

Fitting instruction **A4 2008 ➤**

Body
Rear apron, for scope of delivery 8K0 071 610 Edition 2.08

Contents

1	General information	1
2	Please read carefully before you begin!	2
2.1	Painting guideline for primed PU-RIM components	2
2.2	Application instructions for adhesive	3
3	Components	4
4	Sequence of operations	5
4.1	Preparations	5
4.2	Assembling the rear apron	5
5	Appendix: Certificates	7

1 General information

Please read and apply these DANGER, Caution and Note descriptions before carrying out maintenance or repair work.



WARNING!

- ◆ *Text with this symbol contains information concerning your safety and how you can reduce the risk of serious and fatal injuries.*
- ◆ *Pay special attention to the DANGER symbol. Ensure that you have read this text thoroughly.*



Caution!

- ◆ *Text with this symbol contains information on how to avoid damage to the vehicle.*
- ◆ *A Caution symbol indicates that failure to follow information can lead to vehicle damage. (e.g.: ensure that the ignition has been switched off before the battery is connected, otherwise the engine control unit can be damaged.)*



Note

- ◆ *Text with this symbol contains additional useful information.*
- ◆ *A Note symbol also contains special and additional notes on repair measures and associated information.*

Special tools are required for assembly. Improper installation can cause damage to the vehicle or the add-on components.

Audi AG shall not accept responsibility in the event of failure to comply with these assembly instructions.



2 Please read carefully before you begin!

2.1 Painting guideline for primed PU-RIM components

Sanding: Wet P 600

Base paint:

Quality Herberts:

Corresponds to: LMT 626 / ALD 626 UNI undercoat lacquer
LMT 845 / ALD 645 metallic undercoat lacquer
LPC 045 / ALD 045 pearl colour undercoat lacquer

Viscosity: 20 sec.
Applications: 2
Coat thickness: approx. 20 µm
Airing time: 10 min.
Final airing time: 15 min.
Spray gun: Devilbiss GTI 1.4 mm

Clear paint:

Quality Herberts:

Corresponds to: 2K-MS clear lacquer new
L2K 769 011 + 10% softener
2 : 1 + 10% thinner

Viscosity: 18 sec.
Applications: 2
Coat thickness: approx. 50 µm
Airing time: 10 min.
Drying: Overnight at 20° C
Spray gun: Devilbiss GTI 1.4 mm

Add-on components must always be painted in accordance with the "Audi Paintwork Guideline".

Contrary to the guideline, these add-on components must not be heated when drying - risk of deformation!



Caution!

Drying the add-on components overnight at 20° C!

2.2 Application instructions for adhesive

Suitable for components made of:

- ◆ PUR
- ◆ PUR-RIM
- ◆ PU hard integral foam
- ◆ ABS¹⁾
- ◆ The recommended processing temperature for the adhesive / 3M adhesive tape and material (vehicle components) is between 15° C and 25° C.
- ◆ The installation process should be completed 45 minutes after opening the adhesive.
- ◆ The bonding surfaces on the body and add-on component must be absolutely dry, clean and free of wax and oil or grease.
- ◆ The bonding surfaces must be cleaned with isopropanol immediately prior to applying the adhesive.
- ◆ Observe the information provided in the adhesive kit.
- Use sandpaper to remove paint from and roughen the bonding surfaces of the component. (Remove all paint residue!)
- Remove sanding dust with compressed air.
- Clean bonding surfaces with isopropanol.
- Apply adhesive, affix component in end position and attach firmly.

Caution!

The entire installation process must be completed within 45 minutes.

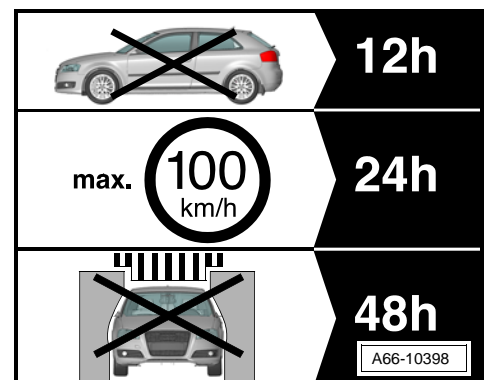
- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.

WARNING!

- **Wait at least approx. 12 hours before removing the adhesive tape.**

The add-on components must not be subjected to any mechanical load for 24 hours.

Do not wash the vehicle for 48 hours.



¹⁾ In the case of ABS components, the bonding surfaces must be carefully coated with primer after cleaning. Any impurities must be immediately removed with isopropanol. Drying time for primer: min. 30 minutes, max. 3 hours



3 Components

Components required:

Mounting kit -8K0 071 610-

Comprising:

Units	Part number	Description
1	8K0 071 610	Rear side attachment parts set
4		Installation aids
1		Installation Instructions

In addition, you will require:

Units	Part number	Description
1	00A 071 785	Adhesive kit



Note

One adhesive kit is enough to install one assembly set. The tip of the tube must be cleaned or exchanged whenever there is a pause in the gluing process. Furthermore, the processing time for the adhesive must be observed ⇒ [page 3](#) and ⇒ Information included in the adhesive kit package.

4 Sequence of operations

4.1 Preparations

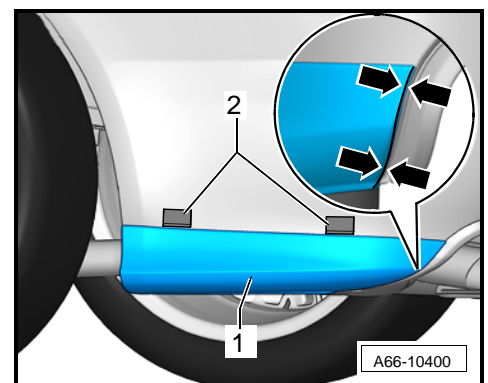
 **Note**

These add-on components are precision-manufactured and already primed. Nevertheless, they must be test-fitted in accordance with these installation instructions prior to painting.

