

Fitting instruction **A5 2008 >**

Body
Side sills, for scope of delivery 8T0 071 685 Edition 10.07

A5 2008 >

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1 General notes

Please read and apply these WARNING, 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 WARNING symbol. Ensure that you have read this text thoroughly.*

Caution!

- ◆ *Text with this symbol contains information on how to avoid vehicle damage.*
- ◆ *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 Overview of components and gluing guidelines

2.1 Components

Components required:

Mounting kit -8T0 071 685-

Comprising:

Units	Description
1	Side sill kit
4	Installation aids
2	Adhesive applicator tips
1	Installation Instructions

In addition, you will require:

Units	Part number	Description
1	00A 071 785	Adhesive kit (Elch adhesive)

 **Note**

One adhesive kit is enough to install the accessory kit. 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 ⇒ *"2.3 Gluing guidelines" on page 2* and ⇒ Information included in the adhesive kit package.

2.2 Painting guideline for primed PU-RIM components

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!

2.3 Gluing guidelines

- ◆ The recommended processing temperature for the Elch 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.

- ◆ Clean with isopropanol immediately prior to attaching.
- ◆ Observe the information provided in the adhesive kit.

 **Caution!**

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.



3 Sequence of operations

3.1 Preparations

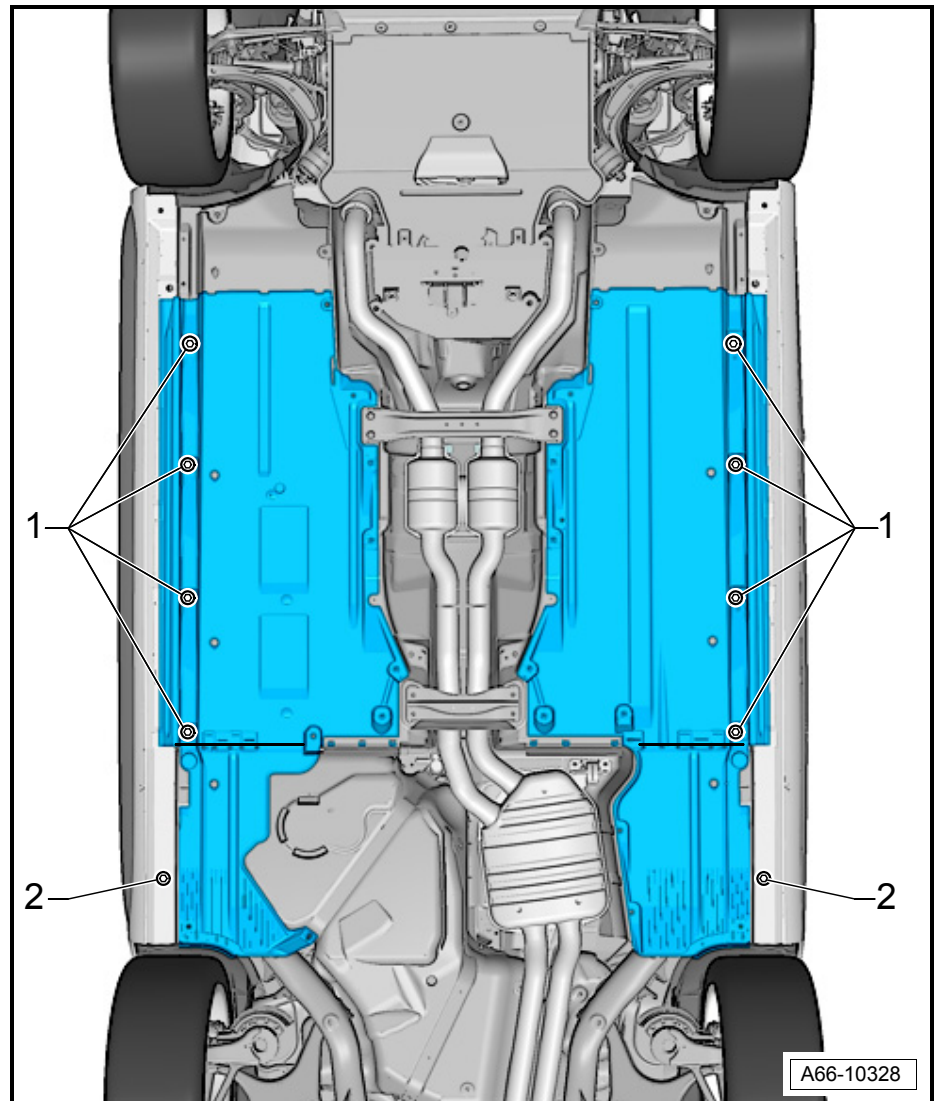


Note

- ◆ *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.*
- ◆ *When preparing to install the side sills, ensure that, when selecting the lifting platform / raising the vehicle, there is adequate clearance for installation.*
- Painting the side sills ⇒ **“2.2 Painting guideline for primed PU-RIM components” on page 2.**

3.2 Installing the side sills

- Raise vehicle on lifting platform. When raising the vehicle, ensure that there is adequate clearance for installing the side sills and the support plates on the lifting platform are placed as far inwards as possible.

