

Audi A8 1994 ➤

General Body Assembly, Exterior (Rep. groups 50, 55, 57, 58, 60, 63, 64, 66)

Edition 05.1998



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List of Workshop Manual Repair Groups

Audi A8 1994 ➤

General Body Assembly, Exterior (Rep. groups 50, 55, 57, 58, 60, 63, 64, 66)

Repair Group

50 - Body front

55 - Bonnet, Flaps

57 - Front doors/Door components/Central locking system

58 - Rear doors/Door components

60 - Sliding/tilting roof

63 - Bumpers

64 - Glazing

66 - Exterior equipment



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Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.

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50 - Body front

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

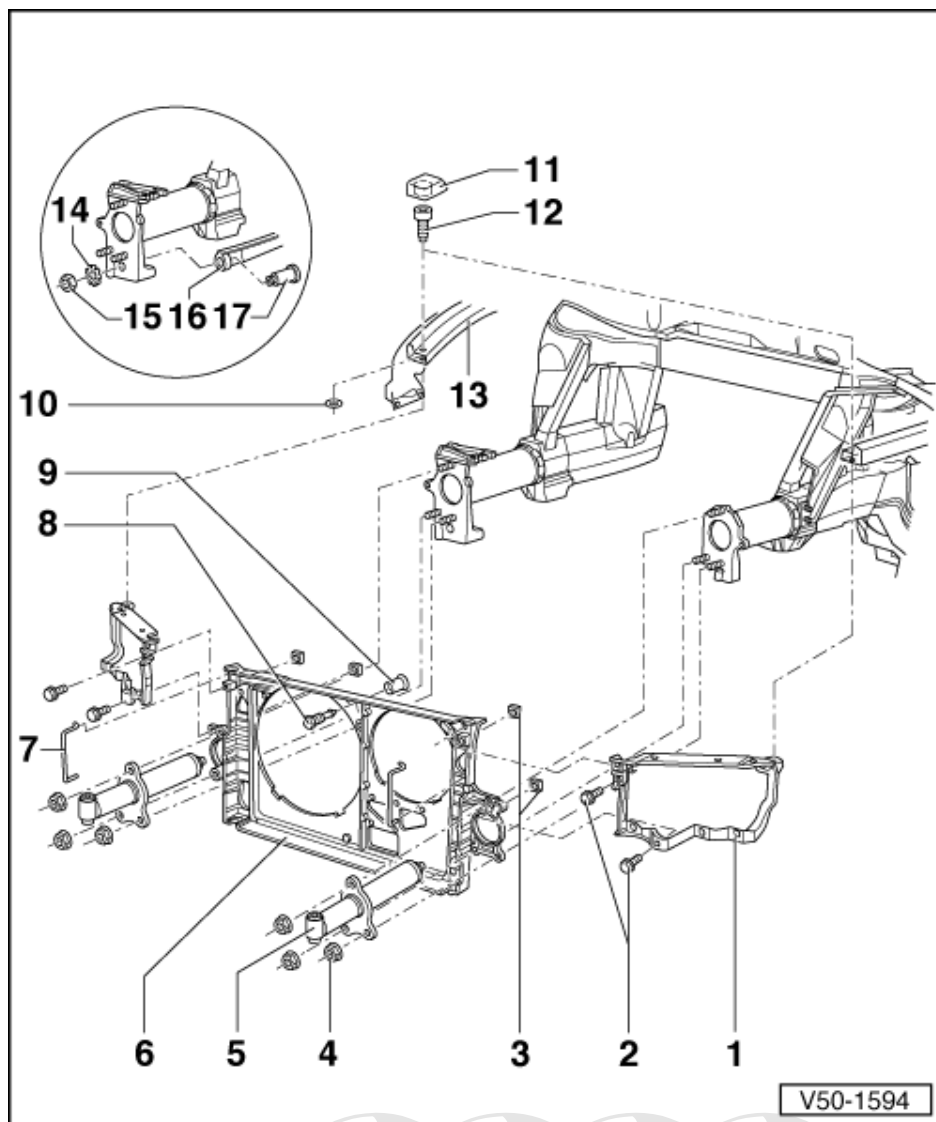
Important

- ◆ **Use only genuine Audi A8 Parts.**
- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**

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2 - Body, front

2.1 - Body, front



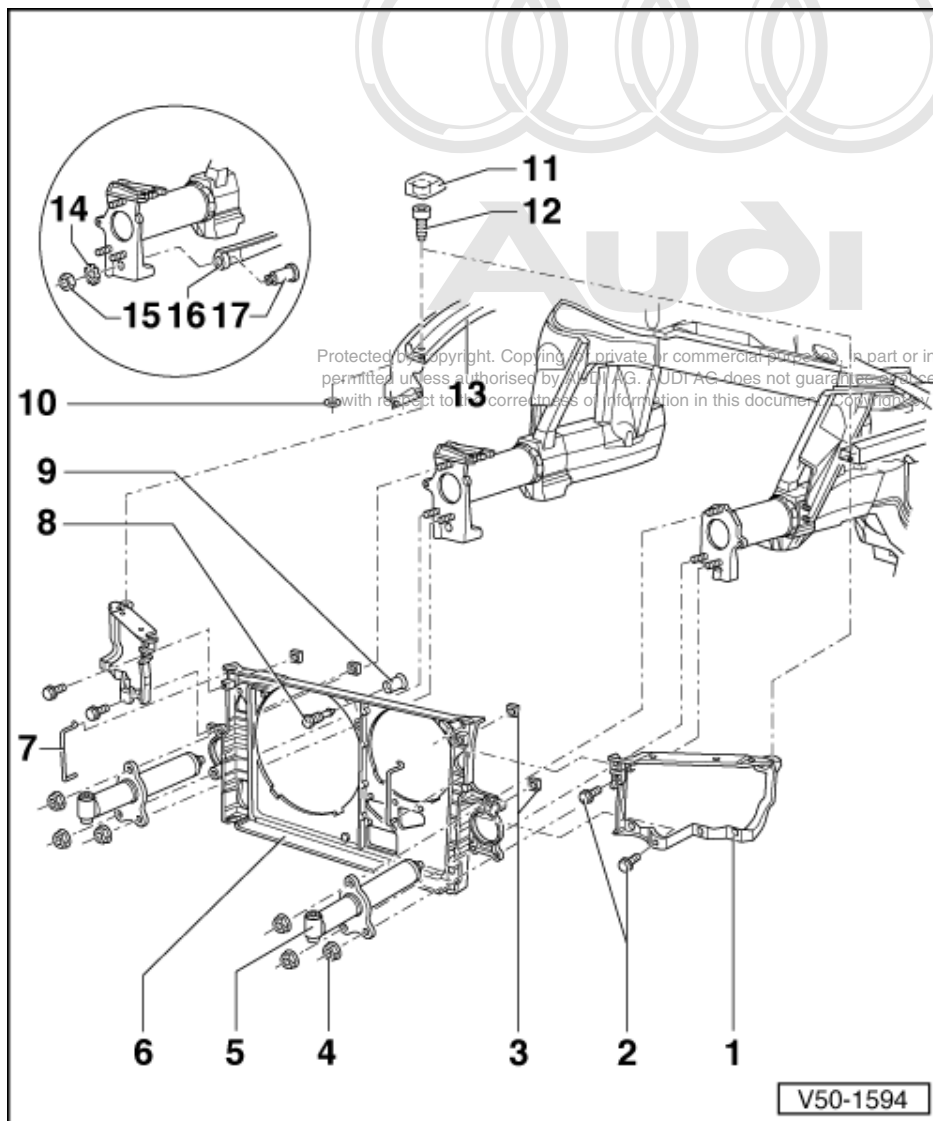
2.2 - Removing and installing radiator and headlight surrounds

