

Installation instruction A5 Coupe 2009 >

Bodywork
Rear spoiler, for scope of supply 8TO.071.645.A Issue date 09.09

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1 General notes

Please read and heed these NOTE, caution and information texts before you carry out maintenance or repair work.

NOTE!

- ◆ *Texts with this symbol contain information related to your safety and how you can avoid the risk of serious and fatal injuries.*
- ◆ *The NOTE symbol must always be heeded. Make sure you read through these texts carefully.*

Caution!

- ◆ *Texts with this symbol contain information about how you can avoid damage to the vehicle.*
- ◆ *A caution symbol informs you that non-consideration of this information can lead to damage to the vehicle. (e.g.: Make sure you switch the ignition off before the battery is connected, otherwise the engine control unit can become damaged.)*

Information

- ◆ *Texts with this symbol contain additional, useful information.*
- ◆ *An information symbol also contains specific and further information about repair measures and information related to this.*

**Special tools are required for fitting work.
Improper installation can lead to damage to the vehicle or body styling parts.**

Audi AG does not accept any responsibility for the non-observance of these installation instructions.



2 Please read carefully before you start work!

2.1 Painting guideline for primed PU parts

Sanding: Wet P 600

Basic coat:

Viscosity: 20 sec.
Spraying cycles: 2
Layer thickness: ca. 20µm
Flash-off time: 10 min.
Final flash-off time: 15 min.
Spray gun: Devilbiss GTI 1.4 mm

Herberts standard:

Corresponds to LMT 626 / ALD 626 UNI pre-coat
LMT 845 / ALD 645 Metallic pre-coat
LPC 045 / ALD 045 Perlcolor pre-coat

Clear coat:

Viscosity: 18 sec.
Spraying cycles: 2
Layer thickness: ca. 50µm
Flash-off time: 10 min.
Drying: Overnight at 20°C
Spray gun: Devilbiss GTI 1.4 mm

Herberts standard:

Corresponds to: 2K-MS clear coat NEW
L2K 769 011 + 10% softening agent
2:1 + 10% thinner

Body styling parts are always painted in line with the “Audi Painting Guide” regulations.

Deviating from this, the body styling parts must not be heated for drying purposes – danger of distortion!



Caution!

The body styling parts must be dried overnight at 20°C

2.2 Processing instructions for fitting adhesive

Suitable for body styling parts made of:

- ◆ PUR
 - ◆ PUR - RIM
 - ◆ PU-hard integral foam
 - ◆ ABS¹⁾
 - ◆ The recommended processing temperature for the fitting adhesive / 3M adhesive tape and material (vehicle and components) is between 15° C and 25° C.
 - ◆ The fitting process should be completed 45 minutes after the fitting adhesive has been opened.
 - ◆ The surfaces of the body and body styling parts to be glued must be absolutely dry, clean, wax and grease-free.
 - ◆ Clean the adhesive surfaces directly before application of the fitting adhesive using isopropanol.
 - ◆ Follow the instructions in the leaflet included with the adhesive set.
- Remove the masking tape over the flutes.
 - Use sand paper to sand the paint off the adhesive surfaces of the body styling part and rough the surface up. (Remove residual paint!)
 - Use compressed air to remove sanding dust.
 - Clean adhesive surfaces with isopropanol.
 - Apply fitting adhesive, press body styling part into its final position and fix in place.

Caution!

The whole fitting procedure must be completed within 45 minutes.

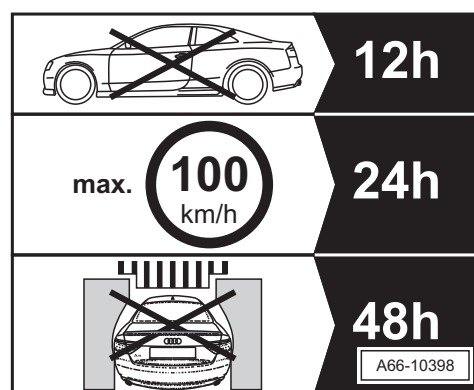
- Remove residual adhesive thoroughly using the enclosed spatula, a cotton cloth and isopropanol.

