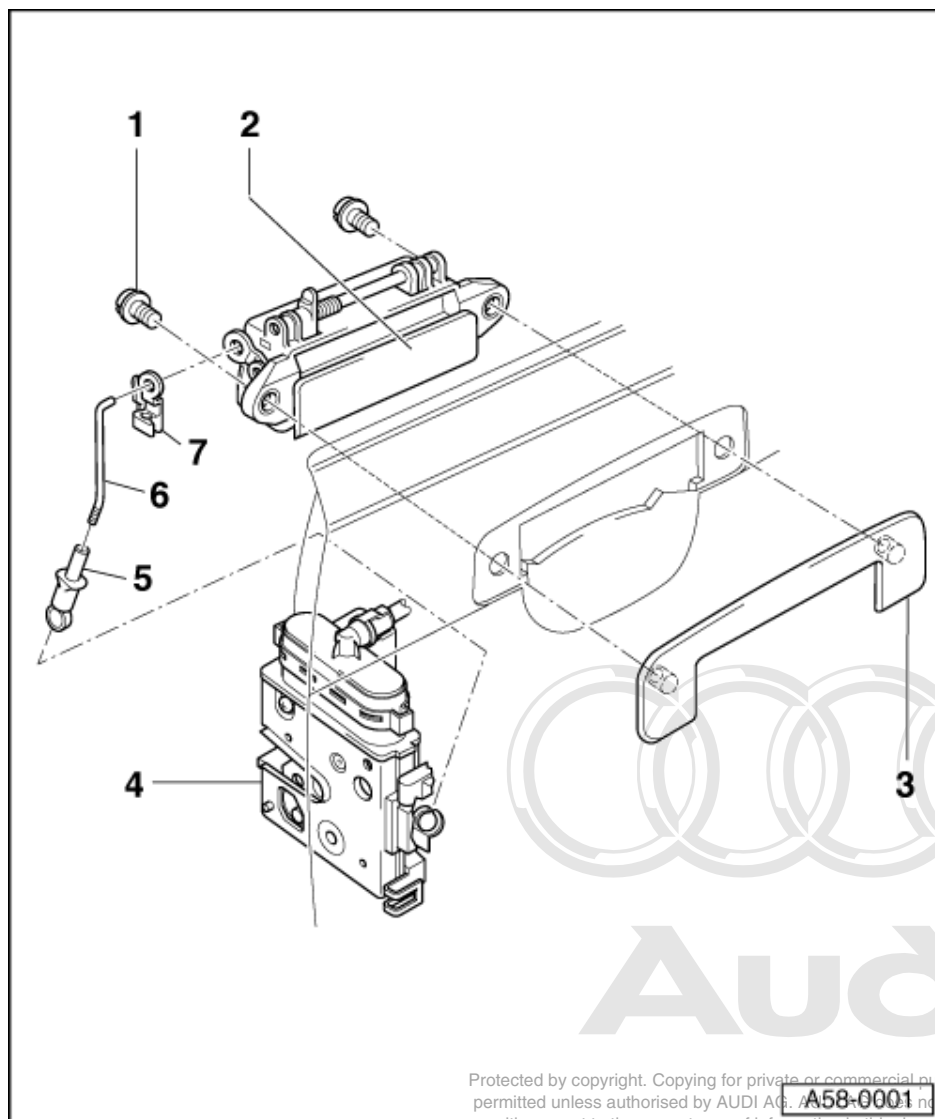


- To remove, unclip Bowden cable -2- from holder -1- and press out of support bracket -3-.

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6 - Removing and installing rear door handle

6.1 - Removing and installing rear door handle



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A58-0001

6.2 - >8D XA 200 000

Note:

To remove door handle, remove door component carrier => Page 114 .

1 Oval head bolt (2x)

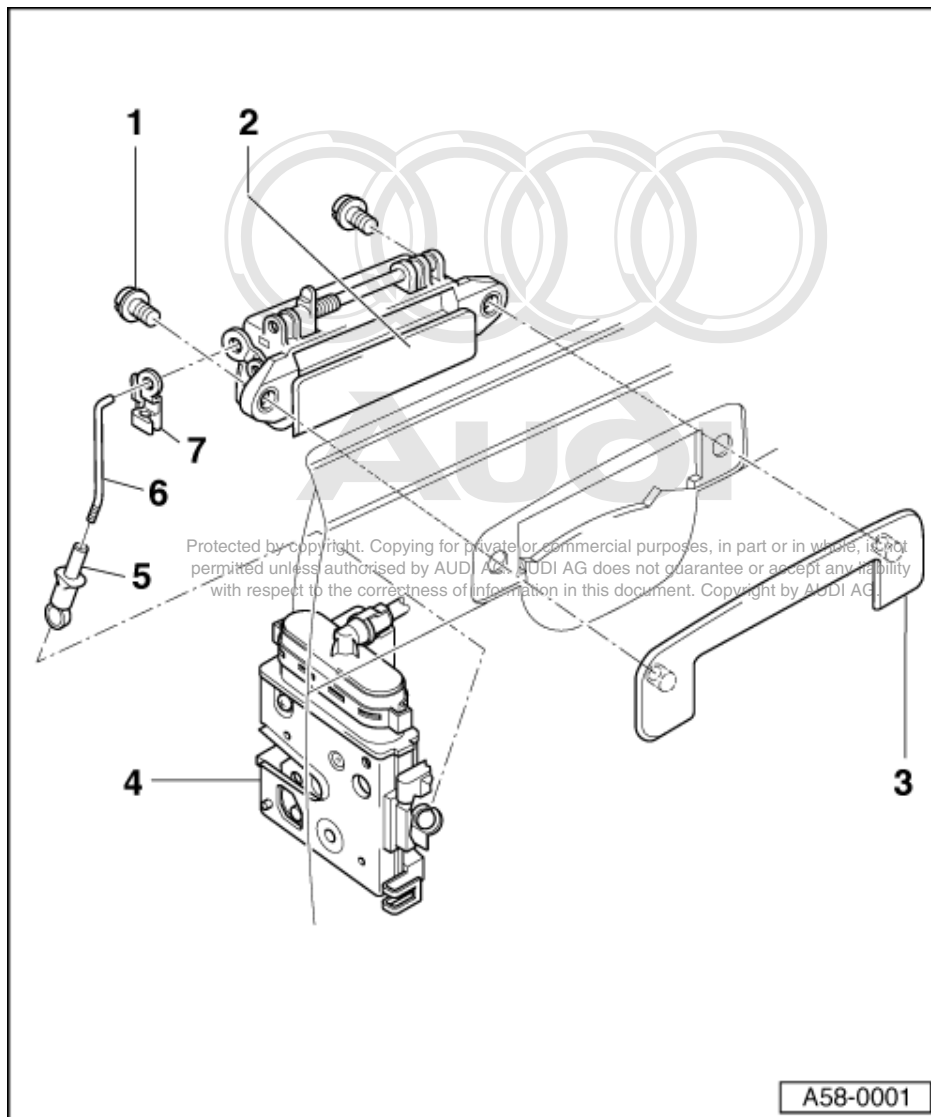
- ♦ Tightening torque 5 Nm.

2 Door handle

- ♦ Disengage operating rod -6- from operating clip -5- and hinged bush -7-.
- ♦ Screw out bolts, detach trim -3- and door handle -2-.

Note:

To avoid damage to paintwork on the handle cover, remove it before removing the door handle =>Fig. 1.



- 3 Panel**
 - ♦ Removing and installing =>Fig. 1.
- 4 Door lock**
 - ♦ Removing and installing =>Page 126.
- 5 Operating clip**
- 6 Operating rod**
 - ♦ Removing and installing =>Page 128.
- 7 Hinged bushing**

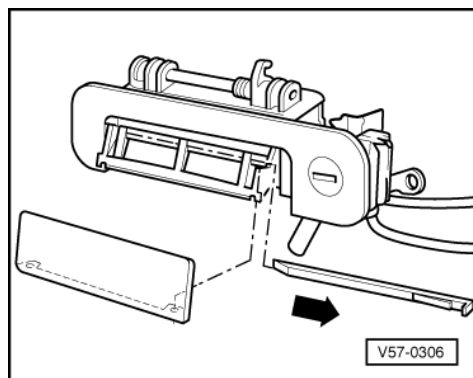
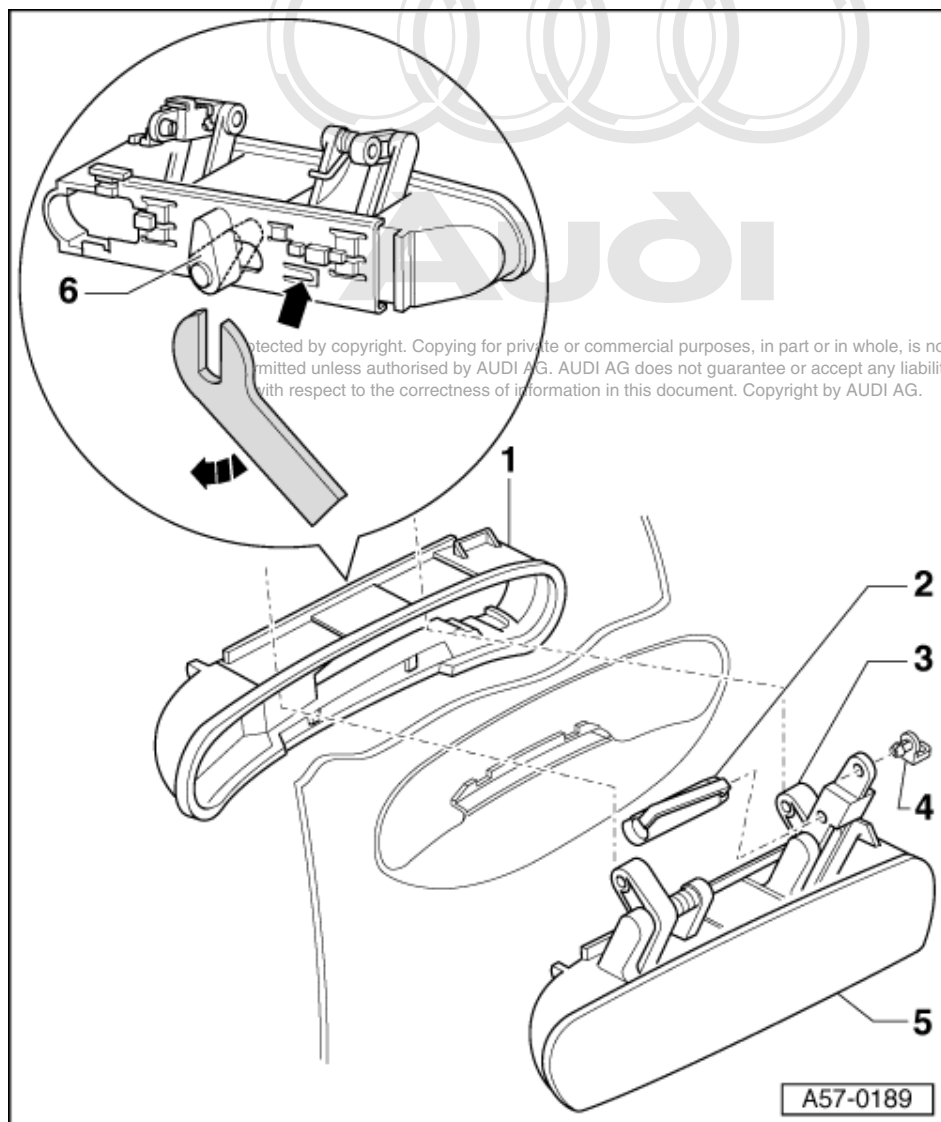


Fig.1 -> Remove cover for door handle

- Pull up door handle.
- Lever fastening strip out of door handle using small screwdriver in direction of arrow and remove.
- Remove door handle cover.

6.3 - 8D XA 200 001>



1 Door handle mount

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

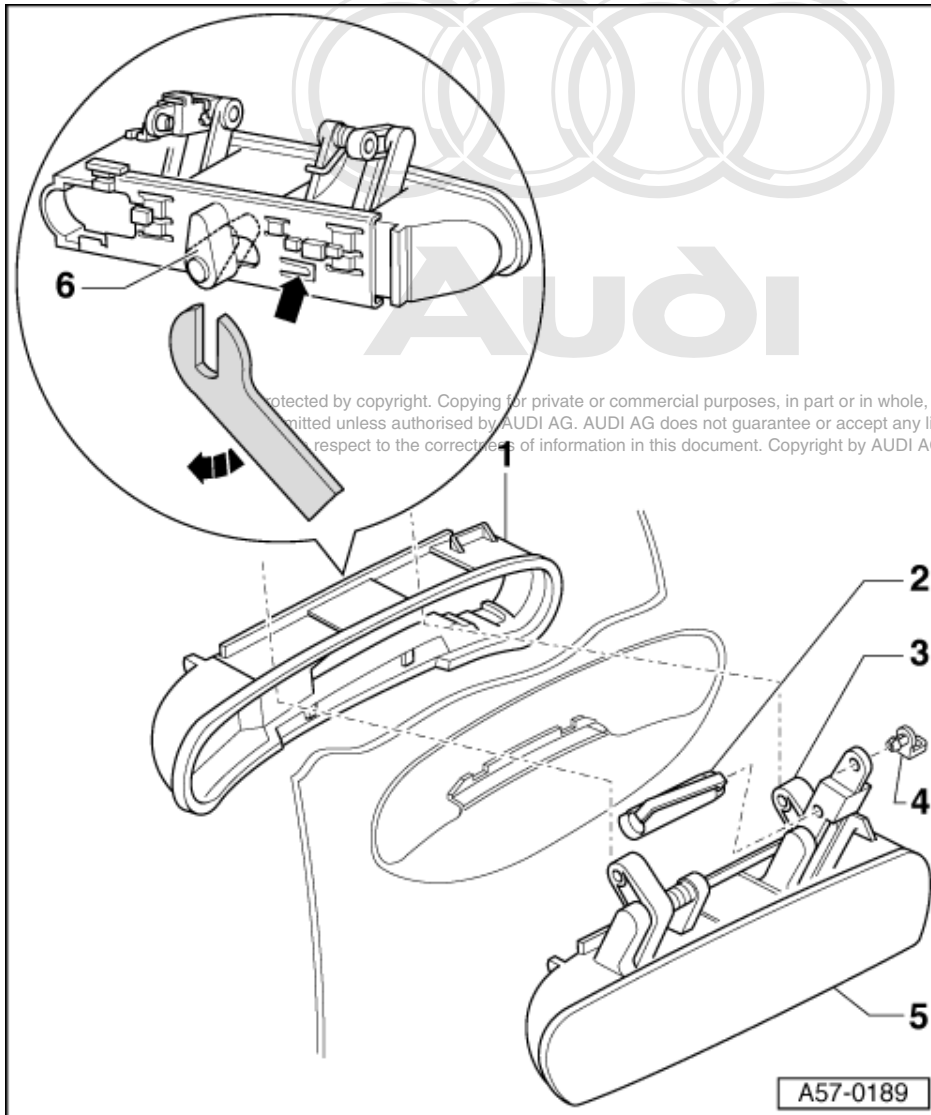
2 Locking pin

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

3 Hinged lever

4 Clip

- ◆ Unclip operating rod for door lock here when removing door handle -5- =>Page 128 .



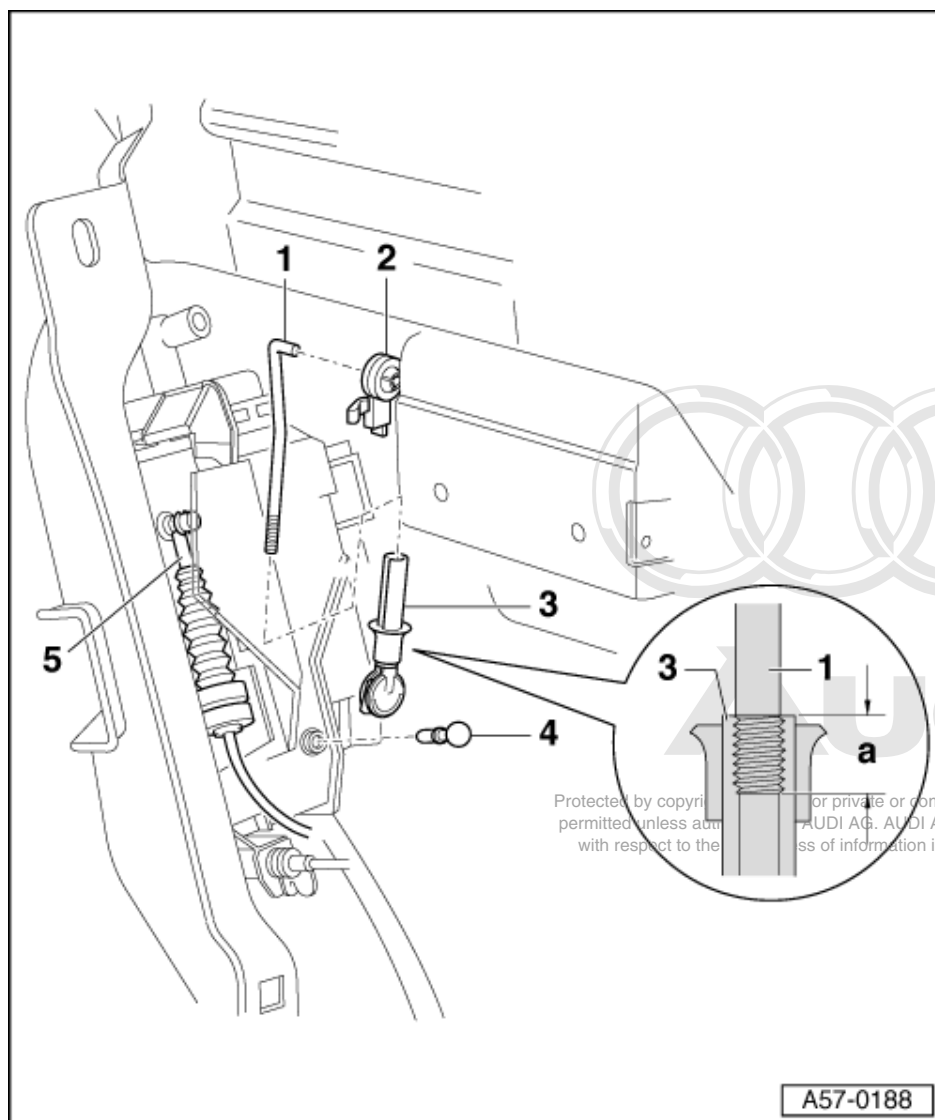
5 Door handle

- ◆ Removing
 - Door trim and door sub-frame removed.
 - Detach operating rod from hinged lever =>Page 128 .
 - Release catch -arrow -A- for slide with a small screwdriver by lifting slightly.
 - With an open-ended wrench, turn cam -6- in direction of arrow -B-, thus releasing the slide.

6 Cam

- ◆ To release door handle mount.

6.4 - Removing and installing operating rods for rear door lock



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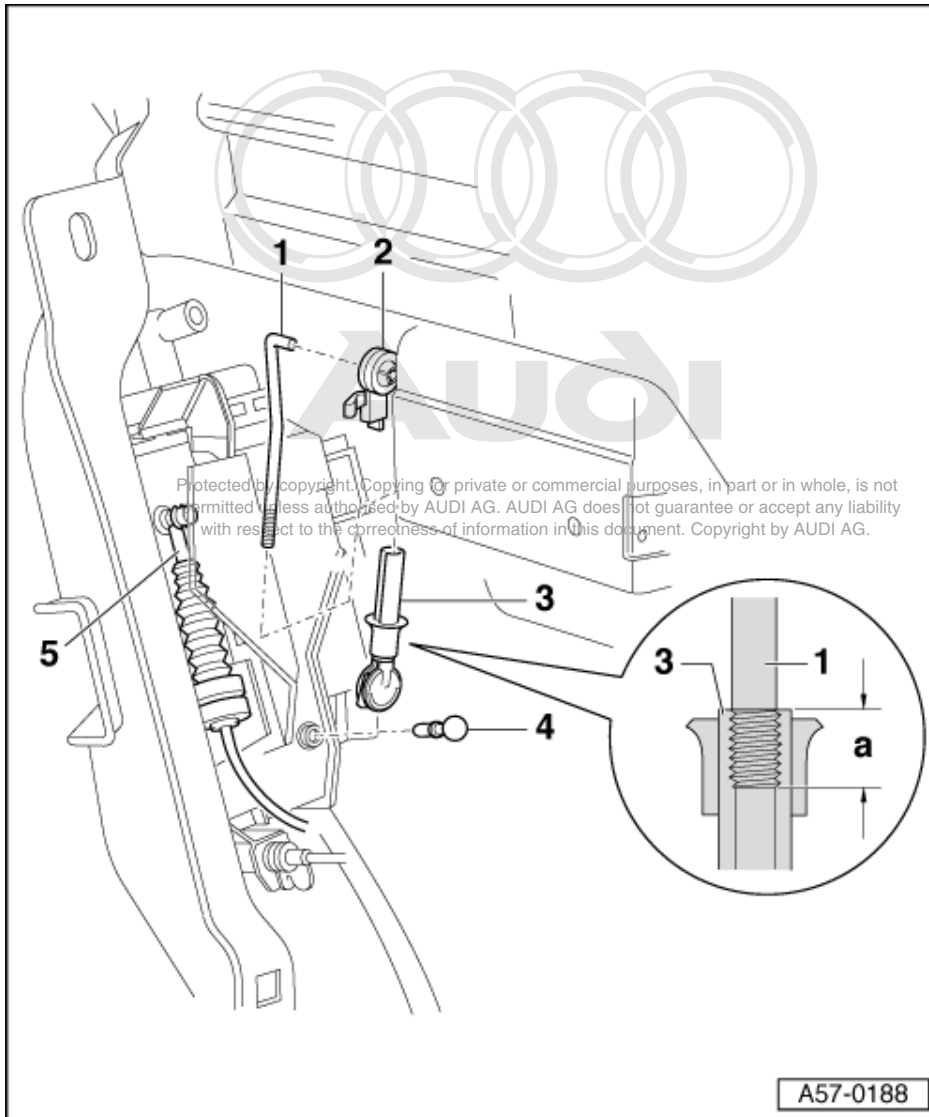
A57-0188

1 Operating rod

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

2 Hinged bushing

3 Operating clip



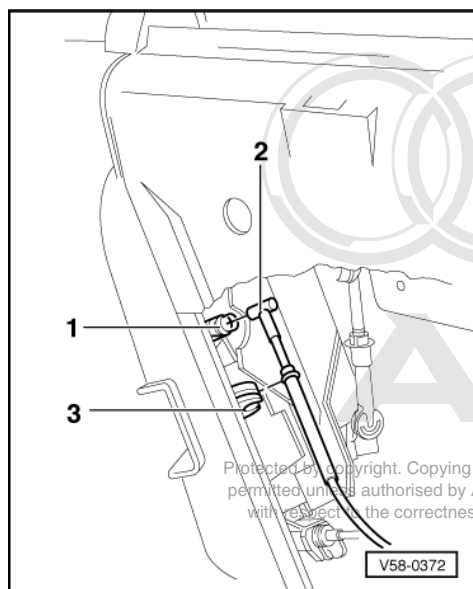
4 Locating pin

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

5 Bowden cable for door locking

- ♦ Removing and installing => Fig. 4 .

Fig.1 Bowden cable for door locking



- To remove, unclip Bowden cable -2- from holder -1- and press out of support bracket -3-.

6.5 - Rear door handle pre-assembly

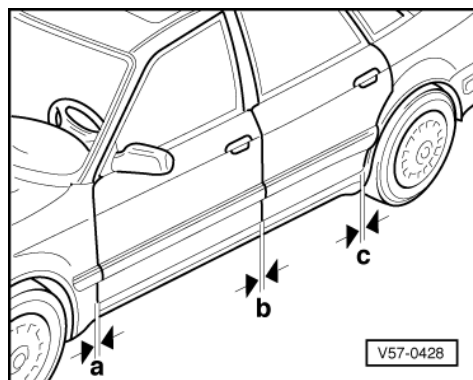
- Pre-assembly of the rear door handle is the same as for the front door handle =>Page 95 .

7 - Adjusting door - Adjustment sequence

7.1 - Adjusting door - Adjustment sequence

7.2 - Adjusting door shell

-> Joint dimensions:



- a = 4 mm ± 0.5
- b = 5 mm ± 0.5
- c = 3.5 mm - 0.5 / + 1

Adjusting to body contour:

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

Note:

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

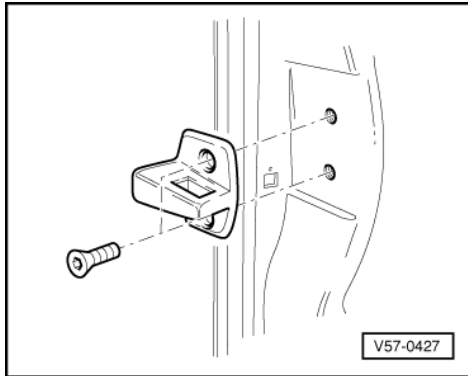


Fig.1 Adjustment with striker wedge

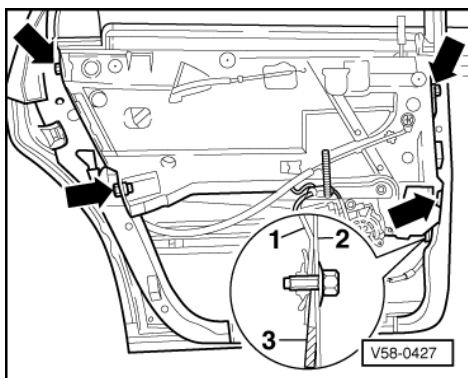
Note:

Rear part of door is adjusted at striker plate.

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

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

7.3 - Adjusting door subframe



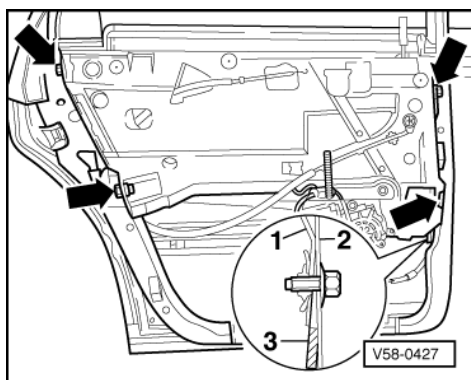
Note:

Door shell must already be adjusted.

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



- Close door.



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

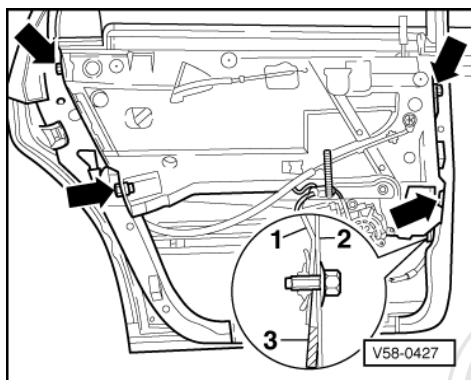
Important

Adjusting wedge -3- must always be installed.

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

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

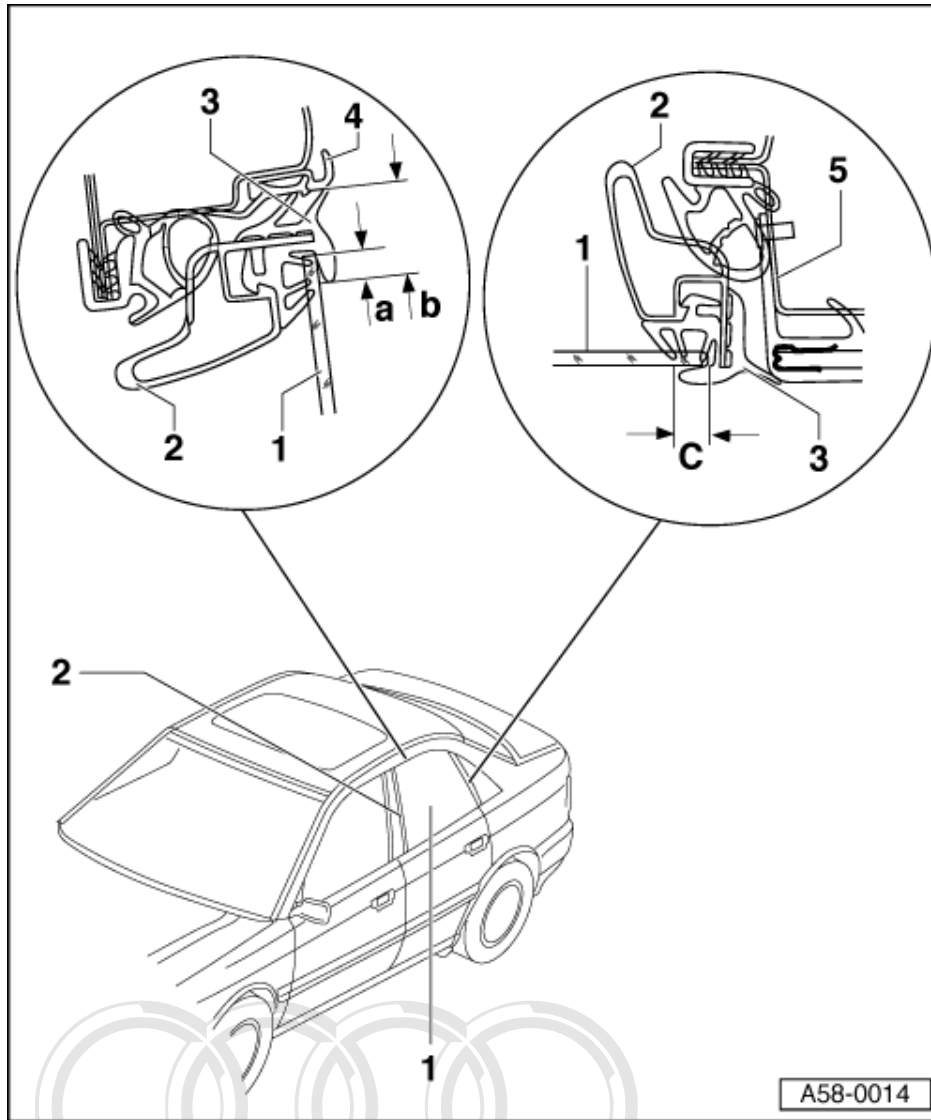
The bottom of the door consequently slopes towards the centre of the vehicle and the top of the door leans outwards.



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



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Check dimension for door component carrier

1 Rear side window

- ♦ At top, window enters 5 mm (dimension a) into door seal -3-.
- ♦ At rear, window enters 5 mm (dimension c) into door seal -3-.

2 Door subframe

3 Door seal

- ♦ Gap between bottom edge of roof trim strip -4- and bottom edge of door seal is 18.3 mm (dimension b).

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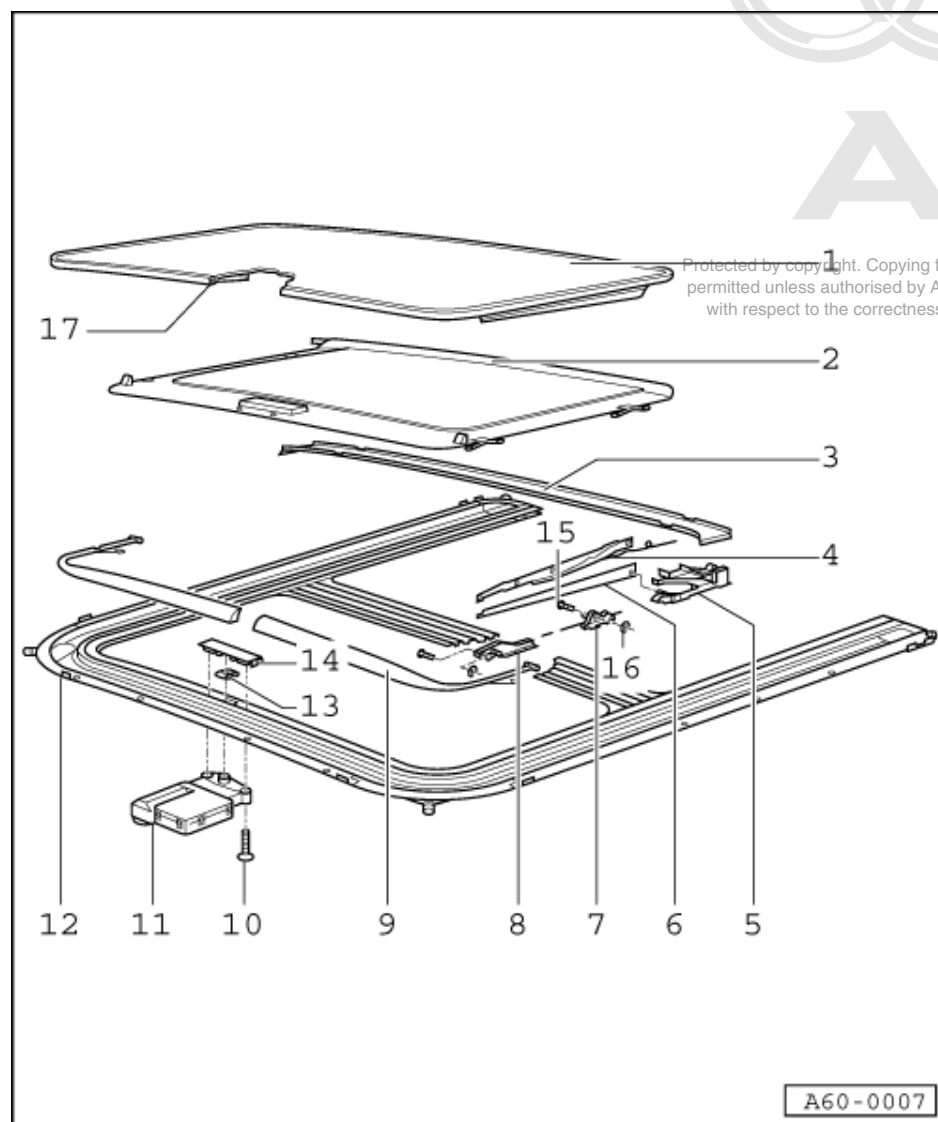
4 Roof trim strip

5 C-pillar

60 - Sliding/tilting roof

1 - Servicing sliding/tilting sunroof

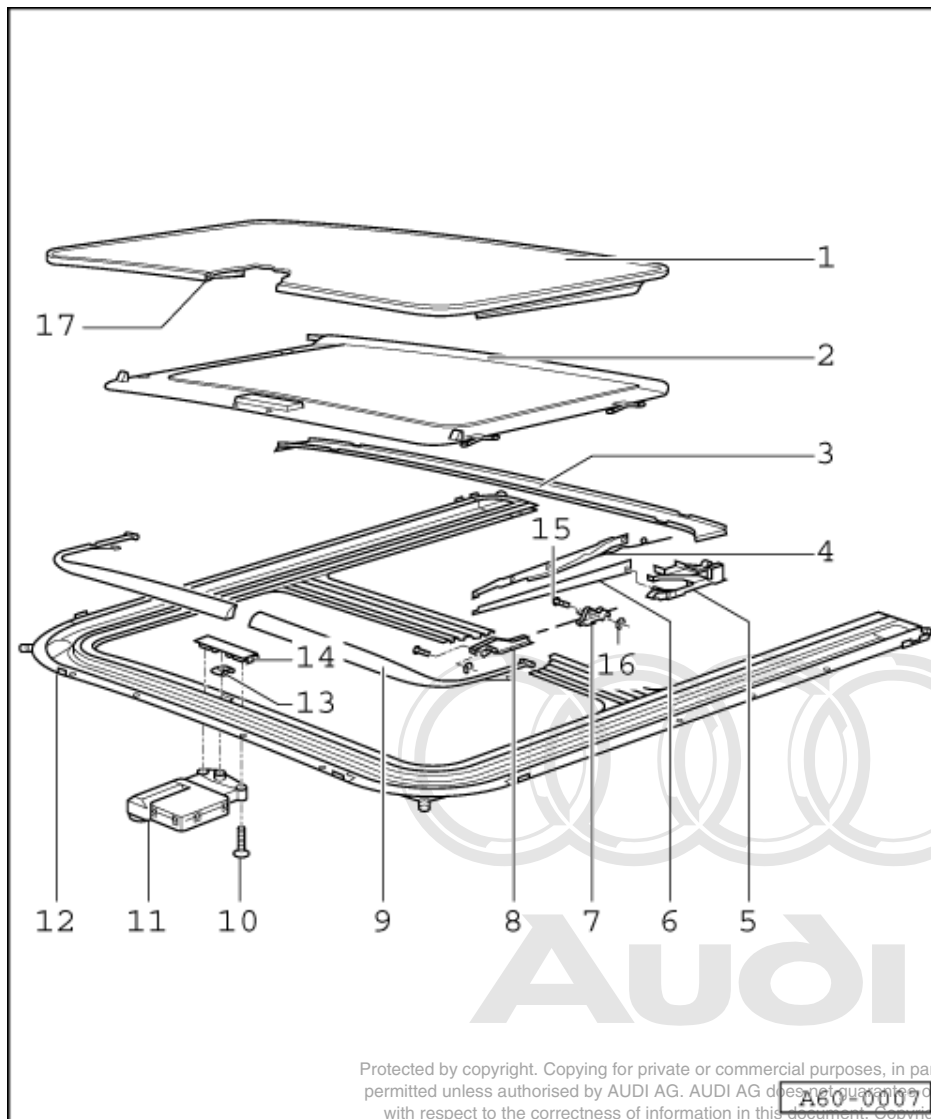
1.1 - Servicing sliding/tilting sunroof



1.2 - Assembly overview

- 1 **Sliding/tilting sunroof panel**
 - ♦ Removing and installing
=>Page 145 .
 - ♦ Adjusting =>Page 145 .
- 2 **Sliding headlining**
 - ♦ Removing and installing
=>Page 148 .
- 3 **Drain channel**
 - ♦ Before removing, remove sunroof panel =>Page 145 .

- Unfasten clips by pressing them forwards and lift out drain channel =>Fig. 3 .



4 Guide plate

- ♦ Removing and installing
=>Page 151 .
- ♦ Can only be removed after dismantling moulded headlining.

=> General Body Assembly; Repair group 70

5 Locating hook guide

- ♦ Is removed together with guide plate.

6 Lower trim

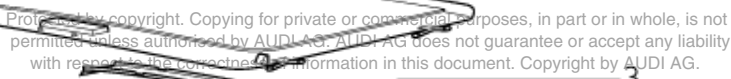
- ♦ Removing and installing => Fig. 2 .

7 Rear guide

- ♦ Is removed together with guide plate.

8 Front guide

- ♦ Is removed together with guide plate.



9 Wind deflector

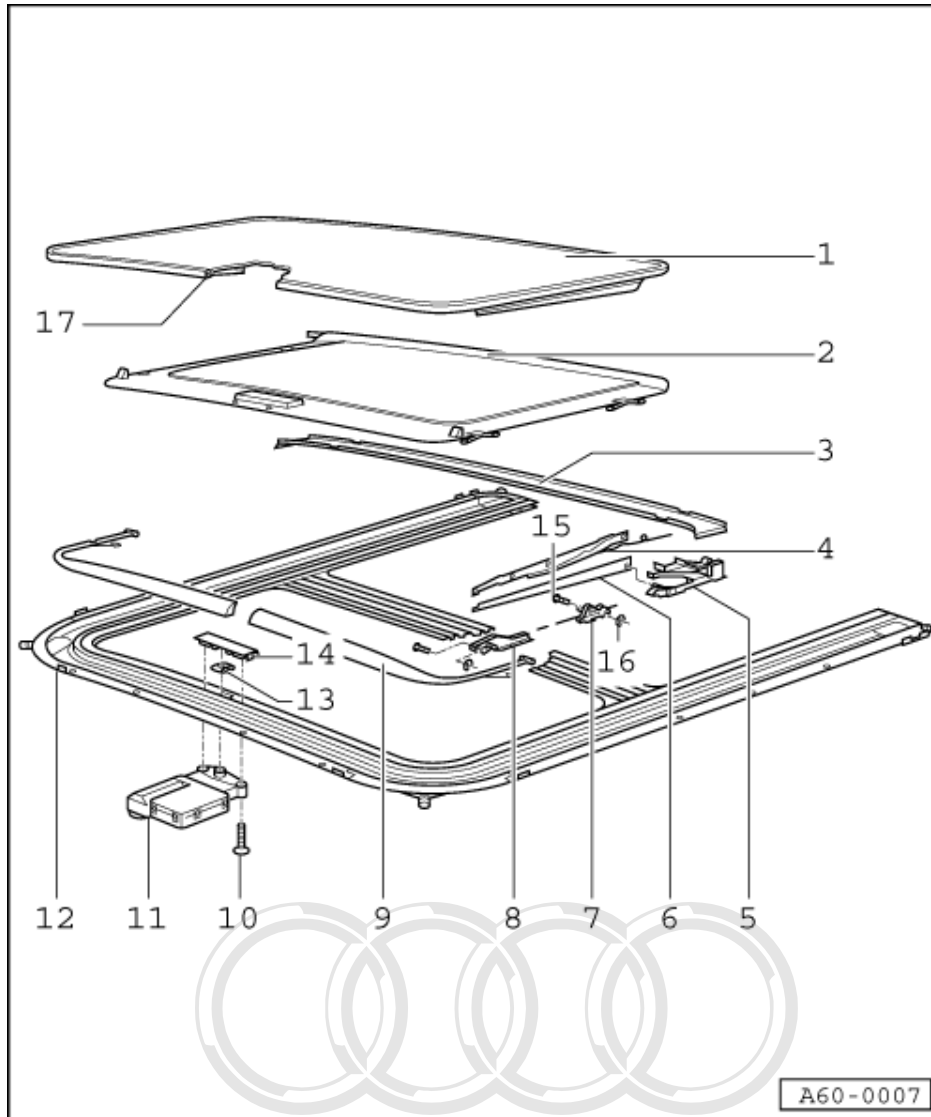
- ◆ Removing and installing => Fig. 4 .

10 Countersunk screw

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

11 Sunroof motor

- ◆ Before removing, remove cover for sunroof motor in headlining.
- ◆ Removing => Page 149



12 Frame

- ♦ Before dismantling, remove headlining.

=> General Body Assembly; Repair group 70

- ♦ Removing and installing =>Fig. 1 .

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13 Clamp

- ♦ Not a replacement part.

14 Panel

15 Pin

- ♦ Not a replacement part.

16 Circlip

17 Seal for sunroof panel

- ♦ Removing and installing
=>Page 147 .
- ♦ Adjusting =>Page 148 .