1 Headlight surround

- ◆ Can be removed separately
- ◆ Removing:
- Headlight removal:

=> Electrical System; Repair group 94; Servicing headlights; Removing and installing headlights Servicing headlights Removing and installing headlights

- Disengage and expose bonnet cable.
- To remove the left surround, unscrew the power steering cooling coil from radiator.
- Remove locking lever -item 7- for lock pin.
- Detach buffer stop -item 11, and unscrew bolts -item 12- and -item 2-



2 Combi bolt - 6 Nm

- ◆ 4 off

3 Square nut

- ◆ 4 off

4 Nut- 14 Nm

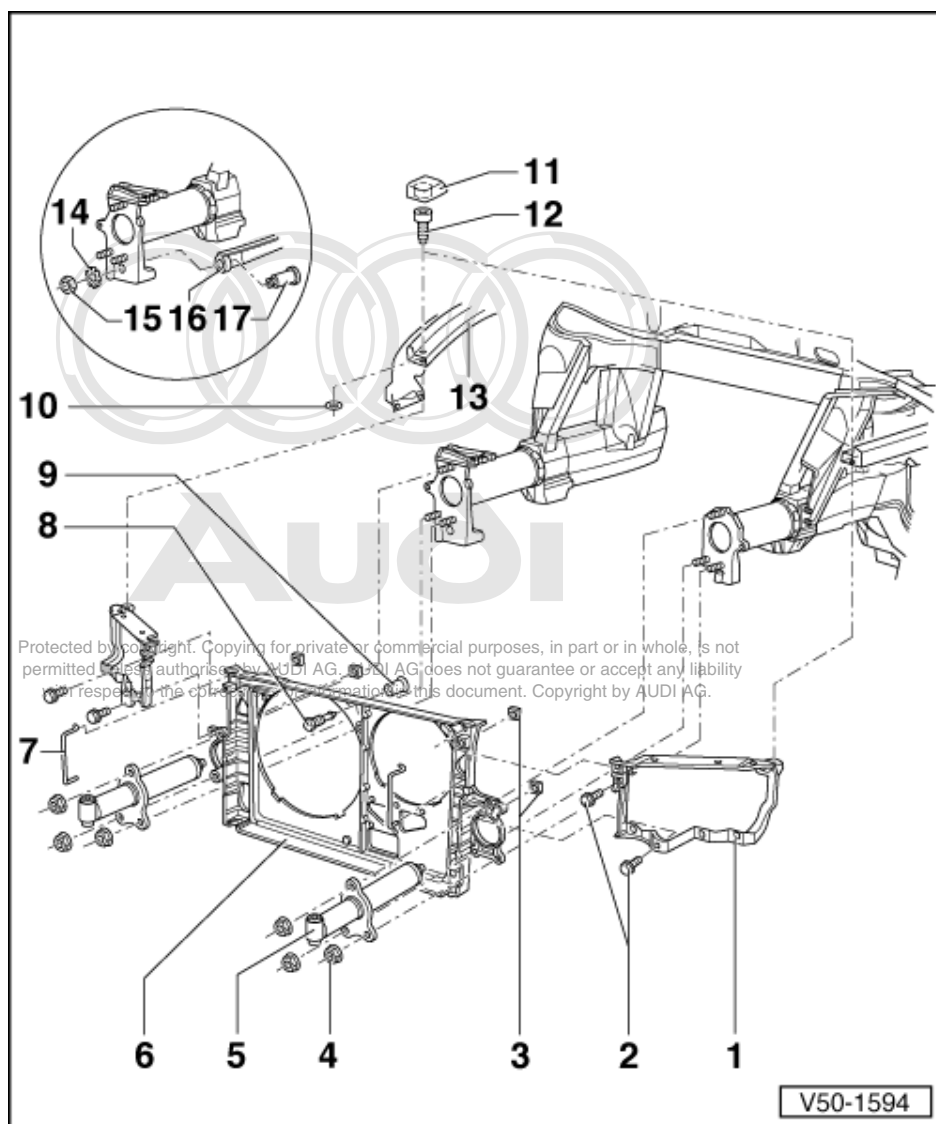
- ◆ Model year 1994 for attaching impact absorber -item **5** - to longitudinal member
- ◆ 6 off

4 - Bolt - 24 Nm

- ◆ Model year 1995 onwards for attaching impact absorber- item **5** - to longitudinal member
- ◆ 6 off

5 Impact absorber

- ◆ 2 off
- ◆ Removing bumper to take out impact absorbers => Page **129**
- ◆ Checking => Page **159**

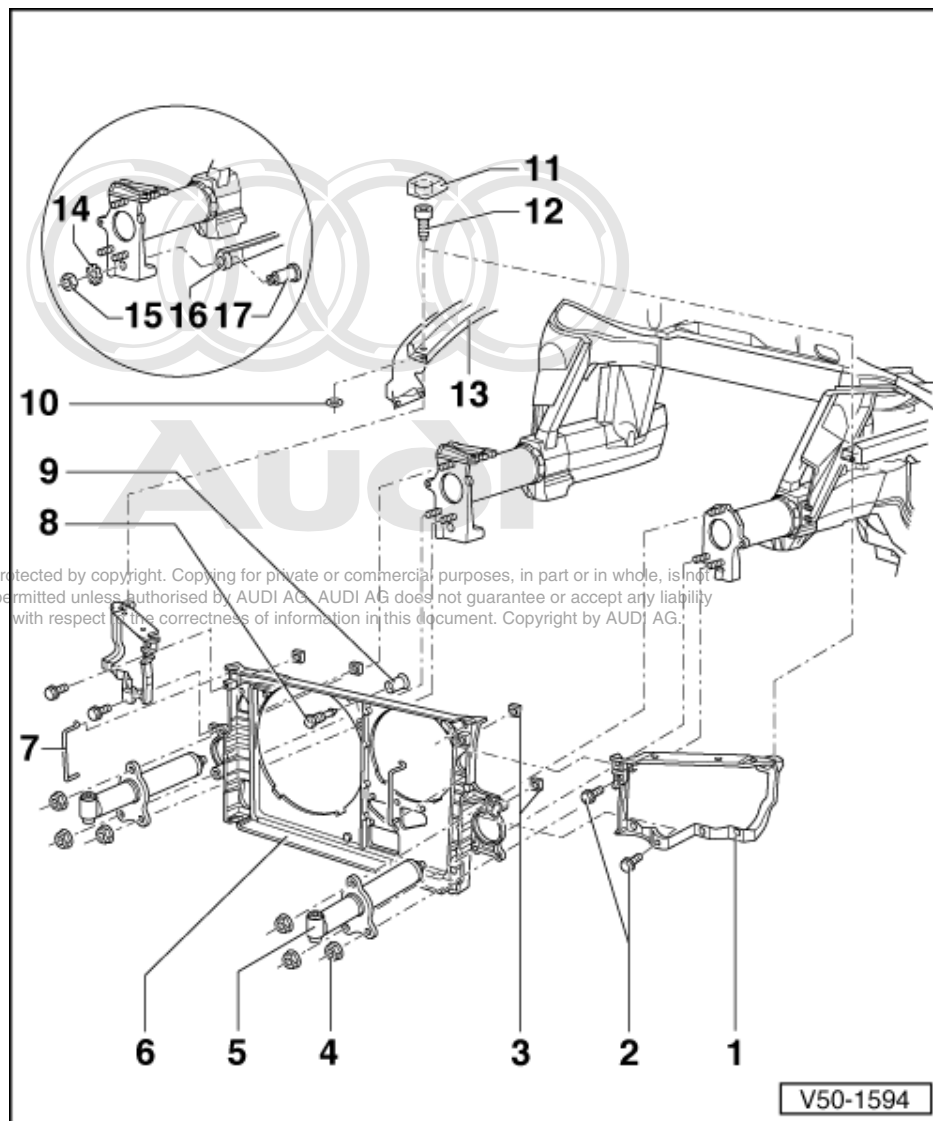


6 Radiator surround

- ◆ Removing:
 - Remove noise insulation => Page 10 .
 - Removing bumper
=>Page 129 .
 - Remove headlight surround -item 1 -.
 - Draining coolant:

=> Engine, Mechanical Components; Repair group 19

- Pull hoses and connectors off radiator.
- Remove radiator fans.
- Where fitted, remove the condenser; do not disconnect/open refrigerant pipes.
- Where fitted, remove ATF cooler.
- Remove radiator.
- Remove impact absorber, -item 5 -.
- ◆ Install in reverse order



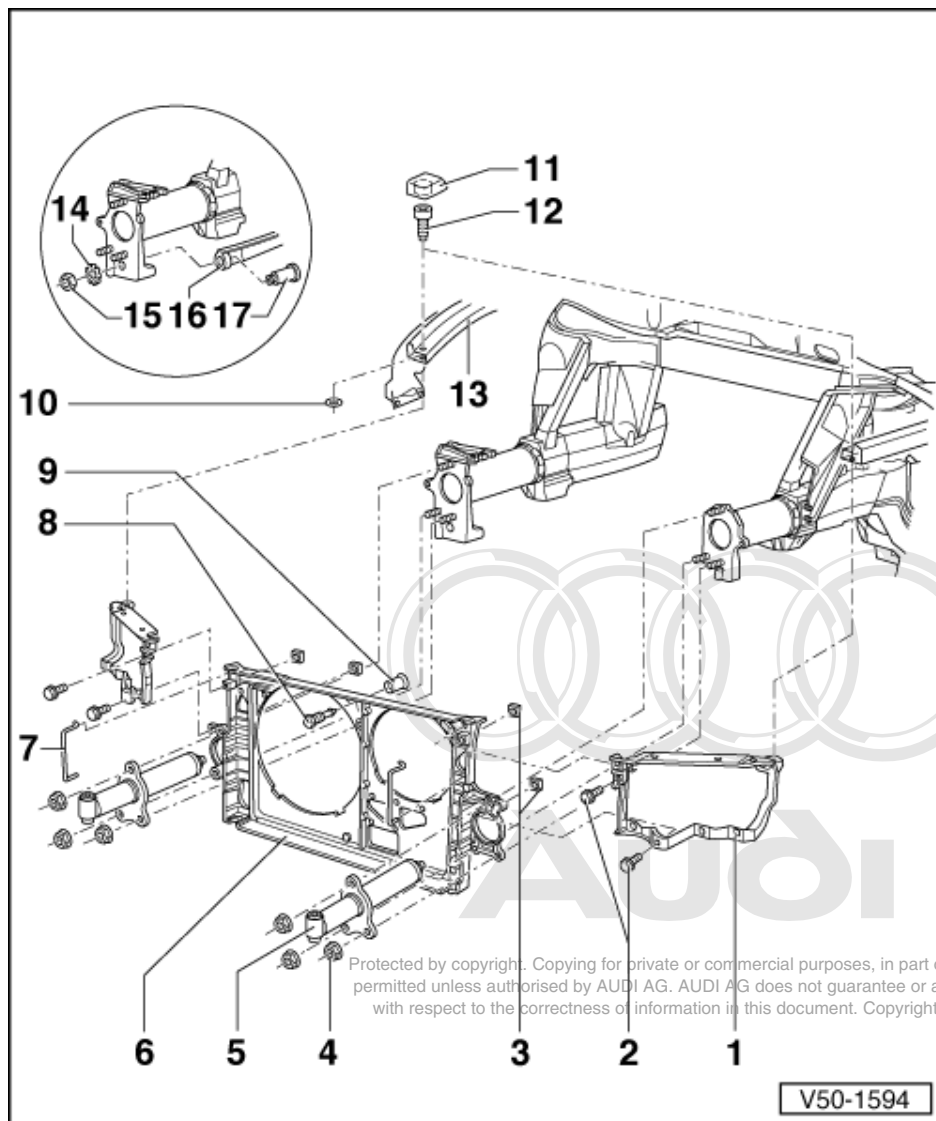
7 Locking lever

- ◆ For lock pin
- ◆ 2 off
- ◆ Disengaging bonnet cable from locking lever and guide clips
=>Page 13.
- ◆ Removing:
 - Lever locking lever over headlight surround at bottom and pull out to front.
 - Unscrew locking lever towards engine.

8 Stud bolt - 30 Nm

9 Sleeve

10 Washer



11 Stop buffer

- ♦ 2 off

12 Hexagon socket-head bolt - 14Nm

- ♦ 2 off

13 Fastening strip

- ♦ For wing

14 Locking plate

- ♦ Replace

15 Nut- 100 Nm

16 Mounting

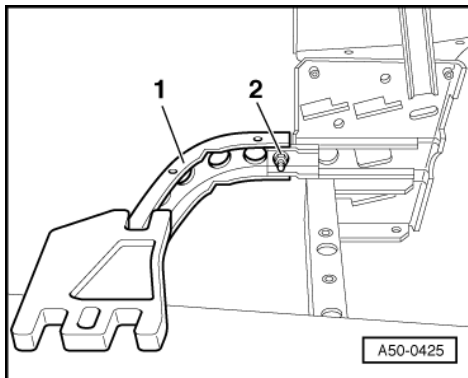
- ♦ For towing eye

17 Sleeve

2.3 - Removing and installing left and right support bracket

- Bumper removed =>Page 129

Note:



-> On 02.97 ▶ vehicles, the brace -1- for support bracket can be renewed separately; tightening torque for bolted joint -2-: 15 Nm.

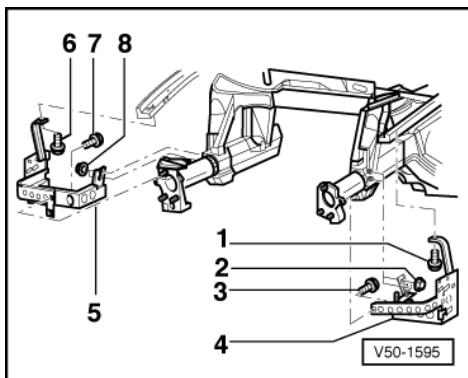
Removing left support bracket:

- Unfastening the bolting-on points for ABS hydraulic unit:

=> FWD and 4WD Running Gear; Repair group 45; General Repair Information; Hydraulic unit and brake pipes
 General Repair Information Hydraulic unit and brake pipes

- Unfastening bolting-on points for air-conditioner reservoir:

=> Air Conditioner; Repair group 87; Servicing refrigerant circuit; Removing and installing reservoir Servicing refrigerant circuit Removing and installing reservoir



- -> Unscrew combi bolts -1- and -3- (23 Nm).
- Screw out (23 Nm) nut -2-.
- Detach left support bracket -4-.