NOTE!

- **Do not remove the fixing elements until after about 12 hours.**

No mechanical load may be placed on the body styling parts for 24 hours.

Do not wash the vehicle for 48 hours.



¹⁾ In the case of body styling parts made of ABS, the adhesive surfaces must be carefully coated with primer following the cleaning process. Use isopropanol to remove any soiling immediately. Primer drying time min. 30 minutes, max. 3 hours



3 Summary of parts

Components required:

Fitting set -8F0.071.645-

Comprising:

Qty	Description
1	Rear spoiler
1	Positioning aid

You also require:

Qty	Part number	Description
1	00A.071.785	Adhesive set



Information

The adhesive set is for fitting the accessory set: The tube nozzle must be cleaned or replaced every time after every break in the adhesive process. In addition, the processing time of the fitting adhesive must be heeded ⇒ page 3 and ⇒ leaflet included with the adhesive set.

4 Procedure

4.1 Preparatory work



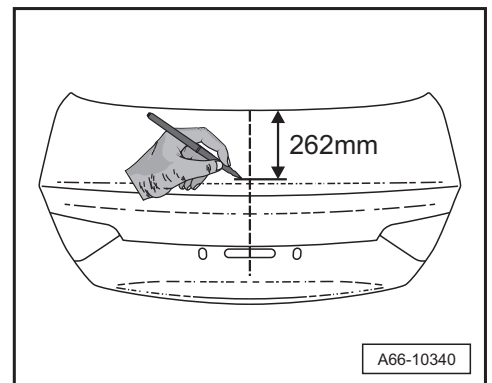
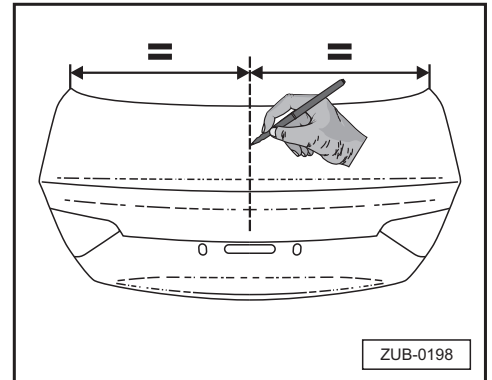
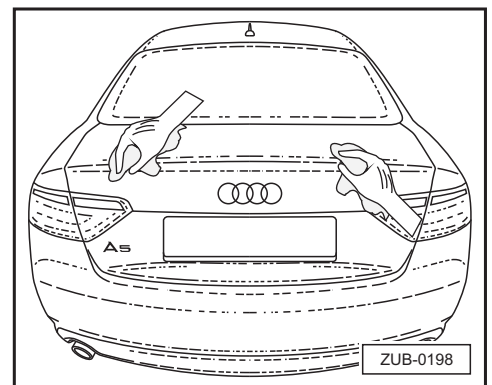
Information

The body styling parts are made to be a perfect fit and have already been primed. You must still carry out test fitting according to these instructions before carrying out any painting work.

