

## Fitting instruction A4 2008 ➤

<b>Body</b>
<b>Diffuser with decorative trim, for scope of delivery 8K0 071 620 A and 8K0 071 620 B</b>
Edition 2.08

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# 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 guidelines for primed PU-RIM parts

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
- ◆ ABS<sup>1)</sup>
- ◆ 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 paint residues).
- 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.**

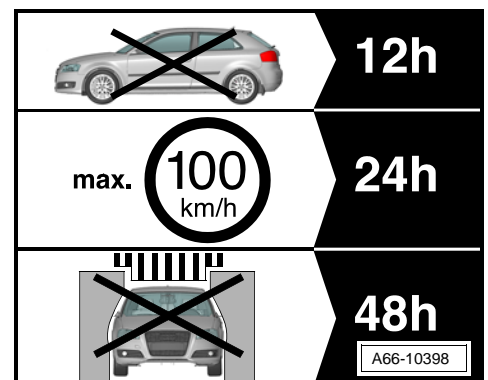
- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.

### **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.**



<sup>1)</sup> 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:

Vehicles with twin exhaust pipes left:

Assembly set -8K0 071 620 A-

Comprising:

Units	Part number	Description
1	8K0 071 611	Rear diffuser, double left
1	8K0 071 311	Decorative trim
1	8K0 071 737 A	Mounting hardware
1		Installation Instructions

Vehicles with an exhaust tailpipe left and right

Assembly set -8K0 071 620 B-

Comprising:

Units	Part number	Description
1	8K0 071 611 A	Rear diffuser, left + right
1	8K0 071 311	Decorative trim
1	8K0 071 737 A	Mounting hardware
1		Installation Instructions

Package contents - mounting hardware for rear diffuser  
-8K0 071 737 A-

Units	Description
2	Expanding plastic rivet 6.2 x 20

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](#), as well as ⇒ 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 3](#).

### 4.2 Removing the underpanel of the bumper cover

- Unscrew the screws -2- on the bottom part of the bumper cover.
- For vehicles with a double exhaust tailpipe on the left, dismantle the expanding rivet completely -1-.

 **Note**

*Replace the two screws on the sides -2- with the expanding plastic rivets provided.*

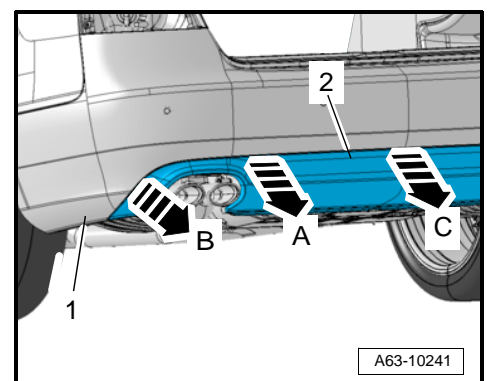
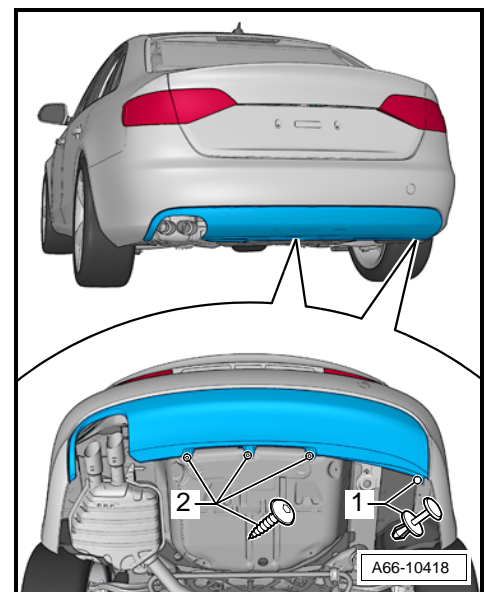
- Starting in the sequence -arrows A ... C-, unclip underpanel -2- for bumper cover above the exhaust tailpipe from the bumper cover -1-.

**If necessary, mount the rear apron left and right ⇒ Rear apron installation instructions.**

### 4.3 Attaching the diffuser with decorative trim

- Installation of the diffuser cannot take place until 24 hours after installation of a rear apron.