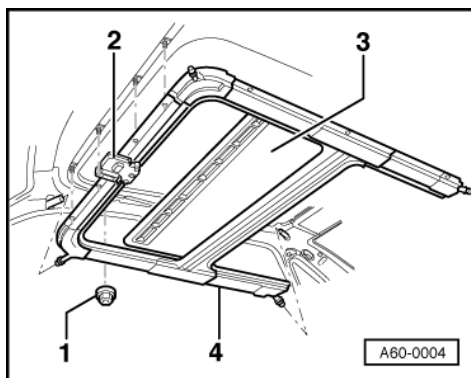


Fig.1-> Removing and installing frame

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

=> General Body Assembly; Repair group 70

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

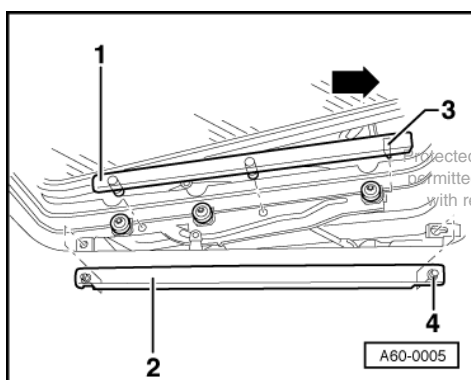


Fig.2 -> Removing cover

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

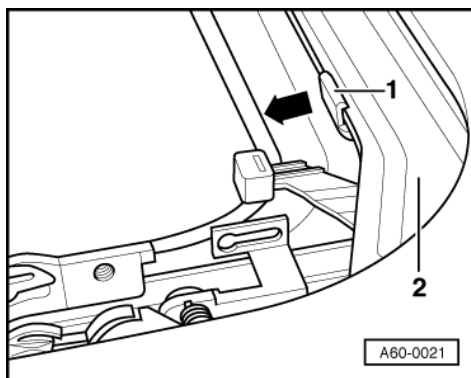
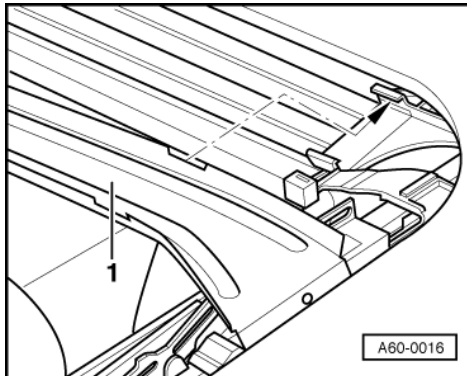


Fig.3 -> Removing and installing drain channel

- Sunroof panel removed.

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



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

Important

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

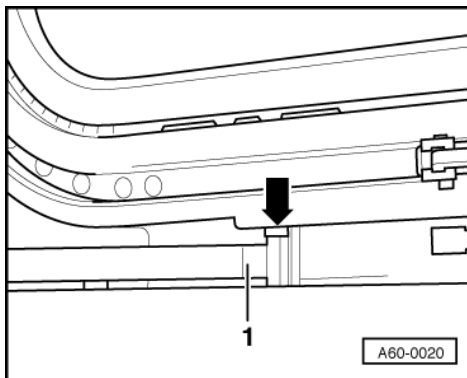
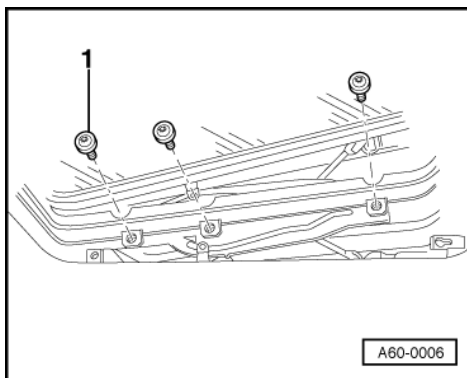


Fig.4 -> Removing and installing wind deflector

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

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1.3 - Removing and installing sliding/tilting sunroof panel



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



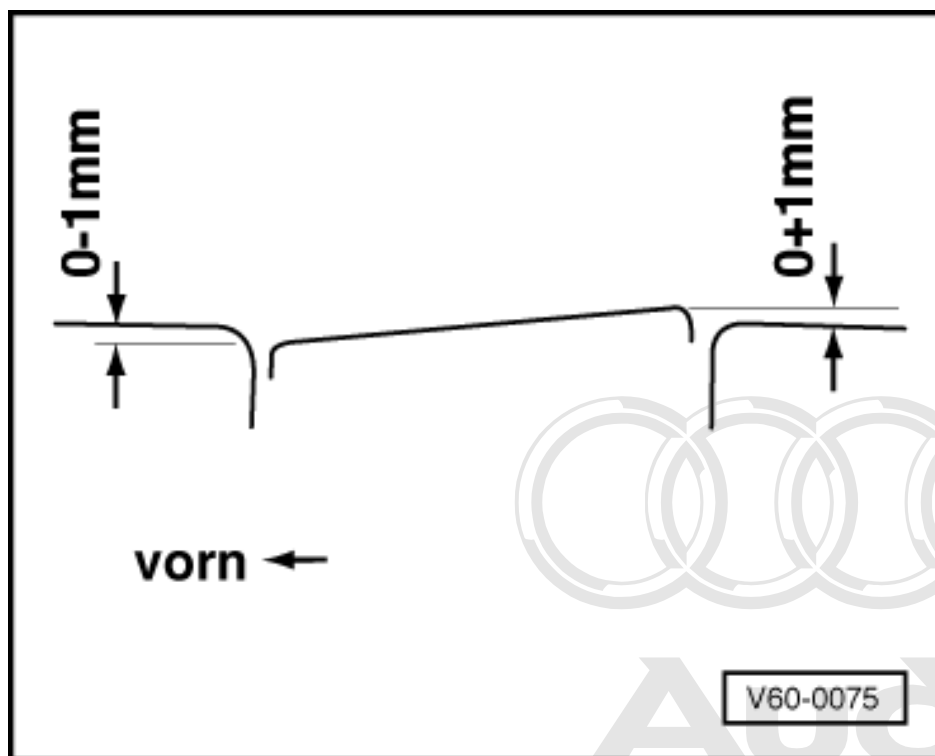
- Lift out sunroof panel.

Important

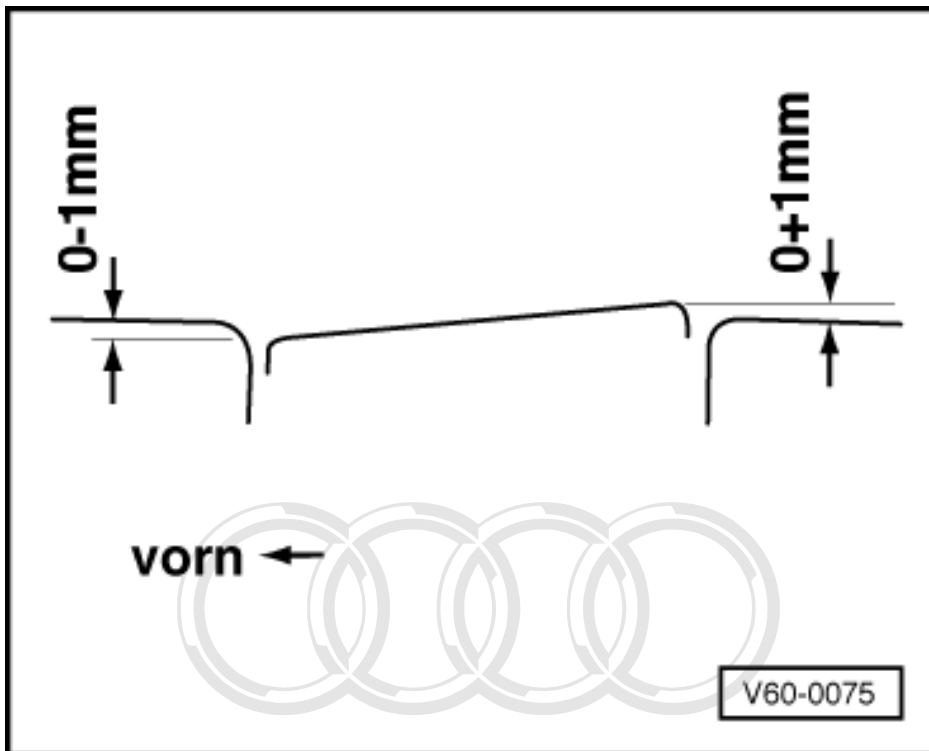
Do not run sunroof backwards into roof of vehicle with panel removed.
Drain channel would catch in roof cross strut, making sunroof difficult to close.

- Tightening torque for Torx bolts on installation: 4.5 + 0.5 Nm.

1.4 - Adjusting sliding/tilting sunroof panel



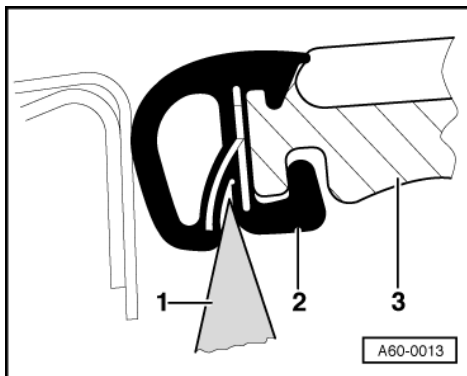
- To avoid wind noise, adjust the sunroof panel at the front and rear as shown.
 - Check height adjustment in each case at end of roof opening radii towards centre of vehicle.
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- -> The sunroof panel should at no point be higher or lower than the roof at the front and rear respectively.
- When performing height adjustment, start by running the sunroof from the open position (i.e. not tilted open) into the closed position.

1.5 - Replacing seal for sunroof panel

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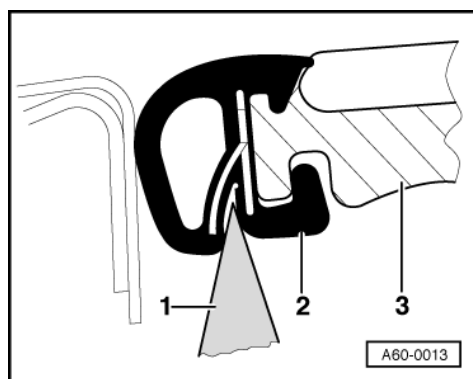
- Remove sunroof panel.
- Pull off seal -2-.
- -> At rear panel edge centrally attach new seal to sunroof panel -3- starting from underneath and working upwards.

Note:

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

- Trim edge of panel seal after installation.

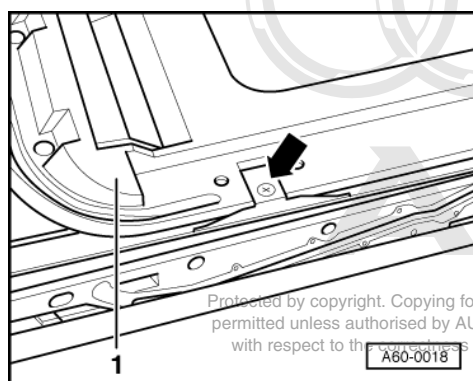
1.6 - Adjusting seal for sunroof panel



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

1.7 - Removing and installing sliding headlining

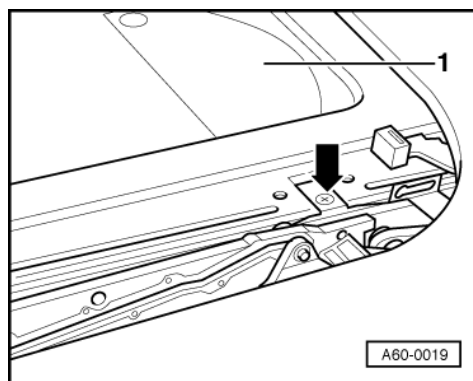
- Slide open sunroof.



- Remove cover frame for moulded headlining

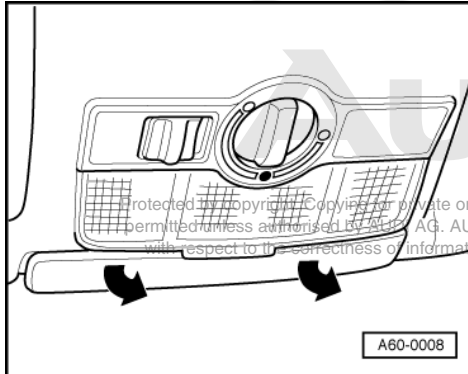
=> General Body Assembly; Repair group 70

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

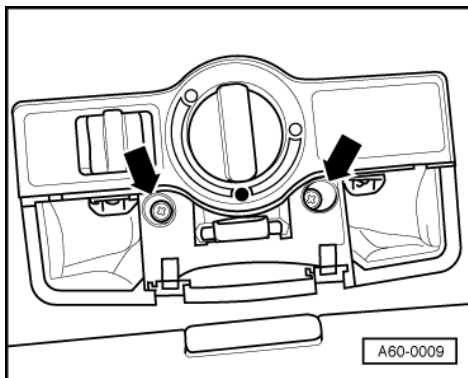


- Push sliding headlining forwards.
- -> Likewise unscrew rear bolts -arrow-, push out springs to rear and remove sliding headlining upwards.

1.8 - Removing and installing sunroof motor



- -> Unclip trim from cover in direction of arrow and detach.



- -> Unscrew bolts -arrows- and detach cover.
- On installation, tighten to 3.5 Nm.

- Removing left/right, and centre sun visors.

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

- Removing left/right pull down handles.

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

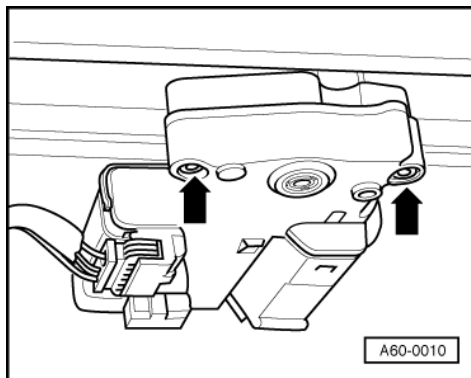
- Removing left/right B-pillar trim.

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

- Pull down moulded headliner at front.

Important

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



- Detach electrical connectors.
- -> Unscrew bolts -arrows- and remove sunroof motor.
- Use new bolts when installing, and clean threads before installation with a tap.
- Tighten bolts to $3.5 + 0.5$ Nm.

1.9 - Adjusting zero position (motor)

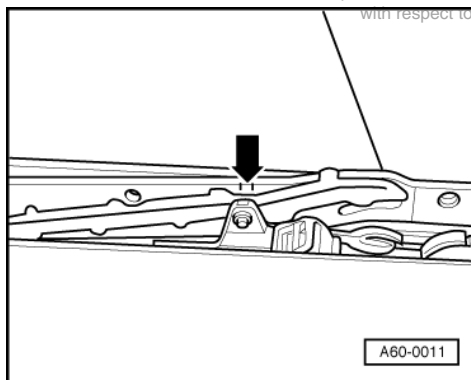
- Motor removed; electrical connections connected.
- Use potentiometer to select "roof closed" on automatic preselection unit.
- Motor runs into zero position and cuts out automatically.
- Install motor in this position with sunroof closed.

1.10 - Checking and adjusting zero setting (guide plate)

Note:

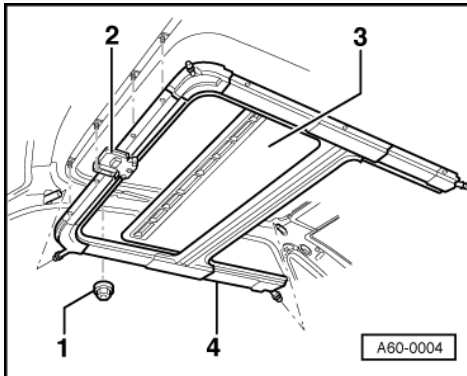
Zero setting can only be made with sunroof motor removed.

- Sunroof motor removed.
- Trims removed.
- Push front guide, rear guide and locating hook guide forwards until lug engages in sunroof frame.



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

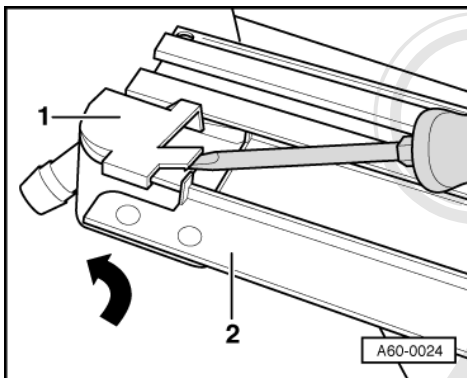
1.11 - Removing and installing guide plate



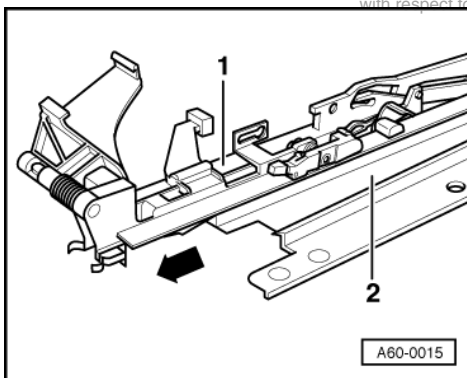
- Remove moulded headlining before dismantling guide plate.

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

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



- -> Prise trim cap -1- off guide rail -2- and pull off to rear in direction of arrow.
- Unscrew stop at rear of guide rail.



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

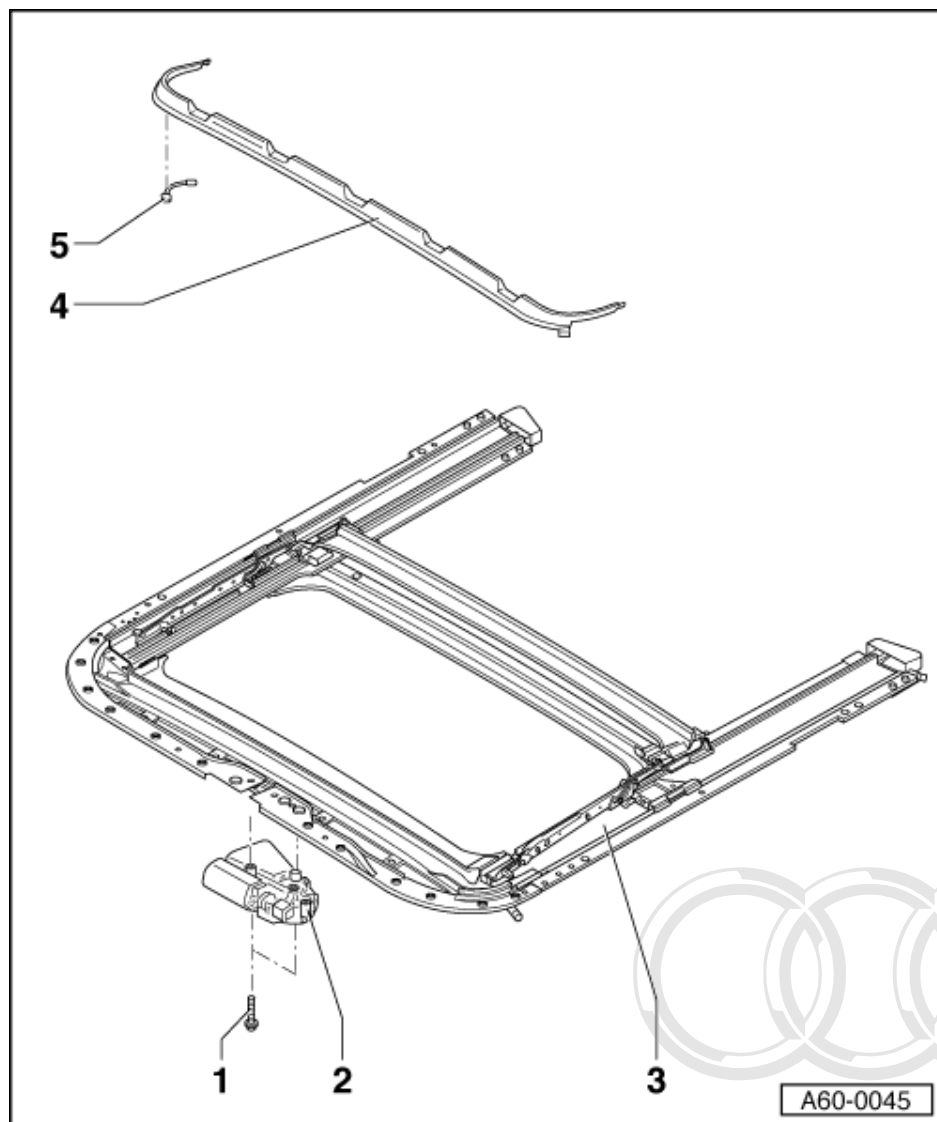
Note:

Always replace guides with cable in pairs.

- Push new guide plates into frame as far as zero setting => Page 150 .

2 - Servicing sliding/tilting sunroof - Avant

2.1 - Servicing sliding/tilting sunroof - Avant



2.2 - From chassis number 8DZVA 081 000

Assembly overview

- 1 **Combi bolt (T 25)**
 - ◆ 3 Nm
- 2 **Sunroof motor**
 - ◆ Before removing, remove cover for sunroof motor in headlining.
- => General Body Assembly; Repair group 70
- 3 **Frame**
 - ◆ Before dismantling, remove headlining.

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- ♦ Remove and install frame as described in Workshop Manual.

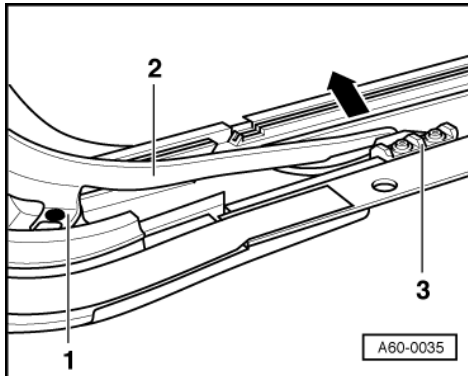
=> General Body Assembly; Repair group 70

4 Wind deflector

- ♦ Removing => Page 153

5 Spring for tilting wind deflector

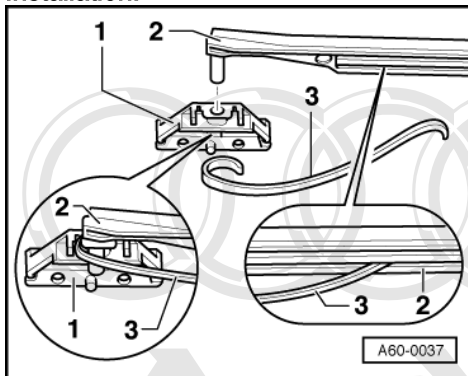
2.3 - Removing and installing wind deflector



Removal:

- Slide back sunroof panel to fully open position.
- -> Press wind deflector -2- out of holder -3- in direction of arrow.
- Pull wind deflector backwards and out of roof cut-out.

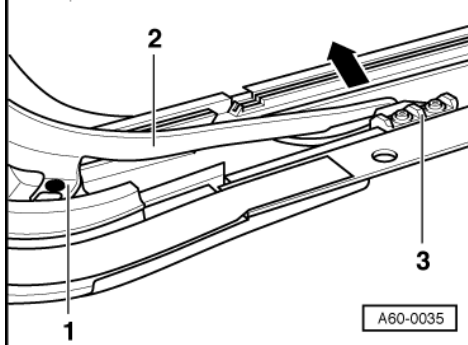
Installation:



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

Note:

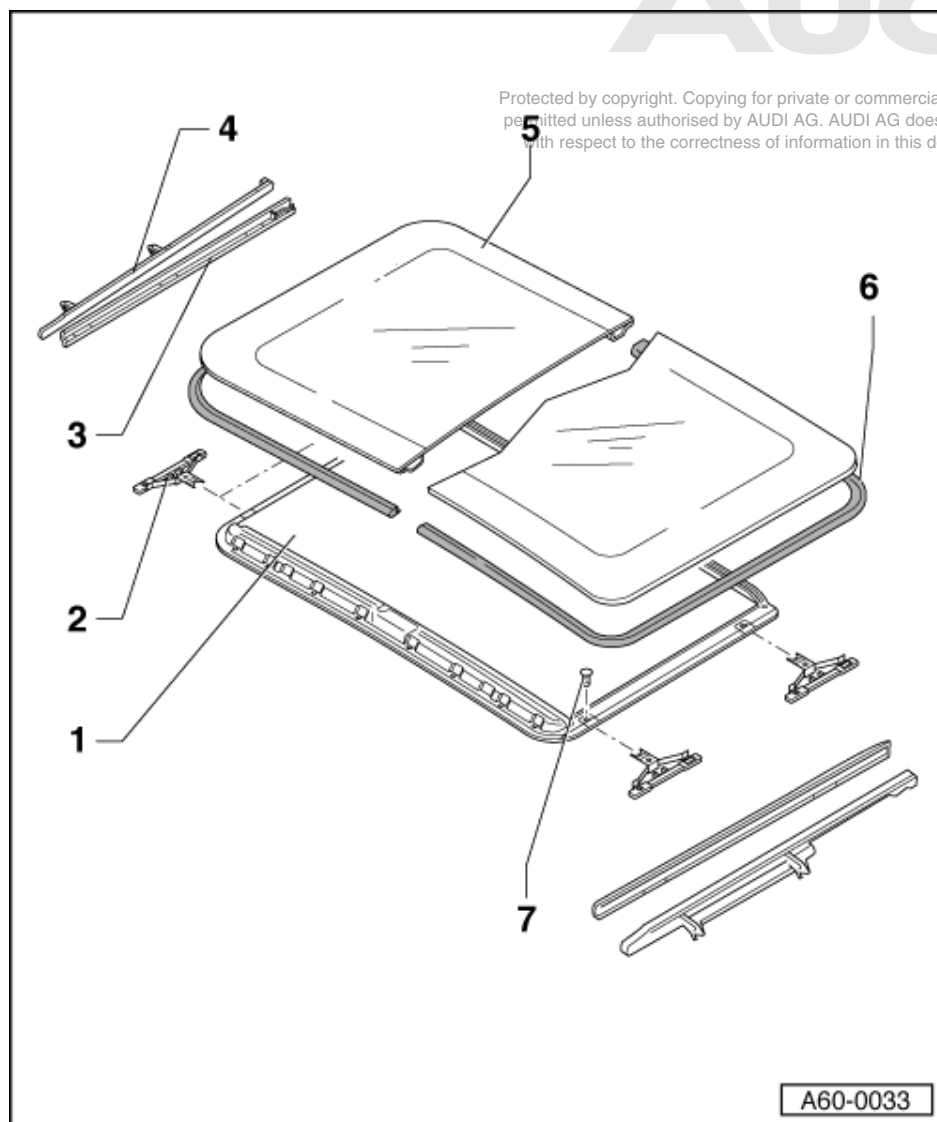
For a clearer illustration, holder -1- is shown removed.





- -> Push stop -1- of wind deflector -2- forwards below the roof cut-out.
- Insert one of the retaining pins of wind deflector into holder -3-.
- On the opposite side push wind deflector in towards centre of vehicle and lock other retaining pin into bracket.

2.4 - Removing and installing sliding/tilting sunroof panel (exploded view)



1 Sliding headlining

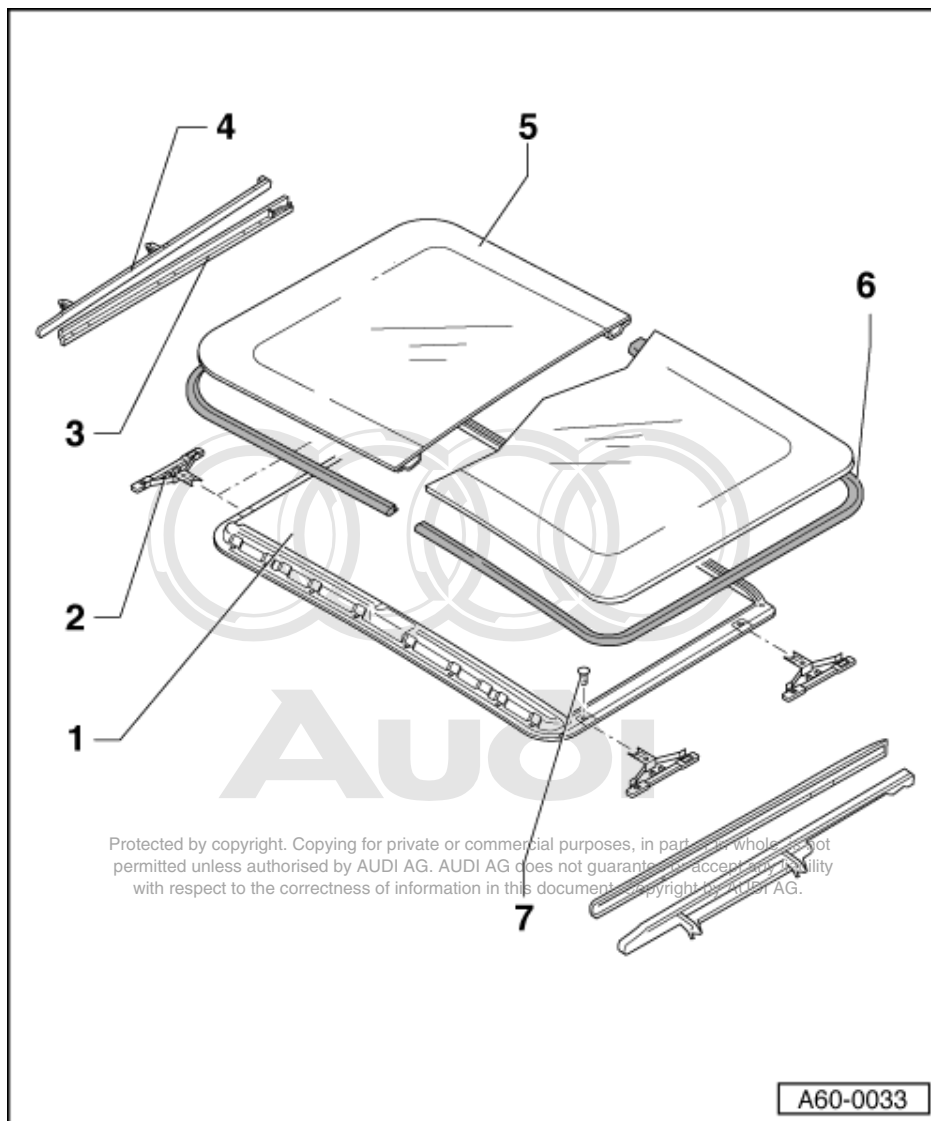
- ♦ Before removing, remove sunroof panel

2 Spring for sliding headlining

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

=> General Body Assembly; Repair group 70

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



3 Lower trim

- ♦ Removal => Page 156 .

4 Upper trim

- ♦ Removal => Page 156 .

5 Sunroof panel

- ♦ To remove, open sunroof panel to tilt position.
- ♦ Remove left and right trims => Page 156 .
- ♦ Remove Torx bolts (T 25) from sunroof panel on left and right and lift out panel =>Page 157 .
- ♦ Adjusting => Page 157

6 Panel seal

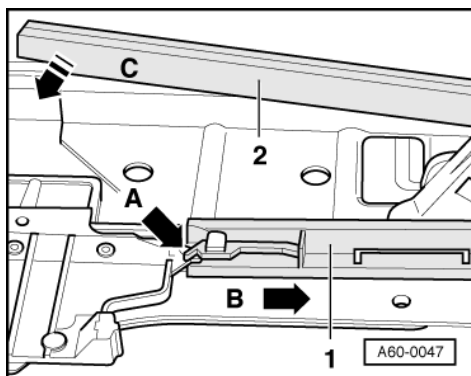
- ♦ Removal => Page 158 .

7 Countersunk screw

- ♦ 1.5 Nm

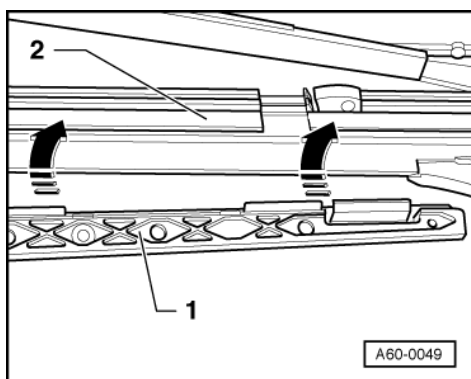
2.5 - Removing and installing trim

Removing

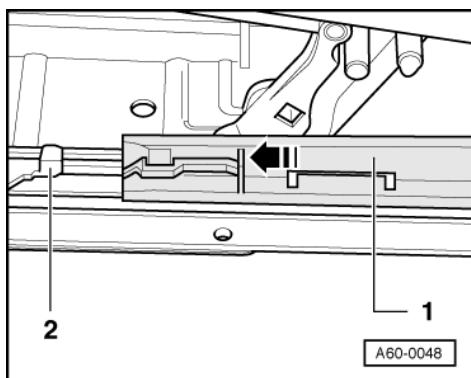


- Tilt sunroof.
- Push the sliding headlining fully to the rear.
- -> Unfasten lower trim -1- from clip at rear in direction of arrow -A- and push forwards, arrow -B-.
- Pull lower trim off guide rail towards centre of vehicle.
- Unclip cover -2- at the front and in the centre and remove in the direction of arrow.

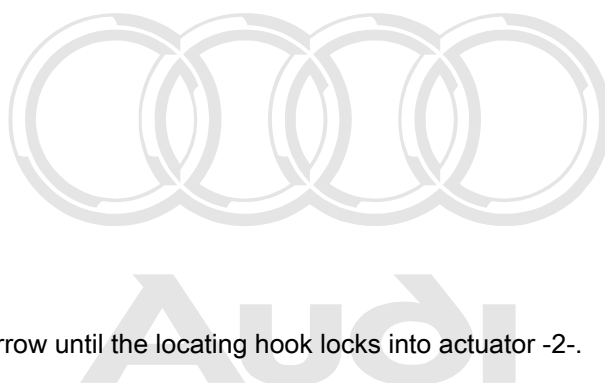
Installing



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

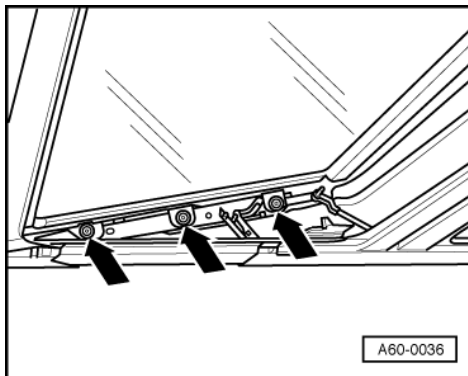


- -> Press lower trim -1- backwards in direction of arrow until the locating hook locks into actuator -2-.
- Press upper trim into guide plate.



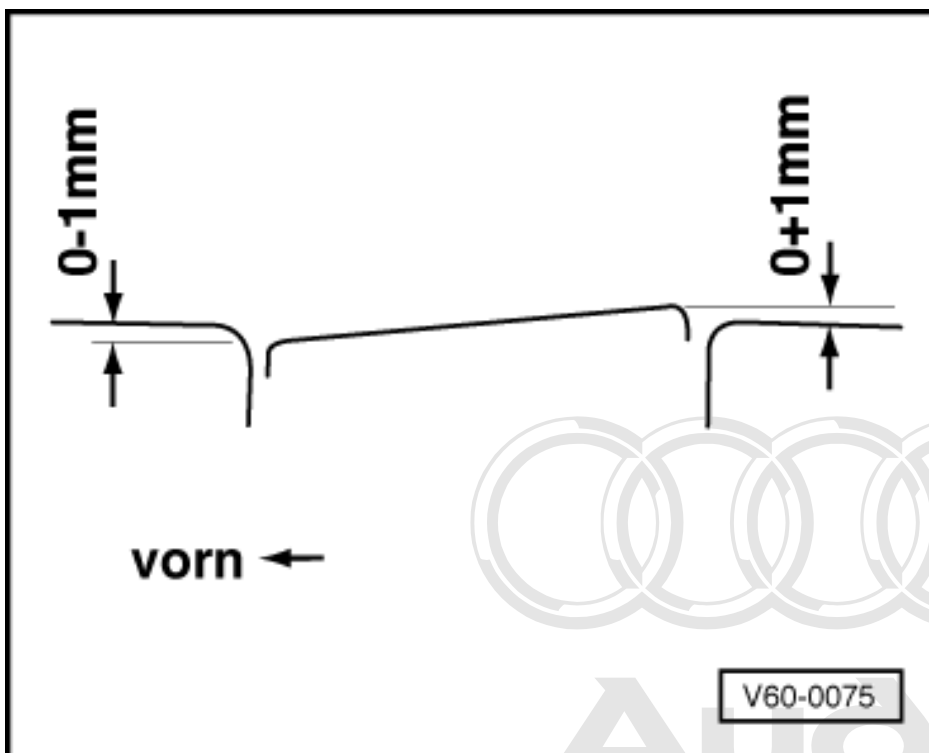
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2.6 - Removing sliding/tilting sunroof panel



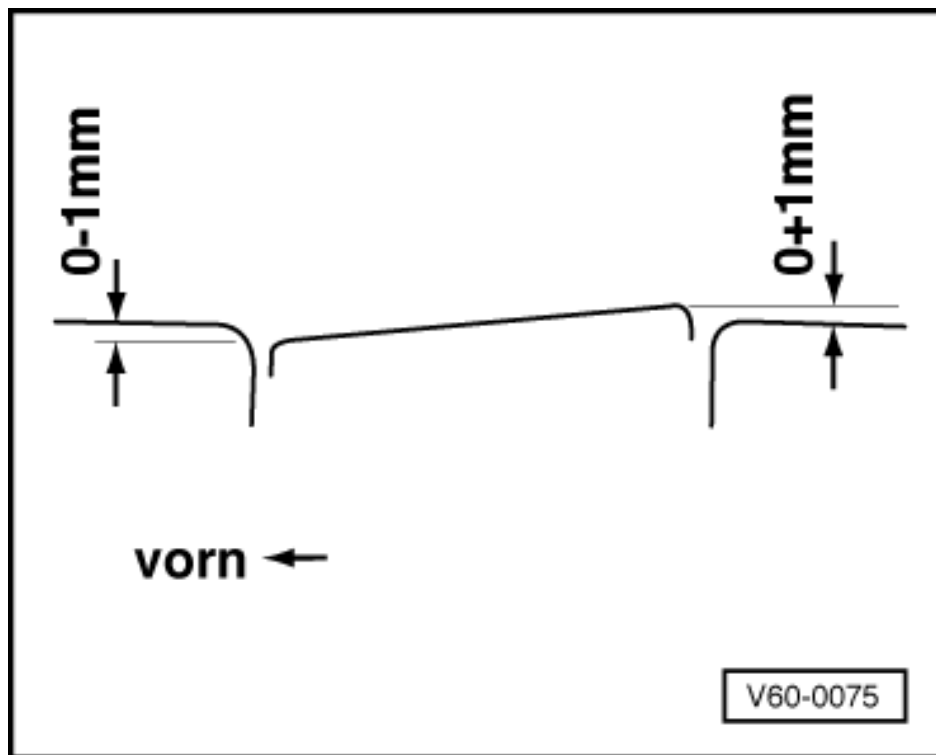
- Trims removed.
- -> Unscrew Torx bolts (T 25) -arrows- on both sides and lift out panel upwards.
- When installing, tightening torque 4.5 ± 0.5 Nm.

2.7 - Adjusting sliding/tilting sunroof panel



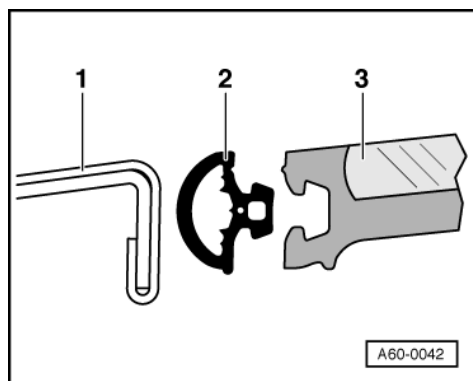
- -> To avoid wind noise, adjust the sunroof panel at the front and rear as shown.
- Check height adjustment in each case at end of roof-opening radii towards centre of vehicle.

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

2.8 - Replacing panel seal



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

Note:

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

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2.9 - Adjusting zero position (motor)

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

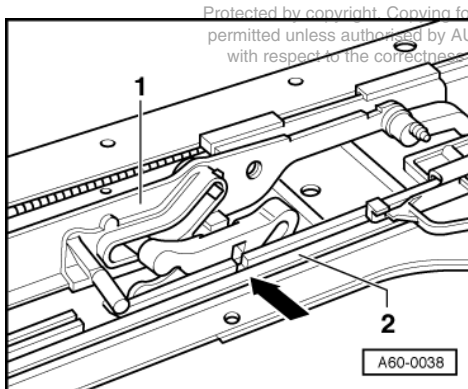
- Install motor in this position with sunroof closed.

2.10 - Checking and adjusting zero setting (guide plate)

Checking

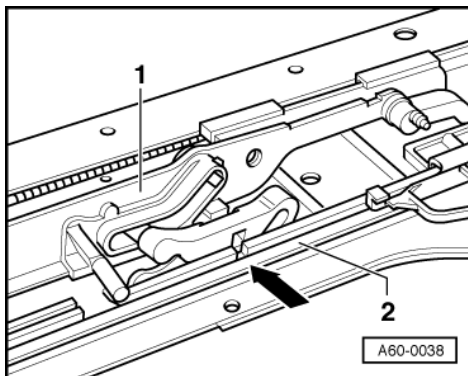
The zero position can be checked using a pocket mirror and a torch, with the sunroof panel installed.

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



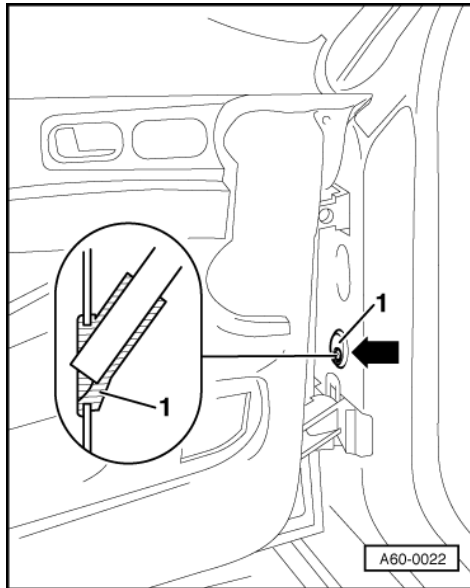
- Push the sliding headlining fully to the rear.
- Place pocket mirror onto sunroof panel and visually check zero position from the side.
- -> Given correct zero setting square hole in tilt mechanism of guide plate -1- must be aligned with recess - arrow- on guide rail -2-.

Adjusting



- Sunroof panel removed.
- Sunroof motor removed.
- Trims removed.
- Push guide plates -1- on both sides from rear to front.
- -> Align square hole in tilt mechanism of guide plate -1- with recess - arrow- at guide rail -2- for sliding headlining.
- This position is the zero position.
- Install motor at zero position.