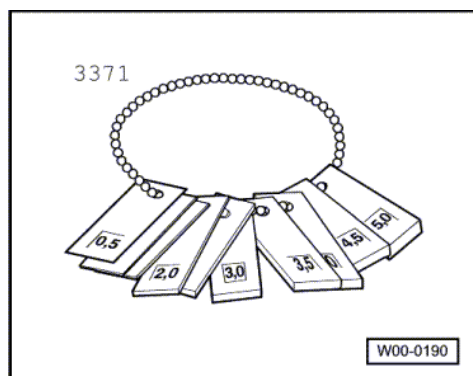
Removing right support bracket:

- Unfastening reservoir for windscreen washer system :

=> Electrical System; Repair group 92; Servicing windscreen washer system; Removing and installing reservoir Servicing windscreen washer system Removing and installing reservoir

- Unscrew combi bolts -6- and -7- (23 Nm).
- Screw out (23 Nm) nut -8-.
- Detach right support bracket -5-.

2.4 - Removing and installing wing



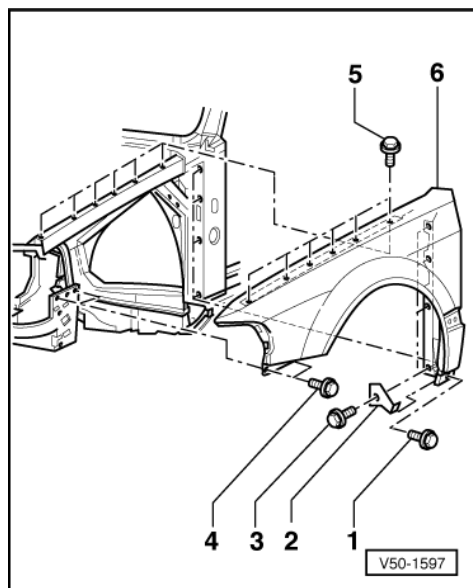
Special tools, testers and auxiliary items required

- ♦ Special tool 3371

Removing

- Removing bumper => Page 129 .
- Removing front wheel housing liner => Page 212 .
- Removing front turn-signal indicator:

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=> Electrical System; Repair group 94; Servicing front turn-signal indicators; Removing and installing turn-signal indicators Servicing front turn-signal indicators Removing and installing turn-signal indicators

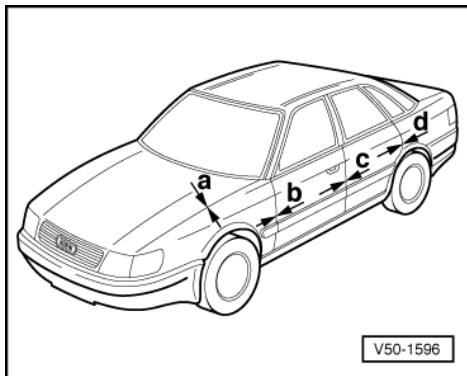
- Removing side turn-signal indicator:

=> Electrical System; Repair group 94; Side turn-signal indicators; Removing and installing side turn-signal indicator Side turn-signal indicators Removing and installing side turn-signal indicator

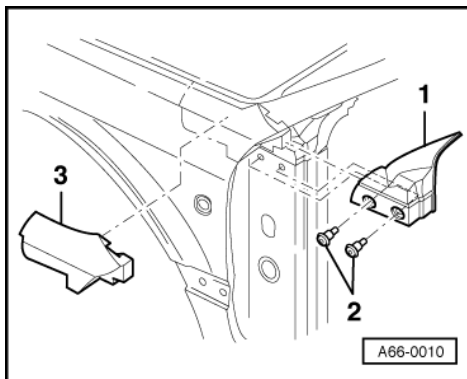
- -> Unscrew combi bolts -1-, -4- and -5- (9.5 Nm).
- Unscrew combi bolt -3- at retaining plate -2- (9.5 Nm).
- Detach wing -6-.

Installing

Installation is carried out in the reverse order; note the following:



- -> Set joint dimensions:
 - Dimension a = 3.5 mm
 - Dimension b = 3.5 mm



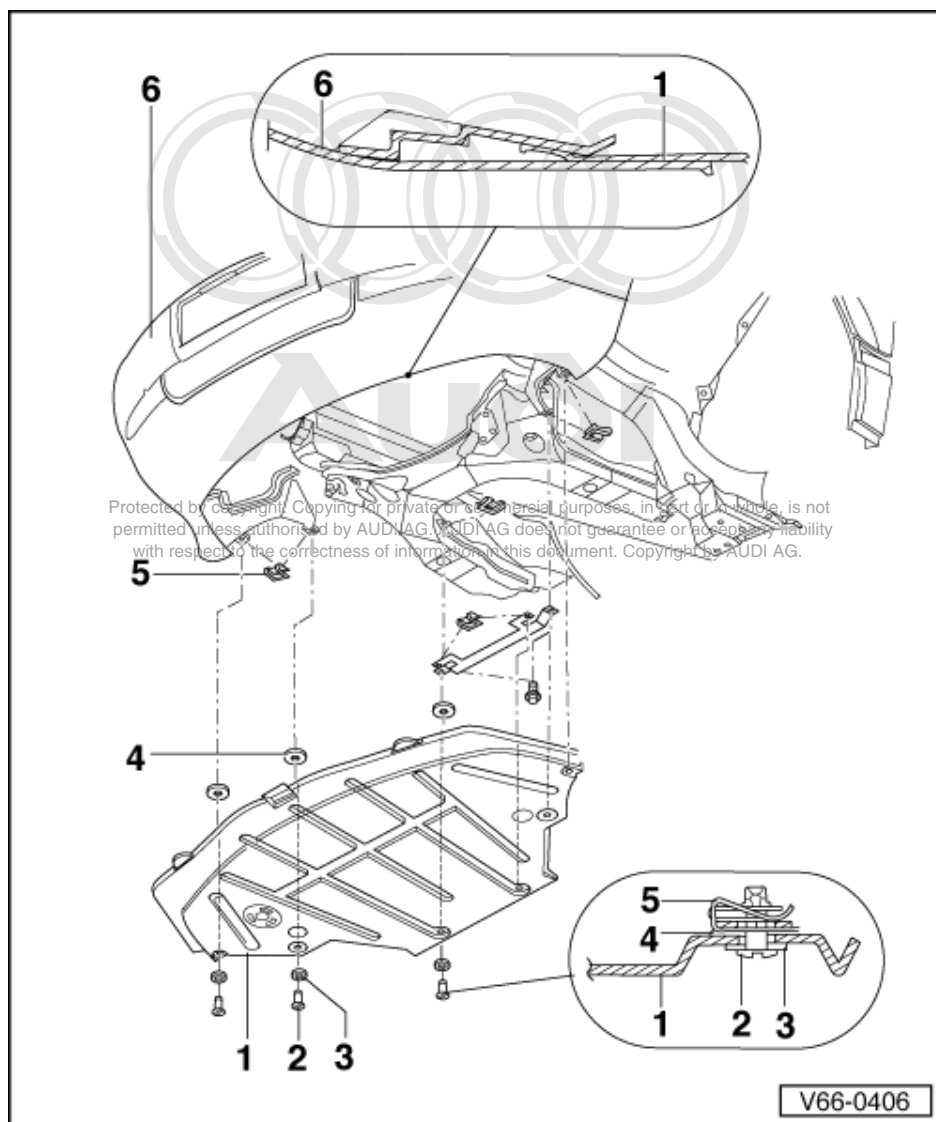
- -> Insert filler piece -3- in wing before installing wheel-housing liner.