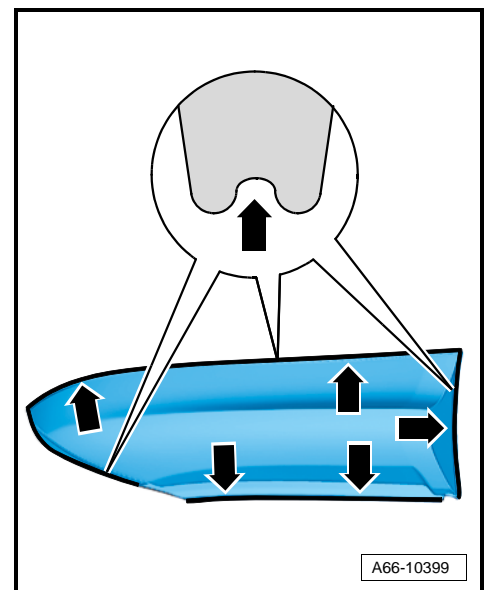
- Check all parts for proper fit on the vehicle before painting.
- Paint the parts to be installed ⇒ [page 2](#).

4.2 Assembling the rear apron

- Place the rear aprons -1- on the series bumper and align on the installation edge with the diffuser -arrow-.
- Attach installation aids -2-.
- Remove the rear apron.



- Roughen the adhesive grooves/bonding surfaces of the rear aprons -arrow- and remove any paint which is present.
- Remove sanding dust with compressed air.
- Clean the adhesive grooves/bonding surfaces of the rear aprons and bonding surfaces on the vehicle with isopropanol.
- Use a clean applicator tip: clean or exchange tip if necessary.
- Apply an even bead of adhesive (approx. 4 mm) Ø to the bonding surfaces/adhesive groove of the rear aprons. Observe guidelines for the adhesive ⇒ [page 3](#).
- Place the adhesive tape ready for fixing the rear apron.

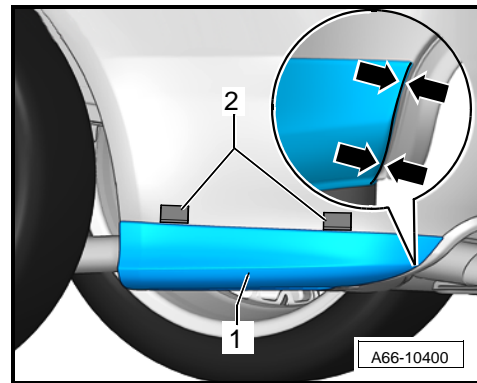


- Place the rear aprons -1- on the side of the serial bumper and align on the installation aids -2- and the installation edge to the diffuser -arrow-.
- Secure the rear apron in place with adhesive tape until the adhesive has cured.

 **Caution!**

Ensure that entire adhesive groove is filled with adhesive.

- After fixing, check the adhesive joint on the installation edge to the diffuser -arrow- and correct if necessary.



 **Note**

The rear apron can tilt downwards on the diffuser installation edge.

- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.

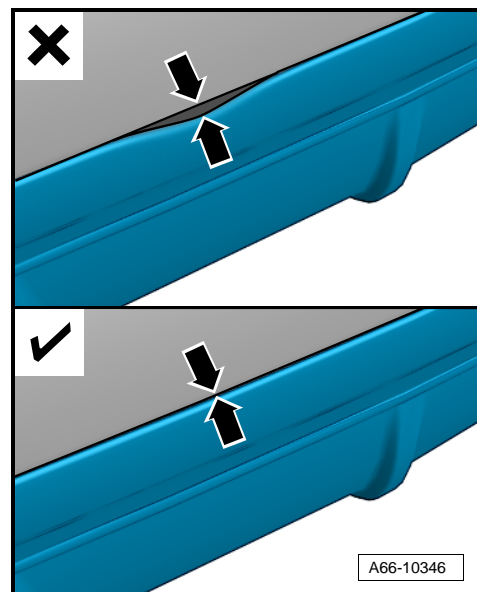
To allow the adhesive to cure, secure rear apron segments in place and remove any excess adhesive:

- Ensure that the adhesive joint -arrows- between the bumper and rear apron is even; secure the rear apron with additional tape if necessary.
- Carry out a final visual check for even adhesive joints and excess adhesive (do not forget the areas underneath the adhesive tape).

 **Note**

The adhesive joint should be checked several times while the adhesive is curing and any adhesive that emerges should be removed.

- Installation of the diffuser (or underpanel of the bumper cover) cannot take place until 24 hours after installation of rear apron ⇒ [page 3](#).
- Install diffuser (or underpanel of bumper cover) after adhesive has been allowed to cure ⇒ Rep. Gr. 63 or ⇒ Fitting instructions; No. 32; Diffuser with decorative trim.



5 Appendix: Certificates

The following are included after the installation instructions:

- ◆ Manufacturer certification from Audi AG
- ◆ Excerpt from the EC certification issued by the German Kraftfahrt-Bundesamt
- ◆ Certificate from TÜV AUTOMOTIVE GMBH (Technischer Überwachungs Verein)

 **Note**

Place any country-specific documents from the appendix with the vehicle documents, so that these can be presented to authorised persons upon request.