2.11 - Cleaning water drain hoses

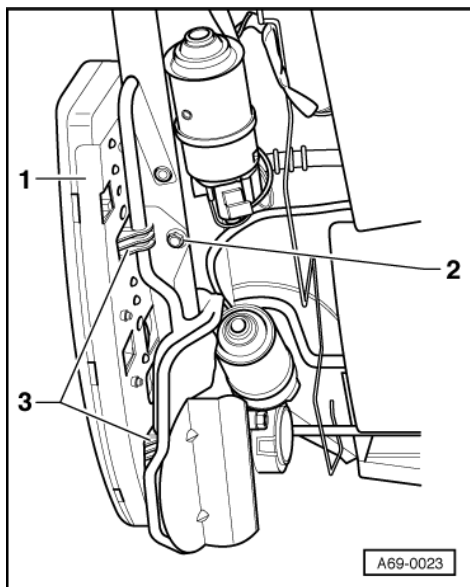


Note:

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

Front drain hoses

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



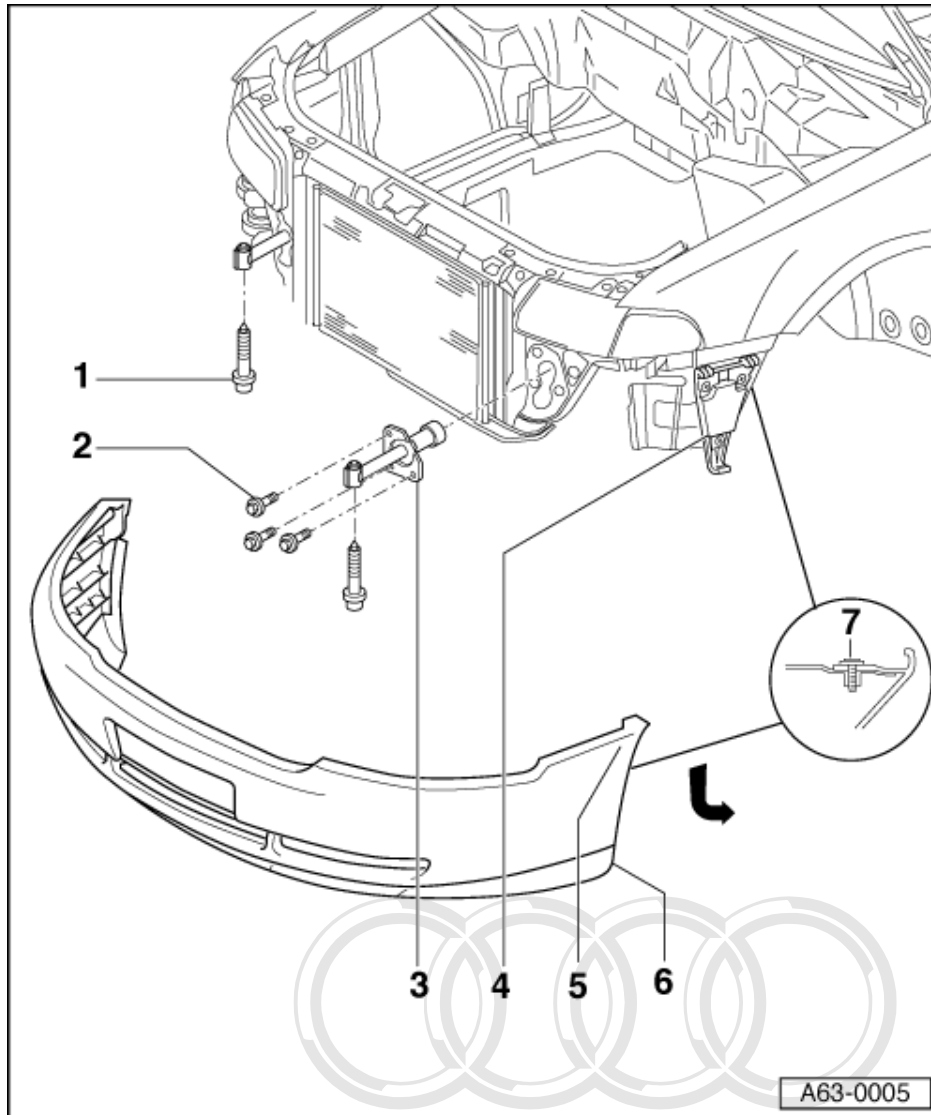
Rear water drain hoses

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

63 - Bumpers

1 - Front bumper

1.1 - Front bumper



1.2 - Removing and installing front bumper (up to chassis number 8D XA 200 000)

Assembly overview

1 Combi bolt

- ◆ 23 Nm

2 Hexagon bolt

- ◆ 45 Nm
- ◆ Impact absorber attached to right longitudinal member with 4 hexagon bolts.

3 Impact absorber

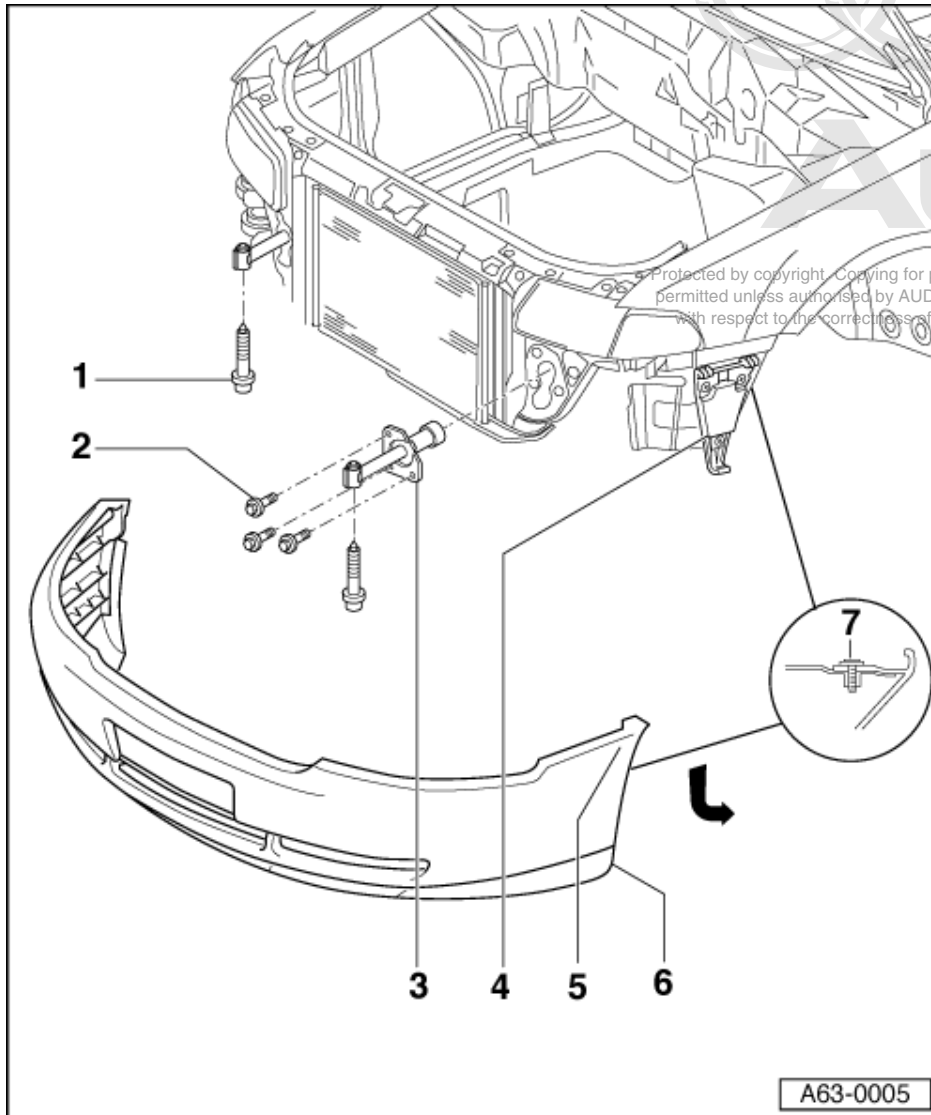
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- ♦ To remove, unscrew hexagon bolts and pull out impact absorber to front.

4 Bracket

- ♦ Removing and installing =>Fig. 2 .



5 Bumper

- ♦ To remove, unscrew torx bolts at wheel housing liner.
- ♦ Pull out air duct grille at bumper.
- ♦ Unscrew combi bolts -1-.
- ♦ On installation, tighten to 23 Nm.
- ♦ Unclip bumper in direction of arrow from bracket -4- and detach to front.

6 Spoiler

- ♦ Removing and installing =>Page 168

7 Torx bolt

- ♦ 1 Nm

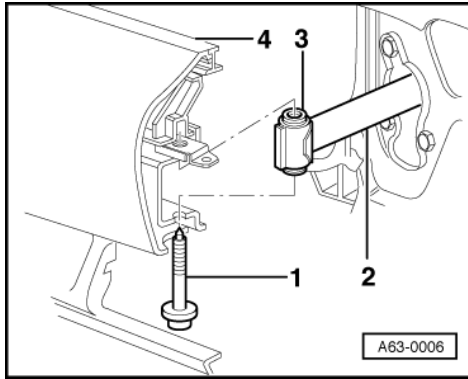


Fig.1 -> Bumper height adjustment

- Height of bumper -4- is adjusted by adjusting threaded sleeves -3- in impact absorber -2-.
- Tighten combi bolt -1- to 23 Nm.

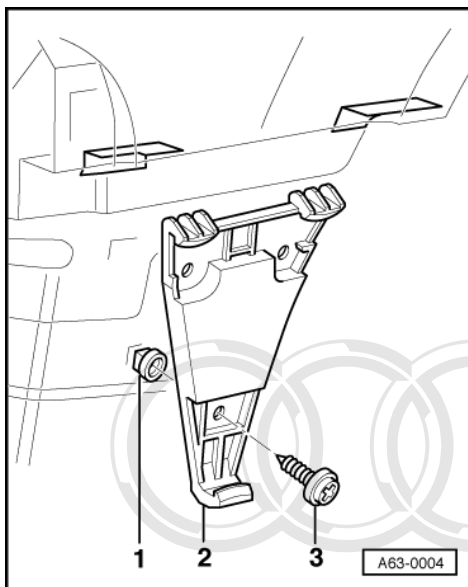


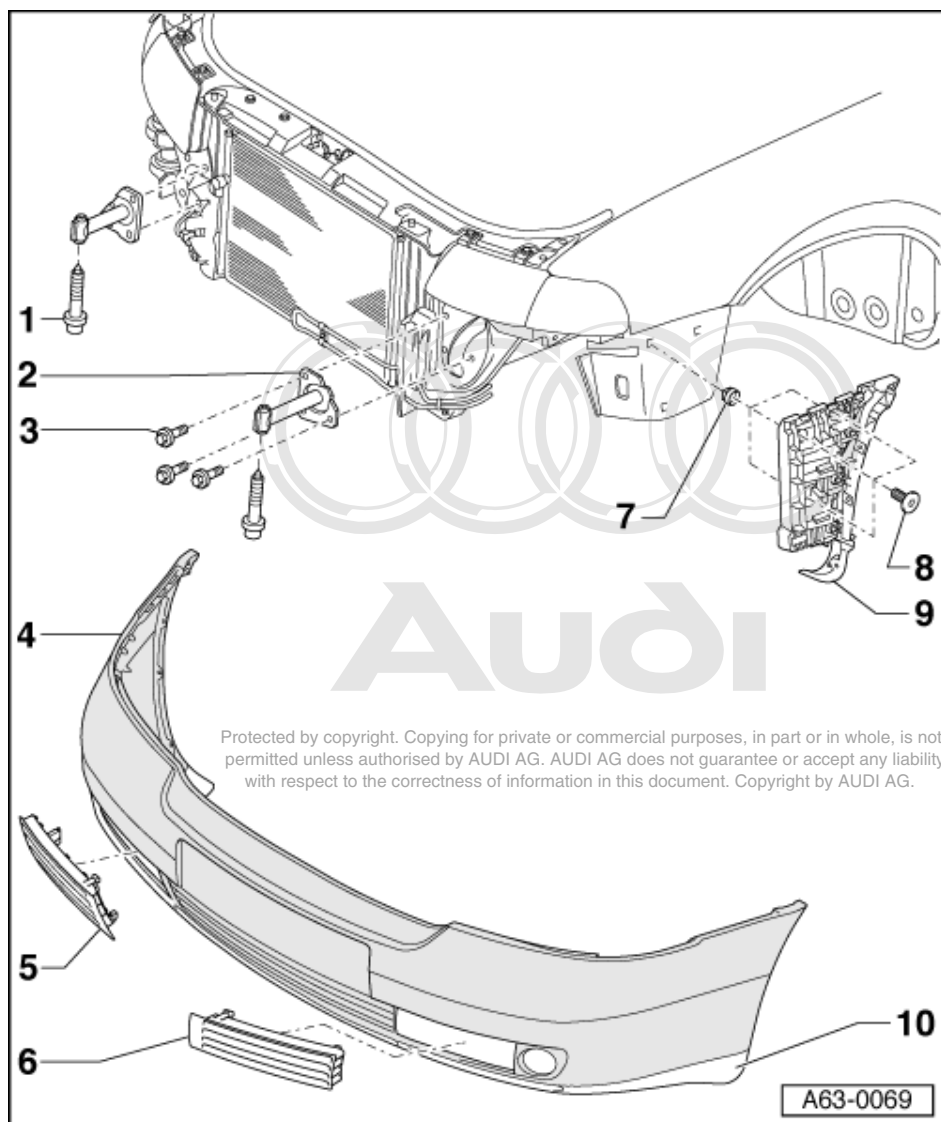
Fig.2 -> Bumper Bracket

- To remove, unscrew bolts -3- and detach bracket -2-.
- Press in clip -1- on installation.

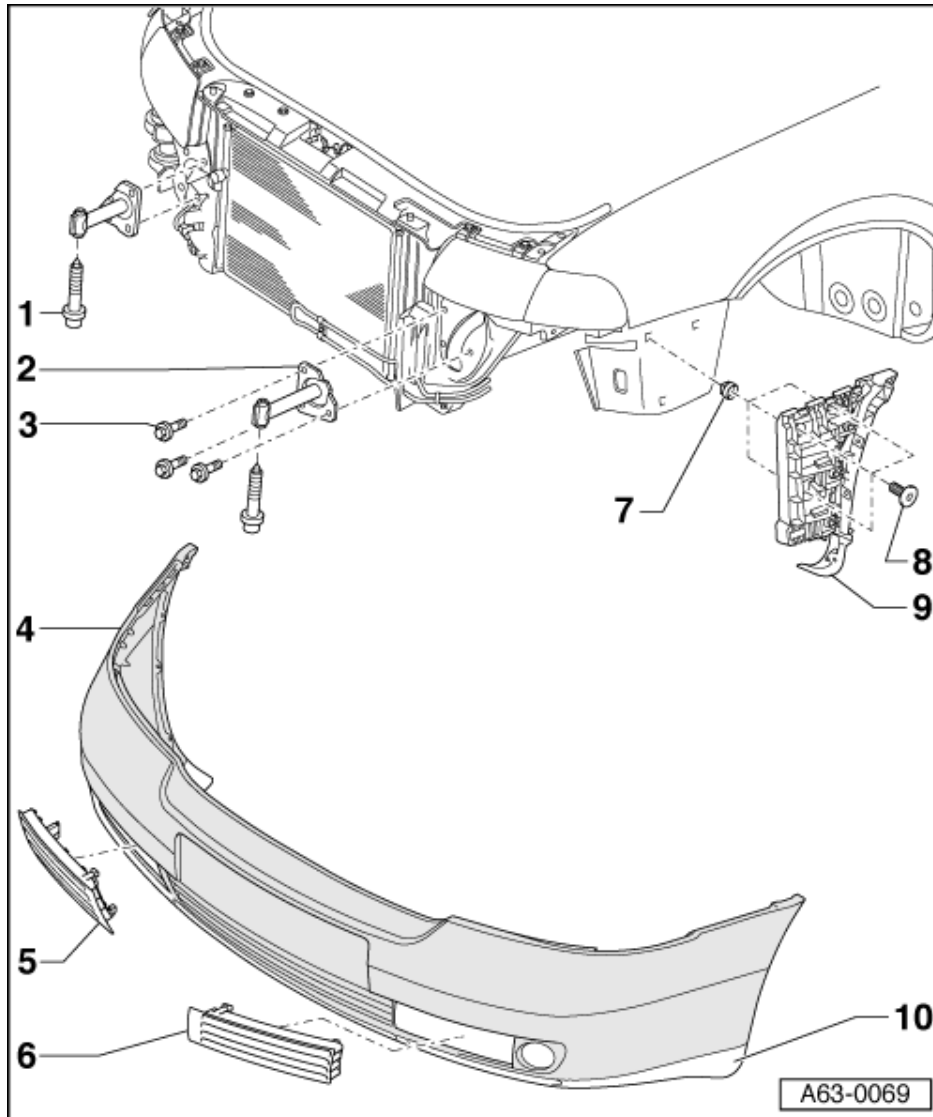
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1.3 - Removing and installing front bumper (from chassis number 8D XA 200 001)



- 1 **Combi bolt**
 - ♦ 23 Nm
- 2 **Impact absorber**
 - ♦ To remove, unscrew hexagon bolts and pull out impact absorber to front.
- 3 **Hexagon bolt**
 - ♦ 45 Nm
 - ♦ Impact absorber attached to right longitudinal member with 4 hexagon bolts.
- 4 **Bumper**
 - ♦ To remove, unscrew torx bolts at wheel housing liner.
 - ♦ Pull out air duct grille at bumper.
 - ♦ Unscrew combi bolts -1-.



- ♦ On installation, tighten to 23 Nm.
- ♦ Unclick bumper in direction of arrow from bracket -4- and detach to front.

5 Left air vent

- ♦ Removing and installing
=> Page 166

6 Right air vent

- ♦ Removing and installing as for right air vent.

7 Clip

- ♦ Press in wing on installation.

8 Combi bolt

- ♦ 1.5 Nm
- ♦ Tighten the upper rear and front and lower screws in the named sequence for installing the bracket.

9 Bracket

- ♦ Removing and installing
=> Page 167

10 Spoiler

- ♦ Removing and installing =>Page 168

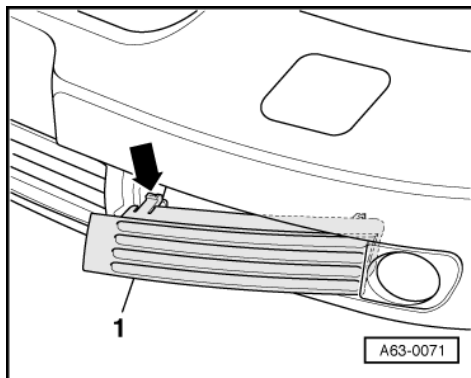
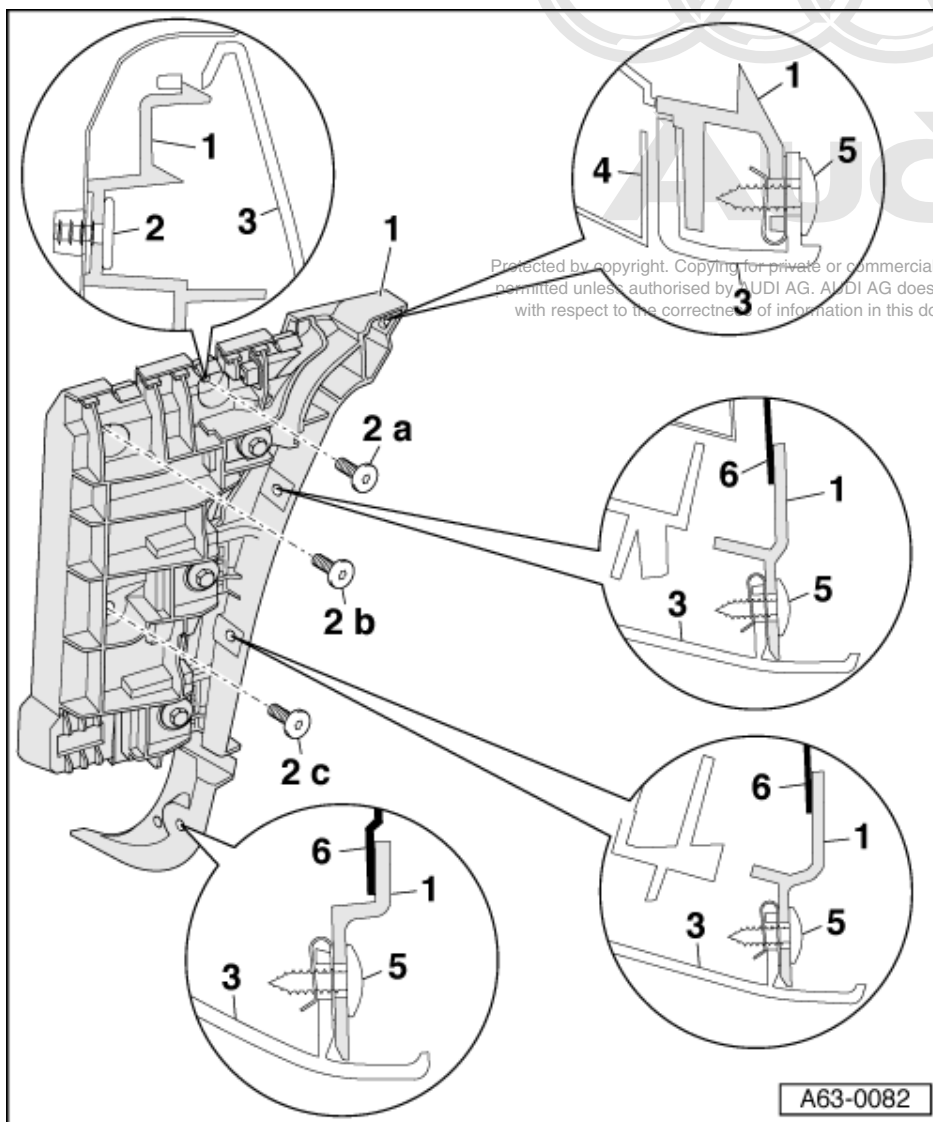


Fig.1 -> Removing and installing air vents

- With a screwdriver -arrows- press the upper and lower locating hooks out of the catches.
- Pull out the air vent from the inside.

1.4 - Removing and installing bracket for bumper



- 1 Front bumper bracket**
 - ♦ The bumper is in two parts, the length of the rear half can be adapted.
- 2 Combi bolts**
 - ♦ 1.5 Nm
 - ♦ Tighten the screws in sequence -a-; -b- and -c-.
- 3 Bumper**
 - ♦ Removing and installing
=> Page **164**
- 4 Wings**
- 5 Self-tapping screw**
 - ♦ 1.5 Nm
- 6 Wheel housing liner**

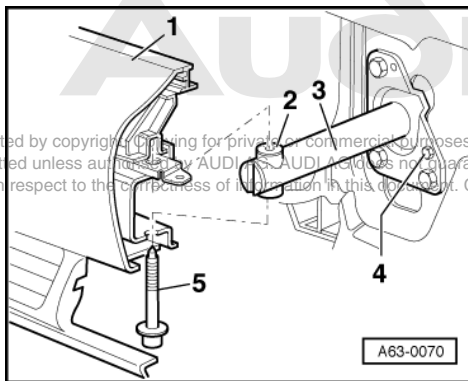
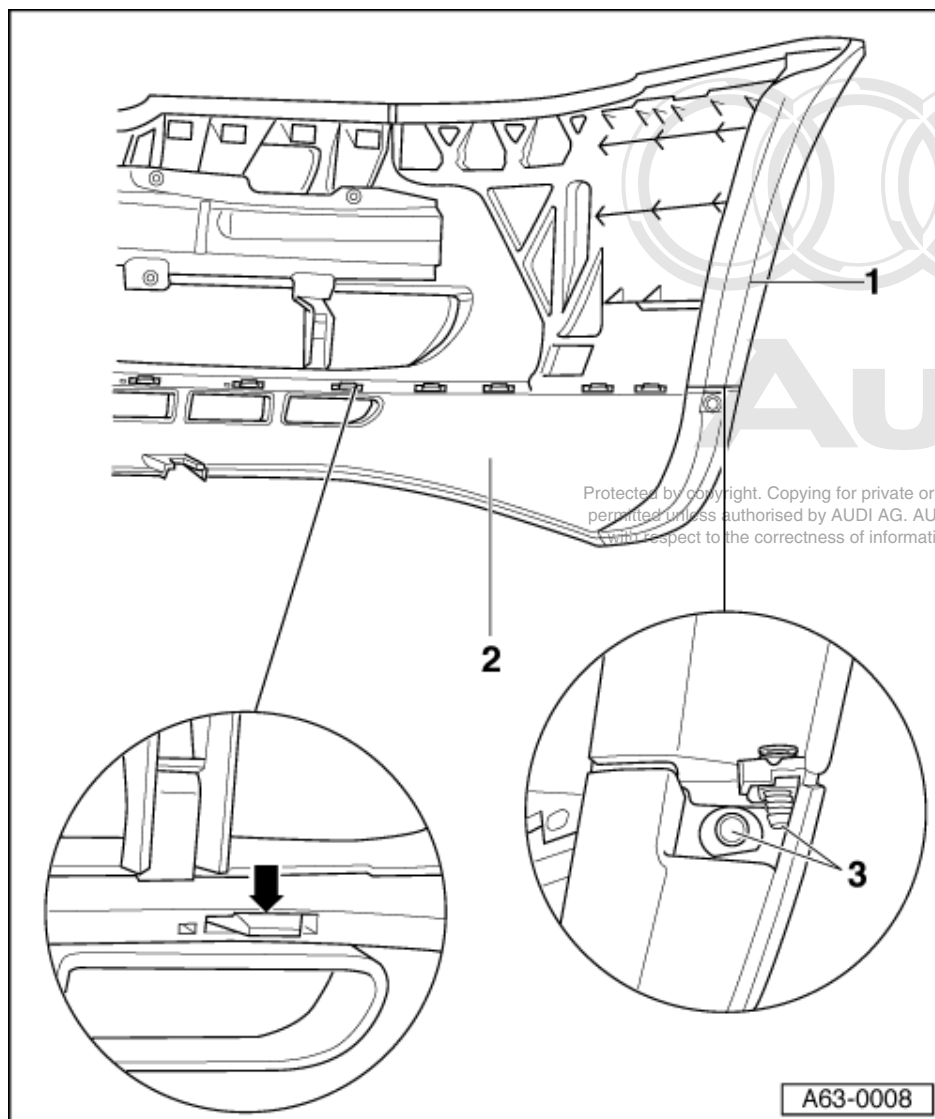


Fig.1 -> Front bumper height adjustment

- The bumper height adjustment -1- can be performed by moving the threaded sleeves -2- at the impact absorbers -3-.
- When installing the bumper, tighten the combi bolts to 23 Nm.
- The screws -4- for fixing the impact absorbers to the bumpers, e.g. for service position.
- Tightening torque 4 Nm.

2 - Removing and installing spoiler

2.1 - Removing and installing spoiler



1 Bumper

- ♦ Remove before dismantling spoiler.

2 Spoiler

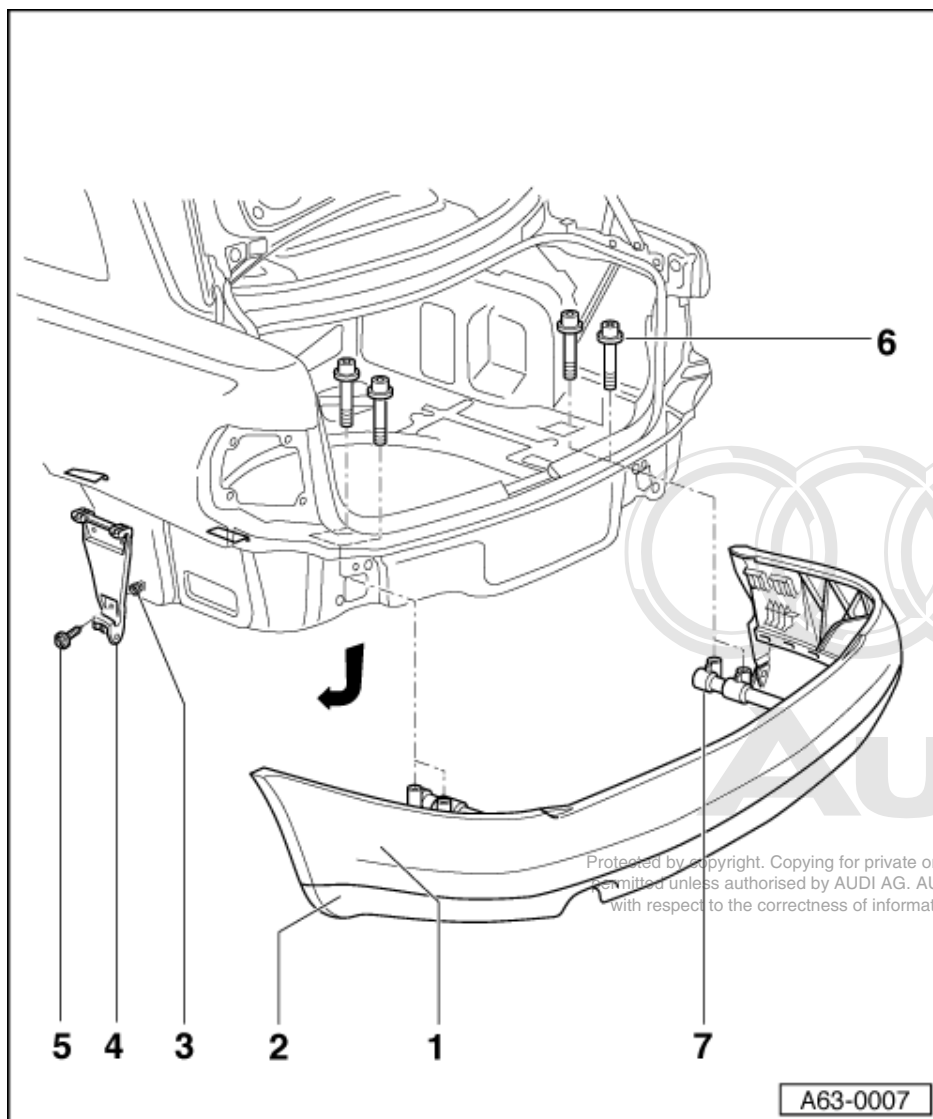
- ♦ To remove, pull out expanding clips -3- on both sides.
- ♦ Disengage retainer tabs -arrow- from spoiler and pull spoiler off bumper.

3 Expanding clip

- ♦ To remove, pull out pins and prise out expanding clips.

3 - Rear bumper

3.1 - Rear bumper



3.2 - Removing and installing rear bumper (up to chassis number 8D XA 200 000)

- 1 Bumper
 - ♦ To remove, unscrew combi bolts -6-.
 - ♦ Unclip bumper in direction of arrow from bracket -4- and detach to rear.
- 2 Spoiler
 - ♦ Removing and installing =>Page 168
- 3 Clip
- 4 Bracket
 - ♦ To remove, unscrew self-tapping screws -5- and detach bracket.
- 5 Self-tapping screw
- 6 Combi bolt
 - ♦ 23 Nm
- 7 Impact absorber

- ♦ Removing from bumper =>Fig. 1.

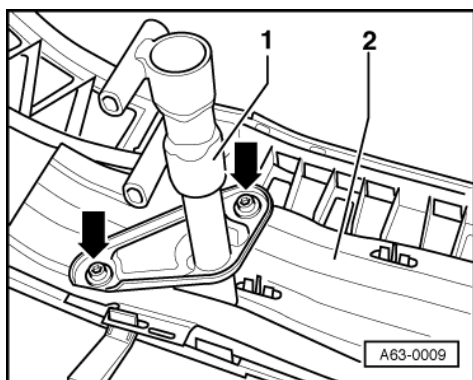


Fig.1 -> Removing impact absorber from bumper

- Unscrew bolts -arrows- and take impact absorber -1- out of bumper -2-.
- On installation, tighten to 23 Nm.

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This exploded view diagram illustrates the assembly of a vehicle bumper. The components are identified by the following numbers:

- 1**: The main bumper body, shown in a light gray color.
- 2**: A mounting bracket or rail located at the bottom of the bumper assembly.
- 3**: A small circular fastener, likely a pin or washer.
- 4**: A complex mounting bracket or support structure.
- 5**: A larger structural component, possibly a cross-member or reinforcement plate.
- 6**: A long, threaded bolt used for securing the assembly.
- 7**: A component at the rear of the bumper, possibly a hitch or a support bracket.

Dashed lines indicate the alignment and assembly path for the various parts.

A63-0073

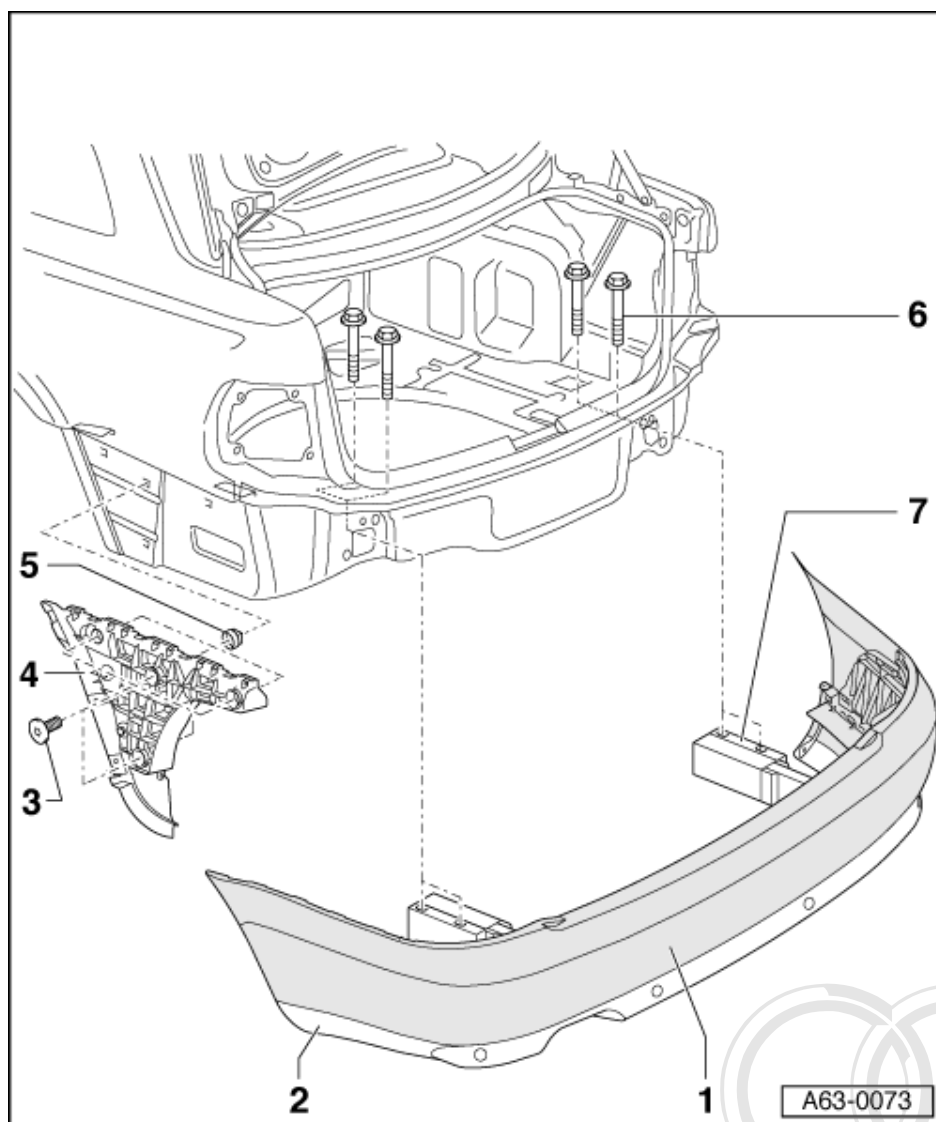
- ◆ To remove, unscrew combi bolts -6-.
- ◆ On S4 models, you must remove an additional screw on the wheel housing liner => Page 173
- ◆ Unclip bumper in direction of arrow from bracket -4- and detach to rear.

- ◆ Removing and installing => Page 168

- ◆ 1.5 Nm

- ◆ The bumper is in two parts, the length of the front half can be adjusted.

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5 Clip

- ◆ Press in wing on installation.

6 Combi bolt

- ◆ 23 Nm

7 Impact absorber

- ◆ Removing from bumper => Page **173**

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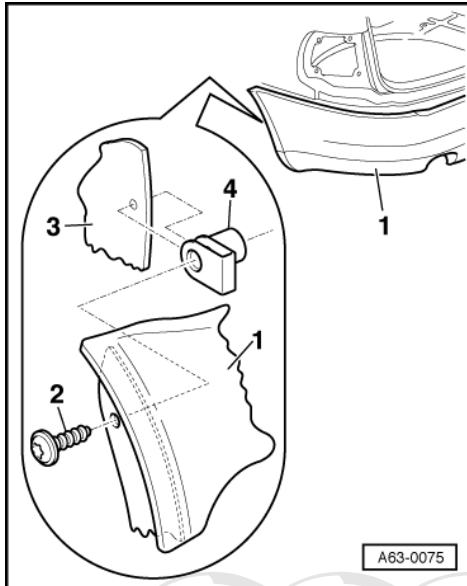


Fig.1 -> Additional attachments for S4

- Before dismantling the bumper -1-, unscrew the screws -2- from the wheel housing liner.
- Clip -4- is attached to the wheel housing liner-3-.

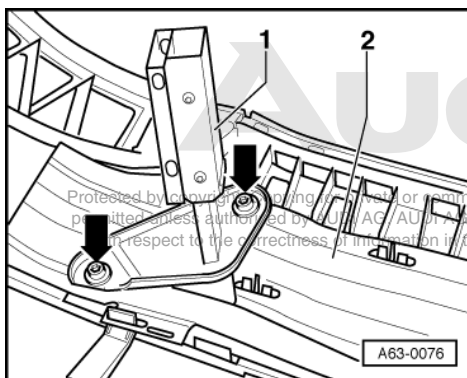


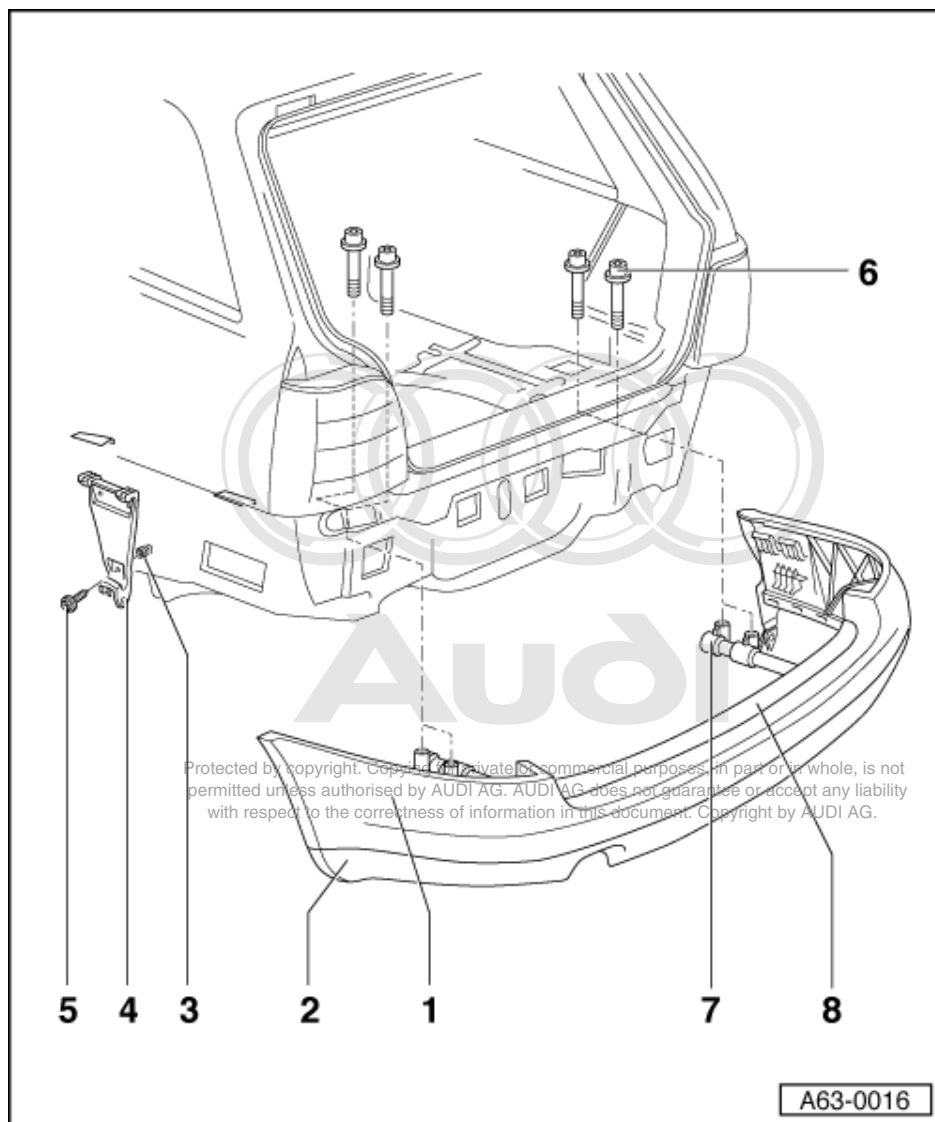
Fig.1 -> Removing impact absorber from bumper

- Unscrew bolts -arrows- and take impact absorber -1- out of bumper -2-.
- On installation, tighten to 23 Nm.



4 - Rear bumper - Avant

4.1 - Rear bumper - Avant



4.2 - Removing and installing rear bumper (up to chassis number 8D XA 200 000)

1 Bumper

- ◆ Before removal, dismantle trim for rear cross panel.