Installation of the diffuser follows the reverse sequence for removal of the underpanel for the bumper cover ⇒ [page 5](#); be careful to observe the following:



- Drill the two drill holes -1- to 6.2 mm. Set depth stop to 15 mm or mark the drill bit with tape.

**! Caution!**

**Do not drill deeper than 15 mm, since various cables are in this area!**

**i Note**

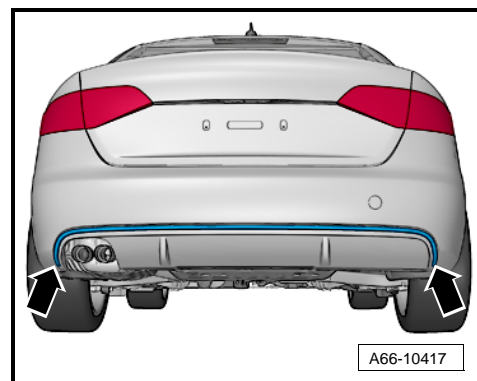
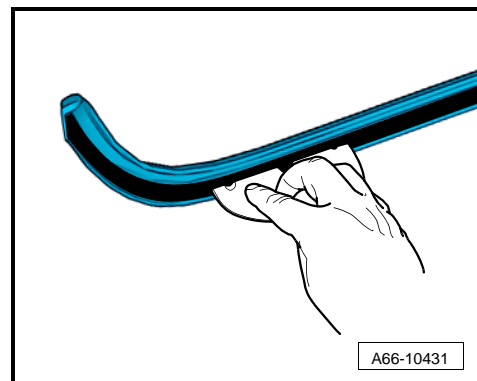
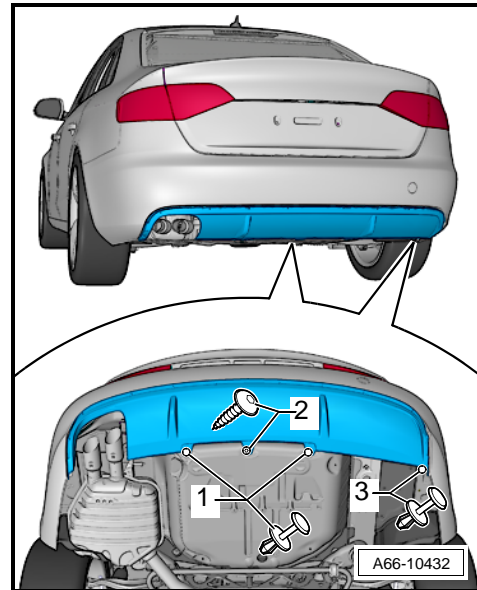
**Do not drill through the fasteners, as otherwise rain water will be able to enter the luggage compartment. If necessary, replace fasteners.**

- On the fastening points -1-, replace the screws with the expanding plastic rivets provided.
- Prior to expanding, ensure that the guide tabs are engaged in the bumper cover and then proceed with final expansion.
- For vehicles with a double exhaust tailpipe on the left, assemble the expanding rivet -3-.
- Align the diffuser on the sides to the bumper.
- Roughen the decorative trim in the bonding area and remove any paint.
- Remove sanding dust with compressed air.
- Clean the bonding surfaces of the decorative trim and the bonding surfaces on the rear diffuser thoroughly (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 surface of the decorative trim. Observe guidelines for the adhesive ⇒ [page 3](#).
- Mount the decorative trim and fix with adhesive tape.

**! Caution!**

**Do not apply excessive force downwards when fixing the decorative trim, as this could cause the adhesive to be pressed off the bonding surface completely!**

- Align the ends of the decorative trim -arrow- and fix with adhesive tape.
- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.
- Ensure that the adhesive joint between the decorative trim and the bumper is even; secure the rear apron with additional tape if necessary.
- Make a final visual inspection to ensure that the adhesive joint is even and that all excessive adhesive has been removed.







**Note**

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

**Tightening torques:**

<b>Component</b>	<b>Nm</b>
Diffuser screw, centre (1x)	1.5



## 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.*