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2.5 - Removing and installing noise insulation



1 Front noise insulation

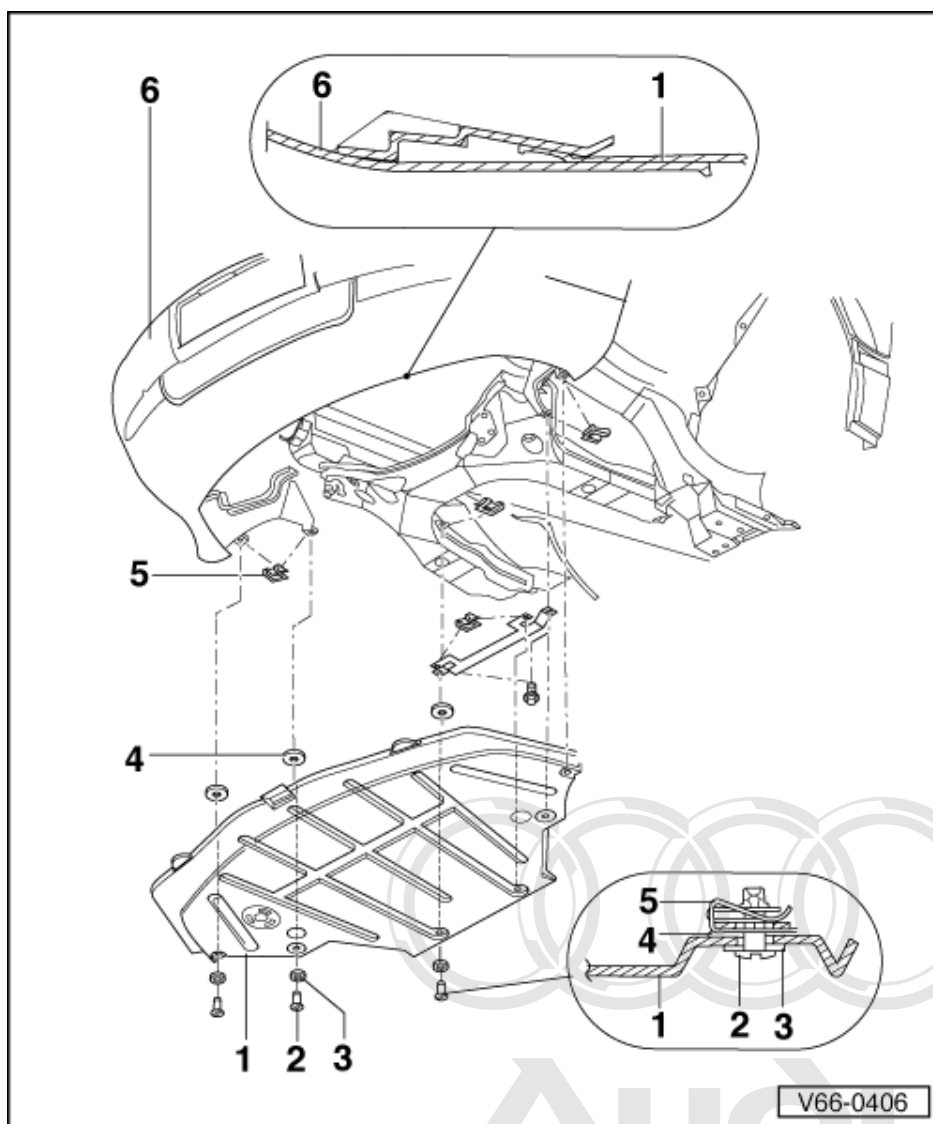
- ◆ Removing:
 - Quick release bolt
 - item 2 -
 - Pull noise insulation downwards slightly and take out to rear
- ◆ When installing, slide noise insulation over bumper -item 6- into holders, as shown in magnified view

2 Quick release bolt

- ◆ 6 off

3 Washer

- ◆ 6 off



- 4 Locking plate**
 ♦ 6 off
5 Snap nut
6 Bumper

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55 - Bonnet, Flaps

1 - Contact corrosion

1.1 - Contact corrosion

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In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

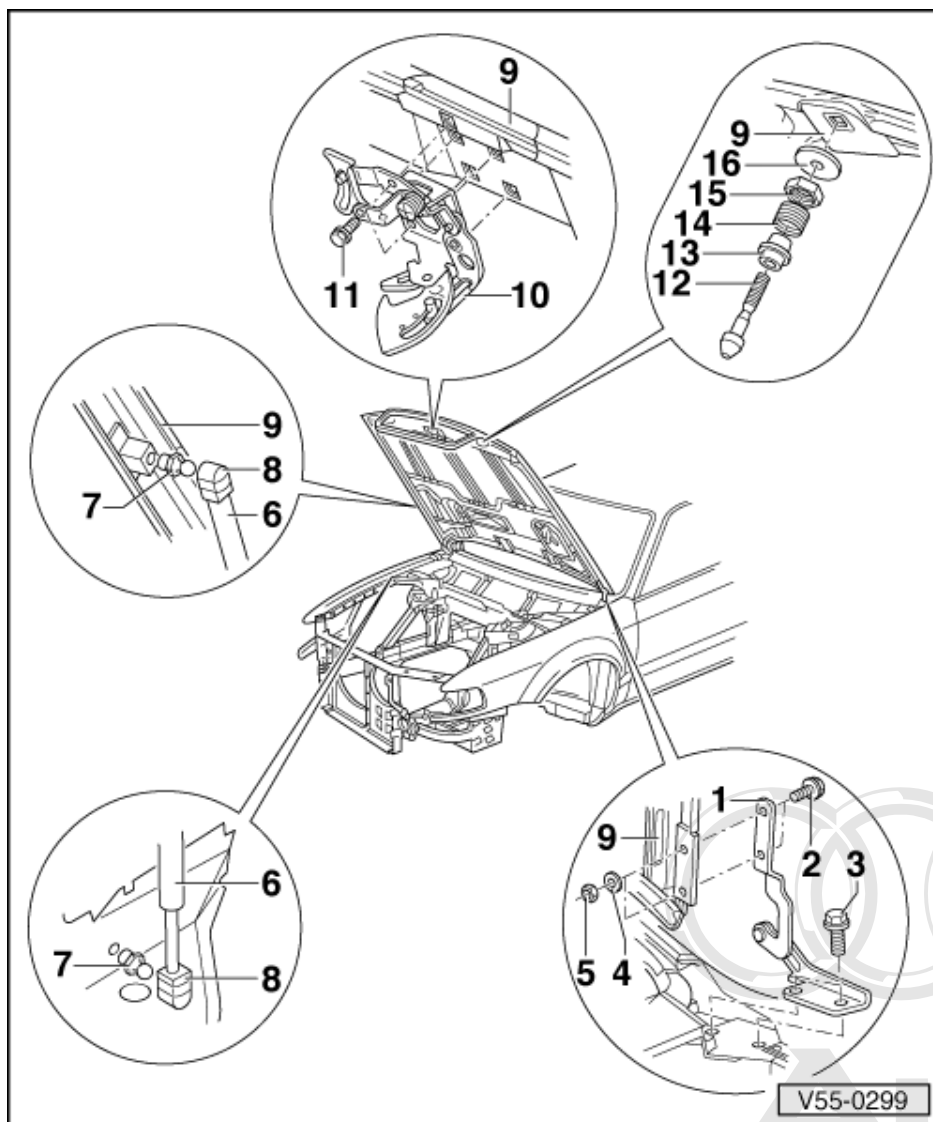
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- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**

