



Installation instructions

Audi A4 2012 ►

**Rear apron,
For scope of delivery 8K0.071.610.A
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⁾ "Rear apron"

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 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

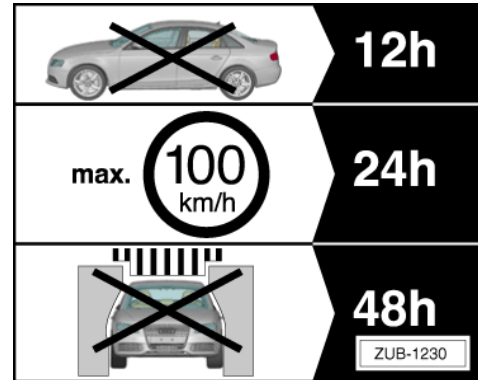


- Use the putty knife provided, together with cotton cloth and isopropanol, to remove any adhesive residue.

⚠ 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 8K0.071.610.A

Comprising:

Units	Part number	Description
1	8K0.071.610.A	Set rear add-on parts, 3-part
2		Expanding plastic rivet 6 x 10
1		Installation instructions

In addition, you will require:

- ◆ Removal lever -80 - 200-
- ◆ Removal wedge -3409-
- ◆ Standard fabric tape/masking tape
- ◆ Audi paint to match the vehicle's colour
- ◆ Cleaning solution D.009.401.04 (isopropanol)
- ◆ Benzine

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

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.

Installation with standard spoiler (standard diffuser)

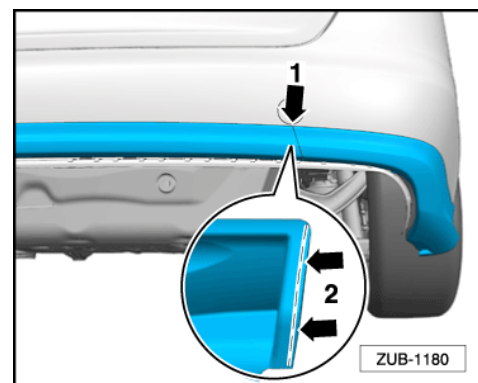
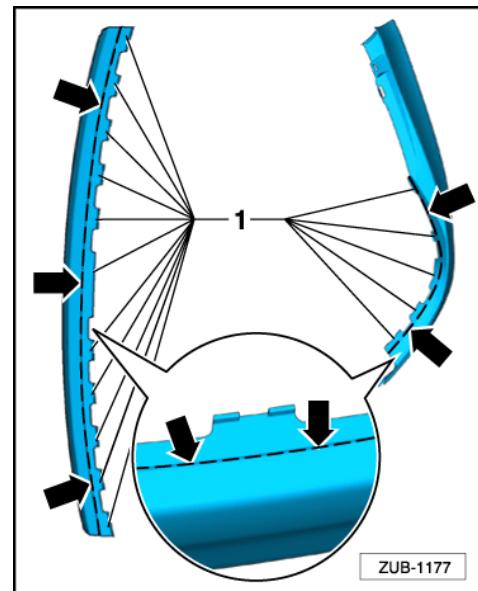
- To install the standard diffuser, the „clip strips“ -1- on the side and the centre add-on part must be removed from the recessed edge -arrows- using workshop tools.
- Re-check for accuracy

Installation with „Audi Genuine Accessories® diffuser“

- To install the „Audi Genuine Accessories® diffuser“, remove the standard spoiler (standard diffuser) ⇒ Installation instructions: diffuser with trim strip, ..., Audi Genuine Accessories®.
- Place the rear apron in the installation position.
- „Audi Genuine Accessories® diffuser“ is installed unpainted ⇒ Installation instructions: diffuser with trim strip, ..., Audi Genuine Accessories®.

All vehicles

- Check all parts for proper fit on the vehicle before painting.
- Check joint -arrow 1-.
- If necessary, adjust the centre part of the apron, left and right, (in the area of -arrows 2-) using workshop tools.
- Mask bonding surfaces.
- Paint the parts to be installed ⇒ [Page 2](#).

