



Installation instructions

Audi A4 Saloon 2012 ►

**Tailgate spoiler,
for scope of delivery 8K5.071.645.B
Audi Genuine Accessories**

Edition 04.2012



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1 General notes

Please read and take note of these WARNING, Caution and Note descriptions before carrying out maintenance or repair work.

 **WARNING**

Text with this symbol contains information concerning your safety and indicates potential accident and injury risks.

 **Caution**

Text with this symbol indicates the risk of damage to your vehicle.

 **Note**

Text with this symbol contains additional information.

- Text with this symbol describes a work instruction (guideline).
- Text with this symbol describes a condition to be maintained (fulfilled).
- ◆ Text with this symbol is used to show a list.

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

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 PUR-RIM components

Sanding: Wet P 600

Base paint:

Herberts quality:

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:

Herberts quality:

Corresponds to: Two-component MS clear paint 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

⚠ Caution

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

Contrary to the guideline, add-on components must not be heat-dried but instead left to dry overnight at 20 °C — risk of deformation!



2.2 Assembly adhesive/processing conditions/basic procedure

Assembly adhesive suitable for add-on components made of:

- ◆ PUR-RIM¹⁾ "Tailgate spoiler"

Processing conditions

- ◆ The assembly process should be completed 45 minutes after opening the assembly adhesive.
- ◆ The bonding surfaces on the body and the add-on component must be completely dry, clean and free from wax and oil or grease.
- ◆ Remove residual wax using benzine; benzine leaves a „greasing residue“, post-cleaning of bonding surfaces with isopropanol is therefore required!
- ◆ The bonding surfaces must be cleaned with isopropanol immediately prior to applying the assembly adhesive.
- ◆ Note the product instructions provided in the adhesive kit.

Basic procedure

- Use sandpaper to remove paint from and roughen the bonding surfaces of the component (remove paint residue).
- Remove sanding dust.
- The bonding surfaces on the body and the add-on component must be completely dry, clean and free from wax and oil or grease.
- Apply assembly adhesive, affix add-on component in its final position and attach firmly.

Caution

The entire assembly process must be completed within 45 minutes of opening the assembly adhesive — refer to the product instructions for the assembly adhesive reaction time.

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

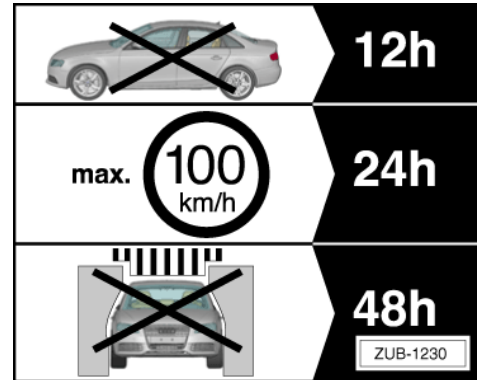


- Use the putty knife provided, together with cotton cloth and isopropanol, to remove any adhesive residue.

⚠ WARNING

- **No vibrations to the adhesive for 12 hours - any required manoeuvring at max. walking speed.**
- **Wait at least 12 hours before removing the adhesive tape; protect the vehicle from water for 12 hours.**
- **The add-on components must not be subjected to any mechanical load for 24 hours — maximum speed 100 km/h.**
- **Do not wash the vehicle for 48 hours.**

The add-on components may work loose and detach when the vehicle is in motion if the adhesive reaction time is not observed — risk of accident.





3 Parts overview

Parts required:

Assembly set 8K5.071.645.B

Comprising:

Units	Part number	Description
1	8K5.071.645.B	Tailgate spoiler
1		Installation instructions

In addition, you will require:

- ◆ Standard fabric tape/masking tape
- ◆ Audi paint to match the vehicle's colour
- ◆ Benzine
- ◆ Cleaning solution D.009.401.04 (isopropanol)

Units	Part number	Description
1	00A.071.785	Adhesive kit

 **Note**

- ◆ *One adhesive kit is enough to install one assembly set. Under favourable conditions, an additional assembly set can be bonded on.*
- ◆ *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 assembly adhesive must be observed ⇒ „**Assembly adhesive/processing conditions/basic procedure**“ on page 3, as must the ⇒ product instructions included in the adhesive kit.*