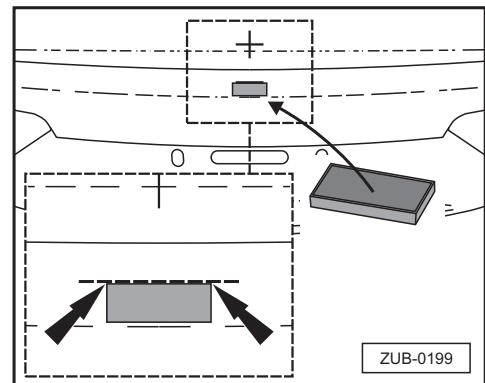
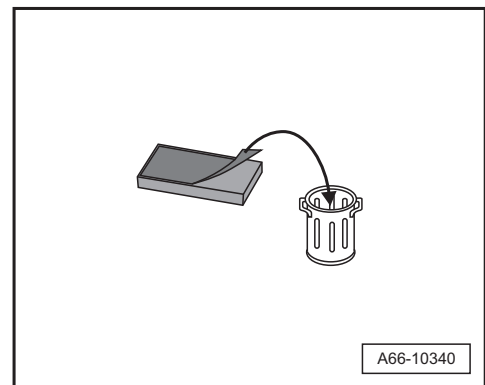
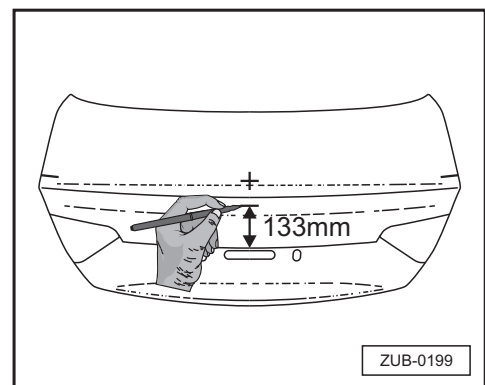
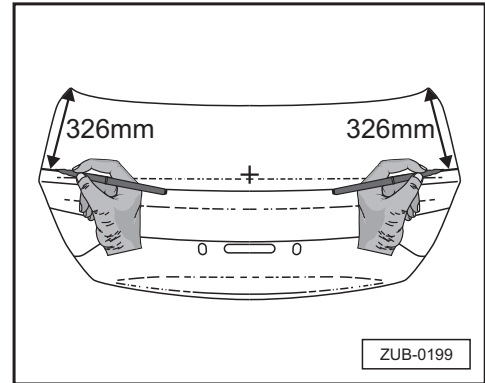
- Paint the rear spoiler ⇒ 2.1 Painting guidelines for primed PU parts" on page 2.

4.2 Fitting the rear spoiler

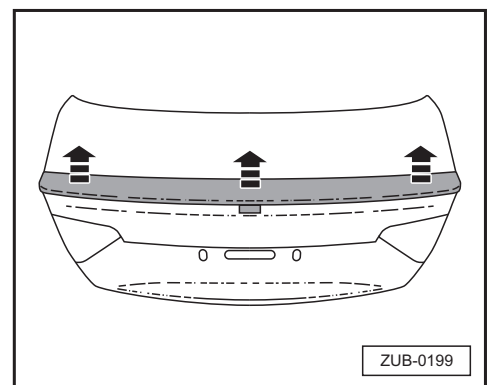
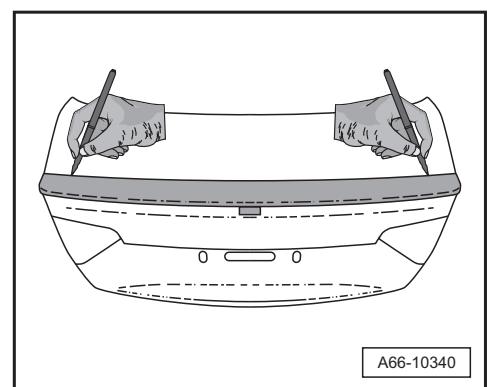
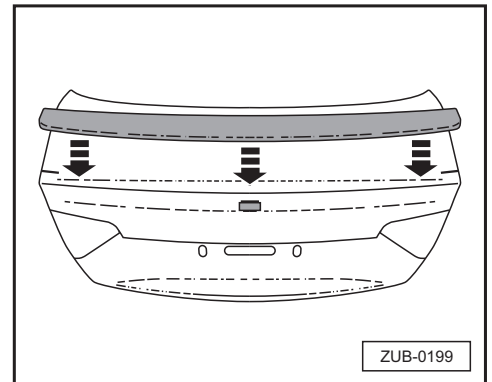
- Clean the tailgate thoroughly in the spoiler contact area.
- Find and mark the centre of the tailgate.
- Mark the dimension of 262 mm as shown in the sketch.