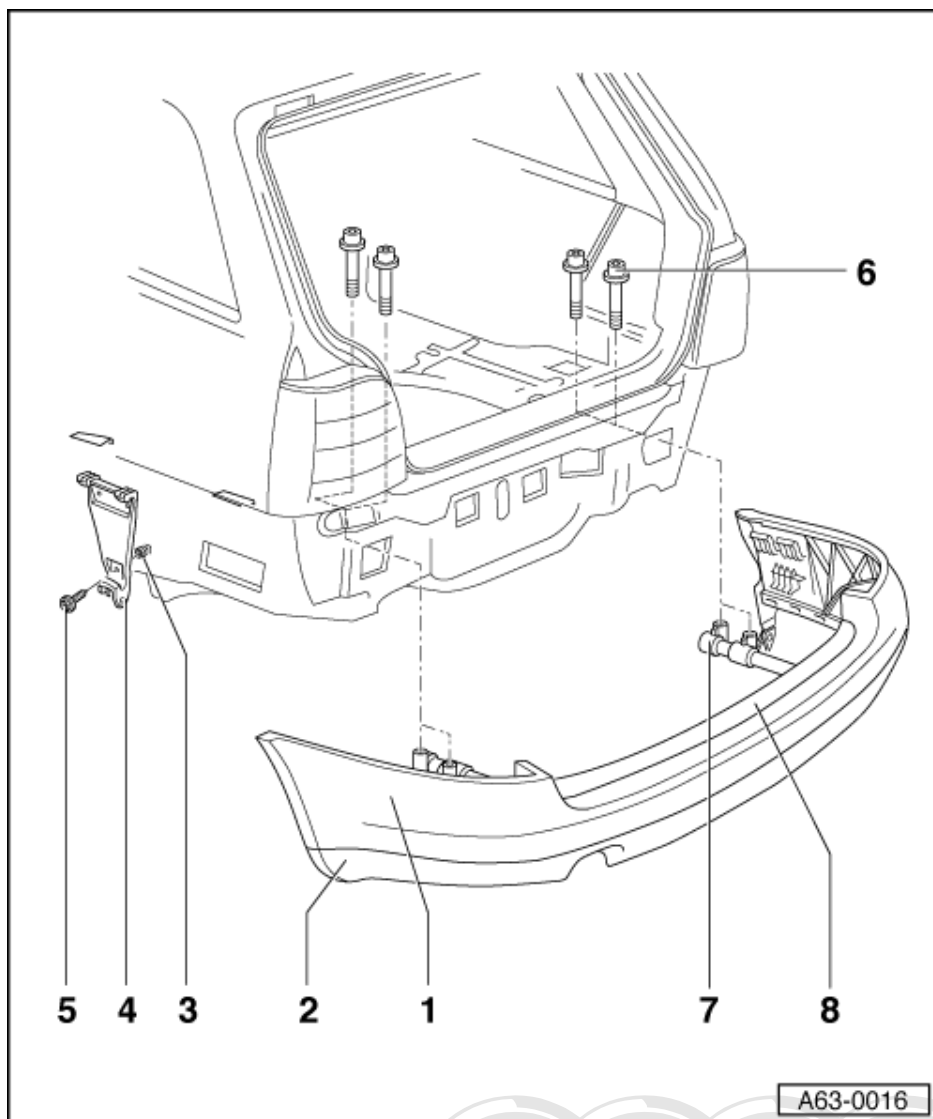
=> General Body Assembly; Repair group 70; Trims Trims

- ◆ Remove tailgate seal in area of sill/side panels.
- ◆ Fold boot lining forwards.
- ◆ Unscrew fastening rings on left and right at side trim and unclip side trim at rear.

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

- ◆ Carefully pull left and right side trim towards centre of vehicle.

- ♦ Unscrew combi bolts -6-.



- ♦ Unclip bumper in direction of arrow from bracket -4- and detach to rear.

2 Spoiler

- ♦ Removing and installing => Page 168

3 Clip

4 Bracket

- ♦ To remove, unscrew self-tapping screws -5- and detach bracket.

5 Self-tapping screw

6 Combi bolt

- ♦ 23 Nm

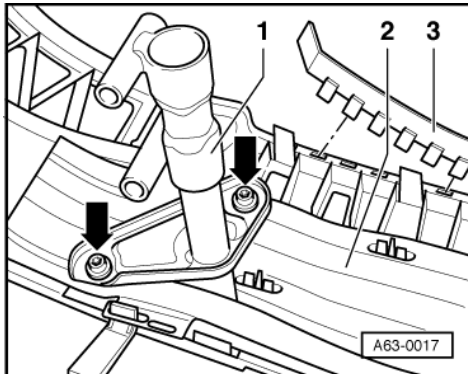
7 Bracket

- ♦ Removing from bumper => Fig. 1
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8 Masking strip

- ♦ Removal => Page 176

4.3 - Detaching masking strip from bumper



- Removing rear bumper => Page **174** .
- -> Release catch and unclip masking strip -3- from bumper -2-.
- For removal of impact absorber.

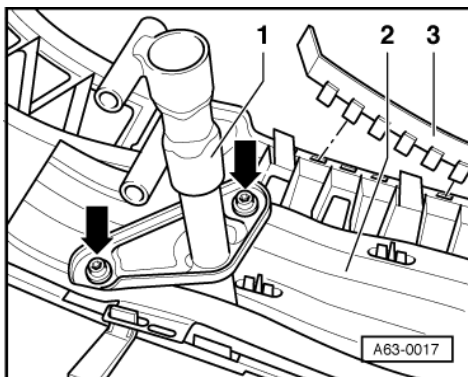
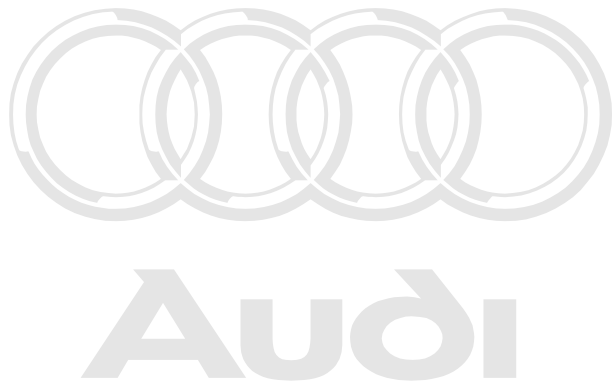


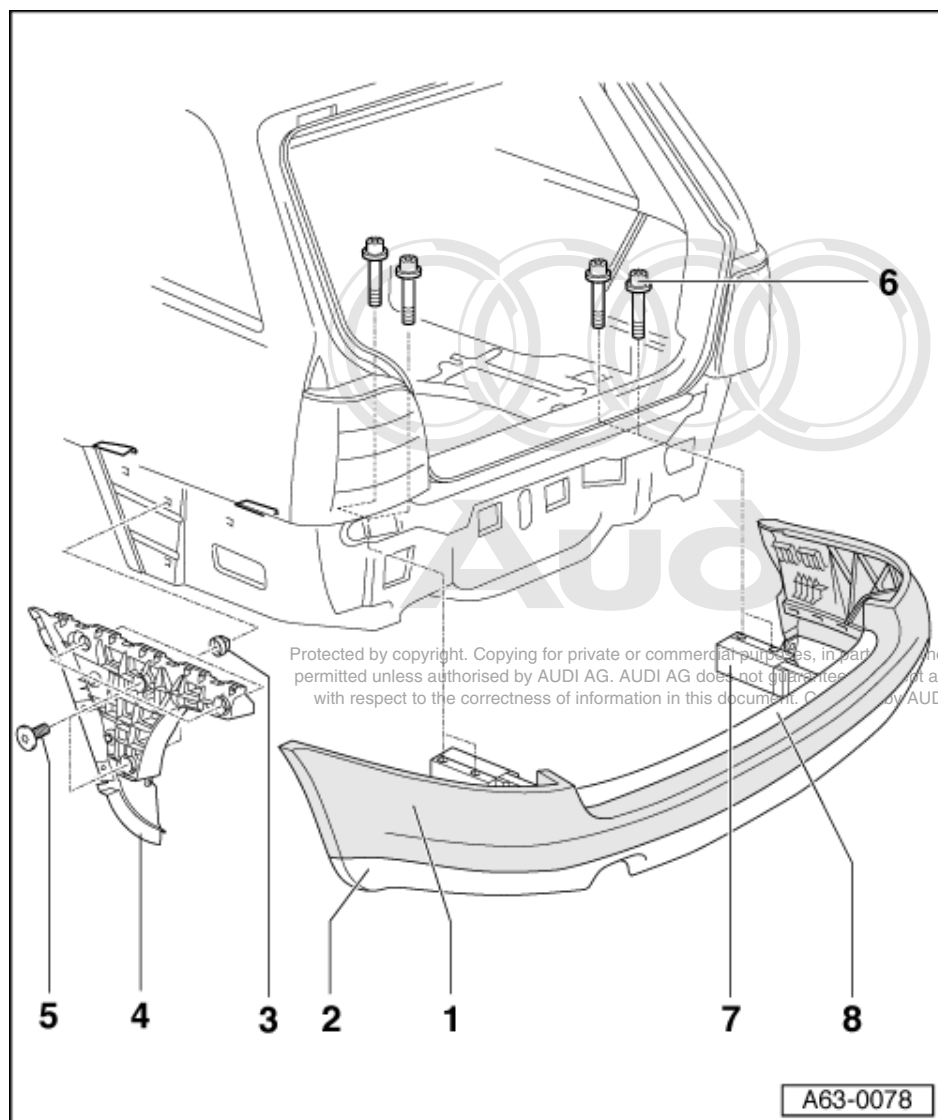
Fig.1 -> Removing bracket from bumper

- Unscrew bolts -arrows- and take bracket -1- out of bumper -2-.
- Tightening torque on installation 23 Nm.



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4.4 - Removing and installing rear bumper (from chassis number 8D XA 200 001)



1 Bumper

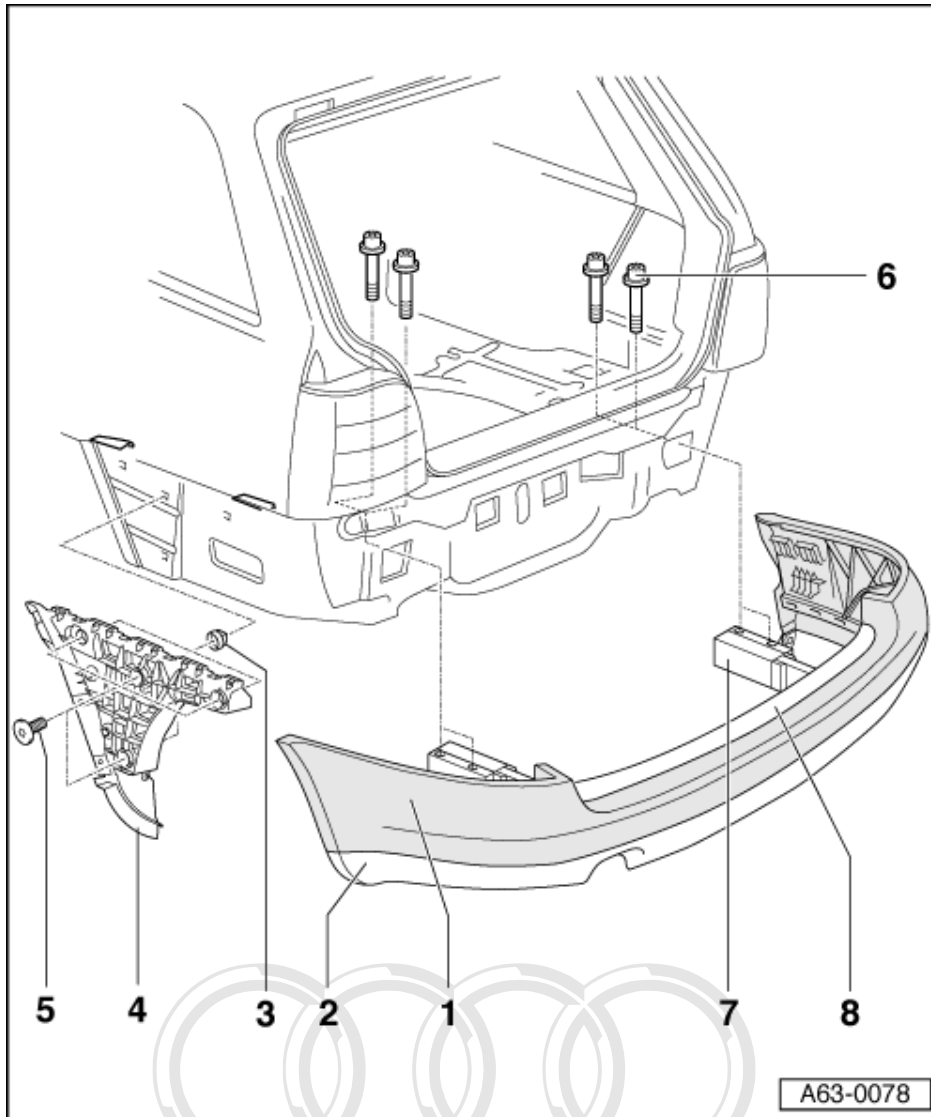
- ♦ Before removal, dismantle trim for rear cross panel.

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

- ♦ Remove tailgate seal in area of sill/side panels.
- ♦ Fold boot lining forwards.
- ♦ Unscrew fastening rings on left and right at side trim and unclip side trim at rear.

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

- ♦ Carefully pull left and right side trim towards centre of vehicle.
- ♦ Unscrew combi bolts -6-.



- ♦ Unclip bumper in direction of arrow from bracket -4- and detach to rear.

2 Spoiler

- ♦ Removing and installing => Page 168

3 Clip

4 Bracket

- ♦ To remove, unscrew self-tapping screws -5- and detach bracket.

5 Self-tapping screw

6 Combi bolt

- ♦ 23 Nm

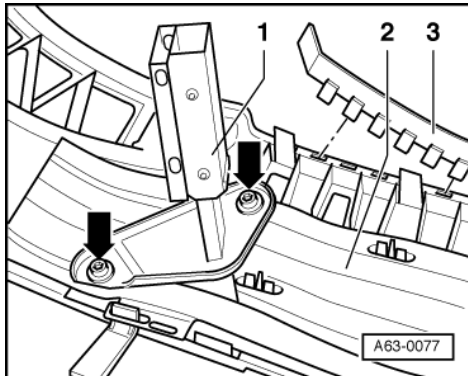
7 Bracket

- ♦ Removing from bumper => Fig. 1 .

8 Masking strip

- ♦ Removal => Page 176 .

4.5 - Detaching masking strip from bumper



- Removing rear bumper => Page 177
- -> Release catch and unclip masking strip -3- from bumper -2-.
- For removal of impact absorber.

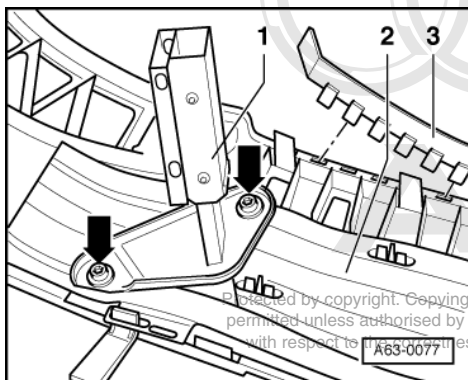
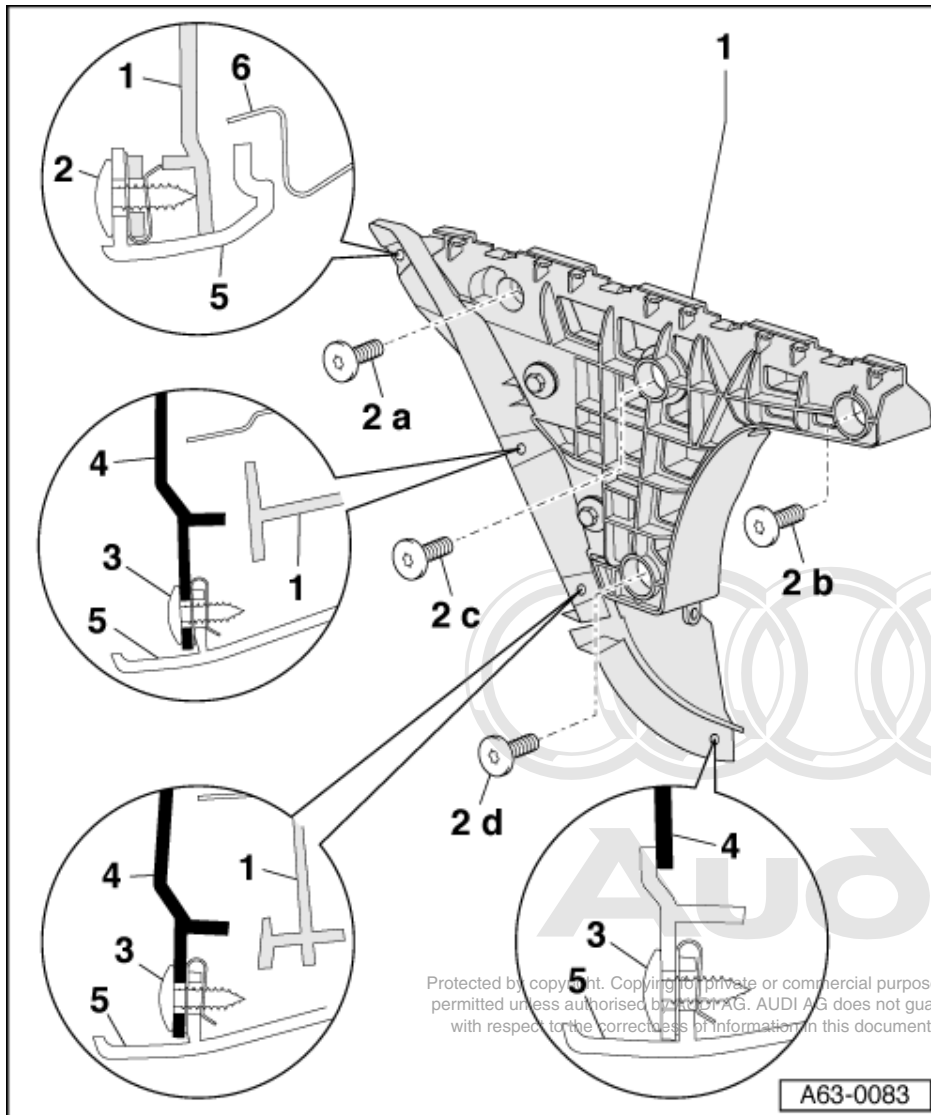


Fig.1 -> Removing bracket from bumper

- Unscrew bolts -arrows- and take bracket -1- out of bumper -2-.
- Tightening torque on installation 23 Nm.

4.6 - Removing and installing bracket for rear bumper



1 Rear bumper bracket

- ♦ The bumper is in two parts, the length of the front half can be adjusted.

2 Combi bolts

- ♦ 1.5 Nm
- ♦ Tighten the screws in sequence -a-; -b-; -c- and -d-.

3 Self-tapping screw

- ♦ 1.5 Nm

4 Rear wheel housing liner

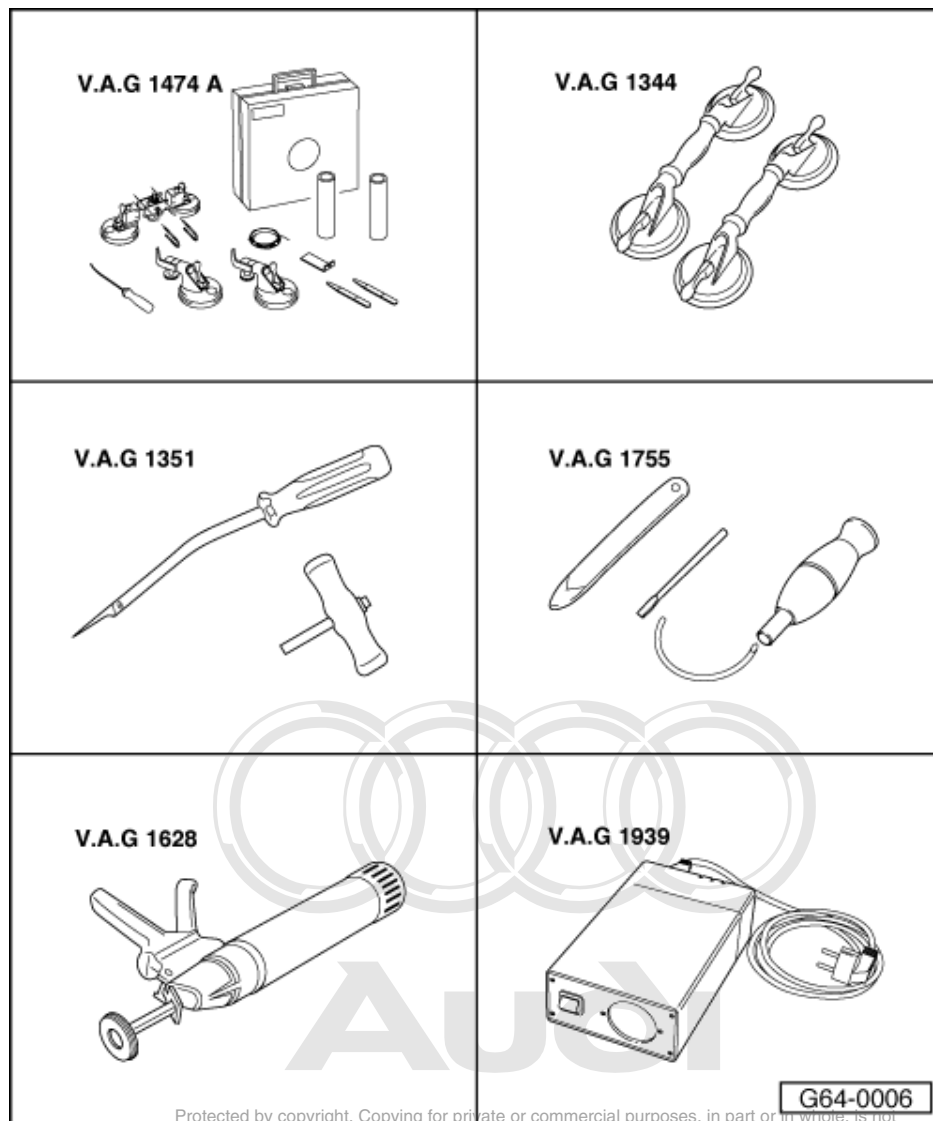
5 Rear bumper

- ♦ Removing and installing
=> Page 177

64 - Glazing

1 - Glass bonded flush with body

1.1 - Glass bonded flush with body



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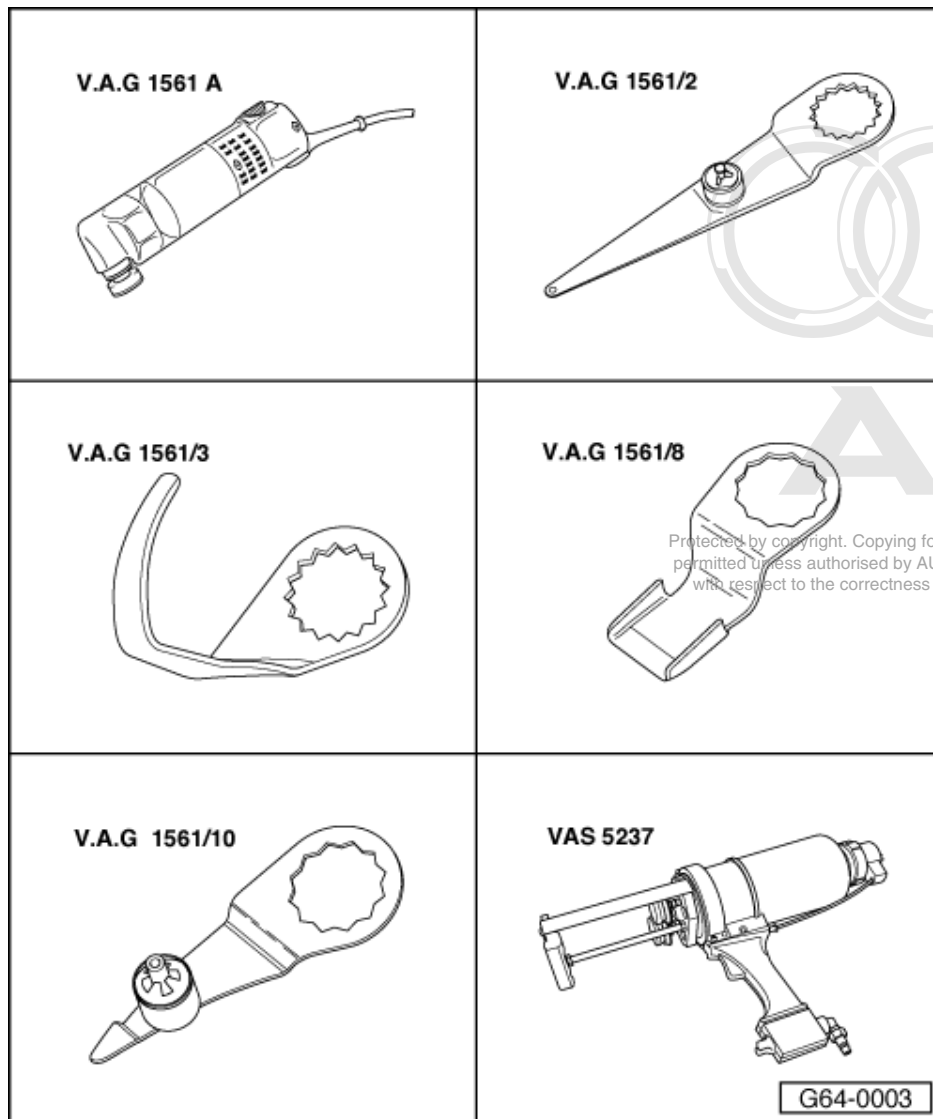
1.2 - Removing and installing flush-bonded windows - general

Special tools and workshop equipment required

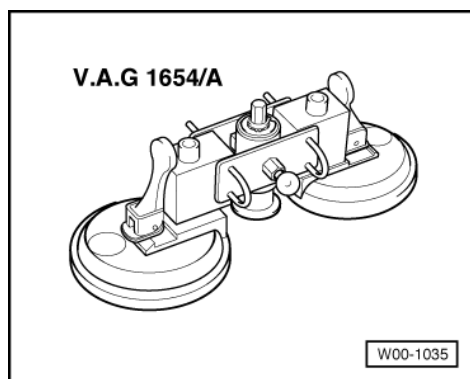
- ◆ V.A.G 1474 A Cutting device for flush bonded windows
- ◆ V.A.G 1344 Suction lifter
- ◆ V.A.G 1351 Cutting tool
- ◆ V.A.G 1755 Window removal kit
- ◆ V.A.G 1628 Hand cartridge gun



♦ V.A.G 1939 Cartridge heater



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



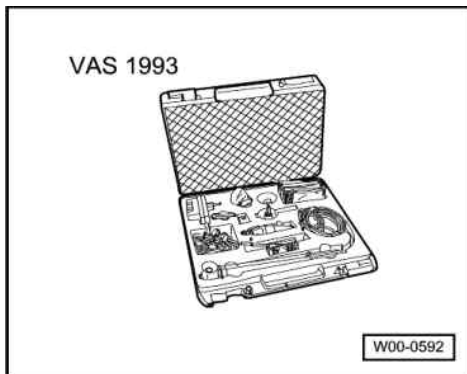
- ◆ -> Winding device V.A.G 1654 A

Notes:

- ◆ Use protective film V.A.G 1474/7 to protect the dash panel when removing the windscreen.
- ◆ When removing with an electric cutter, mask window opening with fabric-reinforced adhesive tape.
- ◆ Deburr tube at front to avoid damaging paintwork.

Important
Follow the manufacturer's safety and usage instructions when handling materials.

1.3 - Repair work using special tool VAS 1993



Repair work using VAS 1993

Notes:

- ◆ -> Windscreens damaged by stone impact can be repaired using the windscreen repair set VAS 1993.
- ◆ The damaged areas must not exceed a certain size, and must not be within the main field of view.
- ◆ Further details can be found in the usage instructions provided with each set.

1.4 - Materials

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

- 1) Note minimum setting time => **Page 184**
- 2) Use double cartridge gun VAS 5237 when handling this material
- 3) Heat according to manufacturer's instructions with cartridge heater V.A.G 1939
- 4) Miniature 110 ml cartridge for sealing and/or for when the 400 ml double cartridge is insufficient



1.5 - Minimum setting times

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

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

Cleaning off adhesive sealant

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

Important

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

Paint areas:

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

Plastic trim:

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

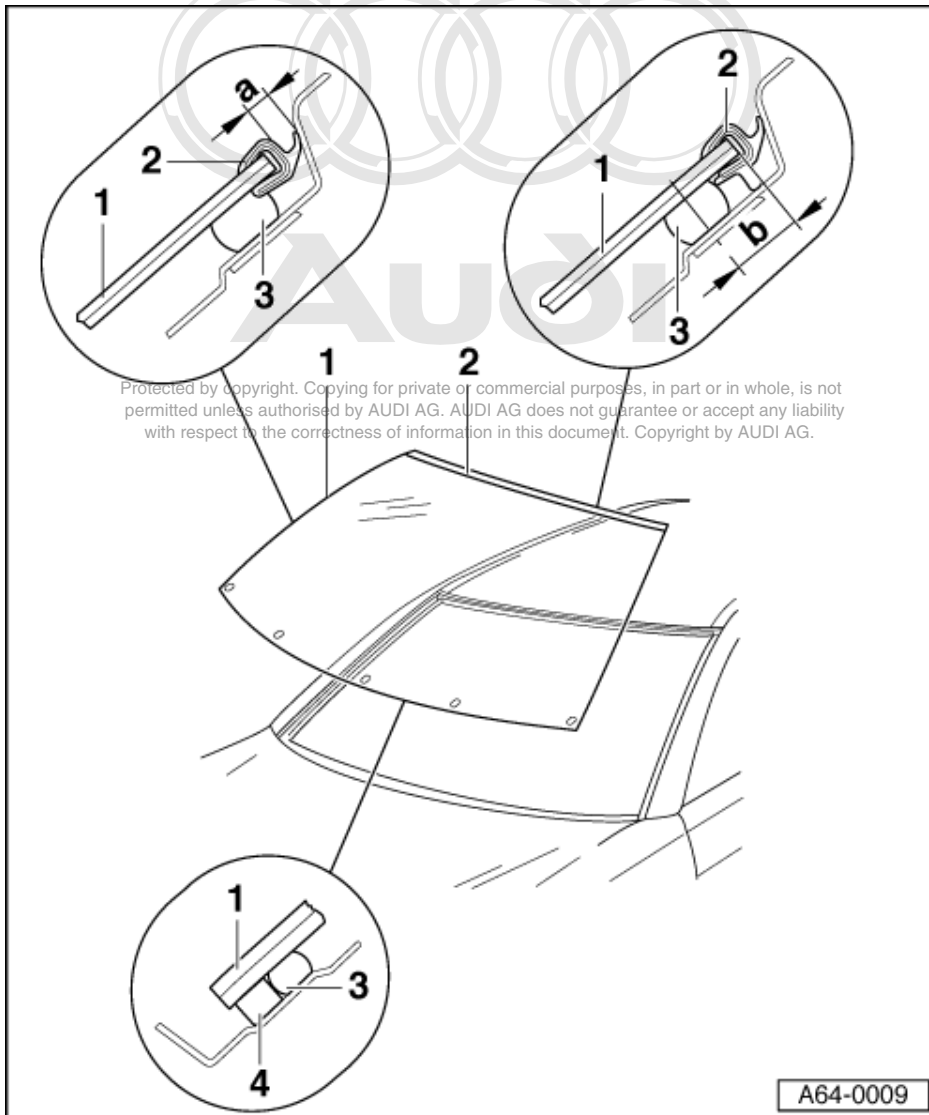
1.6 - Touching up windows with sealant

- Allow leaky area to dry and clean the area.
- Apply and spread adhesive sealant on leaky area between window pane and panel flange.
- Allow adhesive sealant to flash off.
- Apply water to check for leaks.
- Carry out a visual inspection from the passenger compartment.

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2 - Removing and installing windscreen - Assembly overview

2.1 - Removing and installing windscreen - Assembly overview



1 Windscreen

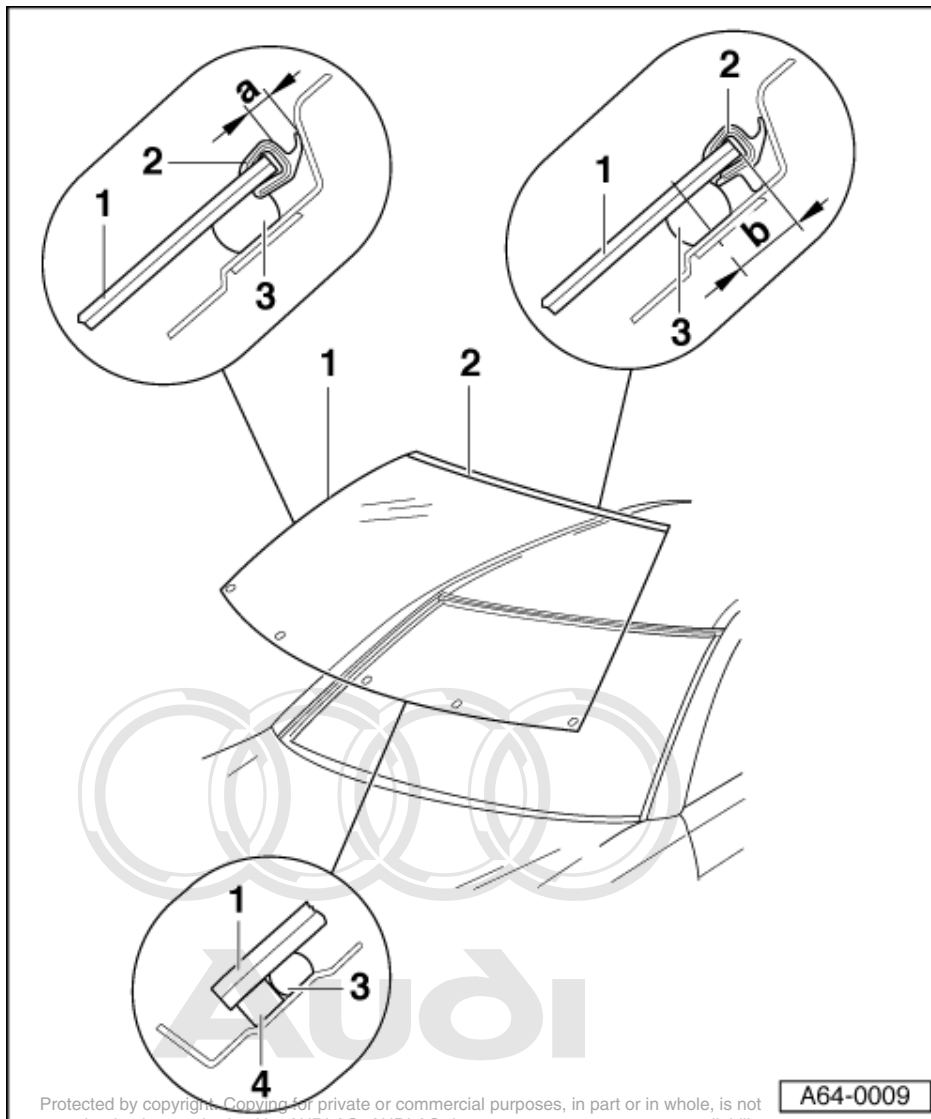
- ♦ Removing windscreen
=> Page 187 .
- ♦ Installing windscreen => Page 192 .
- ♦ Distance -a- between windscreen and roof frame = 4 mm.

Note:

- ♦ If applicable, on the windscreen, the attached label (e.g. Airbag), must be attached in the same place on the new windscreen.

2 Masking strip

- ♦ Push on centrally before fitting windscreen.
- ♦ Note assembly mark on masking strip => Fig. 1 .



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A64-0009

3 Adhesive bead

- ♦ Bead cross-section and distance from edge of windscreen =>Page 191 .

4 Spacer

- ♦ Note different heights of spacers =>Fig. 1 .
- ♦ Outer spacer (2*) height = 6.5 mm
- ♦ Inner spacer (3*) height = 7.5 mm

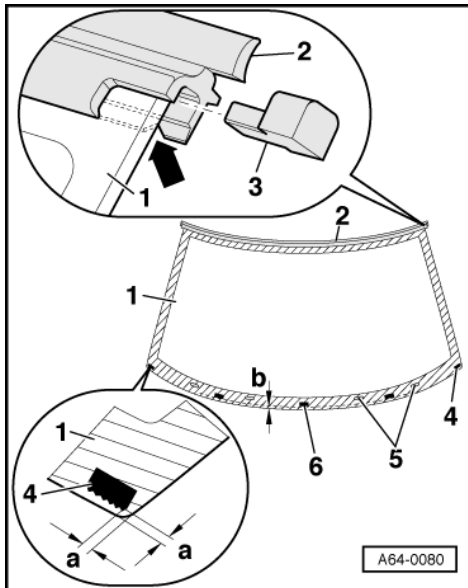


Fig.1 -> Bonding on lower spacers

- Bond on each of three inner spacers -6- (height = 7.5 mm) in centre of windscreen and centred with windscreen wiper marks -5- at a distance -b- = 25 mm±5 mm from bottom edge of windscreen.
- Bond on outer spacer -4- (height = 6.5 mm) at a distance -a- = 0 to 5 mm from outer and bottom edge of windscreen.
- When attaching masking strip -2- to windscreen -1- notches -arrow- must be flush with edge of windscreen.
- Insert filler piece -3-.

2.2 - Removing windscreen

- Remove wiper arms.

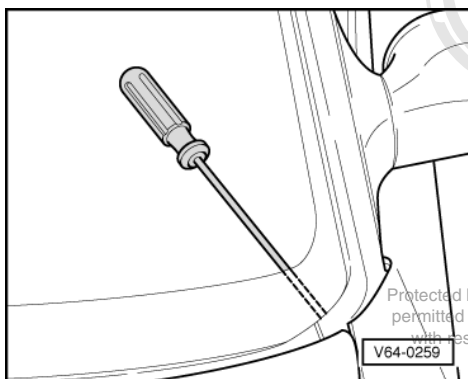
=> Electrical System; Repair group 92

- Remove cowl panel trim.
- Pull left and right water deflectors out of retaining strips (from the bottom upwards).
- Remove sun visors on left, in centre and on right.

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

- Dismantle interior rear-view mirror.

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



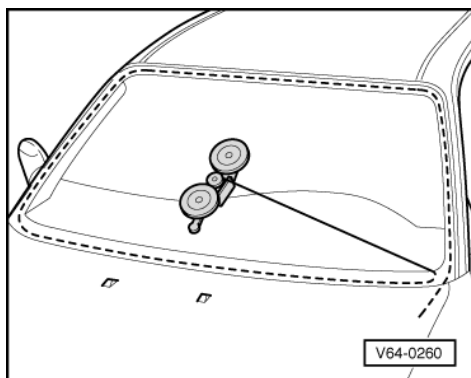
- Dismantle trim on top of A-pillars.

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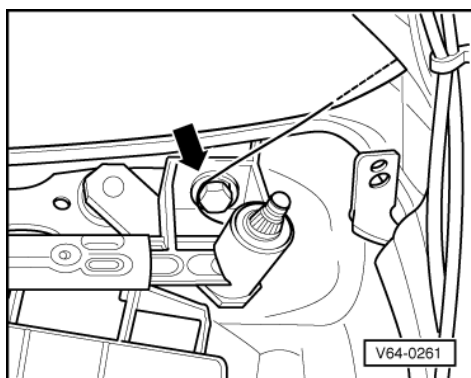


=> General Body Assembly, Interior; Repair group 70; Trims Trims

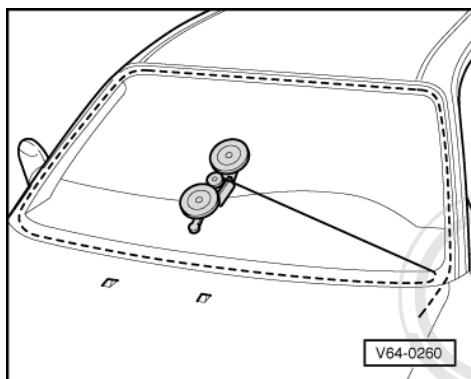
- Using an awl, pierce adhesive bead from inside at bottom left corner of windscreen.
- -> Insert cutting cord into awl and pull through into vehicle interior.



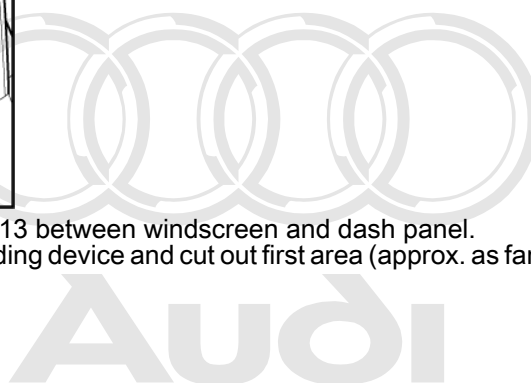
- -> Route cutting cord along entire underside of windscreen.



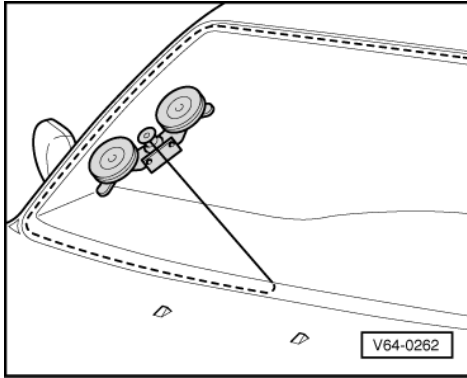
- -> Fasten end of cutting cord at bolt for securing wiper arms.



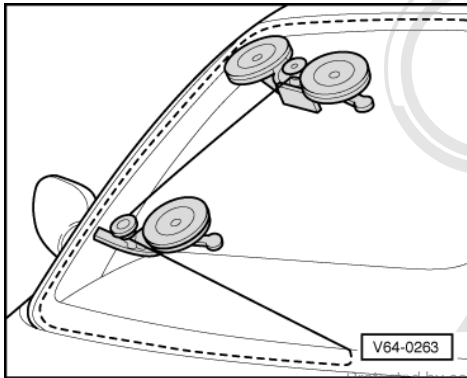
- Insert protective cover V.A.G 1474/13 between windscreen and dash panel.
- -> Secure start of cutting cord in winding device and cut out first area (approx. as far as centre of windscreen).



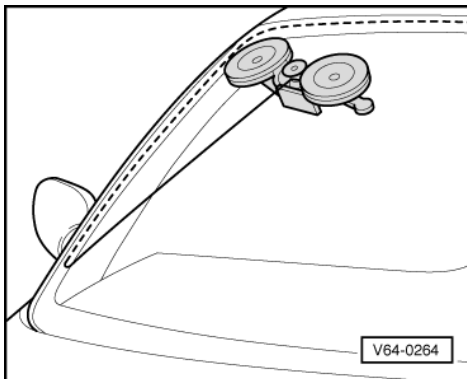
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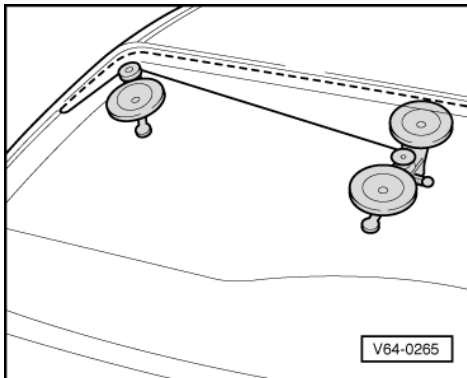
- -> Move winding device as shown in illustration and continue cutting.



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



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





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

2.3 - Preparation for windscreen installation

Preparing removed undamaged window for glazing

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

Important

Keep bonding surface clean and free from grease.

Do not trim bonding surface until shortly before installation.

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

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

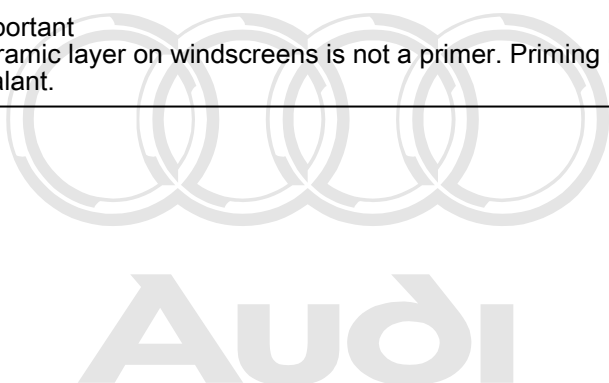
New window

Note:

- ♦ If applicable, on the windscreen, the attached label (e.g. Airbag), must be attached in the same place on the new windscreen.
- Clean bonding area all round windscreen with cleaning fluid (D 009 401 04).
- Apply primer (D 009 200 02) as described below.