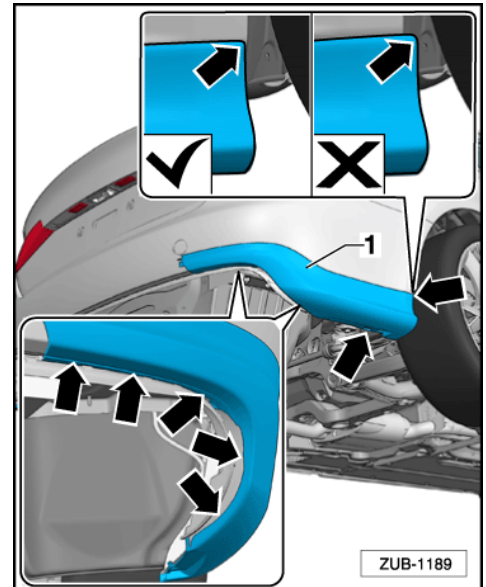


4.2 Install rear apron add-on parts

- Remove standard diffuser (standard spoiler) ⇒ Installation instructions: diffuser with trim strip, ..., Audi Genuine Accessories® or ⇒ Rep. gr. 63.

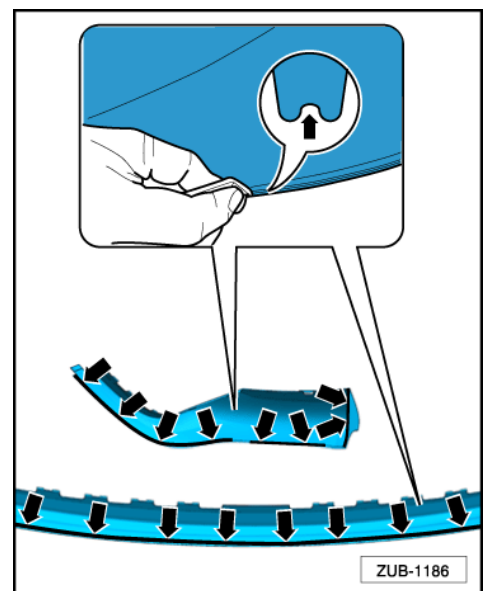


- Place the rear apron add-on parts -1- on the standard bumper and check for an accurate seat and adhesive joint -arrows-.
- Remove rear apron add-on parts.



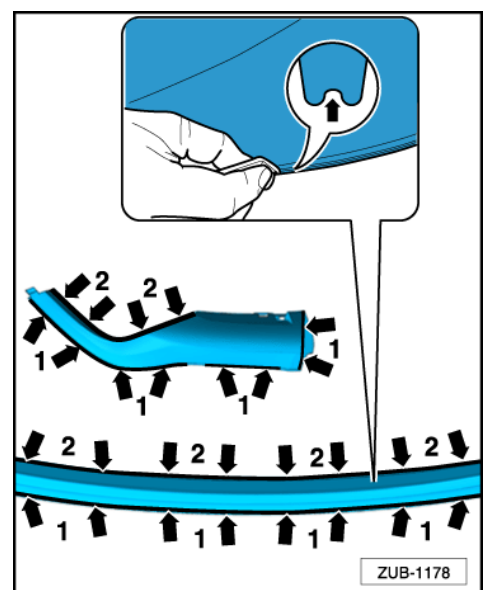
Installation with „Audi Genuine Accessories® diffuser“

- Roughen the adhesive grooves and surfaces on all rear apron add-on parts -arrows-; remove any existing paint.
- Remove sanding dust.
- Thoroughly clean adhesive grooves and surfaces on all rear apron add-on parts on the vehicle, using isopropanol or the cleaning agent provided. Observe airing time.
- Use a clean assembly adhesive applicator tip: clean or exchange tip if necessary.
- Make sure that the adhesive tape to fix the rear apron add-on parts is to hand.
- Apply an even bead of adhesive approx. 5 mm Ø to the bonding surfaces/adhesive grooves -arrows-. Observe the gluing guidelines ⇒ [Page 3](#).



Installation with standard spoiler (standard diffuser)

- Roughen adhesive grooves and surfaces of all rear apron add-on parts -arrows 1- and -arrow 2-; remove any existing paint.
- Remove sanding dust.
- Thoroughly clean adhesive grooves and surfaces on all rear apron add-on parts on the vehicle, using isopropanol or the cleaning agent provided. Observe airing time.
- Use a clean assembly adhesive applicator tip: clean or exchange tip if necessary.
- Make sure that the adhesive tape to fix the rear apron add-on parts is to hand.
- Apply an even bead of adhesive approx. 5 mm Ø to the bonding surfaces/adhesive grooves -arrows 1-. Observe the gluing guidelines ⇒ [Page 3](#).





- Apply an even bead of adhesive approx. 3 mm Ø to the bonding surfaces/adhesive grooves -arrows 2-. Observe the gluing guidelines ⇒ [Page 3](#).

All vehicles

- Place the right rear apron add-on part -1- sideways to the standard bumper, position at the fixed points -arrows 2- and -arrow 3- as far as it will go and align to the wheel arch edge -arrow 4-.
- Fix the rear apron add-on part using adhesive tape.