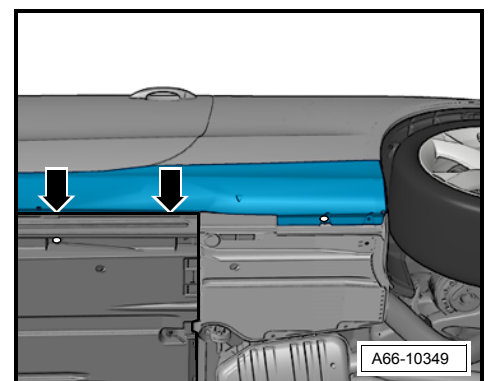


- Remove outer nuts -1- from the front Cw underbody panel (re-use).
- Remove bolt -2- from the rear Cw underbody panel (re-use).

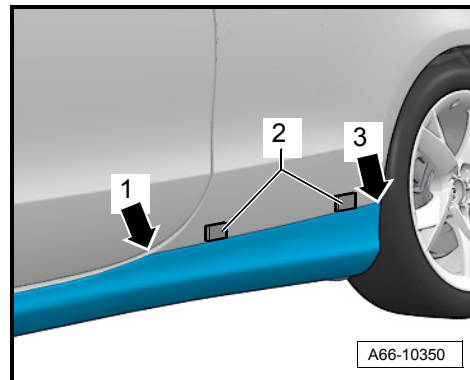
 **Note**

It is recommended to have a 3rd technician available when installing/gluing the side sills.

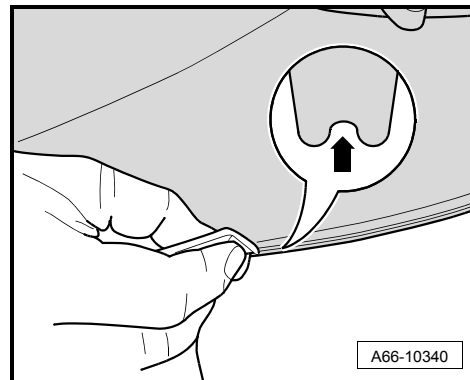
- Guide lower edge of side sill between front Cw underbody panel and body -arrows-.



- Align side sill with lower edge of door and rear wheel housing, and secure in place with adhesive tape. Pay attention especially to transition between lower edge of door and side wall -arrow 1- and transition to rear wheel housing -arrow 3-.
- Attach installation aids -2-.
- Remove side sill.

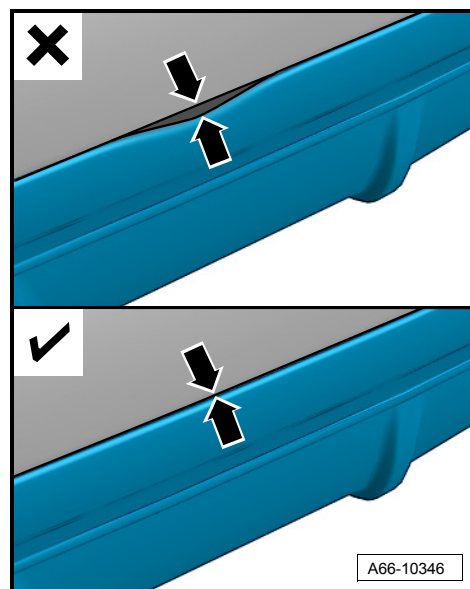


- Roughen the adhesive groove -arrow-; remove any paint that may be present.
- Thoroughly clean the adhesive groove and bonding surfaces on the vehicle with isopropanol.
- Use a clean applicator tip: clean or exchange tip if necessary.
- Apply an even bead of adhesive (approx. 4 mm) Ø to the bonding surface (adhesive groove). The adhesive must form an unbroken sealing surface after installation. Observe guidelines for the adhesive => [page 2](#).
- Secure side sill in place with adhesive tape until the adhesive has cured.
- Re-attach Cw underbody panels.



To allow the adhesive to cure, secure side sill in place and remove any excess adhesive:

- Use the putty knife, cotton cloth and cleaner provided to remove any adhesive residue.
- Ensure that the adhesive joint - arrows- between the side sill and side wall is even; secure the side sill 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.

Tightening torques:

Component	Nm
Bolt for Cw underbody panel	3.5
Nut for Cw underbody panel	2