Important

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



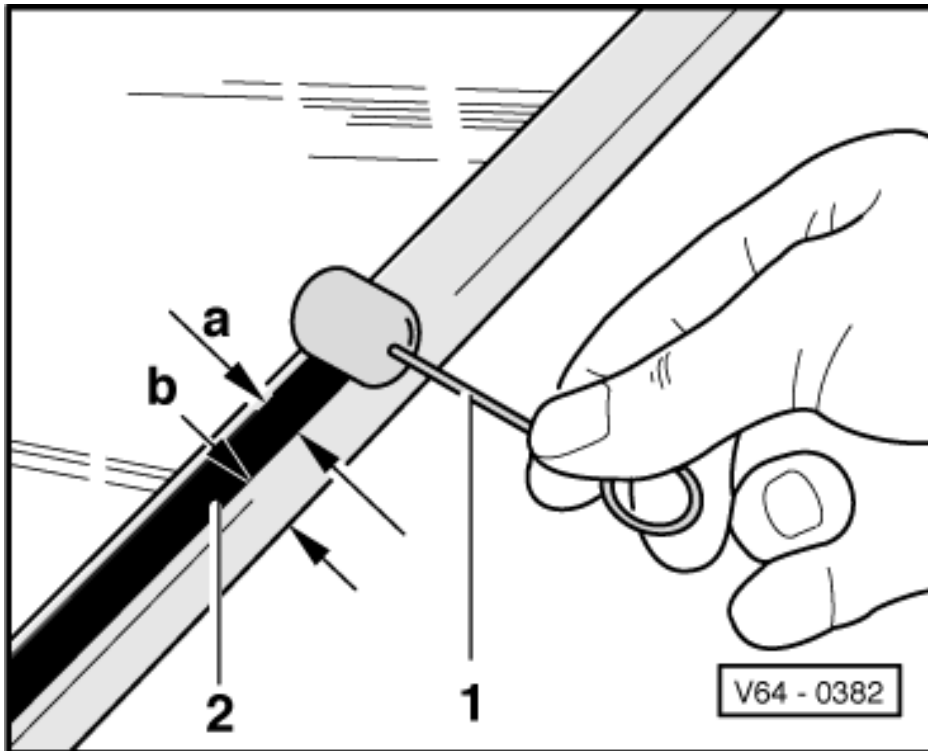


Fig.1 Applying primer

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

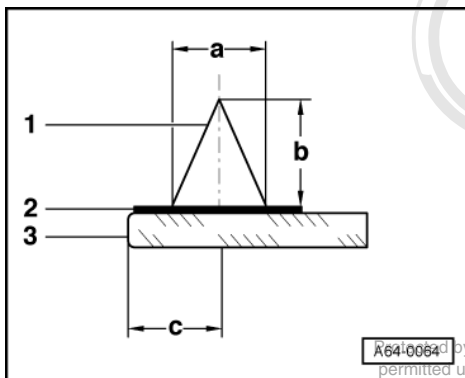


Fig.2 -> Dimensions for applying adhesive

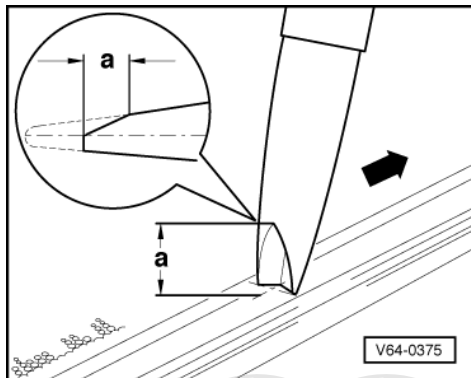
- Adhesive bead -1-.
- Primer -2-.
- Windscreen -3-.
- Dimension -a- = 8 mm.
- Dimension -b- = 12 mm.
- Dimension -c- = 8 mm from edge of windscreen on all sides.

Repaired windscreen flange

- If the windscreen flange has been repaired or replaced, the paintwork must be restored according to specifications in the "Vehicle Painting" Workshop Manual and corrosion protection applied if necessary according to the "Surface Treatment/Chemical Materials" Workshop Manual.

- Clean the repaired area with D 009 401 04, then prime with D 009 200 02.

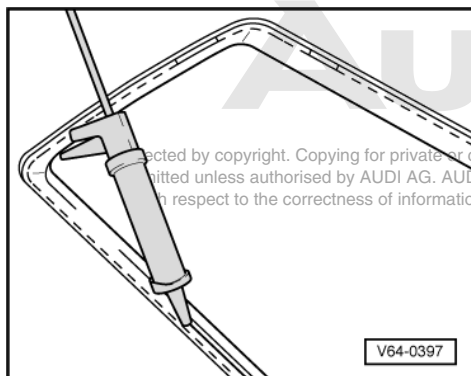
2.4 - Installing windscreen



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

Note:

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

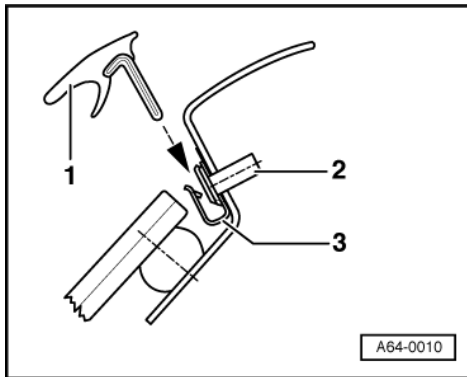


- -> Apply adhesive sealant to perimeter of windscreen as shown in illustration.
- Spacing between centre of adhesive bead and edge of windscreen is 8 mm.
- Using two double suction cups, install windscreen glass in windscreen opening.

Important

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

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



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

2.5 - Adhesive sealing materials and setting times

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

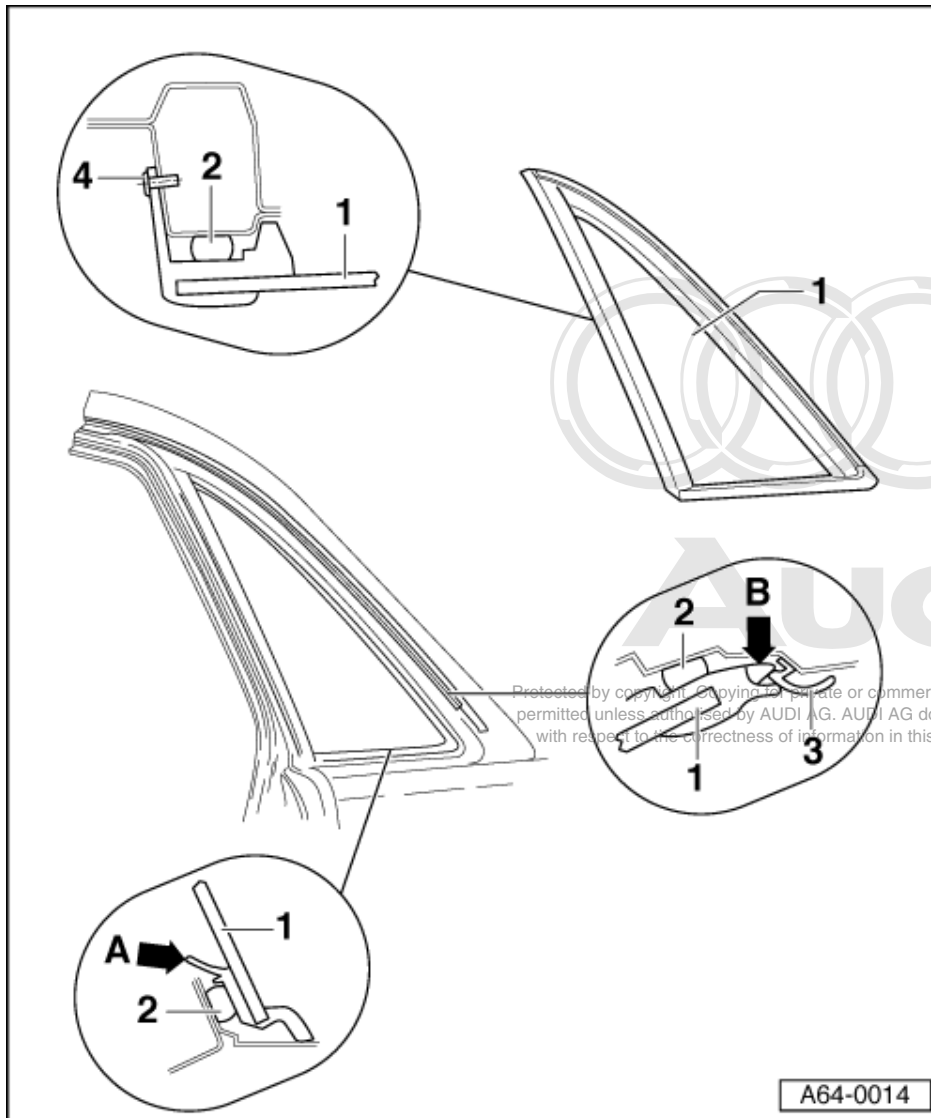
Type of window	Vehicle	Adhesive sealant	Curing time in hours
Windscreen	with/without airbag	DA 004 600 A2	3
Rear window		DA 004 600 A2	3
Side windows		DH 009 100 03	3

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3 - Removing and installing side window

3.1 - Removing and installing side window



3.2 - Assembly overview

Removing rear bench seat and backrest.

=> General Body Assembly, Interior; Repair group 72; Rear seat; Removing and installing rear seat bench

Unclip rear shelf.

Remove C-pillar trim.

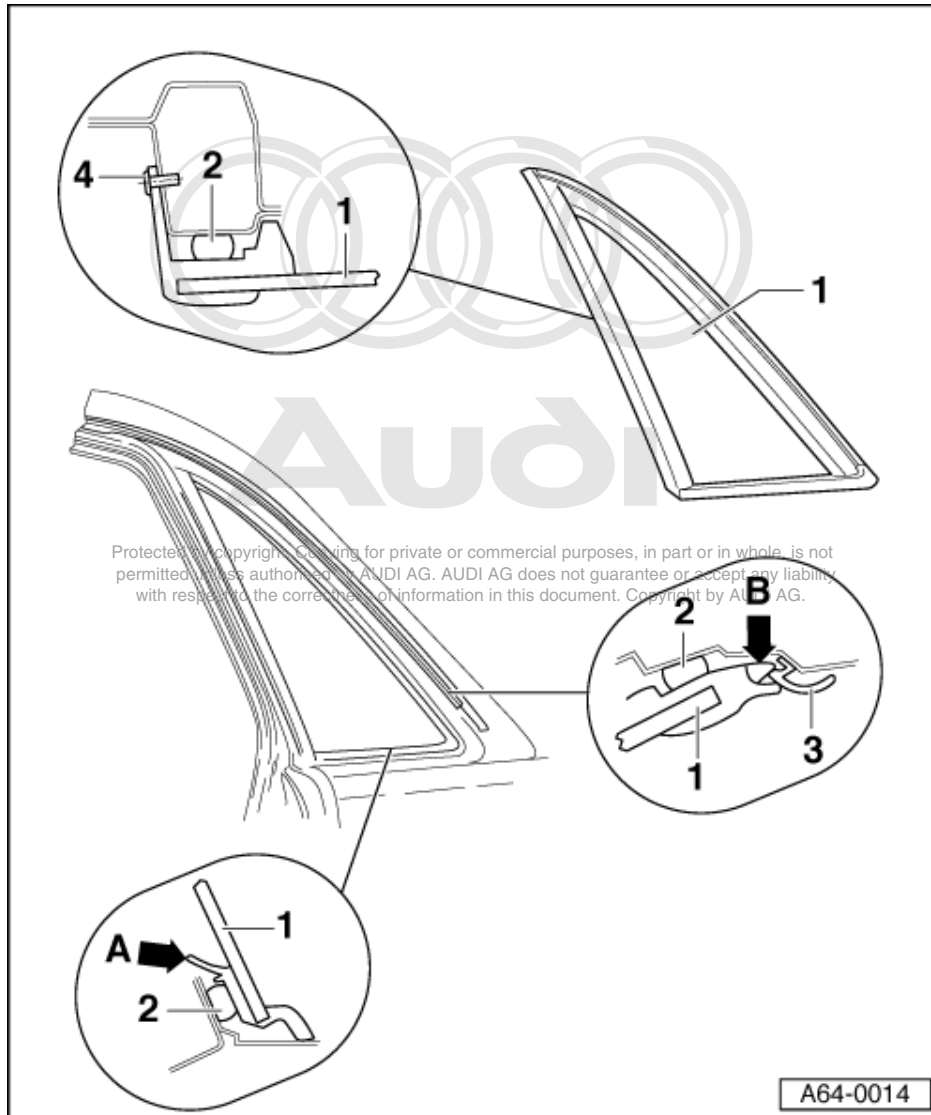
=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing C/D-pillar trim

1 Side window

- ♦ Removing => Page 195 .
- ♦ To avoid damaging lip with cutting wire on removal, bend up -arrow A- and attach to side window with adhesive tape.

2 Adhesive bead

- ♦ Dimensions for adhesive bead application =>Page 198 .



3 Roof trim strip

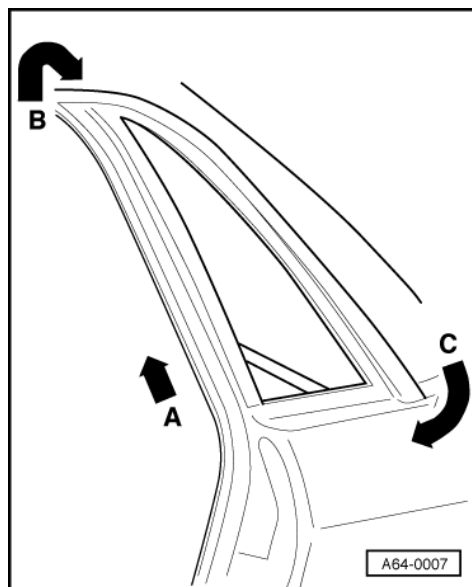
- ♦ On installing window, lug of PVC moulding -arrow B- must be inserted under roof trim strip.

4 Hollow rivet

- ♦ Before removing window, drill off rivet head and knock out shank.

3.3 - Removing an intact window

- Drill off rivet head at C-pillar and knock out shank.

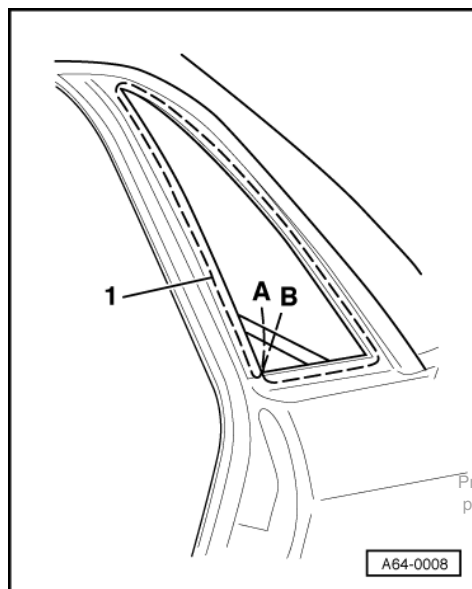


- Pierce through from the inside to the outside in area of C-pillar bottom/side panel using an awl.
- Push cutting wire through from outside to inside.

Important

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

- -> Lay cutting wire from bottom to top -arrow A- on C-pillar under PVC coating.
- Push through cutting wire from top to bottom -arrow B- on D-pillar between PVC coating and roof trim strip.
- First withdraw cutting wire from D-pillar at bottom and then push through between side panel and window in direction of C-pillar -arrow C-.



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

Important

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

3.4 - Installing an intact window

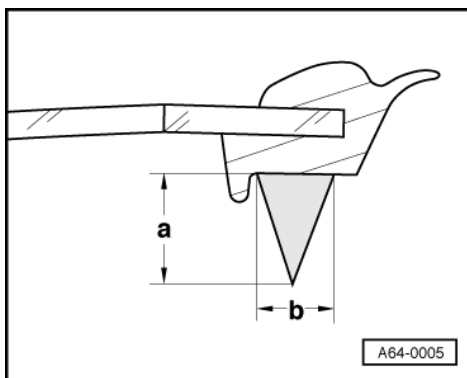
- When re-using an undamaged window, shortly before installing, smooth down adhesive sealant residue on the window pane and window flange with a carpet knife. Under no circumstances remove completely.
- Remaining material serves as a bonding surface for the new adhesive sealant when it is applied.
-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

Important

Note:

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

- Insert window in opening and fix in position with adhesive tape.
- Secure moulding to C-pillar with hollow rivet.



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

Note:

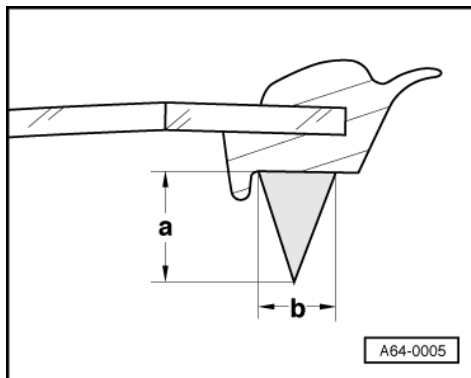
The height of the adhesive bead should be reduced by the height of the remaining residue on the window and the flange.

3.5 - Installing new side window

Note:

Replacement windows are supplied with pre-set adhesive bead. This is to be trimmed back to approx. 2 to 3 mm before applying adhesive. Apply adhesive in usual manner to freshly cut residual bead.

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

Important

Note:

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

Important

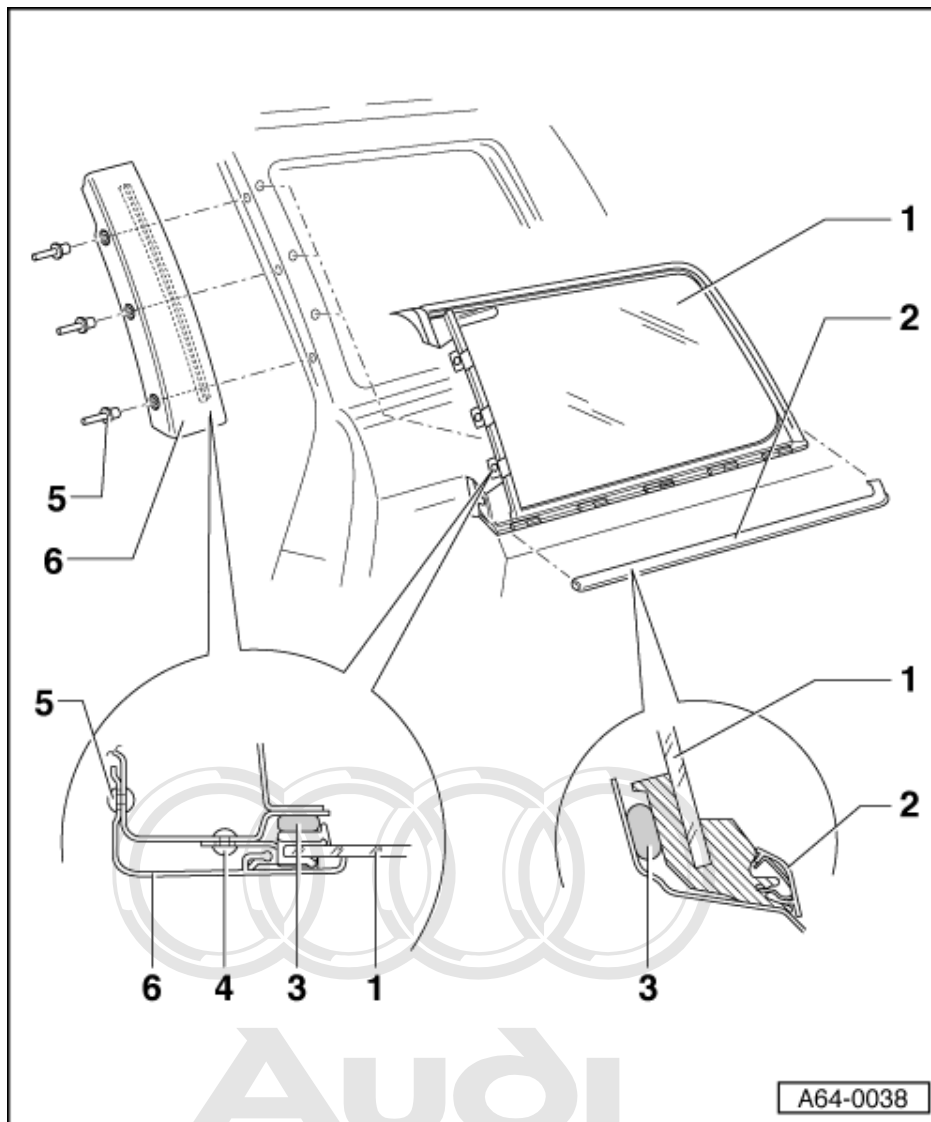
Windscreen must be inserted within 10 minutes, otherwise the adhesive properties of the adhesive sealant will be impaired.

- Note different setting times of adhesive materials => Page 193 .
- 4 hours for DH 009 100.

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4 - Removing and installing side window - Avant

4.1 - Removing and installing side window - Avant



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4.2 - Assembly overview

Note:

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

1 Side window

- ♦ Surrounded by PVC moulding.

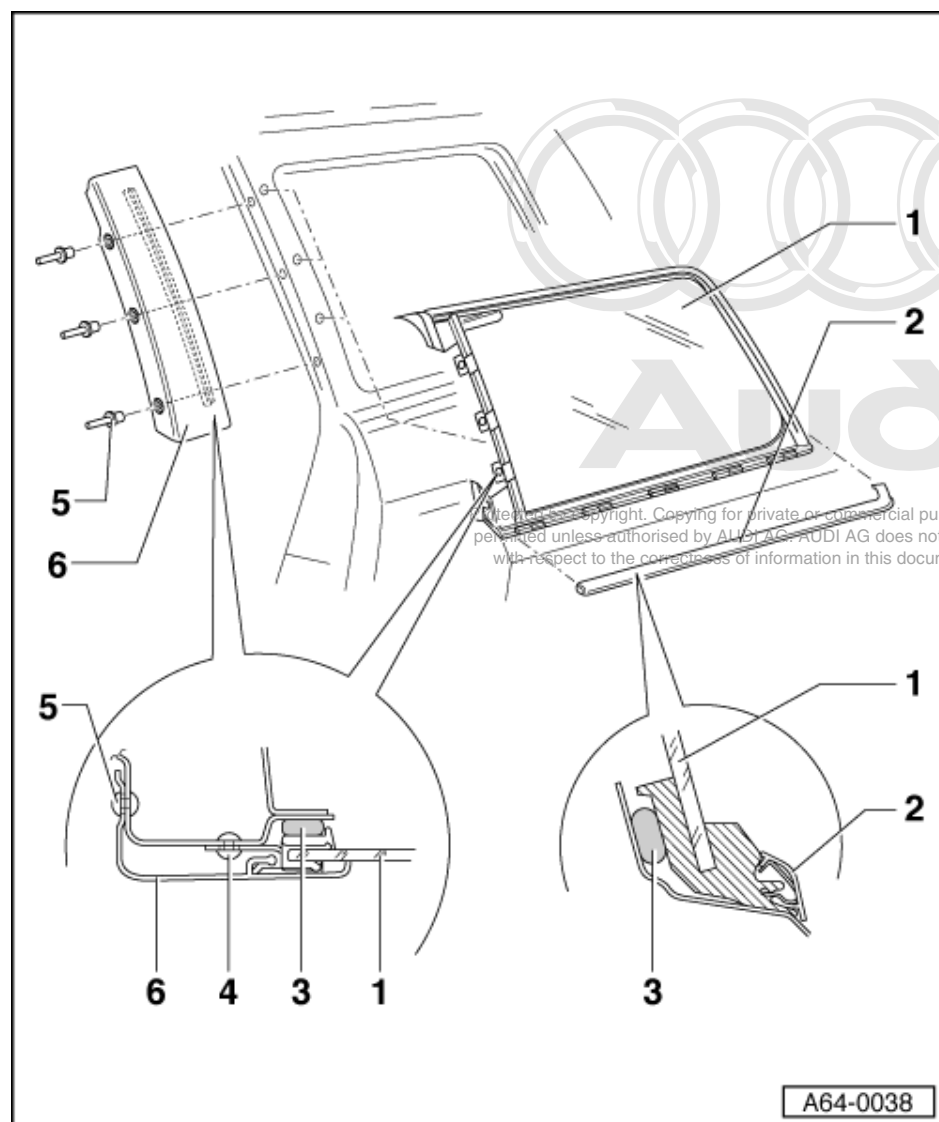
Note:

Replacement windows are supplied with pre-set adhesive bead. This is to be trimmed back to approx. 2 mm before applying adhesive. Apply adhesive in usual manner to freshly cut residual bead.

Important

Do not cut down to PVC.

A bead cut down as far as the PVC can no longer be bonded by workshop means.



2 Trim strip

- ◆ Before removing, mask transition to side panel with adhesive tape to prevent damage to paintwork.
- ◆ Remove => Fig. 1.

3 Adhesive bead

- ◆ Apply adhesive to freshly cut-down residual bead.

4 Hollow rivet

5 Hollow rivet

6 C-pillar trim

- ◆ To remove, drill off rivet heads, knock out shanks and detach trim.

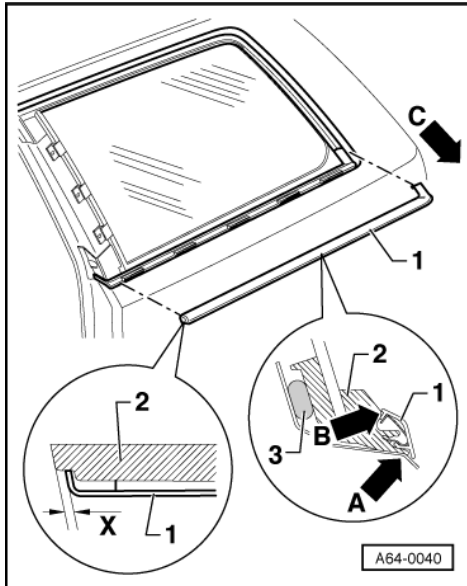


Fig.1 -> Removing trim strip

Important

To prevent damage to paintwork on removal and installation of trim strip, always mask area around bottom of side window and side panel with adhesive tape.

- Unclip bottom of trim strip arrow -A-, then top arrow -B- and pull downwards arrow -C- out of trim strip at D-pillar.

Installing trim strip

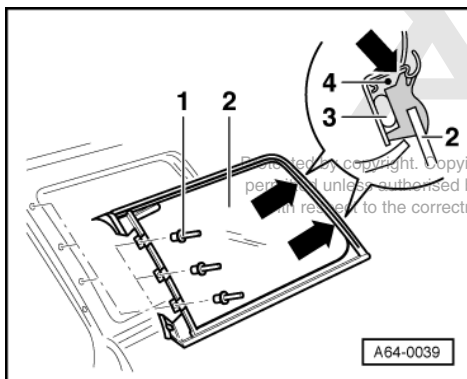
- Push trim strip under roof frame strip at D-pillar and engage.
- Swivel trim strip horizontally to clip in.
- Dimension X = maximum 1 mm.

4.3 - Removing intact side window

- C/D-pillar trim removed
- Side trim removed
- If vehicles are fitted with glass-breakage sensors, detach electrical connector at window to be dismantled and use adhesive tape to stick wire to centre of window.

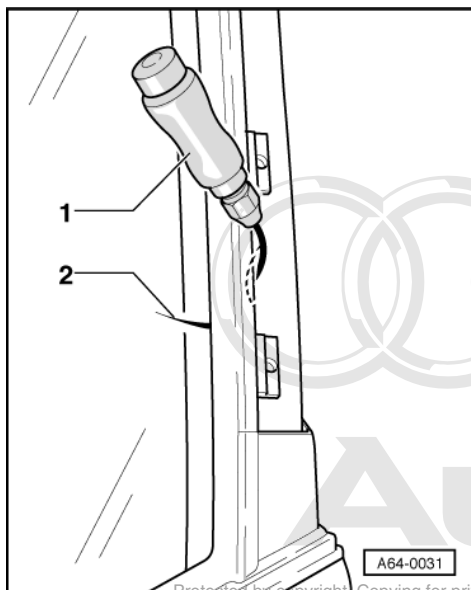
Important

If wire is not detached, it will be severed when cutting and the window destroyed.

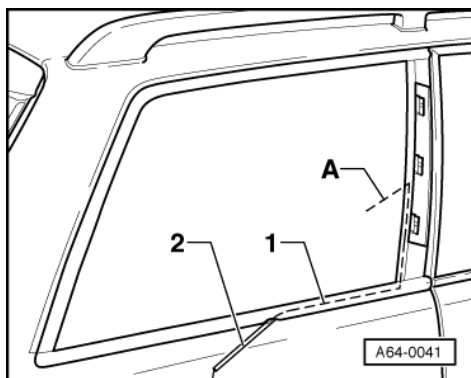




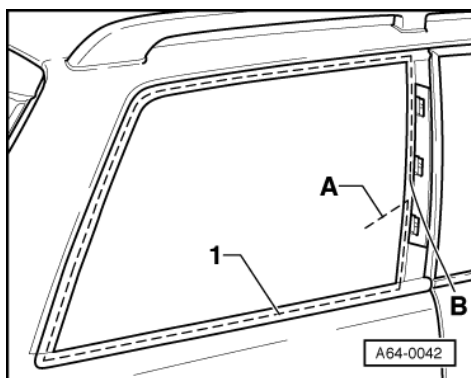
- Drill off rivet heads at C-pillar and knock out shank.
- Detach trim panel at C-pillar
- -> Drill off rivet heads -1- and knock out shanks.
- Remove anodised aluminium trim strips where fitted => Page 201 .



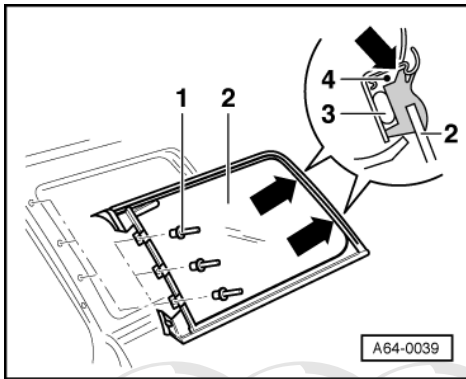
- -> Pierce adhesive bead with trimming needle -2- using handle -1-.
- Trimming needle must run as close as possible to window here.
- Unscrew handle and insert cutting thread in eye of needle.
- Pull end of cutting thread -A- to inside (use pliers and gloves).



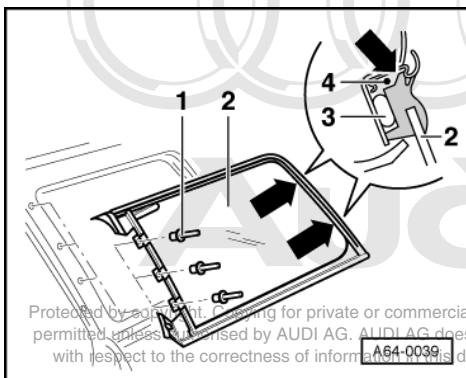
- -> Pull cutting thread -1- with tube -2- under PU moulding of side window.



- -> Route cutting thread -1- all round window.
- Attaching end of cutting thread -B- to catch => Page 204 .



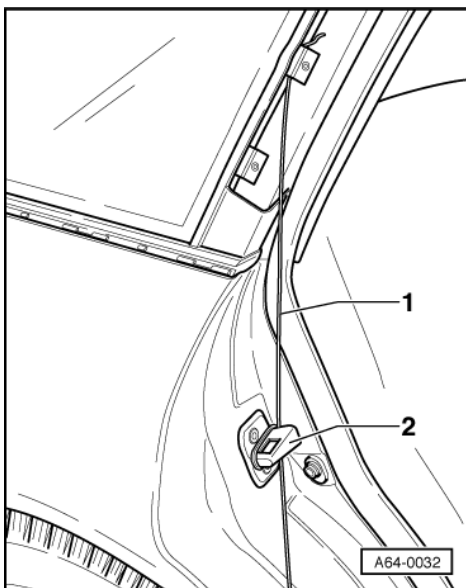
- -> Use trimming needle from special tool V.A.G 1755 to pull cutting thread through under retainers at D-pillar -arrows-.



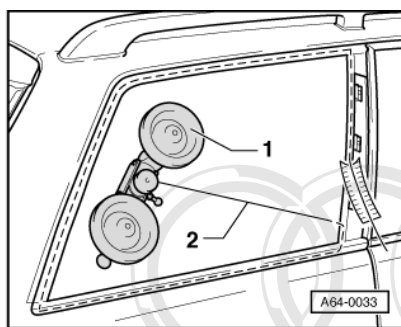
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Important
In area of D-pillar, thread -4- must be positioned beneath the two retainers -arrows- and in front of the adhesive bead.

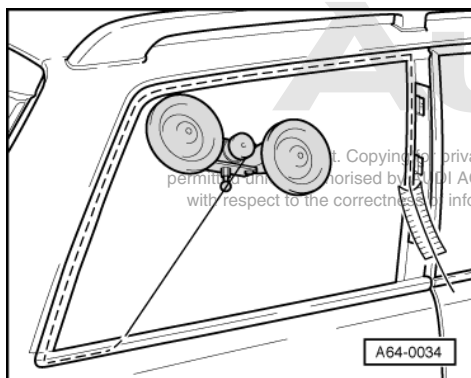
- -> Use trimming needle from special tool V.A.G 1755 to pull cutting thread through under retainers -arrows-.



- -> Attach outer end of thread -1- to catch -2- (place fabric-reinforced adhesive tape -3- under thread).

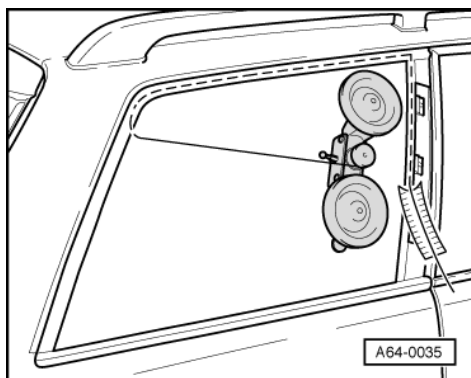


- -> Attach reel as shown and secure cutting thread in it.
- Cut out first area at C-pillar and bottom of window.

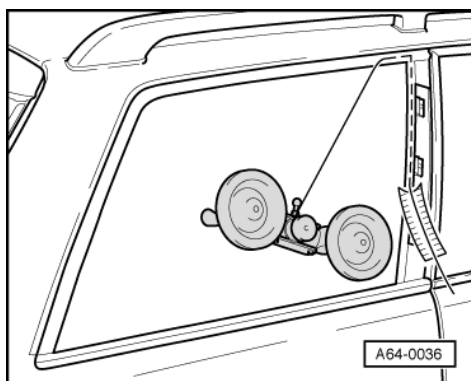


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- -> Move reel and continue cutting.
- Press cutting thread in direction of D-pillar whilst cutting.



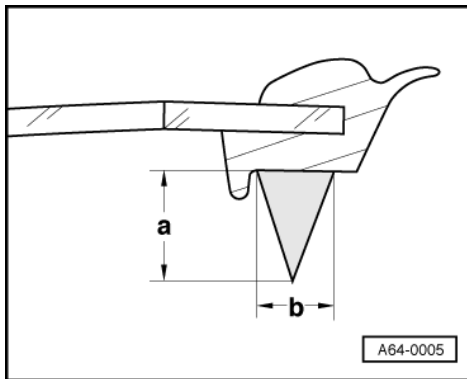
- -> Move reel as shown and continue cutting.
- Press cutting thread upwards whilst cutting.



- -> Move reel downwards and completely cut out side window.
- Press cutting thread in direction of C-pillar whilst cutting.
- Remove side window with double suction cup units.

4.4 - Installing side window

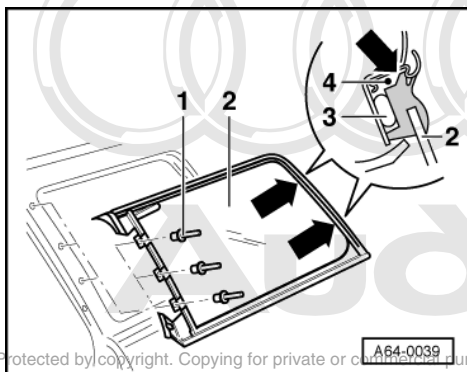
- Trim adhesive bead of side window to approx. 2 mm.
- Trim adhesive bead at window flange.



- -> Apply adhesive sealant centrally all round residual material on window.
- Dimension -a- = 12 mm+2 mm
- Dimension -b- = 8 mm+3 mm

Important

Do not prime bonding surfaces and do not treat with cleaning fluid.
Windscreen must be inserted within 10 minutes, otherwise the adhesive properties of the adhesive sealant will be impaired.

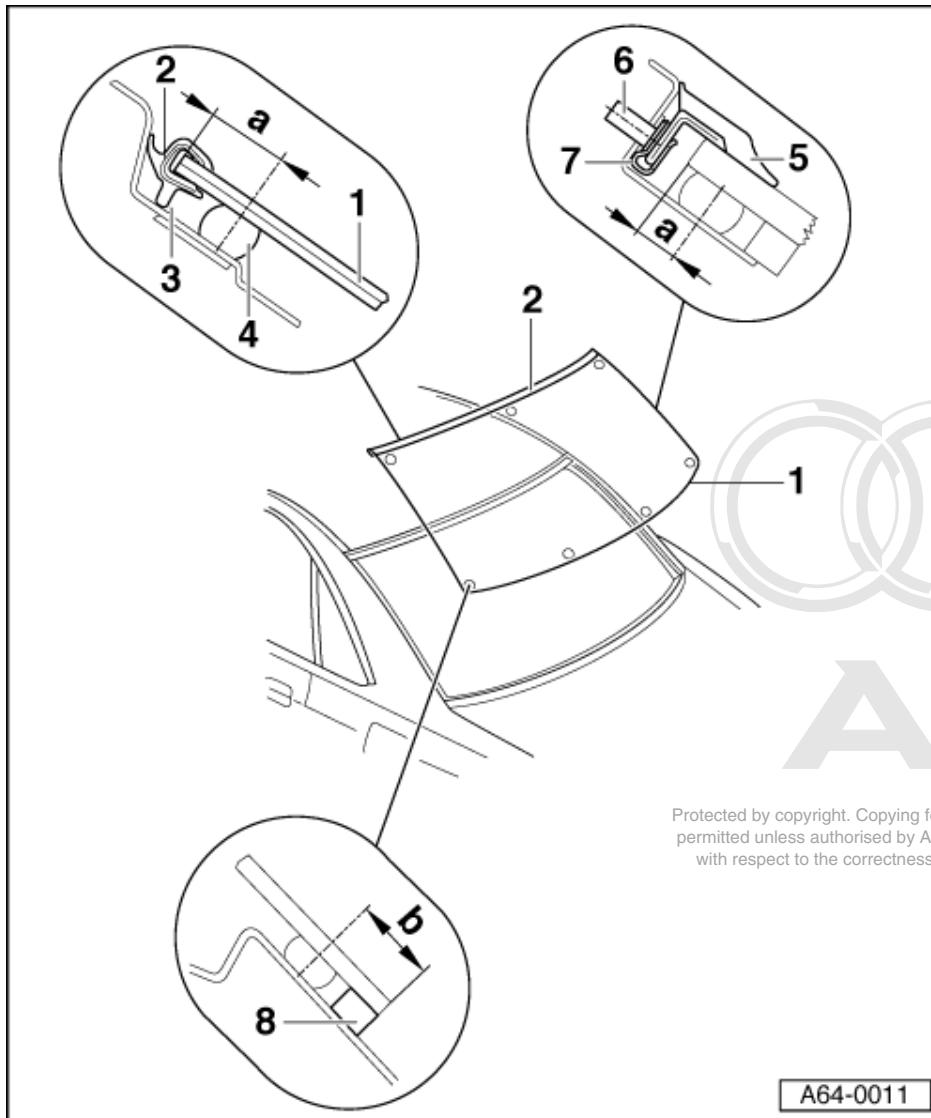


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- > Position window -2- parallel and press the two retainers -arrows- into rear roof strip at D-pillar.
- Align window with opening.
- Use hollow rivet -1- to attach window holder to C-pillar.
- Fit C-pillar trim.
- Setting time 4 hours.

5 - Removing and installing rear window

5.1 - Removing and installing rear window



5.2 - Assembly overview

1 Rear window

- ♦ Removing rear window =>Page 207 .
- ♦ Installing rear window =>Page 212 .

2 Masking strip

- ♦ Push on centrally before fitting windscreen.
- ♦ Note assembly marking on window and masking strip.

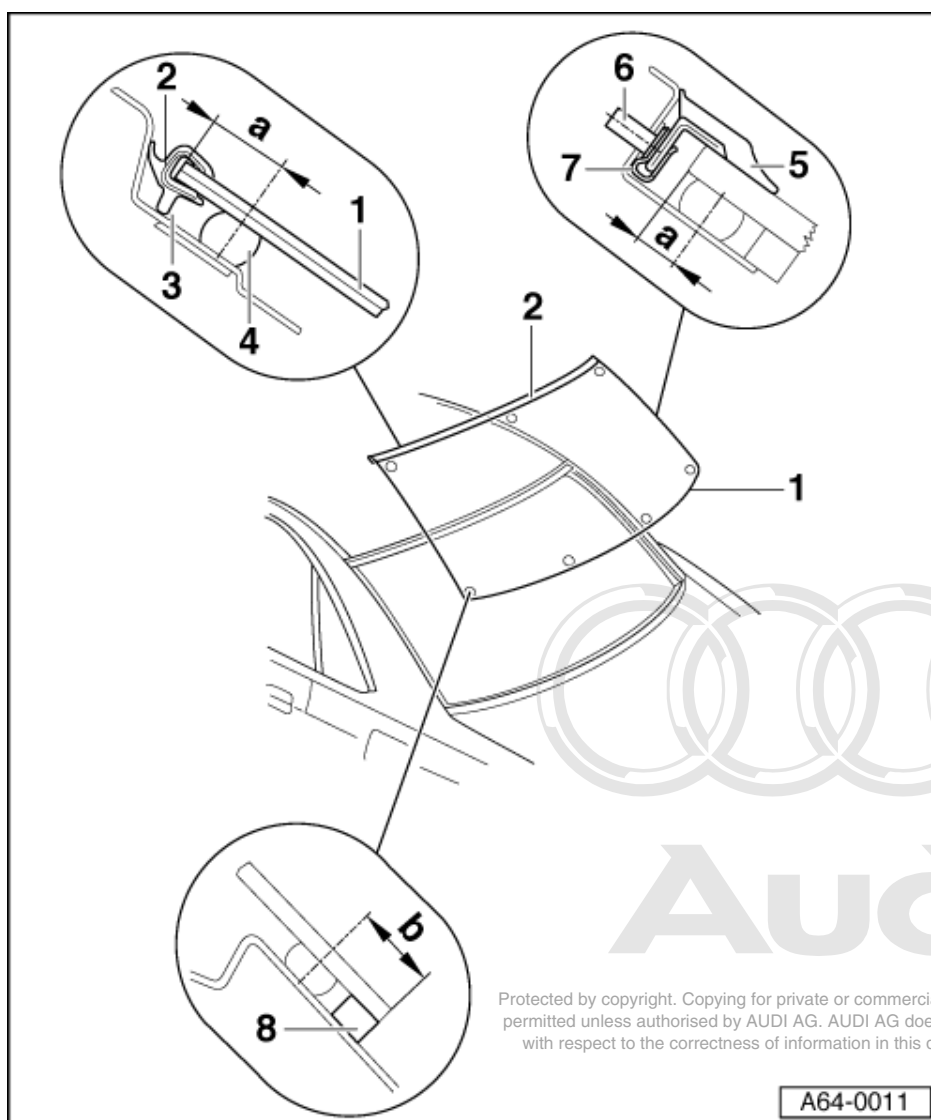
3 Spacer elements

- ♦ Incorporated into masking strip along length of strip.

