

## **Fitting instruction** **A4 Limousine 2008 ➤**

<b>Body</b>
<b>Tailgate spoiler, for scope of delivery</b> <b>8K5 071 645</b> Edition 2.08

A4 Limousine 2008 ➤

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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 guideline for primed PU-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
- ◆ 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 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.**

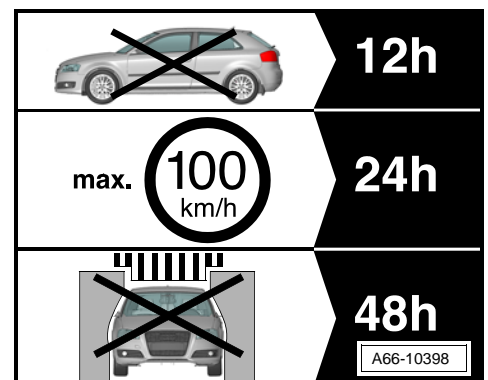
- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.

### **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.**



<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:

Mounting kit -8K5 071 645-

Comprising:

Units	Description
1	Tailgate spoiler
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 add-on component. 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

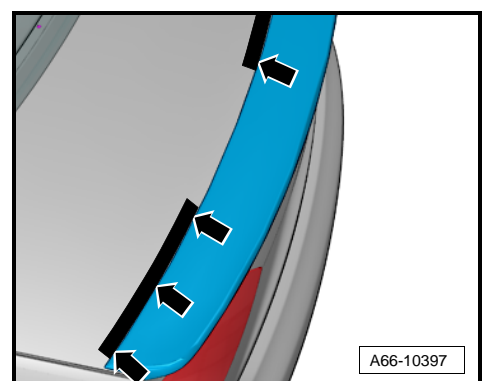
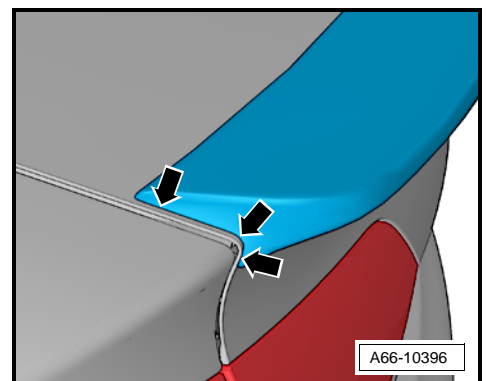
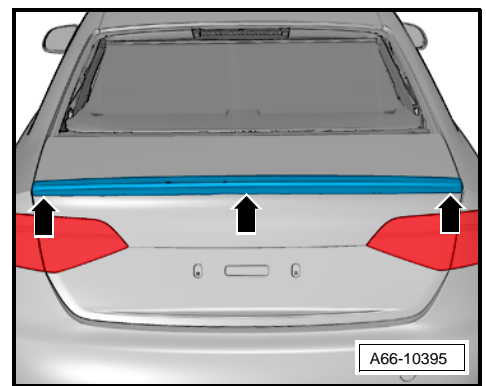
 **Note**

*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.*

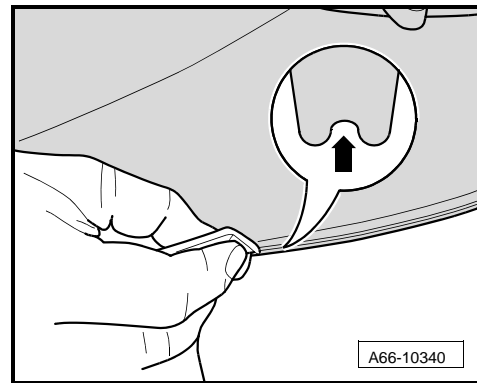
- Painting the tailgate spoiler ⇒ “2.1 Painting guideline for primed PU-components” on page 2.

### 4.2 Mounting the tailgate spoiler

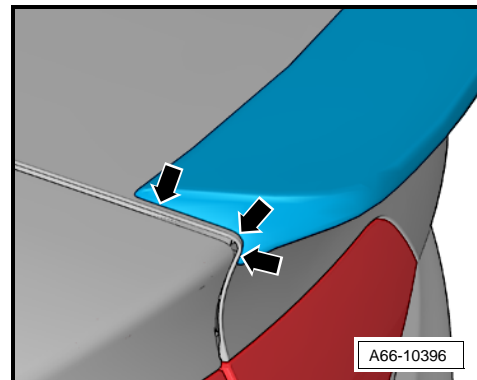
- Place the spoiler on the tailgate and centre it.
- Align the tailgate spoiler so that it fully abuts the contact surfaces. Pay particular attention to the area around the back contact edges -arrows-.
- Check the lateral adhesive joint -Arrows- and adjust the position of the spoiler of necessary.
- Mark the position of the spoiler, with adhesive tape for example.
- Remove the spoiler.



- Roughen the adhesive groove on the spoiler -arrow-; remove any paint that may be present.
- Remove sanding dust with compressed air.
- Clean bonding surfaces 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 (adhesive groove). The adhesive must form an unbroken sealing surface after installation. Observe guidelines for the adhesive ⇒ [page 3](#).
- Centre the spoiler on the tailgate and check the lateral adhesive joint -arrows-. Adjust the position of the spoiler if necessary.
- Secure spoiler in place with adhesive tape until the adhesive has cured.
- Use the putty knife, cotton cloth and isopropanol to remove any adhesive residue.



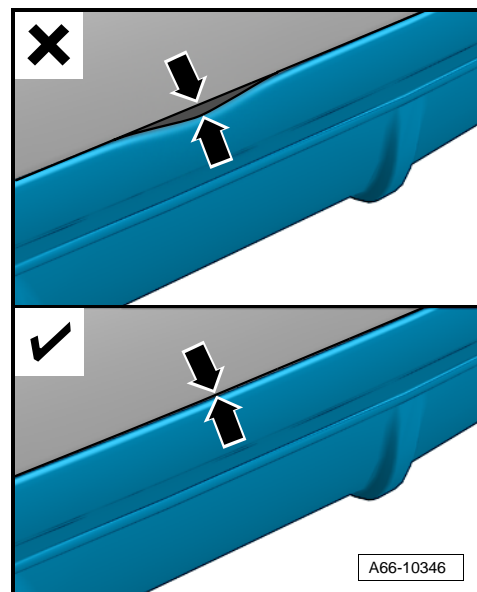
- Ensure that the adhesive joint -arrows- between the spoiler and tailgate is even; secure the spoiler with additional tape if necessary.
- Use the putty knife provided to remove any adhesive that emerges. Do not overlook the areas under the adhesive tape.
- Make a final visual inspection to ensure that 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.*

- Place installation instructions and certificates provided in appendix with vehicle documents.
- Wait at least 12 hours before removing the adhesive tape.





## 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.*