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2 - Bonnet

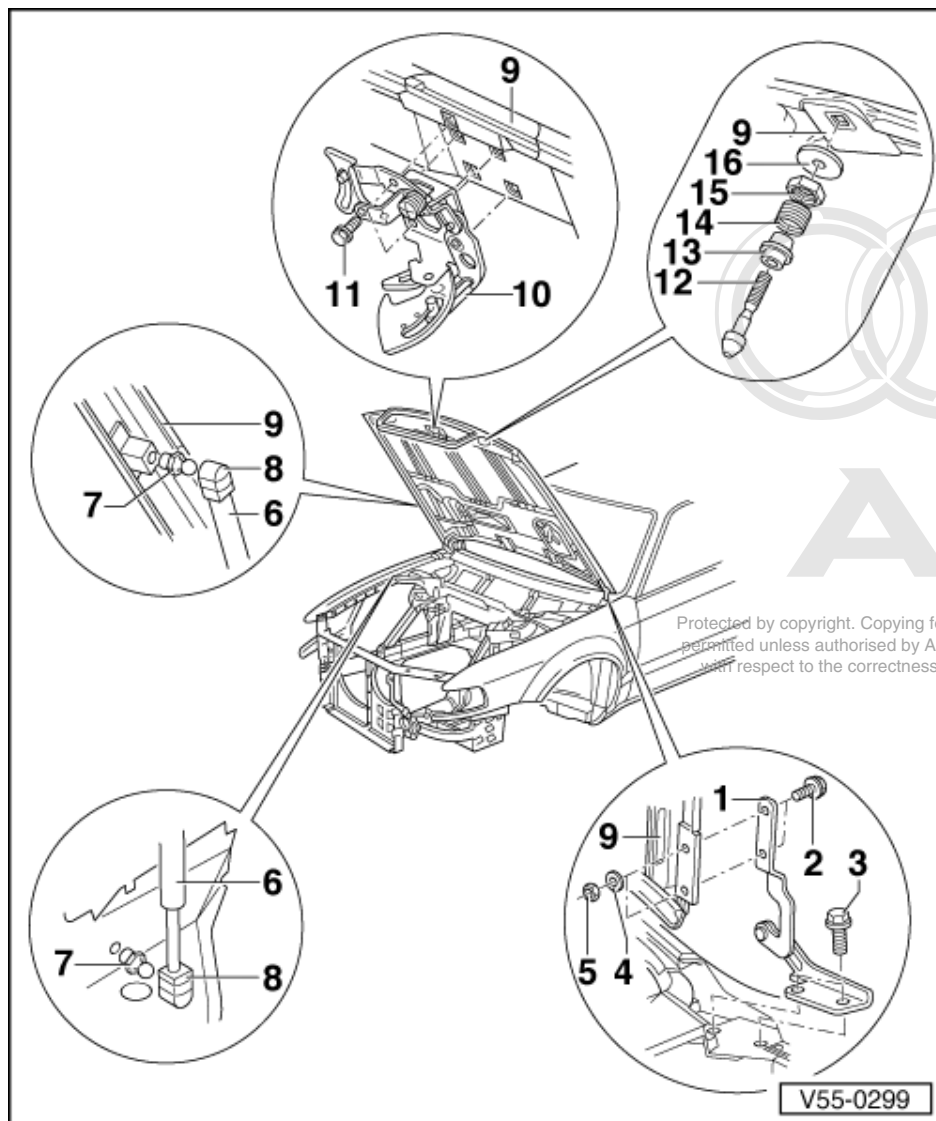
2.1 - Bonnet



2.2 - Bonnet, lock pin and arrester release mechanism

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- 1 Bonnet hinge
- 2 Combi bolt
 - ♦ 2 off
- 3 Combi bolt - 21 Nm
 - ♦ 2 off
- 4 Washer
 - ♦ 2 off
- 5 Hexagon nut- 21 Nm
 - ♦ 2 off



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6 Gas-filled strut

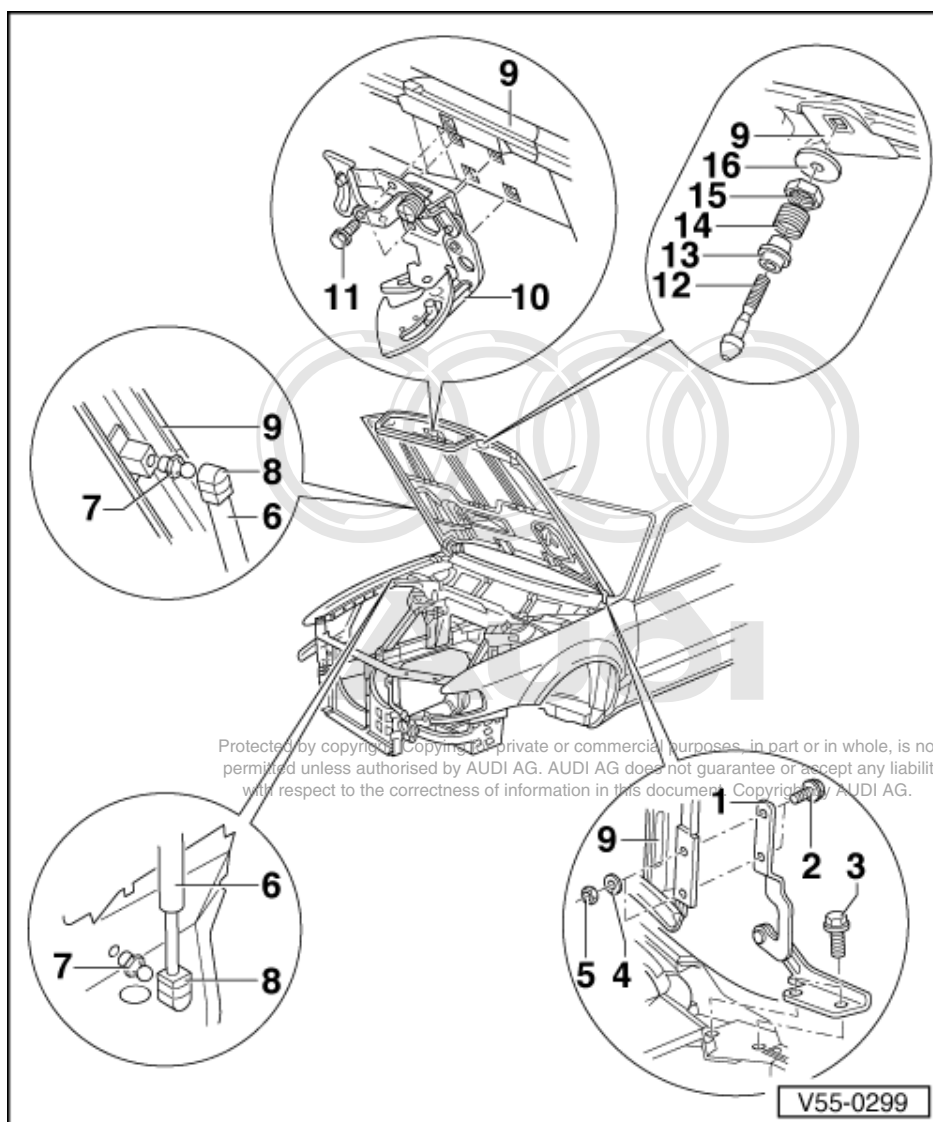
- ◆ Removing:
 - Open and support bonnet -item 9 -.
 - Use a screwdriver to lever off retainer -item 8 -.
 - Detach gas-filled strut.
- ◆ Releasing gas from gas-filled strut
=>Fig. 1

7 Ball pin - 10 Nm

- ◆ Remove gas-filled strut -item 6 -.