4 Adhesive bead

- ♦ Bead cross-section =>Page 214 .
- ♦ Note different distances from edge of windscreen.
- ♦ Distance from edge of window
Dimension a = 8 mm

Dimension b = 13 mm



5 Masking strip

- ♦ Prise out on left and right, starting at bottom, before removing rear window.

6 Hollow rivet

7 Fastening strip

- ♦ Press masking strip -5- into fastening strip after fitting window.

8 Spacer

- ♦ Attach 4* to lower edge of window in line with marks.

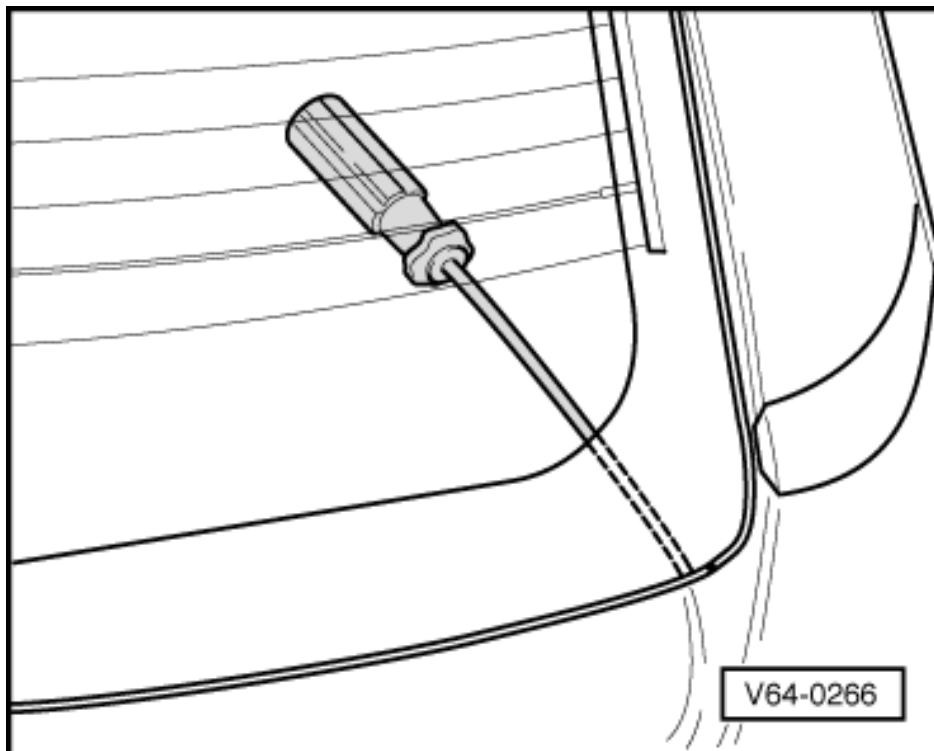
5.3 - Removing rear window

Note:

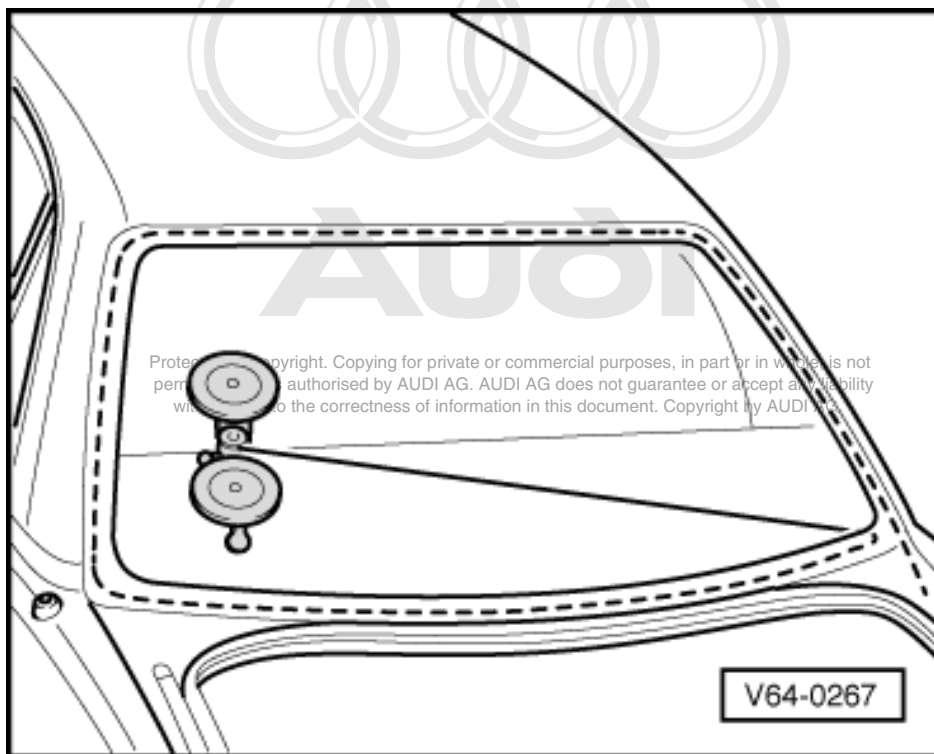
When removing a window, always wear protective goggles and leather gloves.

- Remove rear shelf.

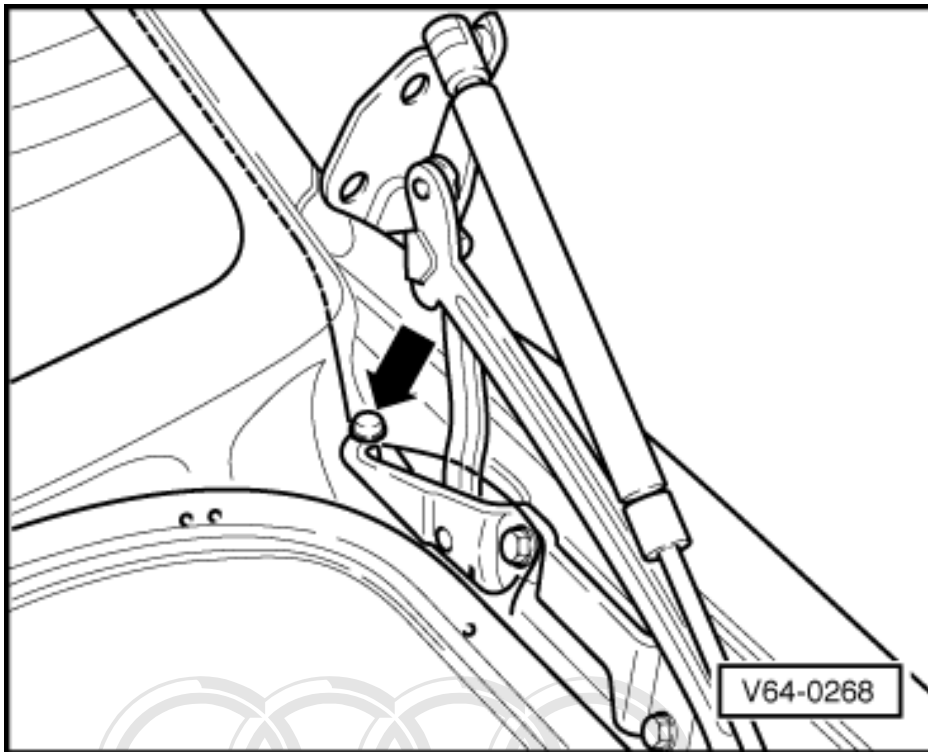
=> General Body Assembly, Interior; Repair group 70



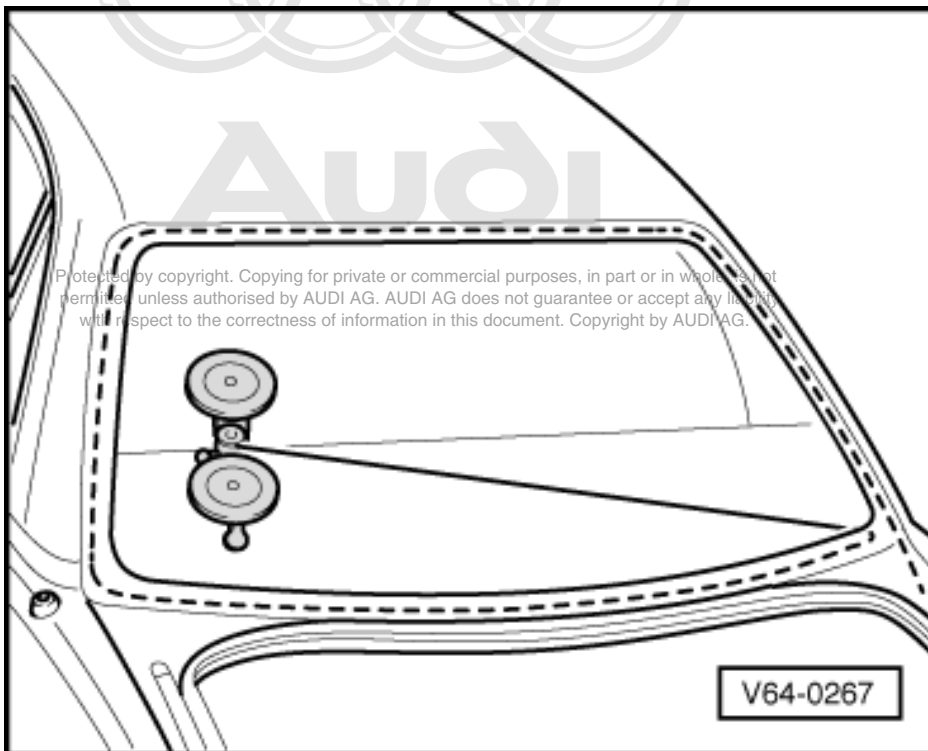
- Unplug or unscrew connections for heated rear window and rear window aerial.
- Press connections onto windowpane directed towards centre of vehicle.
- -> Using an awl, pierce a hole in the adhesive sealing material from inside of vehicle in bottom corner of rear window until awl eyelet is visible on the outside.
- Insert cutting cord into eyelet of awl and pull it into inside of vehicle.



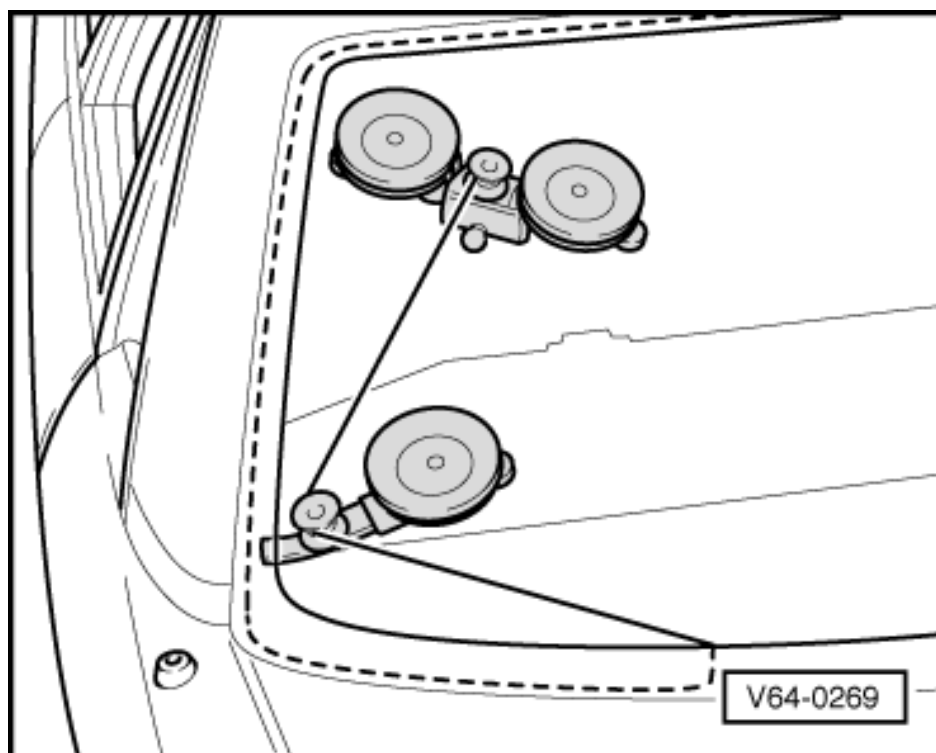
- -> Feed cutting cord into winding device and secure.
- Lay cutting cord around rear window as shown.
- At upper edge of window, press cutting thread below cover strip.



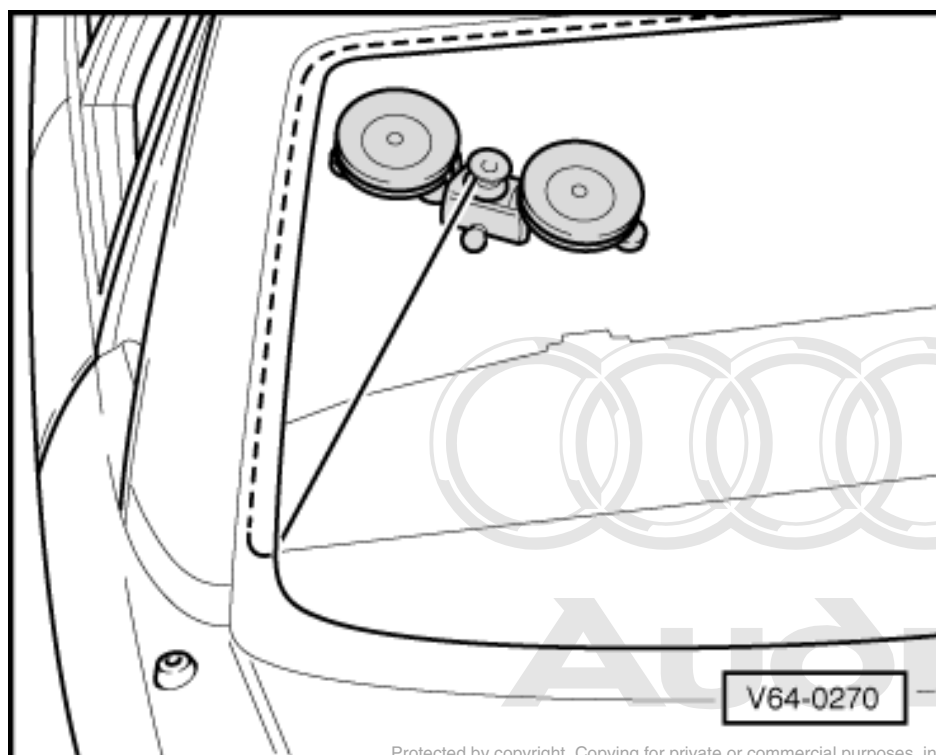
- -> Place end of cutting cord around stop buffer -arrow- and secure with boot lid hinge securing bolts.



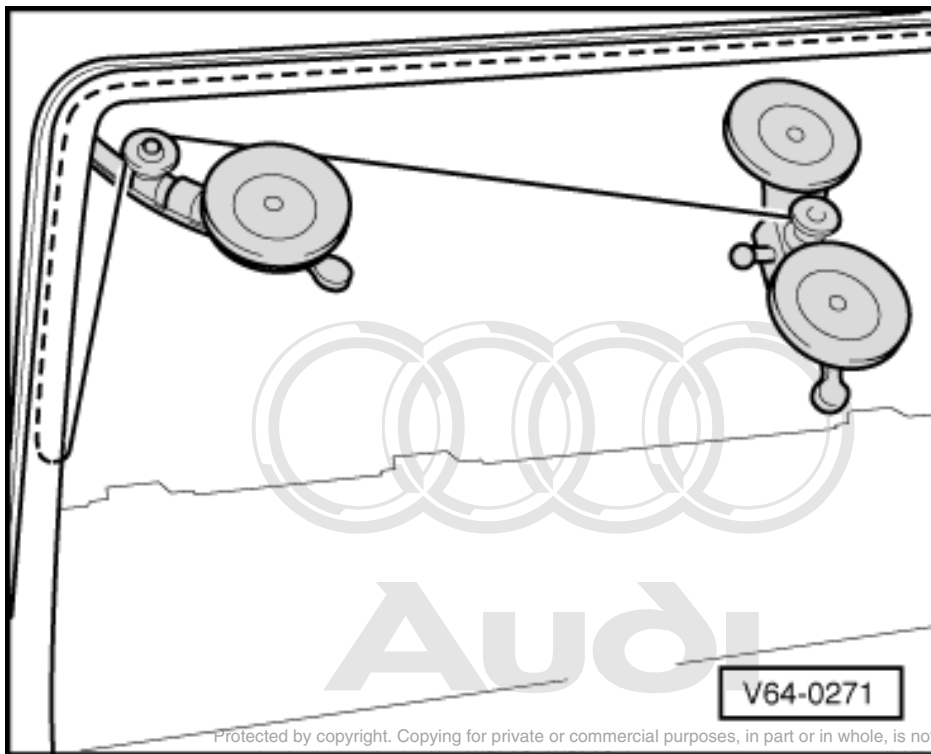
- -> Cut free first section.



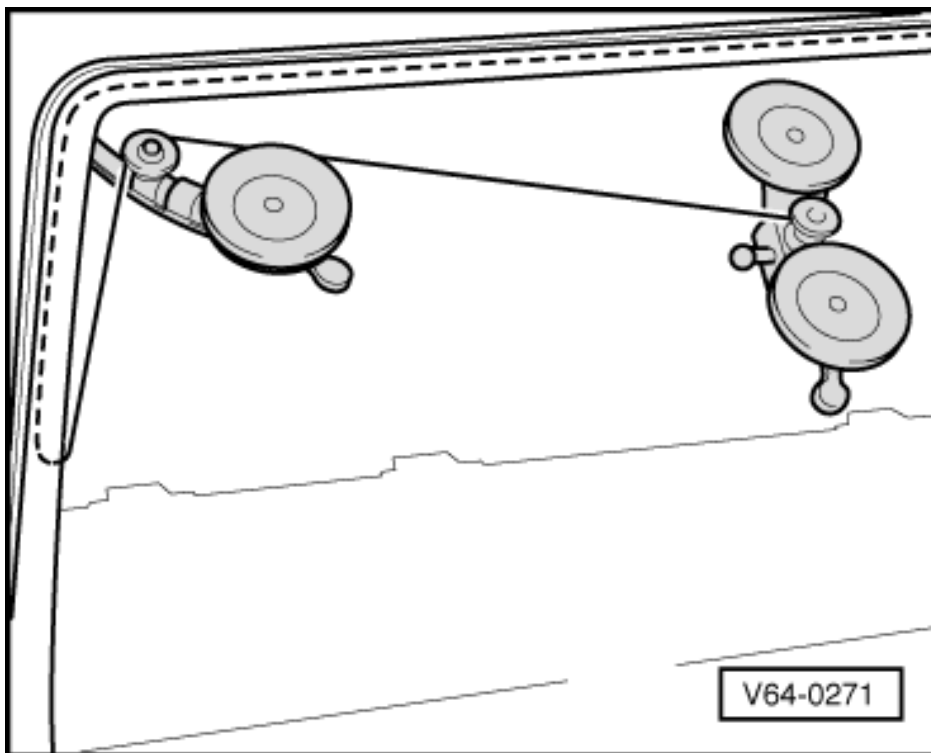
- -> Move winding device to next position as shown and attach relay pulley in lower corner of window.
- Route cutting cord as illustrated.
- Cut out window glass up to the point where thread no longer runs in relay pulley.



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



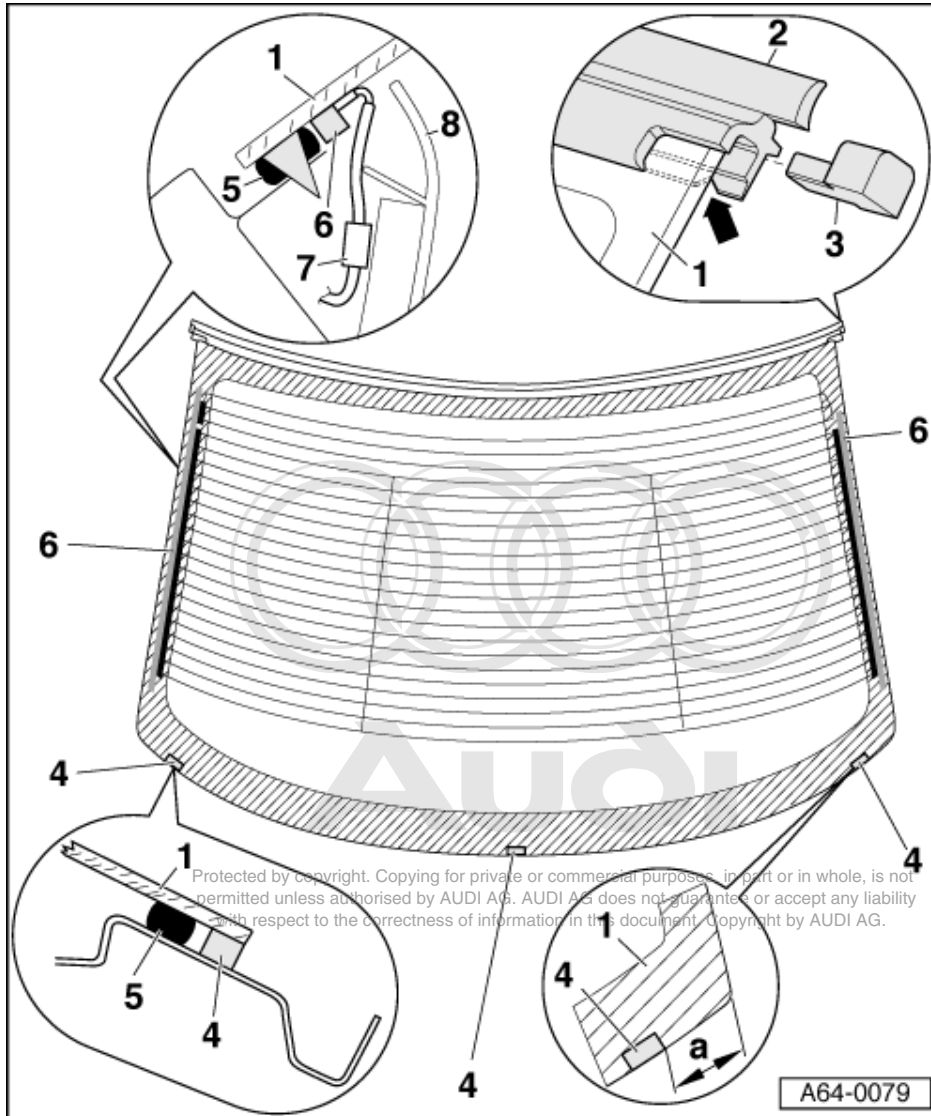
- -> Move winding device to next position as shown and attach relay pulley in upper corner of window.
- Route cutting cord as illustrated.
- Cut out window glass up to the point where thread no longer runs in relay pulley.
- Insert protective cover V.A.G 1474/12 between rear window and moulded headlining.



- -> Remove guide pulley and continue cutting out window.
- Now repeat these steps in the top right and bottom right corners of the window.
- Cut out the window glass completely according to these steps.

- Use double suction holders to remove window.

5.4 - Installing rear window



Assembly overview

Note:

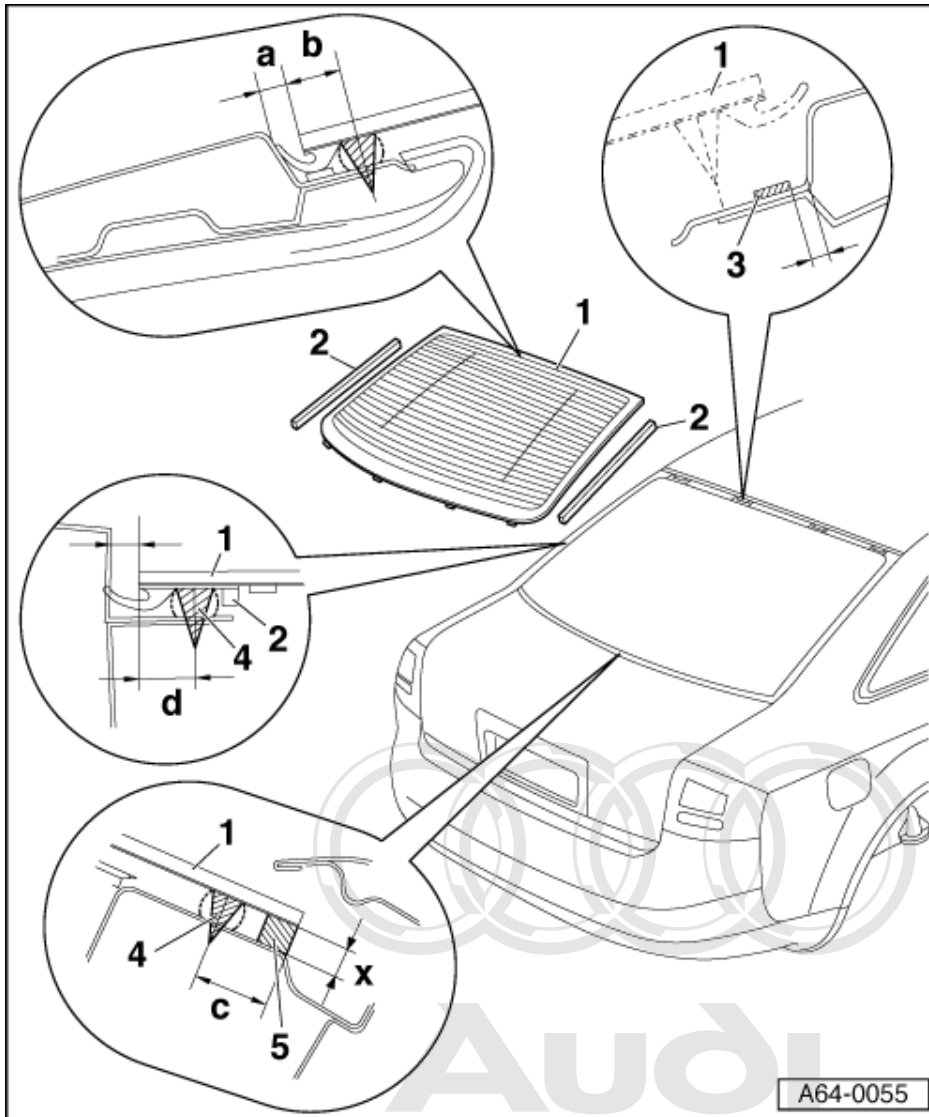
- ♦ New windows are to be cleaned and primed as described under windscreen installation.
- ♦ If intact window is to be re-used, apply adhesive directly to freshly cut residual bead.

1 Rear window

- ♦ Removing => Page 207 .

2 Masking strip

- ♦ Marks on surround -arrow- must be flush with edge of window.



3 Filler piece

- ♦ Fit sideways into masking strip before installing window.

4 Spacer

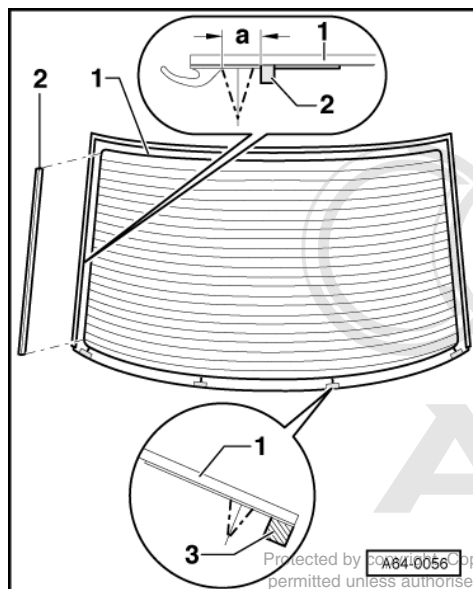
- ♦ Bond to bottom edge of window in centre and on left and right at a distance -a- = 30 mm from edge of window.

5 Adhesive bead

- ♦ Note different spacing of adhesive bead from edge of rear window:

6 Guard strip for adhesive

- ♦ On windows with no strip, bond next to bus bar => Fig. 1 .



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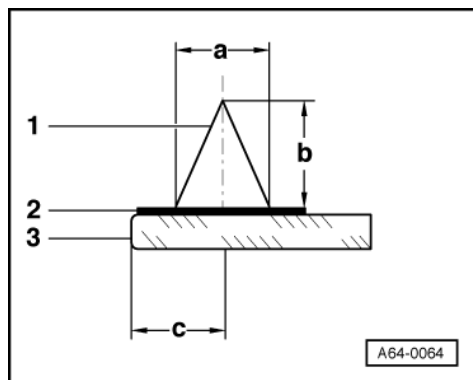
Fig.1 -> Bonding guard strip for adhesive

- Bond guard strip for adhesive -2- at a distance -a- = 15 mm from edge of rear window -1-.

Note:

Allow primer to dry before touching-up primer strip.

- Drying time approx. 10 minutes.



-> Cross-section of adhesive bead.

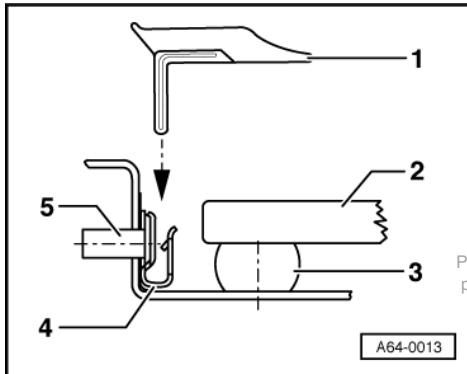
Important

Note different distances between adhesive bead and edge of window.

- Adhesive bead -1-.
- Primer -2-.
- Windscreen -3-.
- Dimension -a- = 8 mm.
- Dimension -b- = 12 mm.
- Dimension -c- at upper edge and side edges of window = 8 mm.
- Dimension -c- at bottom edge of window = 13 mm.

Note:

Any adhesive sealing material emerging at the bottom of the rear window when inserting the window into the window opening must be removed immediately.

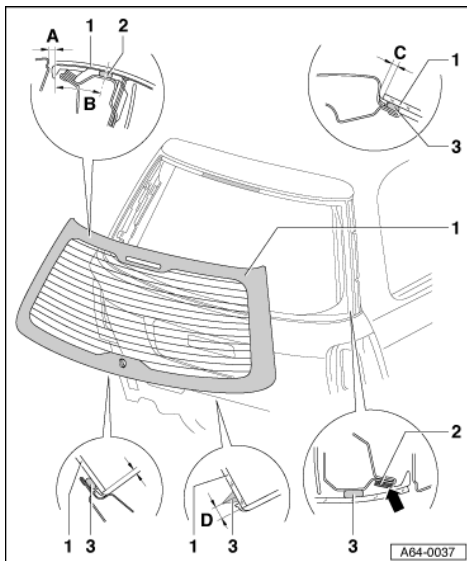


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- -> Masking strip -1-, to begin with left and right upper, to be completely pressed into holding clips -4-.
- Rear window -2-.
- Adhesive bead -3-.
- Hollow rivet -5-.
- Further procedure can be found in "Installing windscreen" section => Page 192 .

6 - Removing and installing rear window - Avant

6.1 - Removing and installing rear window - Avant



6.2 - Assembly overview

Note:

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

1 Rear window

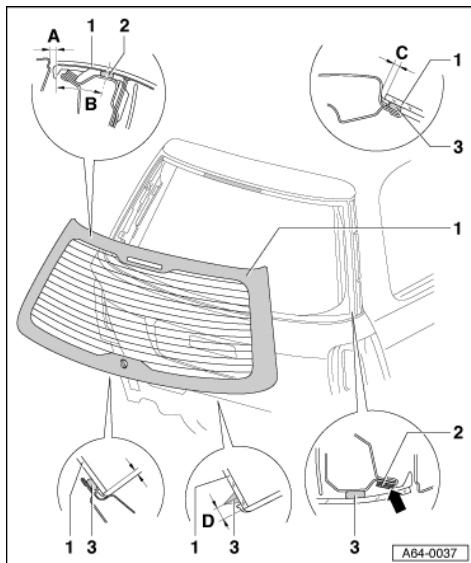
- ♦ Remove intact window
=>Page 216 .



- ◆ Remove broken window
=>Page 218 .

2 Velcro fastening strip

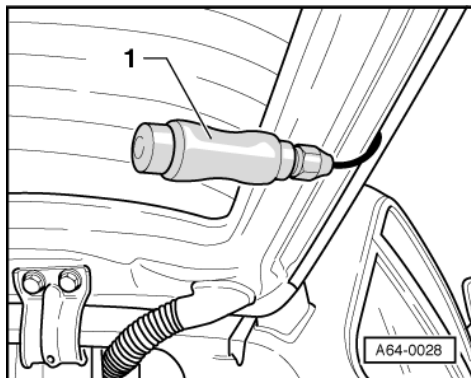
- ◆ Velcro strip -arrow- is only required at production stage and can be removed.



3 Adhesive bead

- ◆ Note different distances from edge of windscreen.
- ◆ Distance from side edge of window, dimension -B- = 38 mm.
- ◆ Distance from top and bottom edge of window, dimension -D- = 12 mm.
- ◆ Dimensions for application of adhesive and cross section of adhesive bead =>Page 220 .

6.3 - Removing an intact rear window



- Remove tailgate interior trims

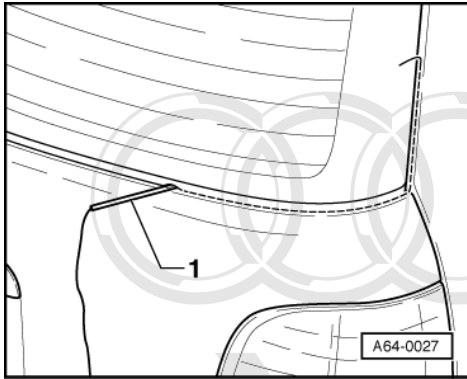
=> General Body Assembly; Repair group 70

- Remove rear window wiper

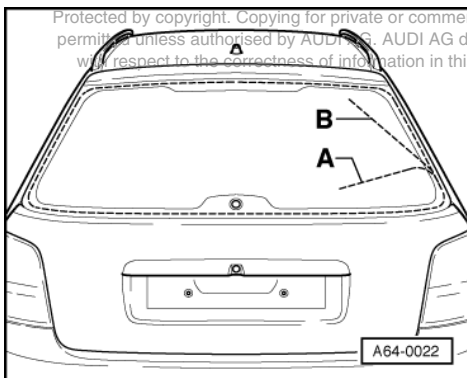
=> Electrical System; Repair group 92

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

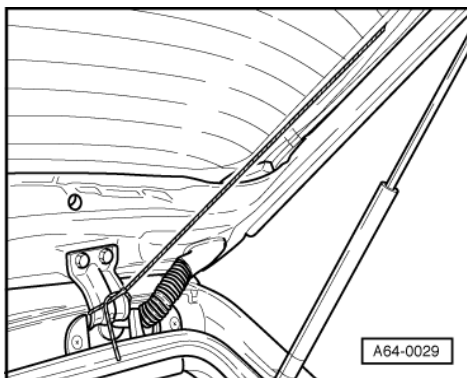
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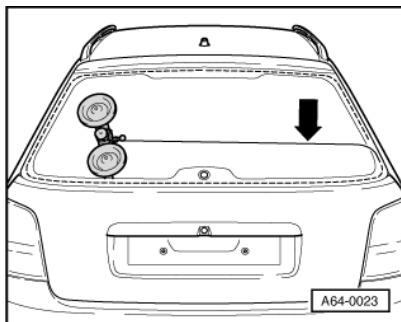
- Detach sealing lip from window flange with plastic wedge and spray with cleaning fluid D 009 401 04 (lubricant substitute).
- -> Place other end of cutting thread around window using the insertion tube.



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



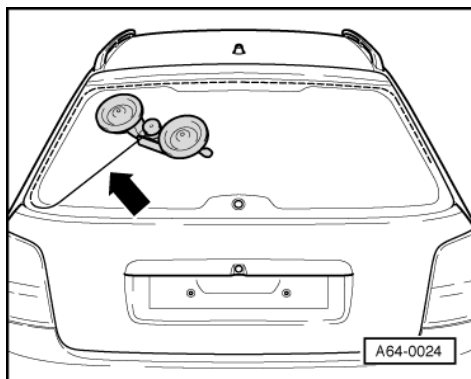
- -> Attach end of cutting thread -B- to tailgate hinge.



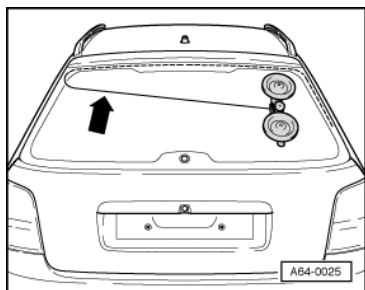
- -> Fasten winding device V.A.G 1654 to rear window as shown.
- Press cutting thread in direction of arrow while cutting along side of window.



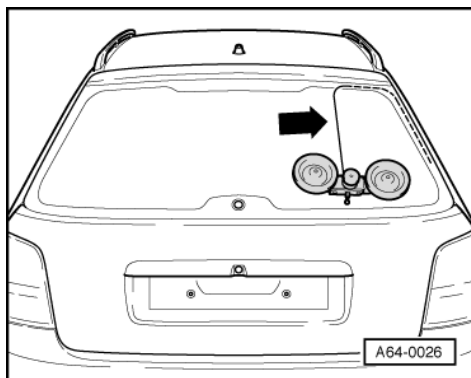
- Cut out window at the bottom.



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



- Move reel and cut out window.
- -> Press cutting thread in direction of arrow while cutting along side of window.
- Cut out window at the top.



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



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6.4 - Removing a broken rear window

- Protect body and passenger compartment against glass splinters.
- Remove pieces of glass up to adhesive sealant.
- Detach connections for rear-window heating.
- Mask flange all round with fabric-reinforced adhesive tape.

- Cut through adhesive sealant (with remaining glass) in window opening using electric cutter and blade V.A.G 1561/10 (with stop roller).

Important
Always wear protective goggles and leather gloves.

6.5 - Preparation for rear window installation

Window removed intact

Note:

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

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

Keep bonding surfaces clean and free from grease.

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

Note:

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

New window

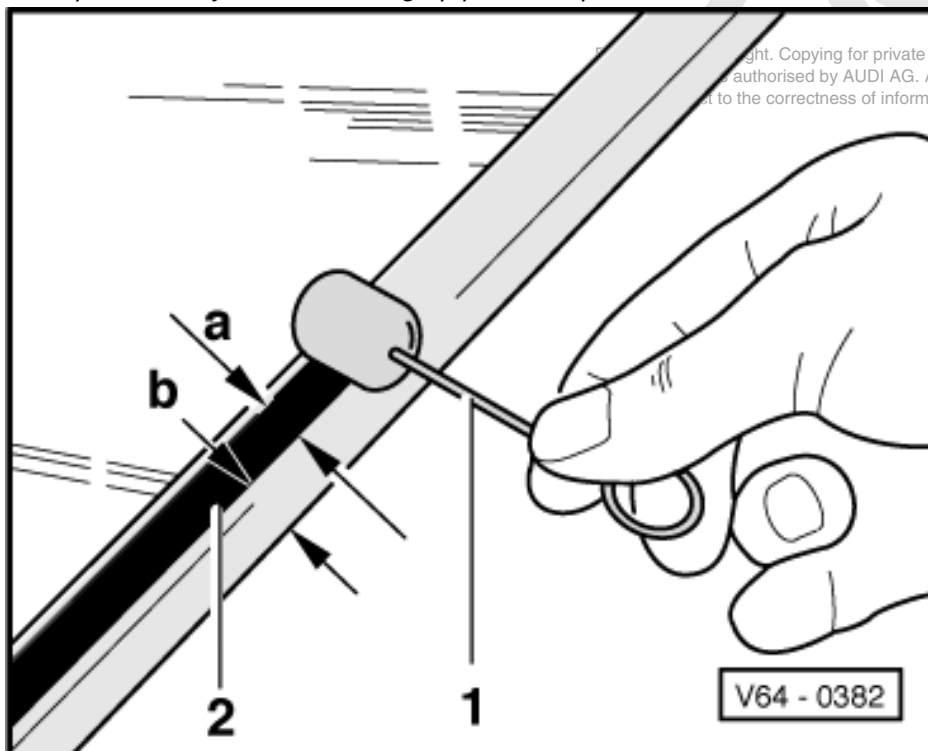
- Clean window all around bonding area with cleaning fluid Part-No. D 009 401 04.
- Primer window all around bonding area with D 009 200 02 Primer.

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

- Drying time approx. 10 minutes.

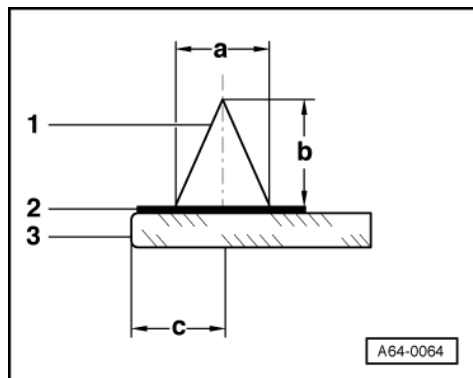
Note:

Allow primer to dry before touching-up primer strip.





- -> Apply primer -2- D 009 200 02 evenly to the window all around bonding area using applicator -1- Part-No. D 009 500 25 (felt pad with wire).
- Primer width = 22 mm



-> Cross-section of adhesive bead

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- Adhesive bead -1-.
- Primer -2-.
- Windscreen -3-.
- Dimension -a- = 8 mm
- Dimension -b- = 12 mm
- Distance from top and bottom edge of window
- Dimension -c- = 12 mm $\pm$ 2 mm
- Distance from side edge of window
- Dimension -c- = 38 mm-1.5 mm

6.6 - Installation instructions

- Apply adhesive all round cleaned window and central to primer.