- Mark dimensions of 326 mm on the left and right of the tailgate as shown in the sketch.
- Mark the dimension of 133 mm.
- Remove the backing film from the positioning aid.
- Position the positioning aid as shown in the sketch and press it firmly in place.



- Set the spoiler on the tailgate, align and centre up the markings.
- Use a suitable pen to mark the spoiler contour.
- Remove the rear spoiler.

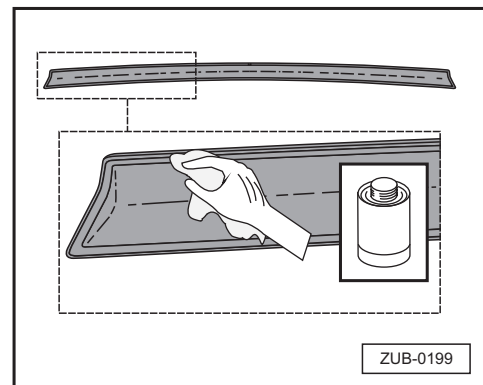
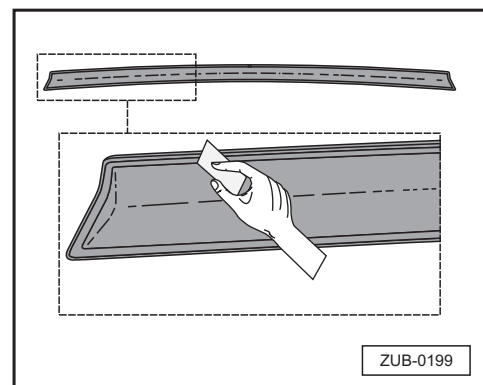
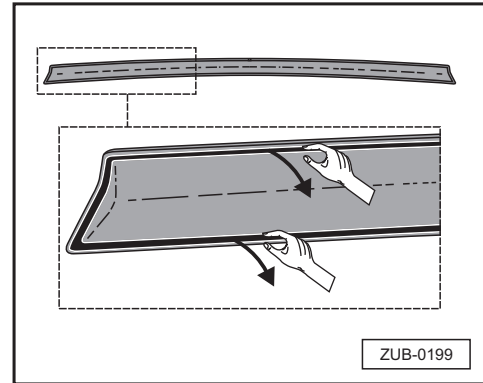


- Remove the adhesive tape as shown in the sketch.
- Sand the rear spoiler near the flute.
- Clean the rear spoiler thoroughly with isopropanol in the flute area.

 **Information**

Sand carefully - do not sand through the paintwork at the edges!

- *Use compressed air to remove sanding dust.*
- *Clean the adhesive surfaces of the rear spoiler and vehicle with isopropanol.*

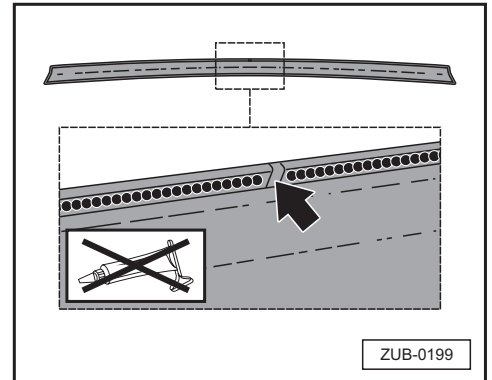
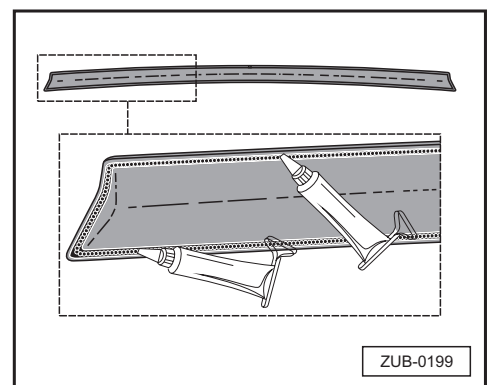
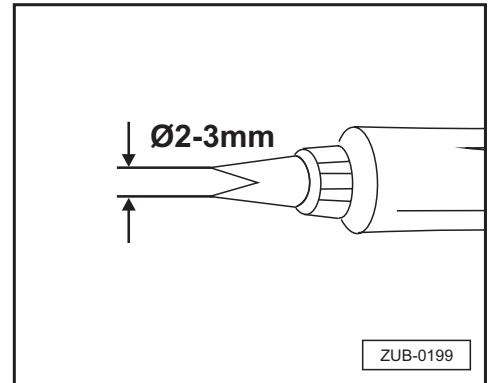