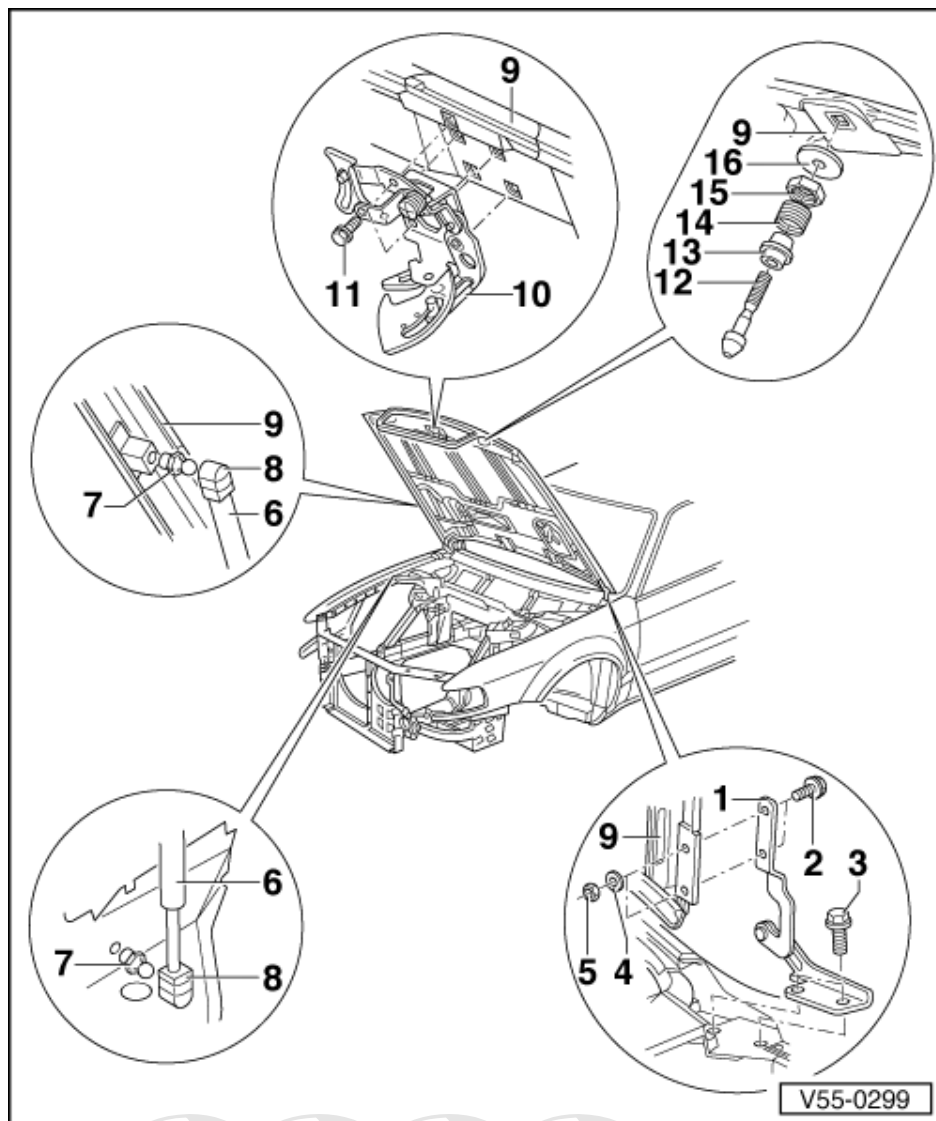
8 Securing spring

- ◆ 2 off



9 Bonnet

- ◆ LHD and RHD bonnets differ
- ◆ Removing:
 - Open and support bonnet.
 - Detach electrical connectors.
 - Detach gas-filled struts -item 6 - at bonnet.
 - Unscrew bolts -item 2 - and detach bonnet.
- ◆ Adjusting:
 - Height is adjusted at the rear by means of bolts -item 2 -.
 - Height is adjusted at the front by means of lock pins -item 12 -.
 - Lateral and longitudinal adjustment is performed by means of bolts -item 3 -.
- ◆ Adjusting => Page 18