Important

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

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

66 - Exterior equipment

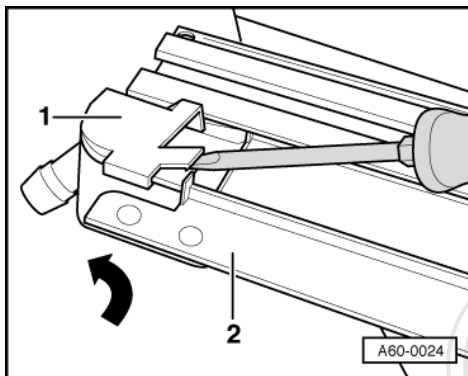
1 - Protective trim strips

1.1 - Protective trim strips

1.2 - Removing and installing protective trim strips

Note:

Protective trim strips cannot be removed without destroying them.



- -> Surface to be bonded must be clean and free from grease.

Protective trim strips are only to be bonded at room temperature.

Vehicle and protective trim strips should be left standing at room temperature for at least 2 hours before performing work.

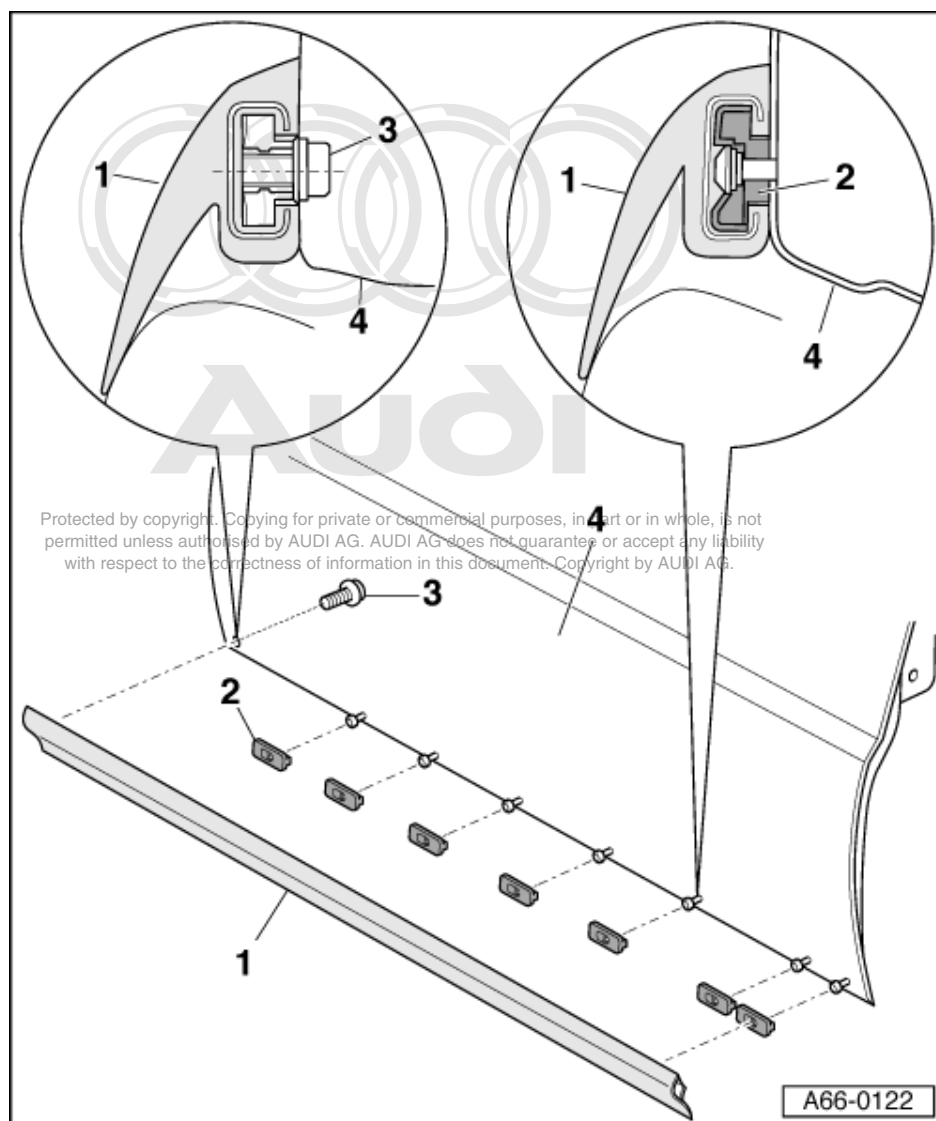
- Pull off backing -4- shortly before fitting.

Once backing has been removed, protective trim strips must be bonded within 90 minutes.

- Start bonding protective trim strip -1- -2- or -3- at front with guide pin and work towards rear.
- Press or roll on protective trim strips applying a pressure of 100 N/cm.
- After bonding strip, vehicle must be left standing at room temperature for a further 4 hours.

2 - Lower cover for front door

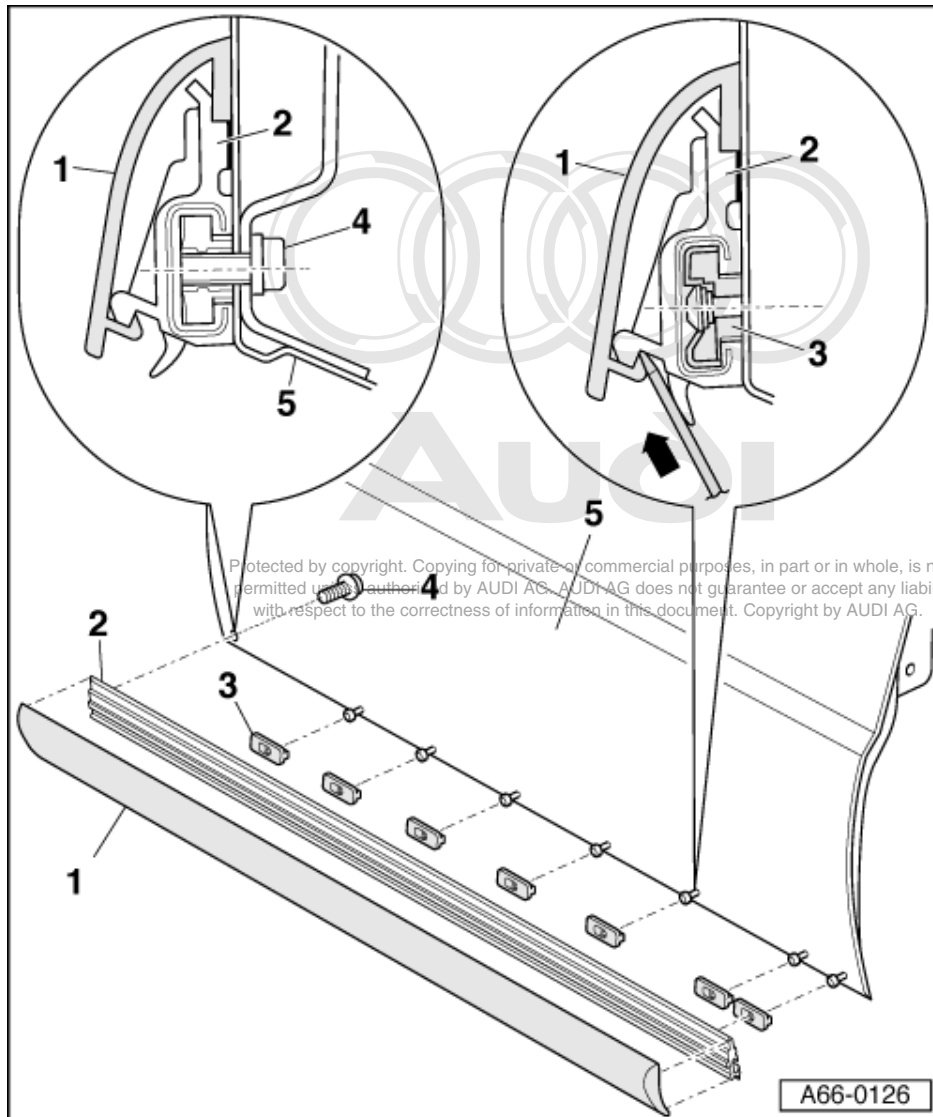
2.1 - Lower cover for front door



2.2 - Removing and installing lower cover panel

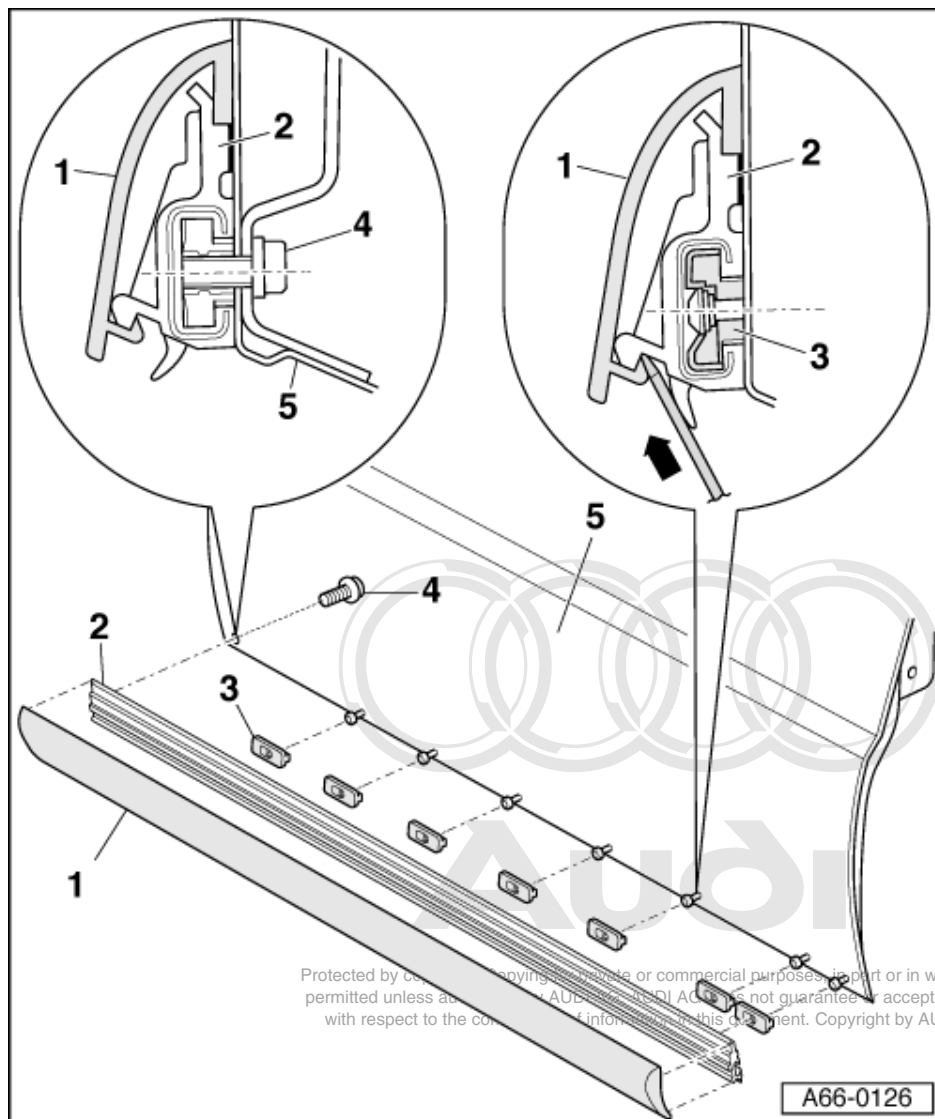
- 1 Lower cover panel
 - ◆ Unscrew the combi bolts -3- and push the cover out of the brackets from behind -2-.
 - ◆ Install in reverse order.
- 2 Retaining clip
- 3 Combi bolt
 - ◆ 1 Nm
- 4 Front door

2.3 - Removing and installing lower cover panel (S4)



1 Lower cover panel

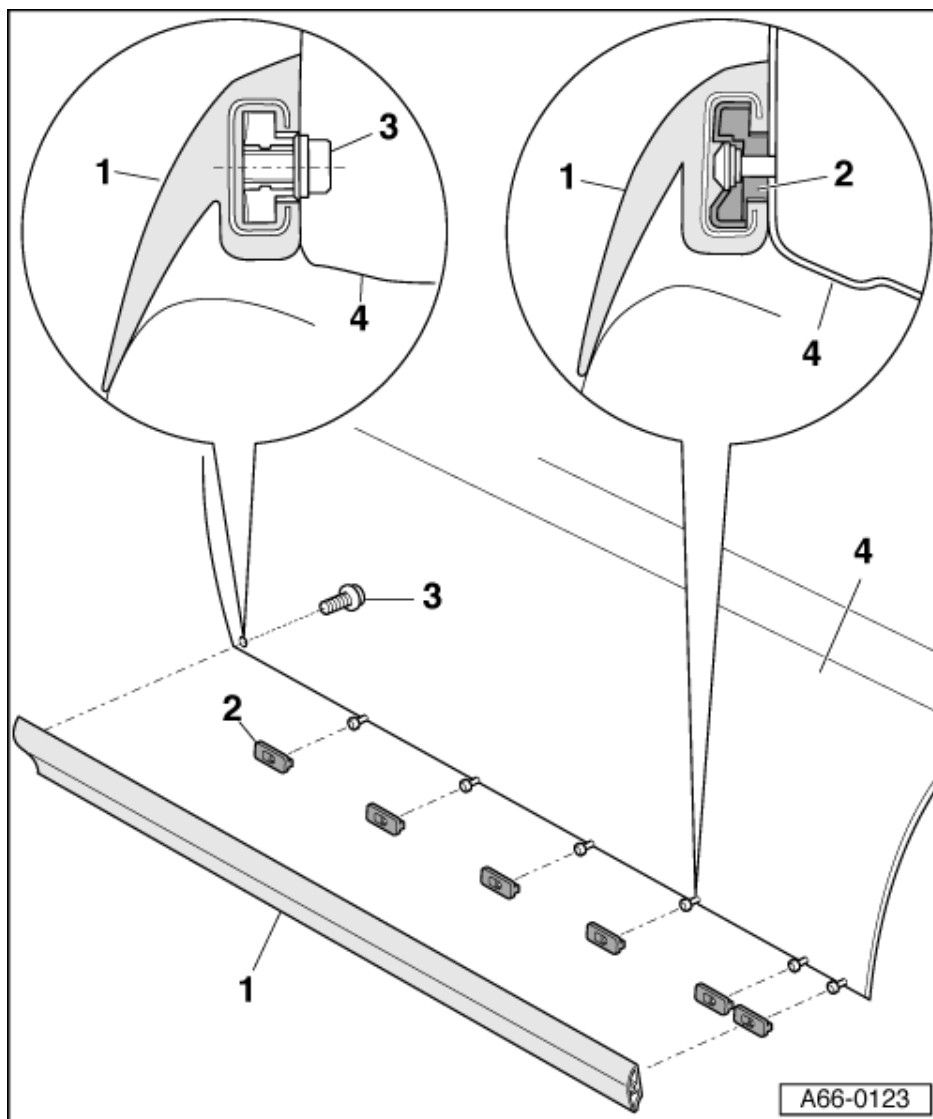
- ◆ When removing, gradually press out the catches on the retaining strip -arrows- from the cover and lift out.
- Gradually press out the catches on the retaining strip, with e.g. a screwdriver, in the direction of the arrows and lift off from the cover.
- Lay the cover to one side of the retaining strip.
- ◆ Installing
- Re-attach the cover from the top centre to the bottom to the retaining strip.
- Press on the cover underneath on the side to the retaining strip.



- 2 Retaining strip
- 3 Retaining clip
- 4 Combi bolt
 - ♦ 1 Nm
- 5 Front door

3 - Lower cover for rear door

3.1 - Lower cover for rear door



3.2 - Removing and installing lower cover panel

1 Lower cover panel

- ♦ Unscrew the combi bolts -3- and push the cover out of the brackets from behind -2-.
- ♦ Install in reverse order.

2 Retaining clip

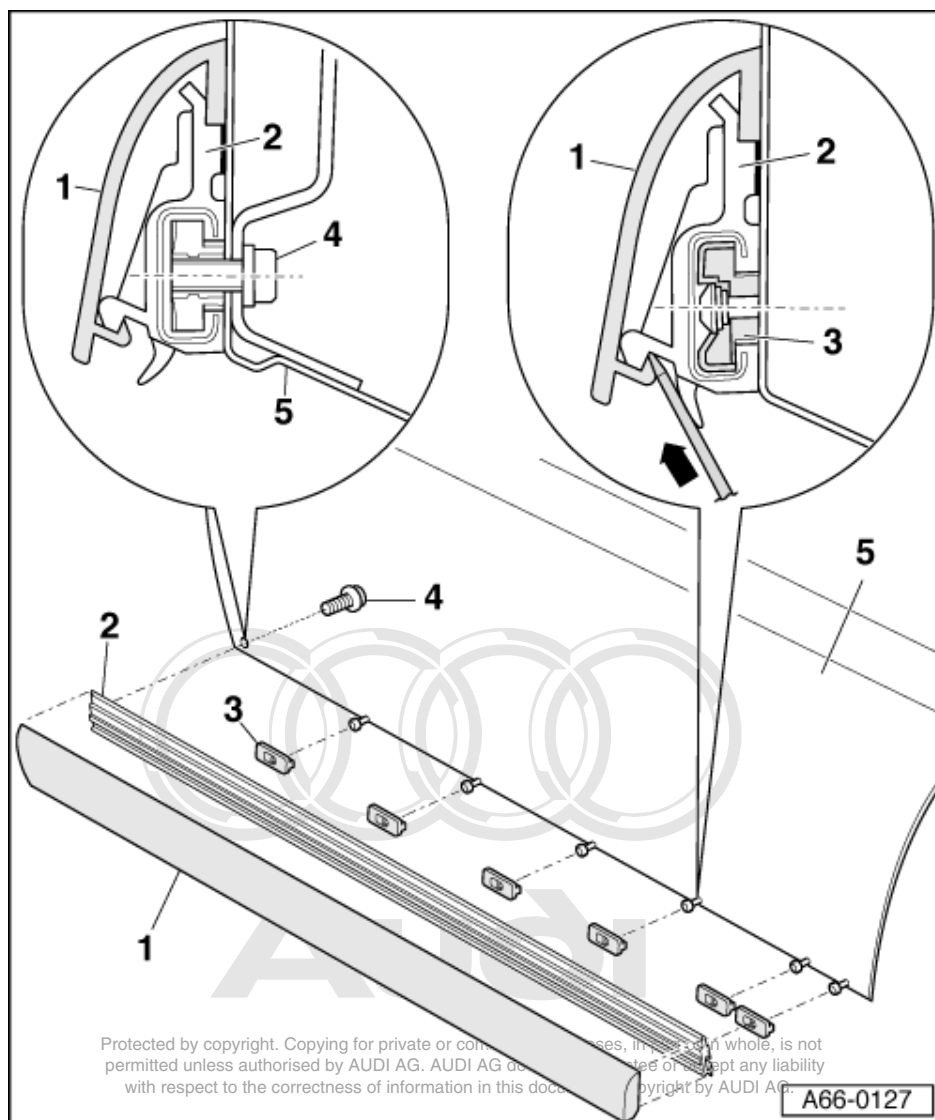
3 Combi bolt

- ♦ 1 Nm

4 Rear door

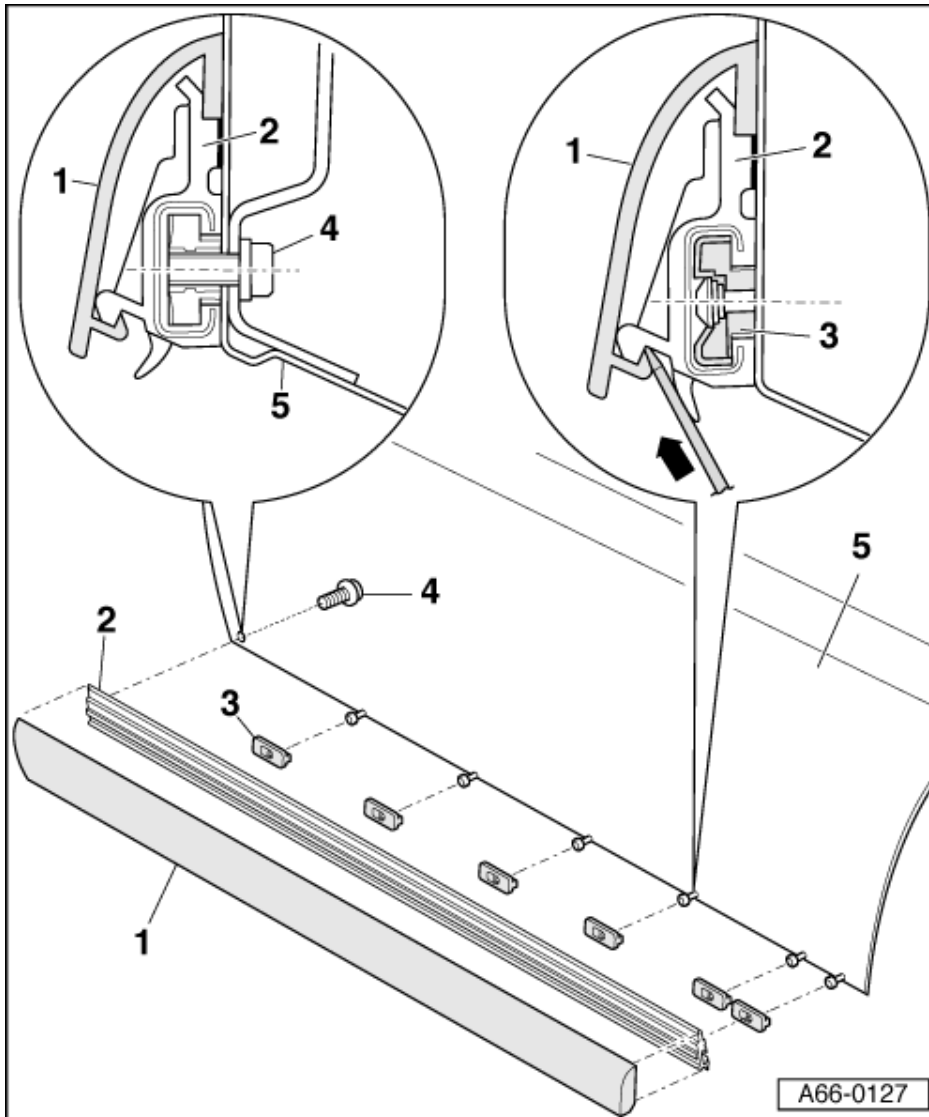
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3.3 - Removing and installing lower cover panel (S4)



1 Lower cover panel

- ◆ Removal:
 - Gradually press out the catches on the retaining strip, with e.g. a screwdriver, in the direction of the arrows and lift off from the cover.
 - Lay the cover to one side of the retaining strip.
- ◆ Installing
 - Re-attach the cover from the top centre to the bottom to the retaining strip.
 - Press on the cover underneath on the side to the retaining strip.



- 2 Retaining strip
- 3 Retaining clip
- 4 Combi bolt
 - ♦ 1 Nm
- 5 Rear door

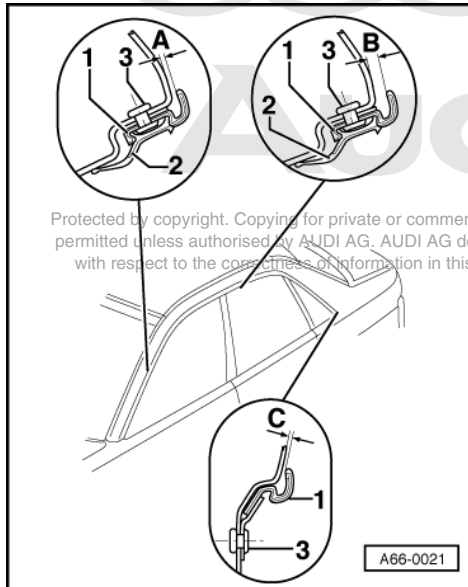


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4 - Roof trim strip

4.1 - Roof trim strip

4.2 - Removing and installing roof trim strip



- Removing side window => Page 194 .
- Removing and installing outer B-pillar trim =>Page 238 .
- Pull off door seals in area of roof trim strip.

Removal:

- -> Lever masking strip -2- out of roof trim strip -1-.
- Drill off rivets -3- and detach roof trim strip -1-.

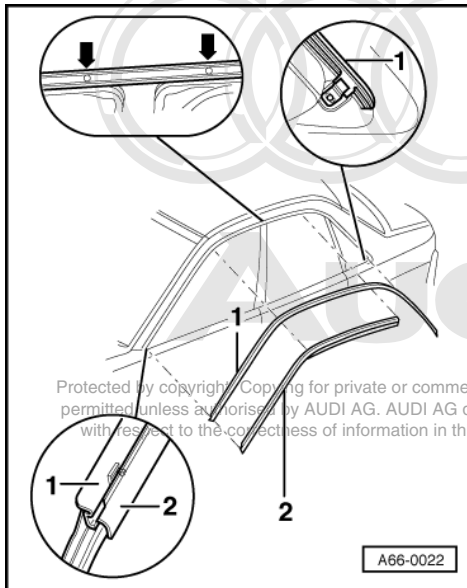
Installation:

A = 0.7 + 0.5 mm

B = 3 + 0.5 mm

C = 1.5 + 0.5 mm

- Dimensions must be adhered to.



- -> Start by riveting on roof trim strip -1- at -arrows- to centre it.
- Then rivet on to front and rear.
- Use special tool V.A.G 1617 B to fit rivets.

Note:

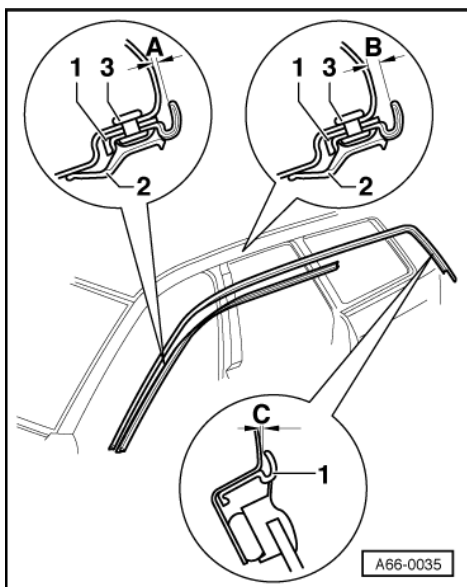
If paintwork is damaged when drilling off rivet, make good the paint coating as specified in the vehicle paintwork Workshop Manual and apply corrosion protection if necessary as described in the "Surface Treatment/Chemical Materials" binder.

- Clip in masking strip -2- starting at front and working to rear.

5 - Roof trim strip - Avant

5.1 - Roof trim strip - Avant

5.2 - Removing and installing roof trim strip



- Removing side window => Page 194 .
- Removing and installing outer B-pillar trim =>Page 238 .
- Pull off door seals in area of roof trim strip.

Removal:

- -> Prise masking strip -2- out of roof trim strip -1-.
- Drill off rivets -3- and detach roof trim strip -1-.

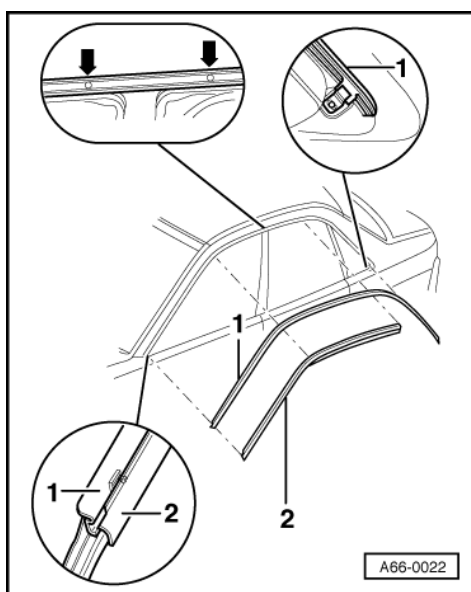
Installation:

A = 0.2 + 0.5 mm

B = 2.5 + 0.5 mm

C = 1 + 0.5 mm

- Dimensions must be adhered to.



- -> Start by riveting on roof trim strip -1- in area of upper B-pillar at arrows to centre it.
- Then rivet on to front and rear.
- Use special tool V.A.G 1617 B to fit rivets.

Note:

If paintwork is damaged when drilling off rivet, make good the paint coating as specified in the vehicle paintwork Workshop Manual and apply corrosion protection if necessary as described in the "Surface Treatment/Chemical Materials" binder.

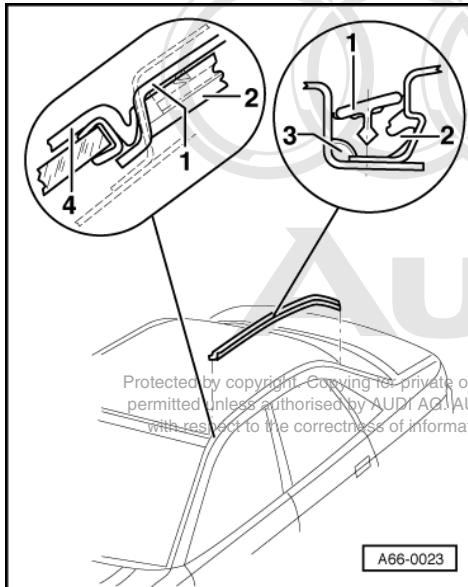
- Clip in masking strip -2- starting at front and working to rear.

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6 - Roof joint strip

6.1 - Roof joint strip

6.2 - Removing and installing roof joint strip



- Cover strip for rear window removed.
- -> Prise out roof joint strip -1- starting at rear and working to front.

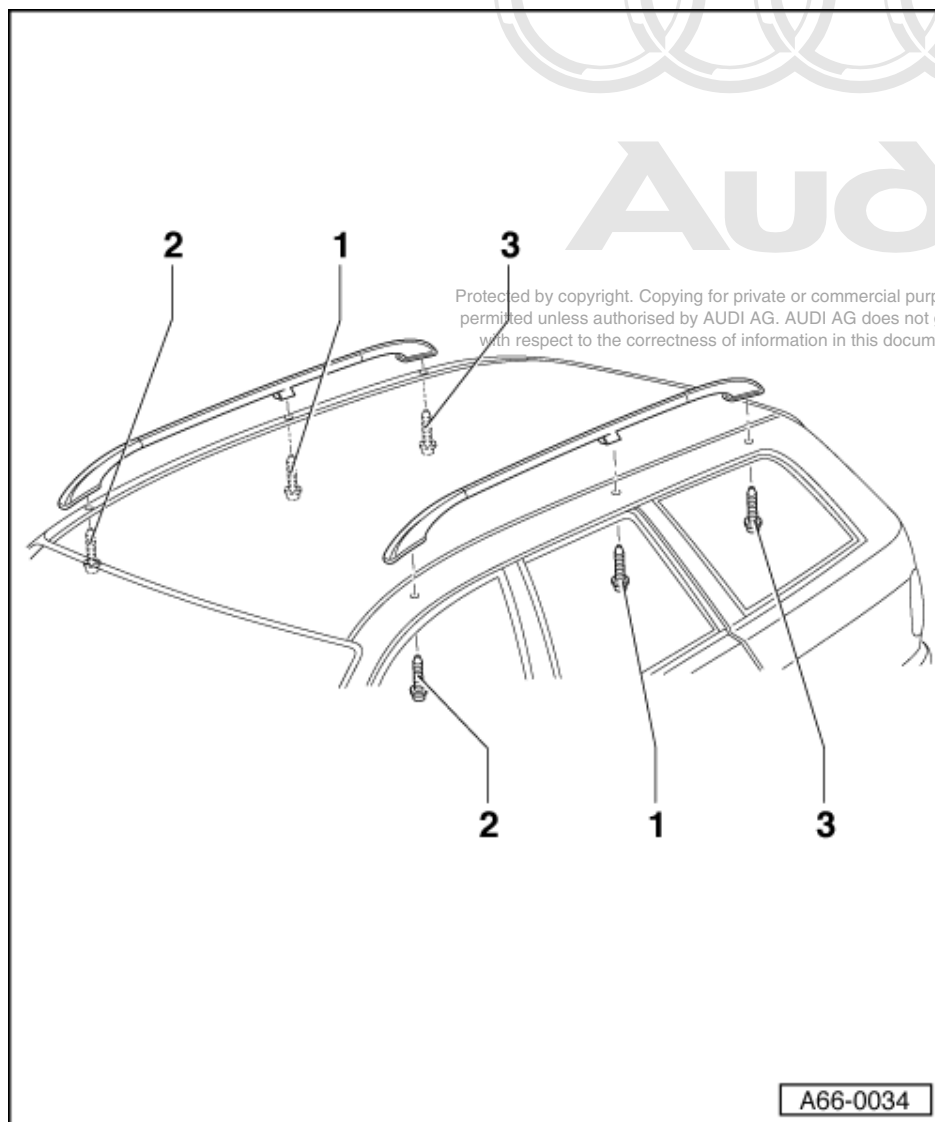
Note:

Take care not to damage paintwork when levering out roof joint strip.

- Attach seal -2- to roof joint strip before installing.
Seal must be pressed on at front and rear and then pressed into joint strip towards centre.
- Sealing lip -2- must point towards centre of vehicle.
- Seal -2- must not rest on seam -3-.
- Position front of roof joint strip flush with roof and press into roof channel, working towards rear.

7 - Removing and installing roof rail

7.1 - Removing and installing roof rail



Removing:

1 Roof rail

- ◆ Dismantle moulded headliner to remove rail.

=> General Body Assembly; Repair group 70

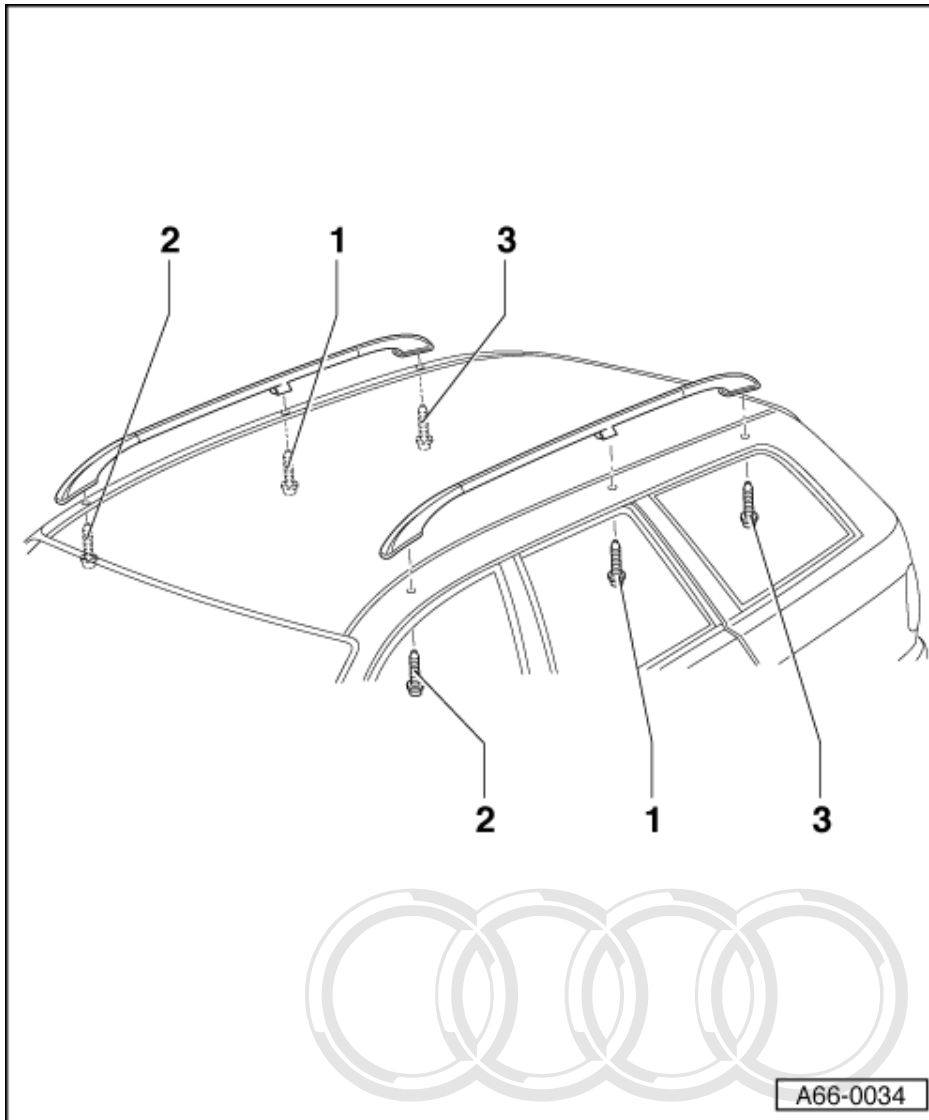
- ◆ Installation sequence => Page **233** .

2 Bolts

- ◆ Unscrew 3x and remove roof rail -1-.
- ◆ Torque: 23 Nm +2

3 Seals with bonded-in sealing ring

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



Installation sequence:

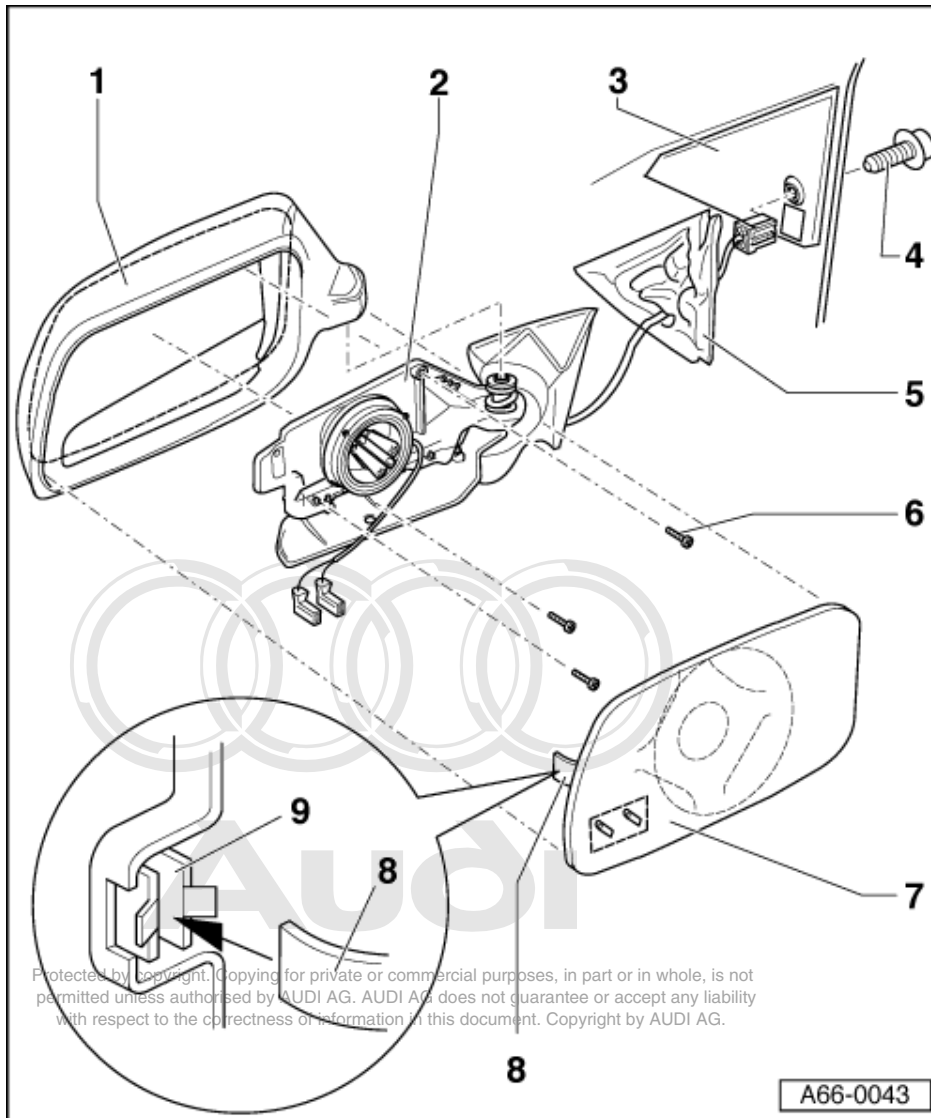
- ♦ 1. Place roof rail in position and bolt on until seal makes even contact.
- ♦ 2. Centrally align roof rail.
- ♦ 3. Tightening sequence of bolts: Centre - front - rear

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8 - Rear-view mirror

8.1 - Rear-view mirror



8.2 - Removing and installing rear-view mirror

1 Mirror housing

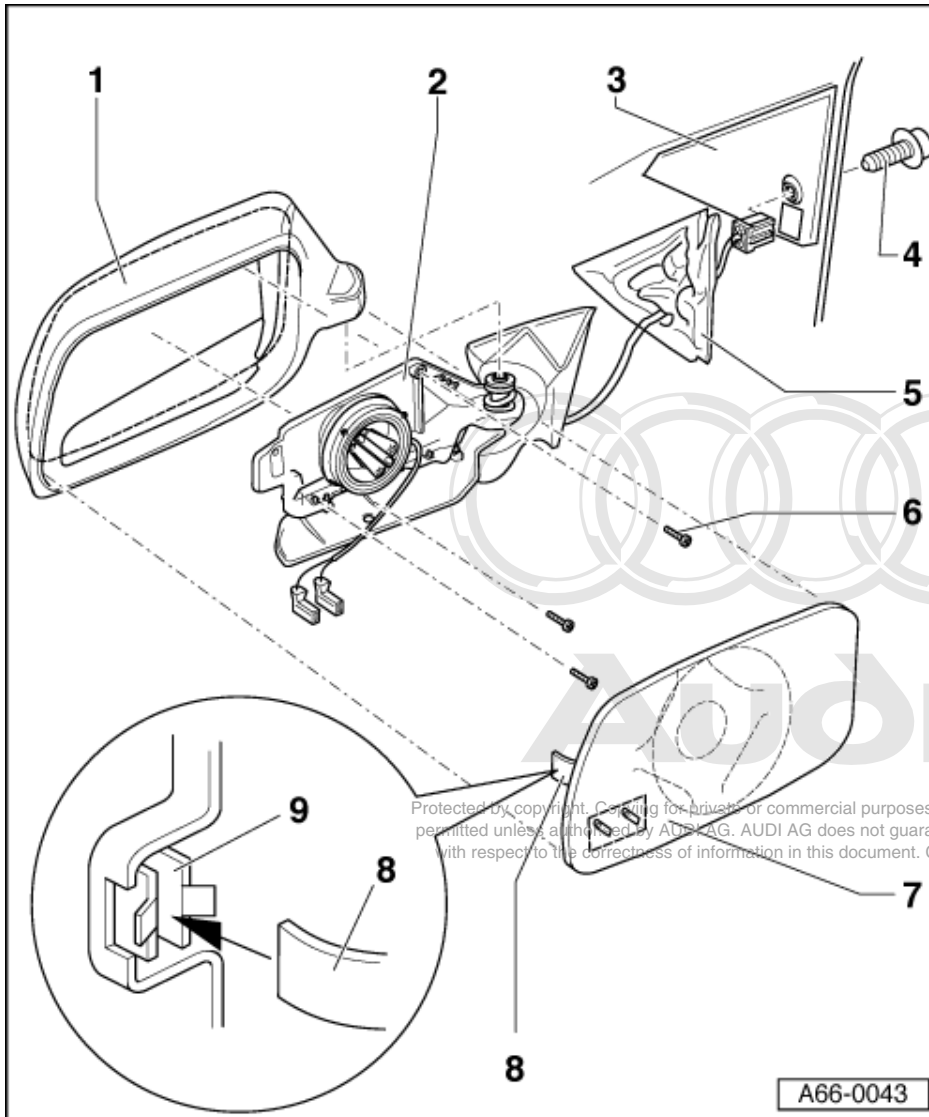
- ♦ Can be removed from door without dismantling entire rear-view mirror =>Page 237 .