⚠ Caution

Ensure that entire adhesive groove is filled with adhesive.

- Position the opposite rear apron add-on part in the same way.
- After fixing, re-check the adhesive joint on the installation edge to the diffuser -arrows 2- and correct if necessary.

Installation with „Audi Genuine Accessories® diffuser“

- Apply an even bead of adhesive approx. 5 mm Ø to the bonding surface (adhesive groove) of the centre rear apron segment. ⇒ [Fig. „Installation with „Audi Genuine Accessories® diffuser““ on page 7](#) Observe the gluing guidelines ⇒ [Page 2](#).

Installation with standard spoiler (standard diffuser)

- Apply an even bead of adhesive approx. 5 mm Ø to the bonding surfaces, above and approx. 3 mm Ø to the adhesive surfaces below the centre rear apron ⇒ [Fig. „Installation with standard spoiler \(standard diffuser\)“ on page 7](#). Observe the gluing guidelines ⇒ [Page 2](#).

All vehicles

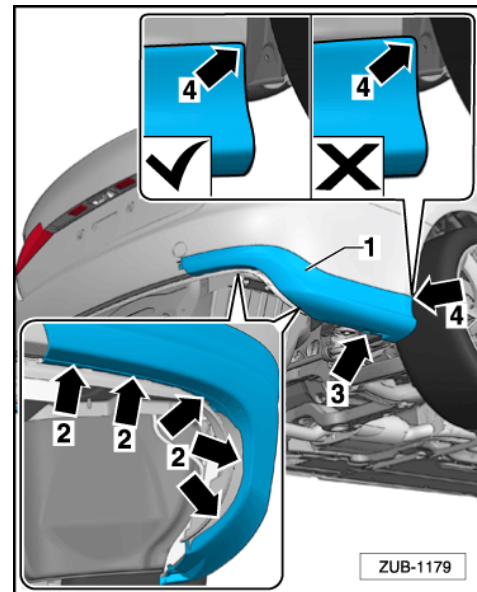
- Hold centre rear apron segment in place, centre and secure with adhesive tape until the adhesive has cured.

⚠ Caution

Ensure that entire adhesive groove is filled with adhesive.

Installation with „Audi Genuine Accessories® diffuser“

- Install diffuser straightaway ⇒ Installation instructions: diffuser with trim strip, ..., Audi Genuine Accessories®.
- Check the centre rear apron add-on part as with the side rear apron add-on parts for even adhesive jointing and seating, correct and clean as required.





- Drill \varnothing 6 mm hole -arrow-, insert and close expanding rivet.
- Use the putty knife provided, together with cotton cloth and isopropanol, to remove any adhesive residue.

To allow the adhesive to cure, secure rear apron segments in place and remove any excess adhesive:

- Ensure that the adhesive joint -arrows- between the bumper and rear apron is even; secure the rear apron with additional tape if necessary.

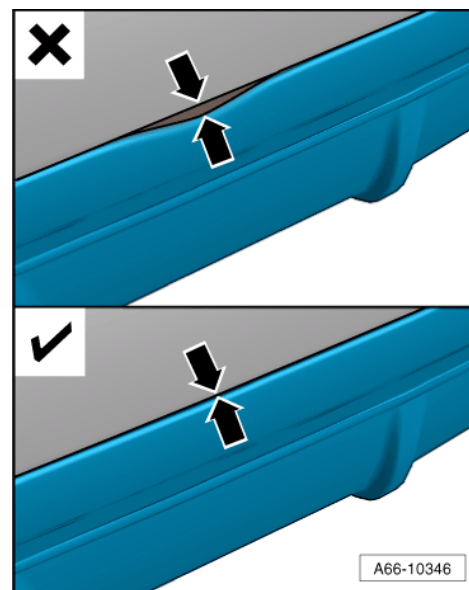
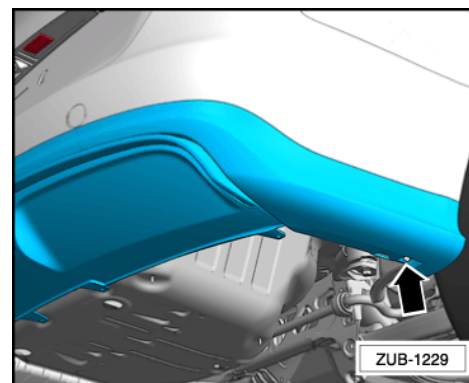
***i* Note**

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

- Carry out a final visual check for even adhesive joints and excess adhesive (do not forget the areas underneath the adhesive tape).

***i* Note**

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





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.