4 Sequence of operations

4.1 Preparations

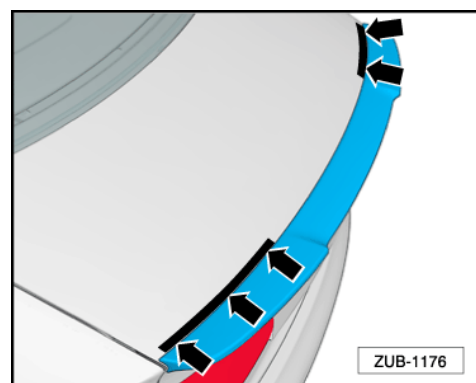
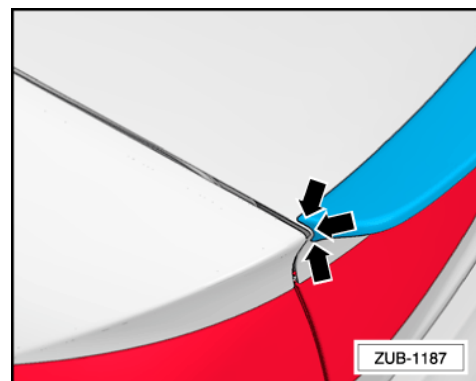
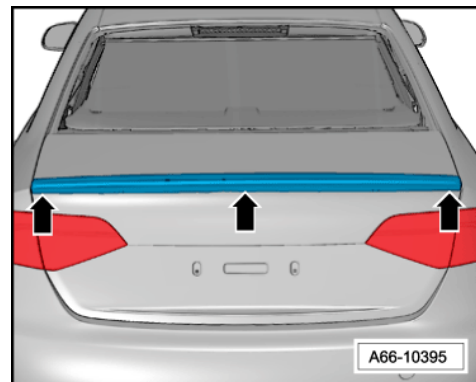
i Note

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

- Mask bonding surfaces
- Painting the tailgate spoiler ⇒ „Painting guideline for primed PUR-RIM components“ on page 2.

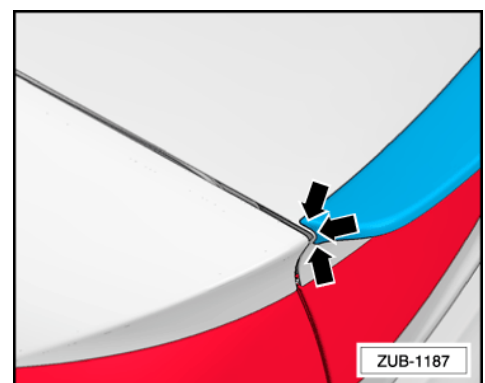
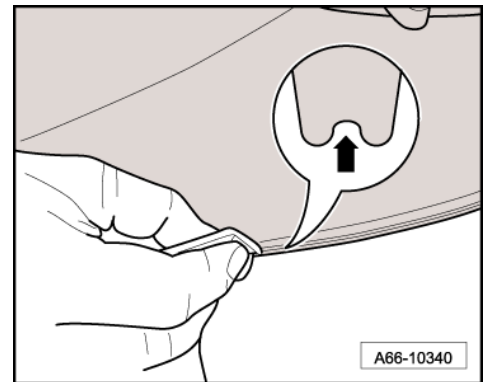
4.2 Mounting the tailgate spoiler

- 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 rear spoiler -arrow-; remove any paint that may be present.
- Remove sanding dust.
- Thoroughly clean bonding surfaces with cleaning solution.
- Use a clean assembly adhesive applicator tip: clean or exchange tip if necessary.
- Apply an even bead of adhesive approx. 5 mm Ø to the bonding surface (adhesive groove). The adhesive must form an unbroken sealing surface after assembly. Observe the gluing guidelines ⇒ [Page 3](#).
- Ensure vent holes right/left are kept free of assembly adhesive.
- 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 provided, together with cotton cloth and cleaning solution, to remove any adhesive residue.

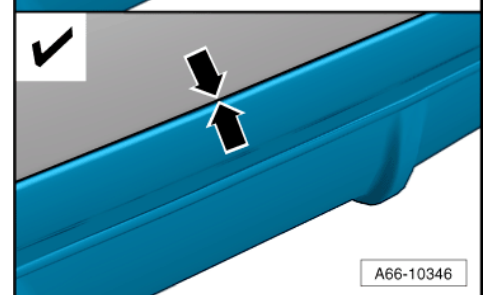
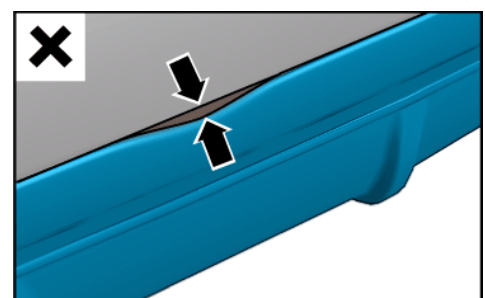


- Ensure that the adhesive joint -arrows- between the spoiler and tailgate is even; secure the spoiler with additional tape if necessary.

i Note

If beads develop, as shown in the upper half of the illustration, the component must be replaced and re-bonded.

- 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 make sure that the adhesive joint is even and that all excessive adhesive has been removed.
- Check vent holes for residual adhesive and remove if necessary.



i 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 Appendices: Certificates, expert evaluations

The following are included after the installation instructions:

- ◆ the manufacturer's certificate of Audi AG
- ◆ Excerpt from the EC certification issued by the German Federal Motor Transport Authority
- ◆ Certificate from SGS-TÜV Saar GmbH (Technischer Überwachungs Verein/Technical testing organisation)

Note

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