2 Mirror adjuster unit

- ♦ Remove mirror from door before removing adjuster unit.
- To remove, lever off mirror glass, unplug electrical connectors for mirror heater, unscrew cross-head bolts -6- and take mirror adjuster unit out of mirror housing -1-.

Note:

- ♦ On vehicles with a seat memory, the door trim has to be removed before removing the mirror adjuster unit.



3 Door subframe

4 Hexagon socket-head bolt

- ♦ 12 Nm

5 Seal

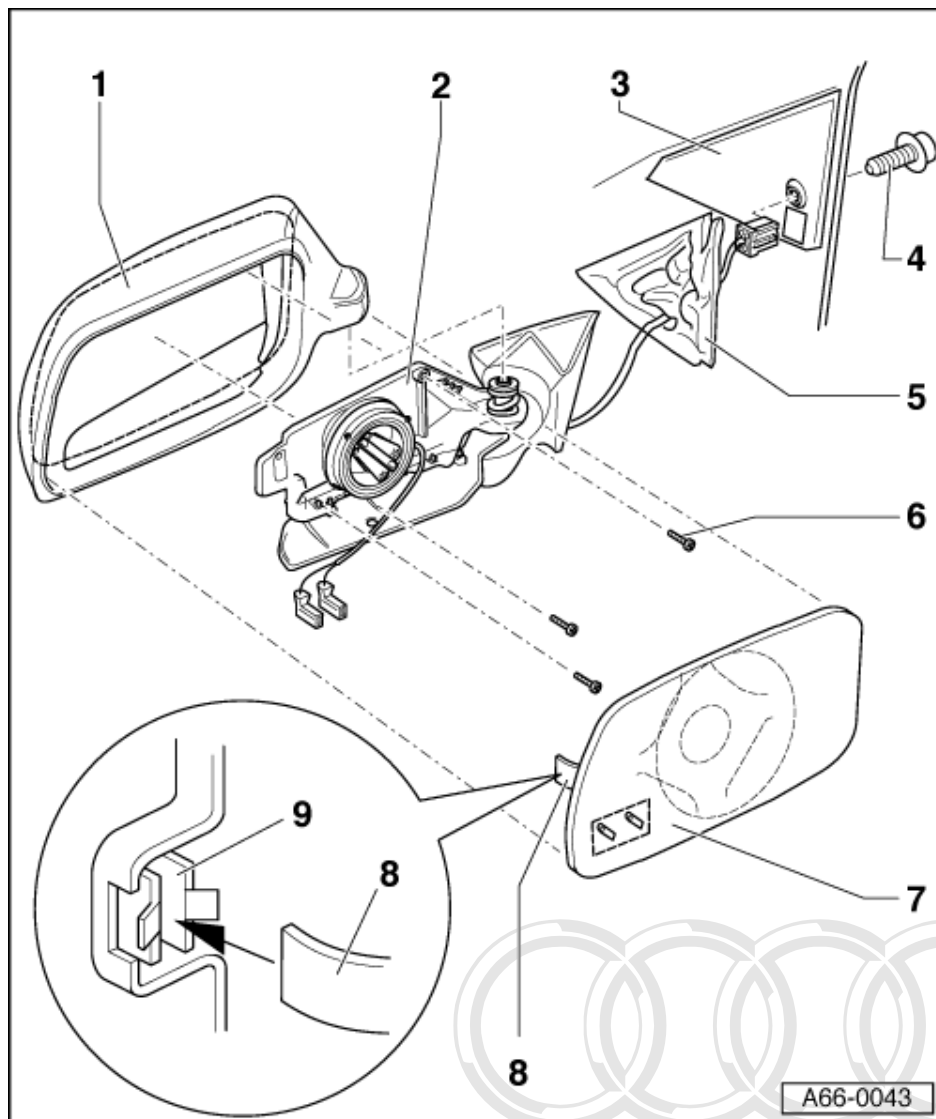
- ♦ When installing, make sure seal is seated correctly.

6 Cross-head screw

- ♦ 1 Nm

7 Mirror glass

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



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

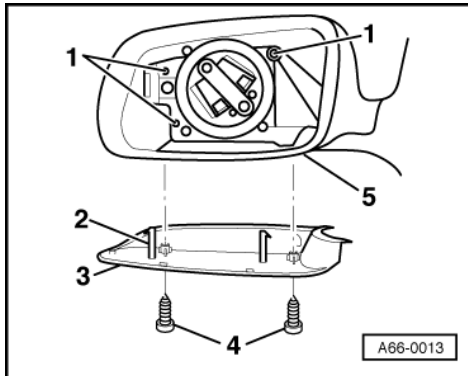
8 Friction finger

- ◆ When installing the mirror glass, friction finger -8- must be inserted into friction spring -9- in housing.

9 Friction spring

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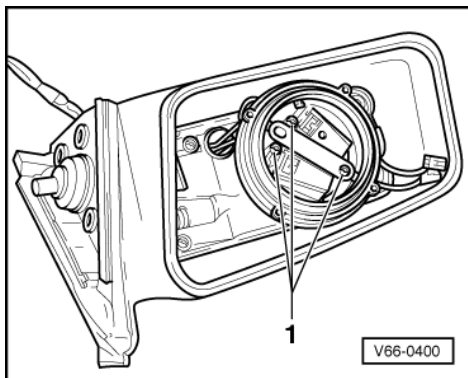
8.3 - Replacing exterior mirror housing



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

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8.4 - Replacing electrical mirror adjuster unit



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

Note:

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

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

Note:

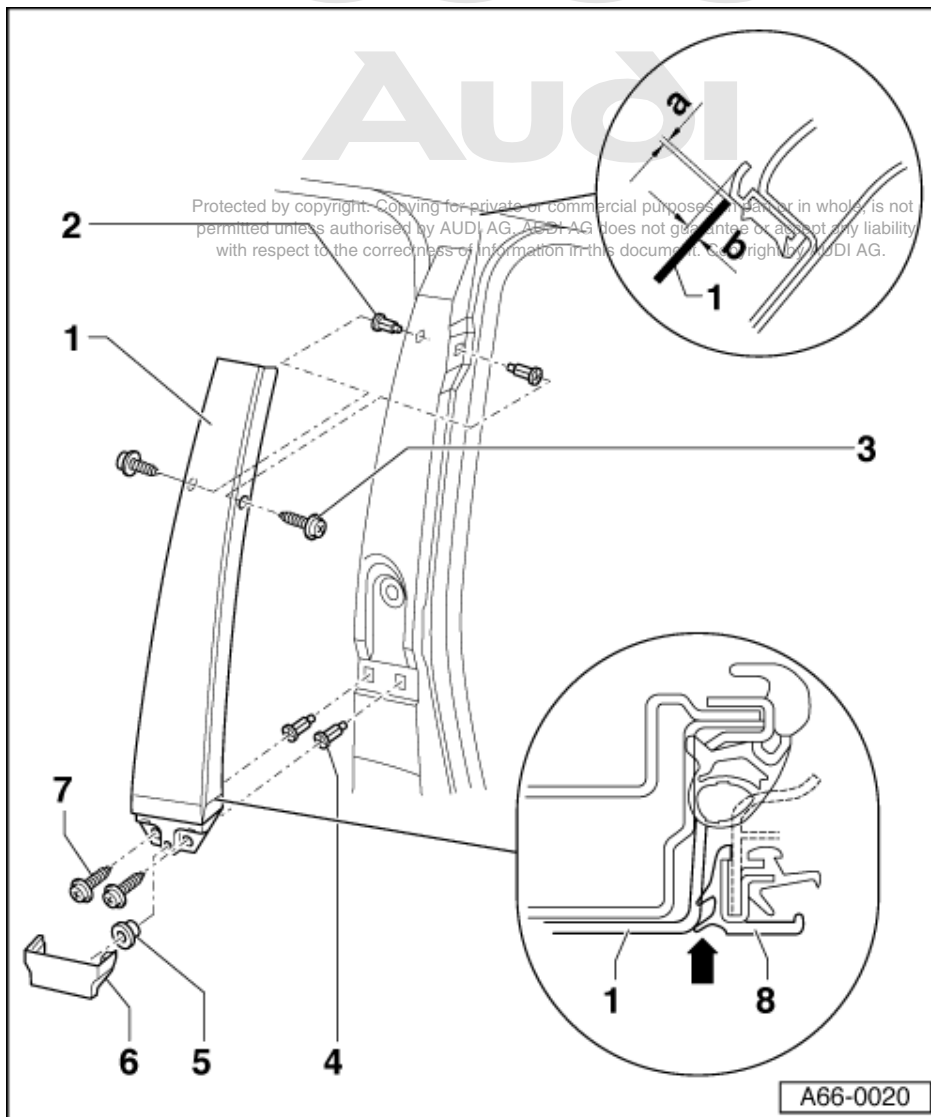
Note configuration of electric wires on old adjuster unit.

Use appropriate current flow diagram.



9 - Outer B-pillar trim

9.1 - Outer B-pillar trim



9.2 - Removing and installing outer B-pillar trim

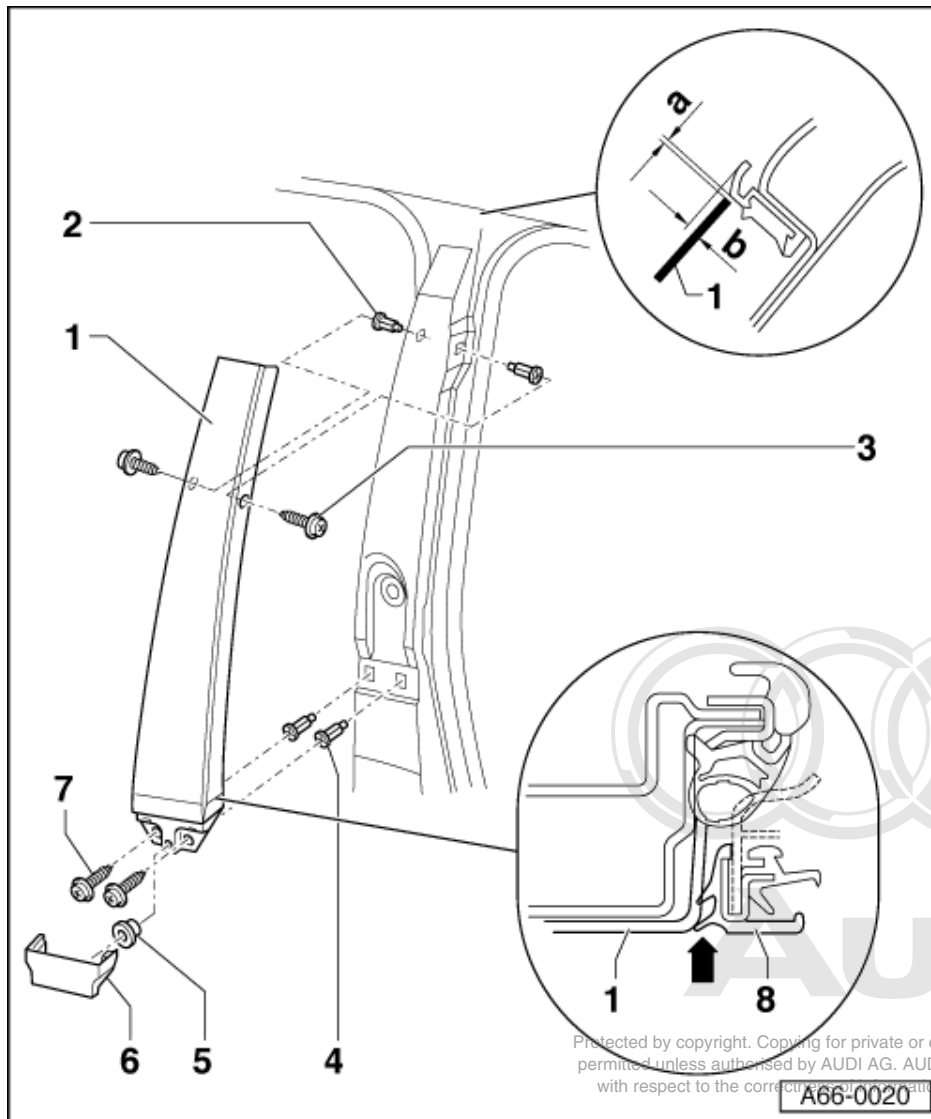
1 Outer B-pillar trim

- ♦ Removal:
 - To remove, unclip trim cap -6- and unscrew bolts -3- and -7-.
- ♦ Installation:
 - Install in reverse order.
 - Distance between B-pillar trim and roof trim strip: dimension a = 0.5 mm; dimension b = 2 mm.
 - B-pillar trim must be flush with seal for door component carrier -8-.

2 Expanding nut (2x)

3 Bolt (2x)

- ♦ Tightening torque 1.5 Nm.



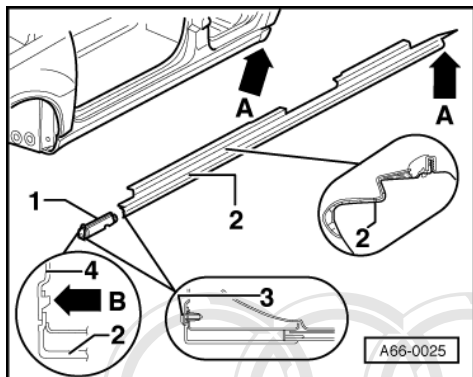
- 4 Expanding nut (2x)
- 5 Plastic clip
- 6 Trim cap
- 7 Bolt (2x)
 - ♦ Tightening torque 1.5 Nm
- 8 Seal for door component carrier

10 - Outer sill panel trim

10.1 - Outer sill panel trim

10.2 - Removing and installing outer sill panel trim

Removal:

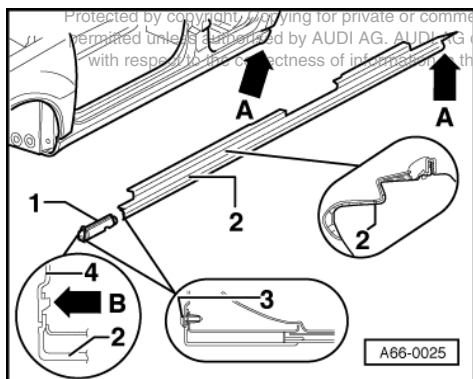


- -> Unscrew bolts -3- (2x) for front wheel housing liner and detach end piece of sill panel trim -1-.
- Unscrew end piece in area A.
- Pull off sill panel trim -2-.
- Remove residual adhesive from surfaces.

Installation:

Vehicle should be left at room temperature for at least 2 hours.

- Surface to be bonded must be clean and free from grease.



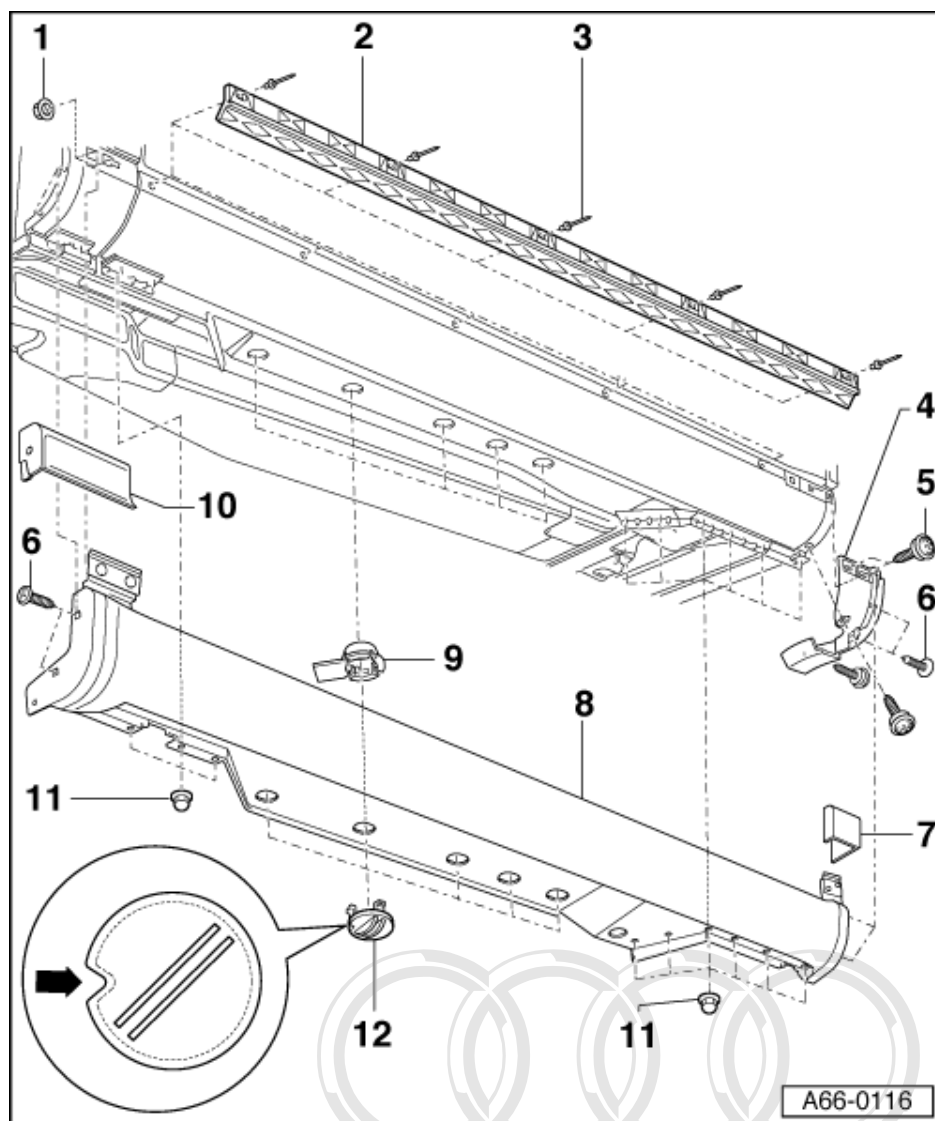
- -> Heat sill panel trim to 40 °C +10°C.
- Pull off backing -4- shortly before fitting.

Once backing has been removed, protective trim strips must be bonded within 90 minutes.

- Press or roll on sill panel trim, applying a pressure of 100 N/cm.
- After bonding on sill panel trim -2-, vehicle must be left standing at room temperature for a further 4 hours.
- Fit both end pieces.

11 - Removing and installing sill panel trim (S4)

11.1 - Removing and installing sill panel trim (S4)



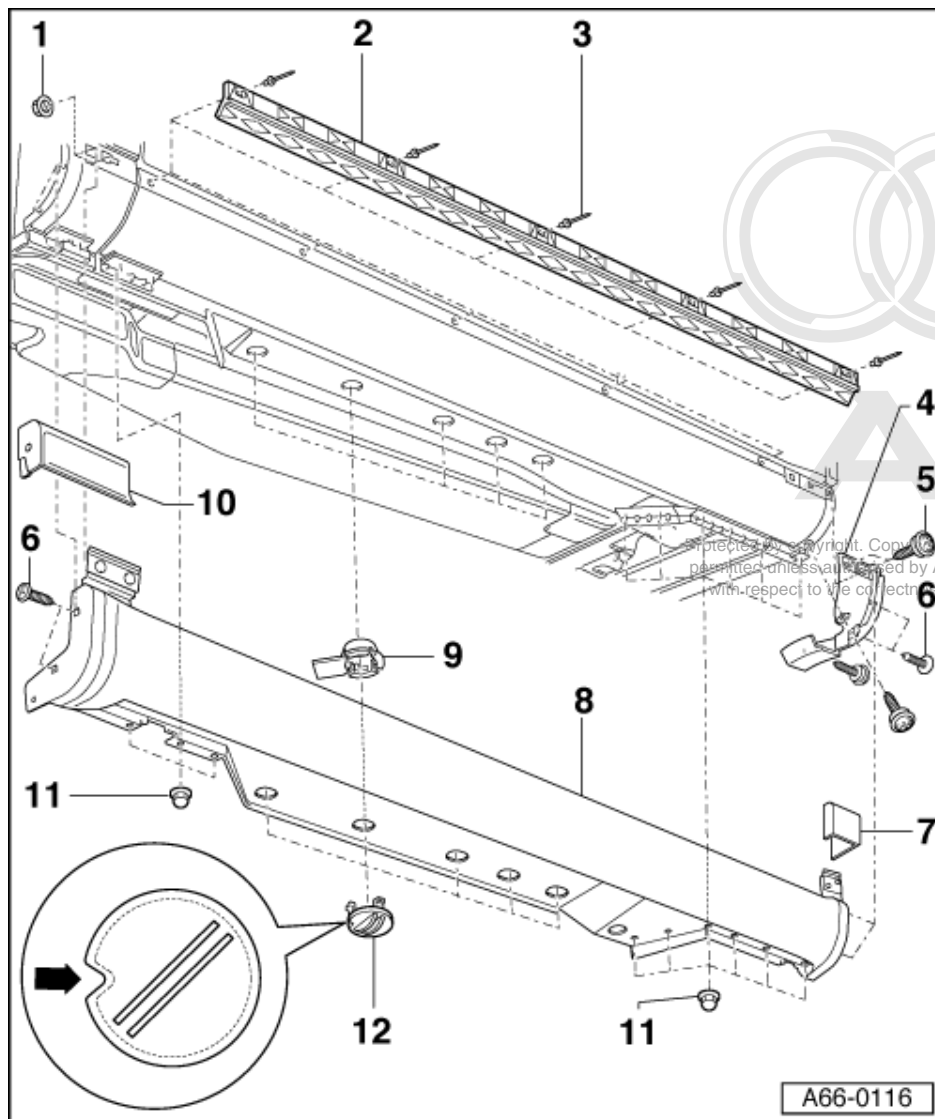
1 Hexagon nut

- ◆ 1 Nm

2 Retaining strip

- ◆ Bonding surface must be free from dust and grease before pressing the retaining strip on.
- ◆ Self-adhesive, pull off the protective sheet just before assembly.
- Warm the retaining strip before assembly with hot air gun at around 40°C +10°C.
- Centre the front and rear retaining strip with a tubular rivet.
- Press the retaining strip firmly onto the bonding surface completely flat, at the sill panel.
- Rivet the retaining strip, starting from the front to back, at the sill panel.

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3 Tubular rivet

- ◆ 5x

4 Bracket

5 Collar bolt

- ◆ 1.5 Nm

6 Cross head screw

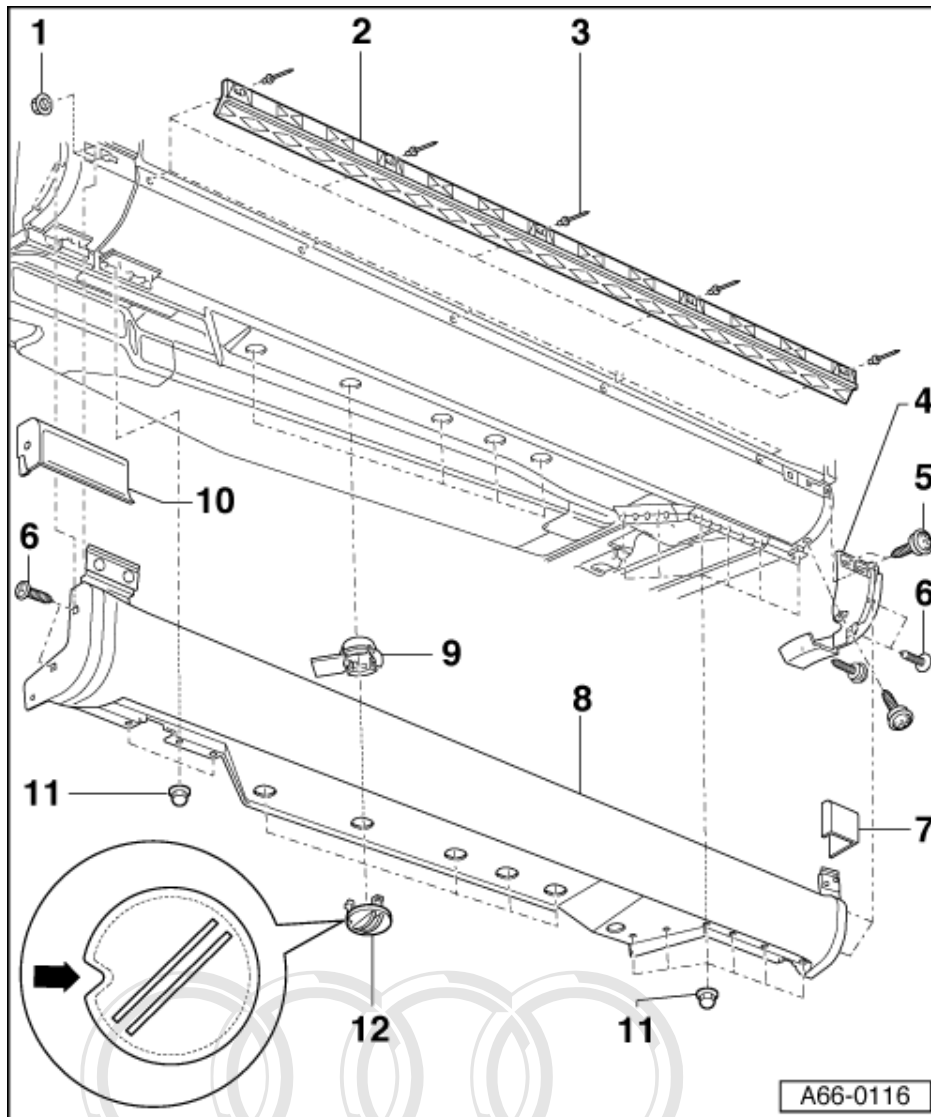
- ◆ 1.5 Nm

7 Rear cover

- ◆ Remove => Fig. 1.

8 Sill panel trim

- ◆ Before assembly, remove the rear cover -7- => Fig. 1.
- ◆ Remove front end cap -10-.
- Unscrew the front and rear crosshead bolt -6-.
- Release the catches -12- and pull them out.
- Unbolt cap nuts -11-.

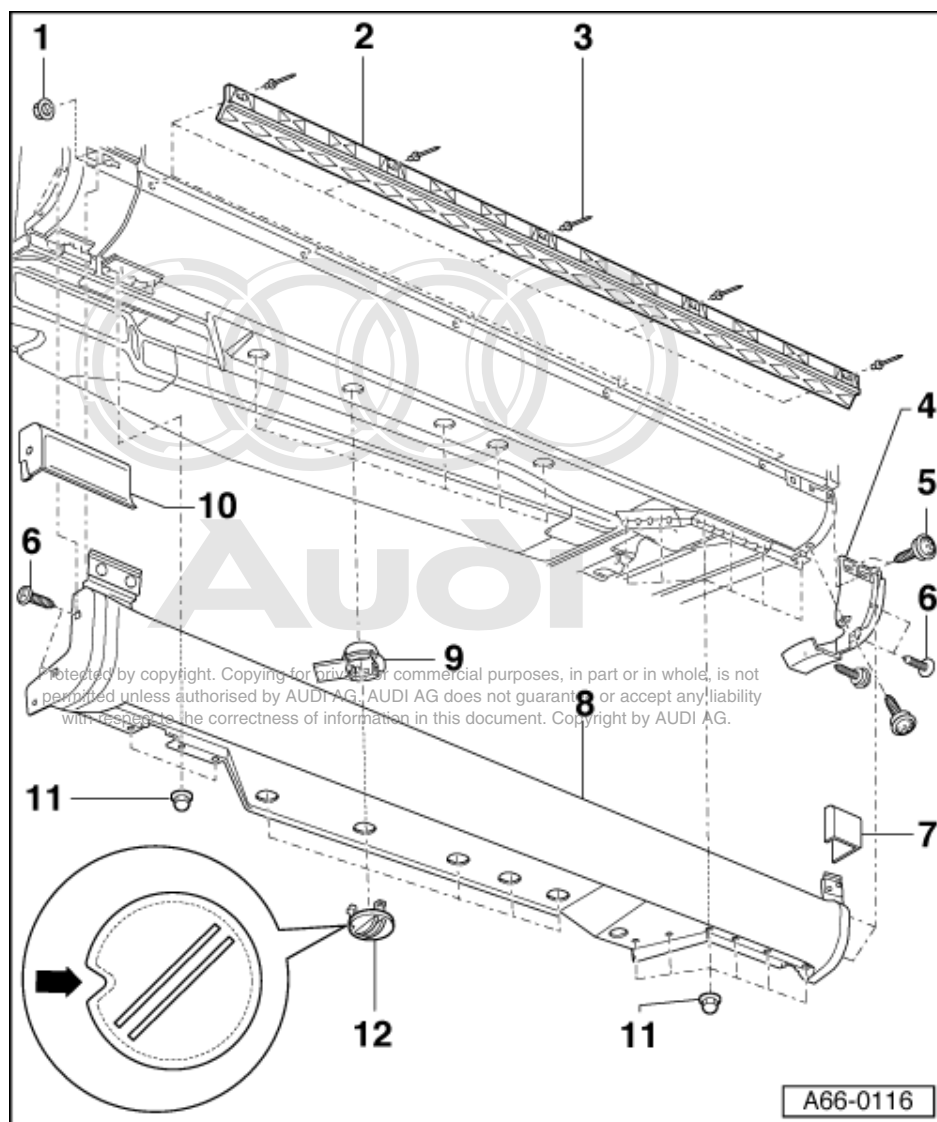


- Unscrew the screws attaching the wheel housing liner in the hexagon bolts area -1-.
- Press out the wheel housing liner to the side and unscrew the hexagon bolts -1-.
- On the right side, you must detach additional screws attached for the activated charcoal filter.
- Take off sill panel trim from the front of the bracket -4- and remove from the sill panel.

9 Screw lock for mount

- ◆ Tab on mount must point to centre of vehicle.

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10 Front end cap



11 Cap nut

- ◆ 1.5 Nm

12 Screw lock

- ◆ Notches -arrow- must show at the front in the direction of travel

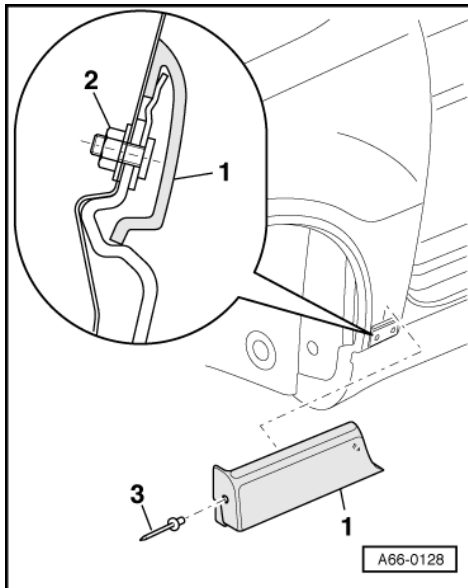


Fig.1 -> Removing and installing front end cap

- Front wheel removed.
- Drill the rivet head of the tubular rivet -3- and fold the shank.
- Unscrew the front end cap screws from the wheel housing liner.
- Press out the wheel housing liner to the side and unscrew the hexagon bolts -2-.
- Remove the front end cap -1- on the side of the wing.

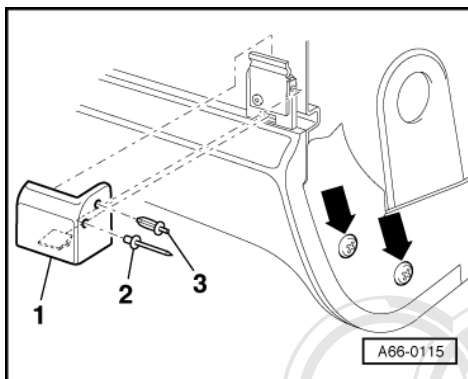


Fig.1 -> Removing and installing rear cover

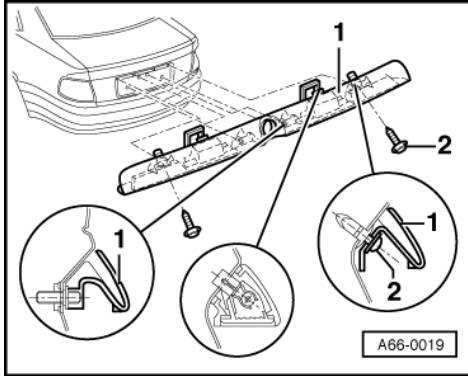
- Drill the rivet head of the tubular rivet -2- and fold the shank.
- Push out the pin from the split rivet and remove the split rivet from the cover.
- You will need the pin for the split rivet again when installing.
- Remove the cover from the bracket, upper first and then remove from the outside.
- On further removing the sill panel trim, unscrew the crosshead screws -arrows-.

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12 - Grip panel for boot lid

12.1 - Grip panel for boot lid

12.2 - Removing and installing grip panel for boot lid

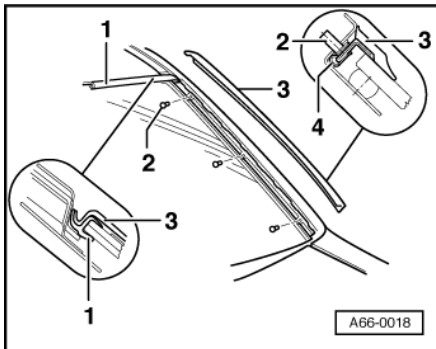


- Remove boot lid trim.
- Unscrew nuts (2x) for lock cylinder on inside of boot lid.
Tightening torque 6 Nm.
- -> Remove screws -2- (2x).
Tightening torque 2.5 Nm.
- Pull out grip panel -1- until wiring for both number plate lights can be disconnected.
- Remove grip panel -1-.

13 - Weatherstrip

13.1 - Weatherstrip

13.2 - Removing and installing holders for weather-strip

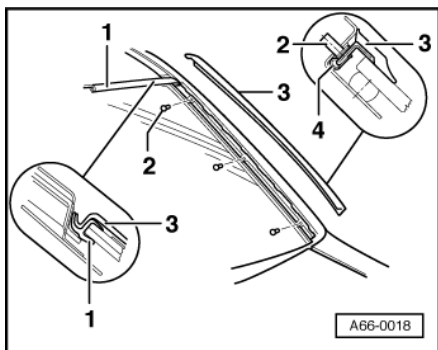


- Removing windscreen => Page 185 .
- -> Drill off rivets -2- (3x) to remove holders -4- for weather-strip.
- Use special tool V.A.G 1617 B to fit rivets.

Note:

If paintwork is damaged when drilling off rivet, make good the paint coating as specified in the vehicle paintwork Workshop Manual and apply corrosion protection if necessary as described in the "Surface Treatment/Chemical Materials" binder.

13.3 - Removing and installing weather-strip



- -> Carefully prise weather-strip -3- out of clip -4-.
- As shown in magnified view, weather-strip -3- must make contact with windscreen surround -1- on installation.

Important

Do not press against windscreen when using screwdriver to lever out weather-strip -3-.

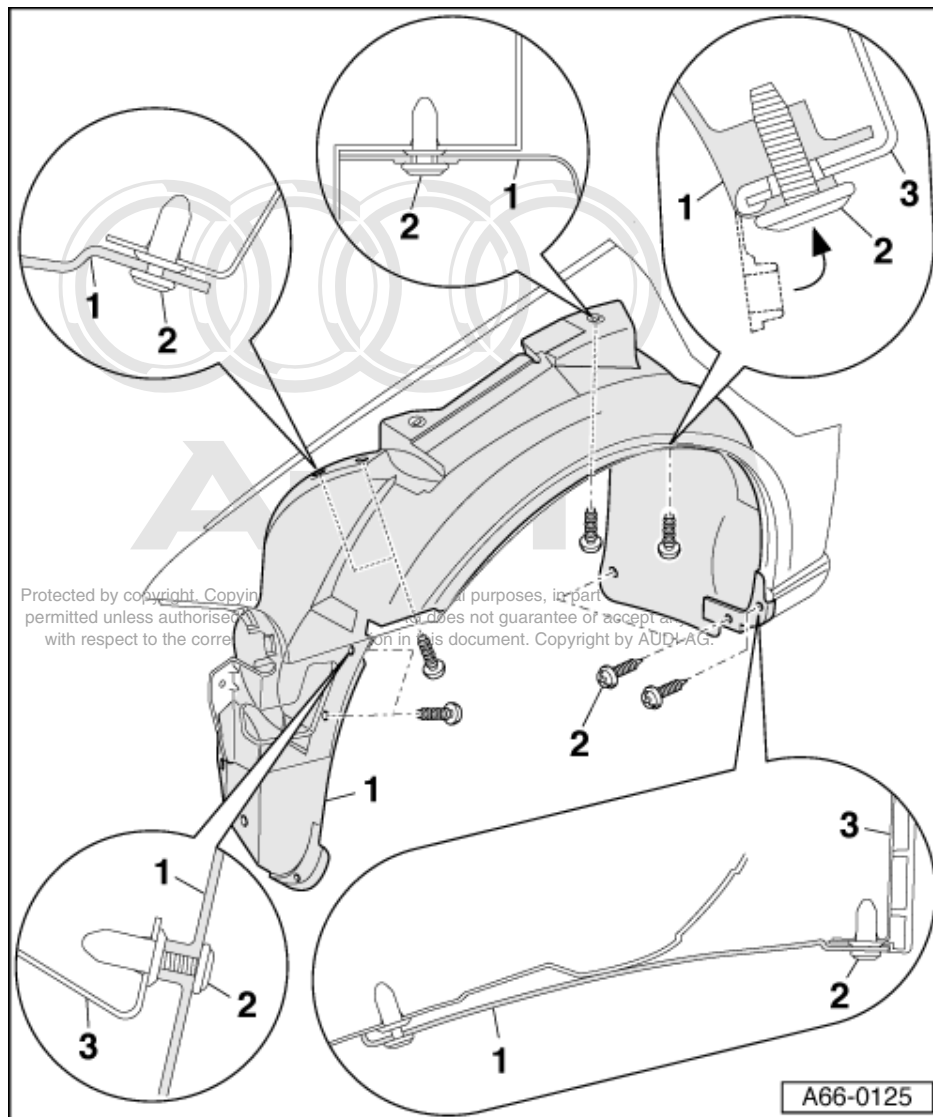


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14 - Removing and installing front wheel housing liner

14.1 - Removing and installing front wheel housing liner



1 Front wheel housing liner

- ◆ Front wheel removed
- ◆ When removing, unscrew the screws -2- (10x) and remove the wheel housing liner under the wing.
- ◆ When installing, first press the plastic tabs (underlined) in the direction of the arrows in the holes on the wing and then screw in the cross-head bolts.

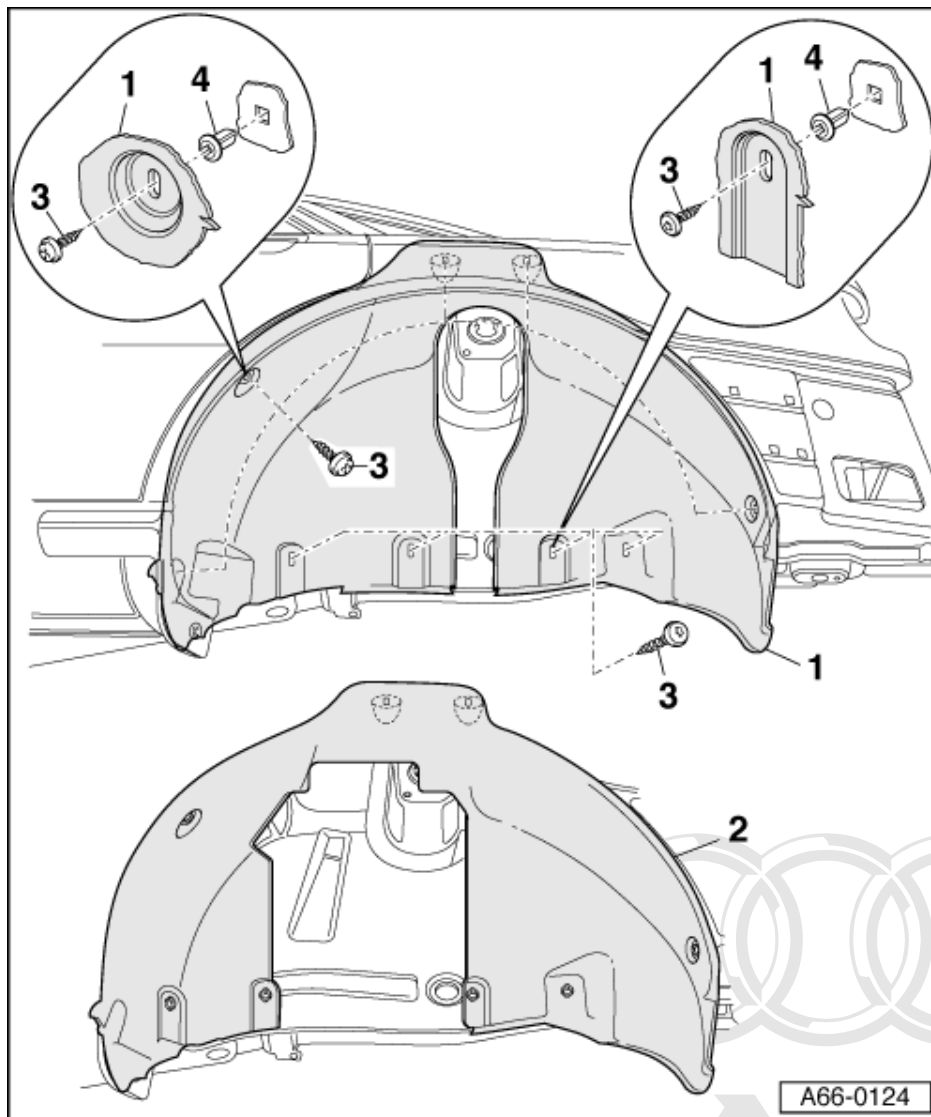
2 Cross-head bolts

- ◆ 2.5 Nm

3 Wings

15 - Removing and installing rear wheel housing liner

15.1 - Removing and installing rear wheel housing liner



1 Rear wheel housing liner (FWD)

- ◆ Rear wheel removed
- Unscrew the upper (5x) and lower (4x) cross-head bolts -3-.
- Remove the wheel housing liner over the included suspension strut on the side part.

2 Rear wheel housing liner (quattro)

- ◆ Removing and installing as for FWD

3 Cross head screw

- ◆ 2.5 Nm

4 Clip