 **Information**

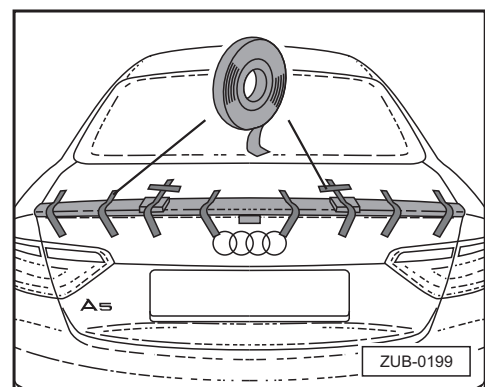
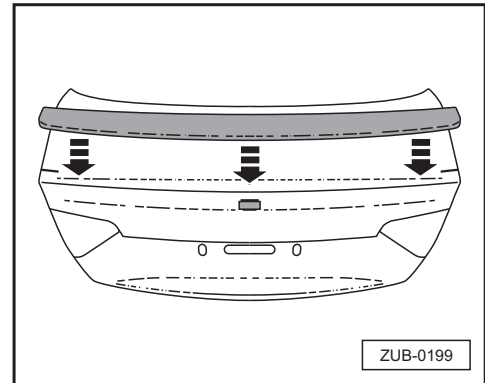
- Cut the tip for the fitting adhesive in the centre of the second stage - arrow.
 - Apply the adhesive with a constant bead of 2 - 3 mm \varnothing on the adhesive surface (flute). The adhesive has to result in a closed sealed surface after fitting. Leave an area of 5 mm free next to the water channel - arrow - on the rear edge of the spoiler.
- Heed adhesive guideline \Rightarrow page 3

 **Information**

- The water channel is required for draining condensation and for pressure compensation in heat/cold.



- Set the rear spoiler on the markings on the tailgate and check the joint pattern. Correct the position of the rear spoiler if necessary.
- Fix the rear spoiler in place using adhesive tape until the adhesive has dried.
- Make sure the joint pattern between the rear spoiler and the tailgate is even, to do this fix the rear spoiler in place with further adhesive tape and e.g. a flat piece of polystyrene if necessary.
- Remove residual adhesive thoroughly using the enclosed spatula, a cotton cloth and isopropanol. Do not forget the areas under the adhesive tape.
- Remove the positioning aid once the fitting adhesive has dried.
- Carry out final optical check of even joint pattern and any escaped fitting adhesive.



 **Information**

- *During the fitting adhesive drying period, check the joint pattern several times and remove any adhesive that may have escaped.*
- Check the water channel for any blockage and clean the opening if necessary.
- Heed the adhesive's reaction time ⇒ page 3, and only remove the fixing elements after 12 hours.
- Enclose installation instructions and certification/expertise as an appendix to the vehicle papers.

5 Enclosures: Certification, expertise

Following the installation instructions you will find:

- ◆ Manufacturer's certification from Audi AG
- ◆ Extract from the EC approval issued by the Federal Department of Motor Vehicles (German abbreviation: KBA)
- ◆ Expertise from TÜV AUTOMOTIVE GmbH (Technical Control Board)



Information

Include the country-specific documents required with the vehicle papers so that these can always be presented on demand to those responsible.