10 Arrester

11 Combi bolt - 8 Nm

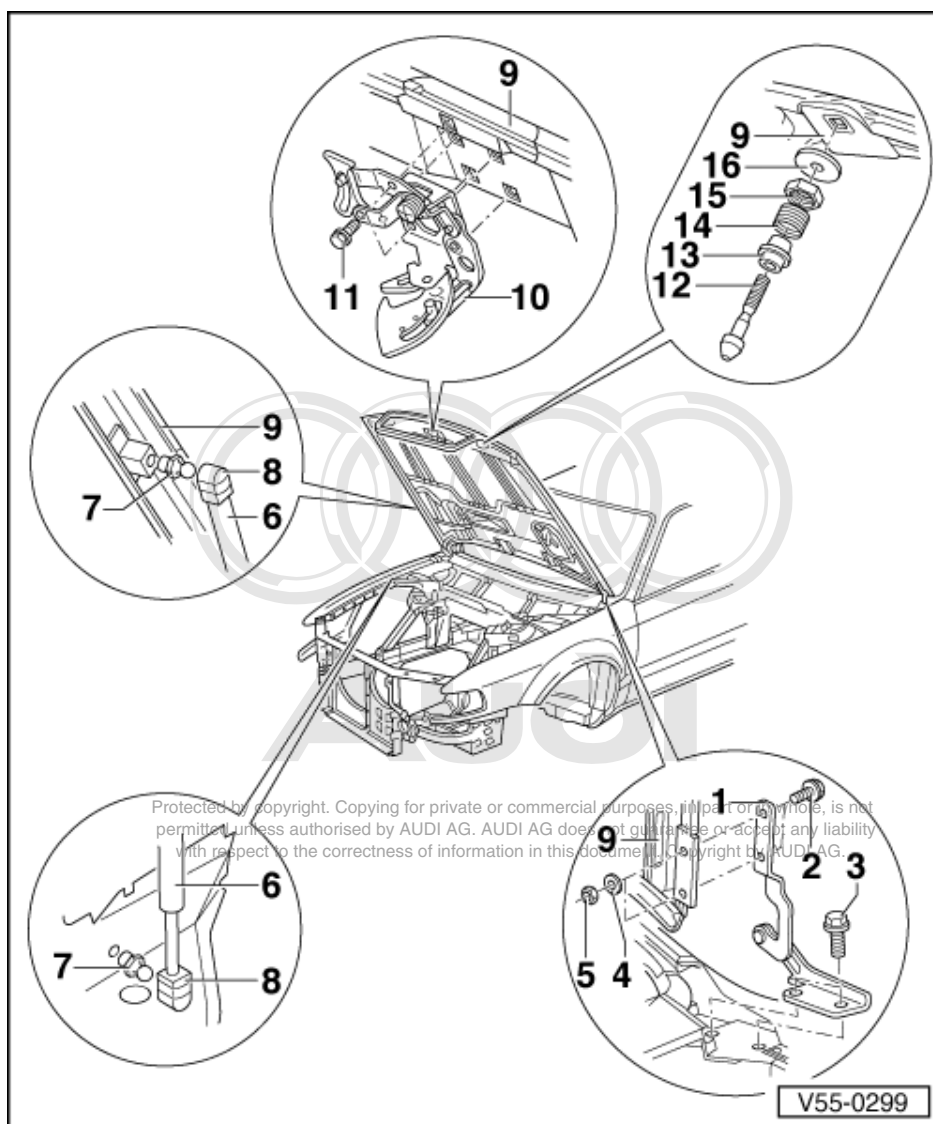
- ◆ 5 off

12 Lock pin

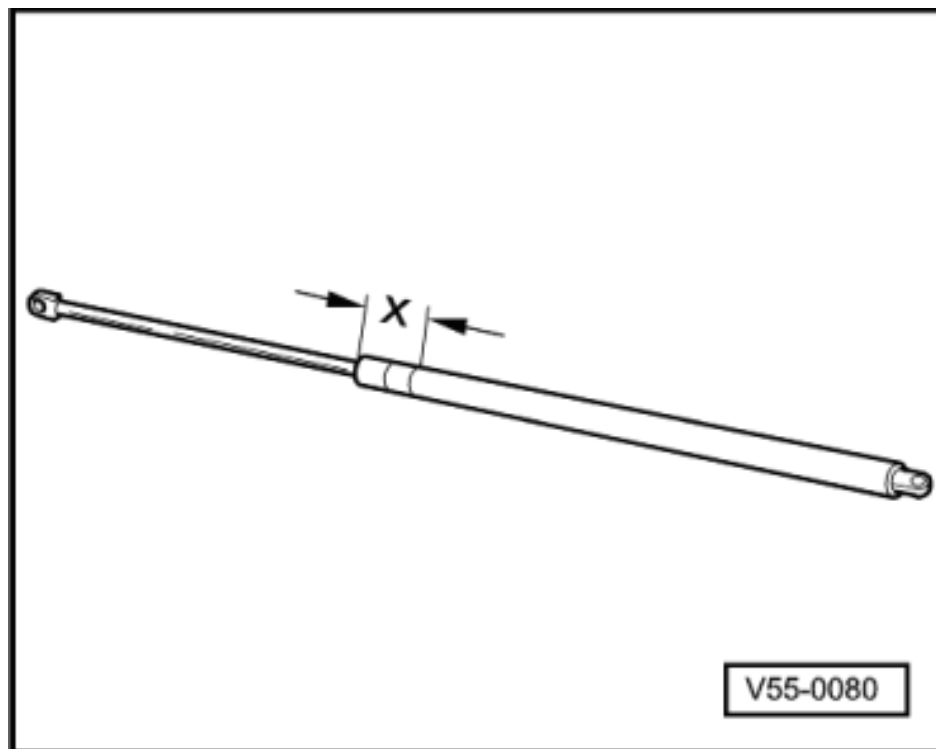
- ◆ Adjusting:

- Tighten castle nut -item **15** - so that lock pin can still move slightly.
- Roughly adjust depth of lock pin with screwdriver.
- Checking setting of bonnet cable
=>Page **20**.
- Carefully close bonnet.
- The bonnet must be at the same height as wing. If not, adjust lock pin.
- Open bonnet, adjust lock pin and tighten castle nut -item **15** -.

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- 13 Guide bush
- 14 Spring
- 15 Castle nut - 10 Nm
- 16 Washer



-> Fig.1 Releasing gas from gas-filled strut

- Clamp gas-filled strut in vice in area x = 50 mm.

Important

Only clamp the strut in this area. Otherwise there is risk of accident.

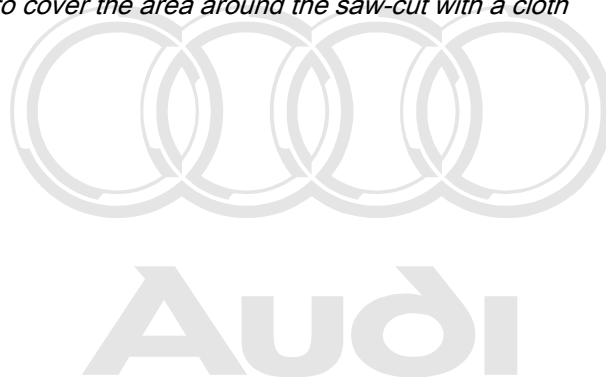
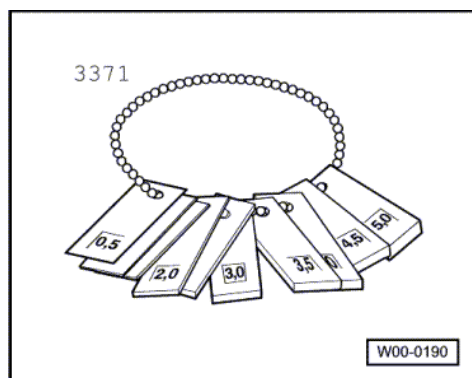
- Saw through cylinder of telescopic strut in first third of overall cylinder length - starting from reference edge on piston rod side.

Note:

Goggles must be worn during sawing. It is also appropriate to cover the area around the saw-cut with a cloth to catch any escaping fluid.

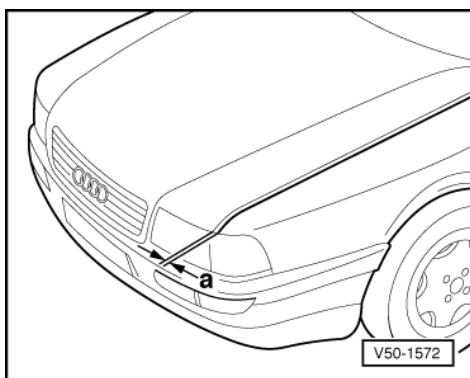
2.3 - Adjusting bonnet

Special tools, testers and auxiliary items required



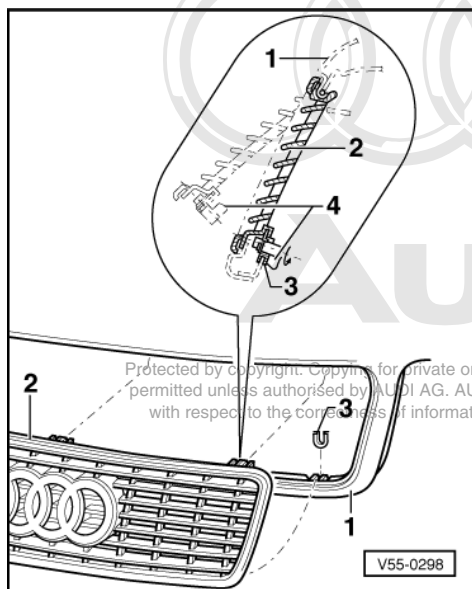
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- ◆ Special tool 3371



- Set left and right of bonnet to same joint dimension.
 - -> Distance a = 3.5 mm

2.4 - Removing and installing radiator grille

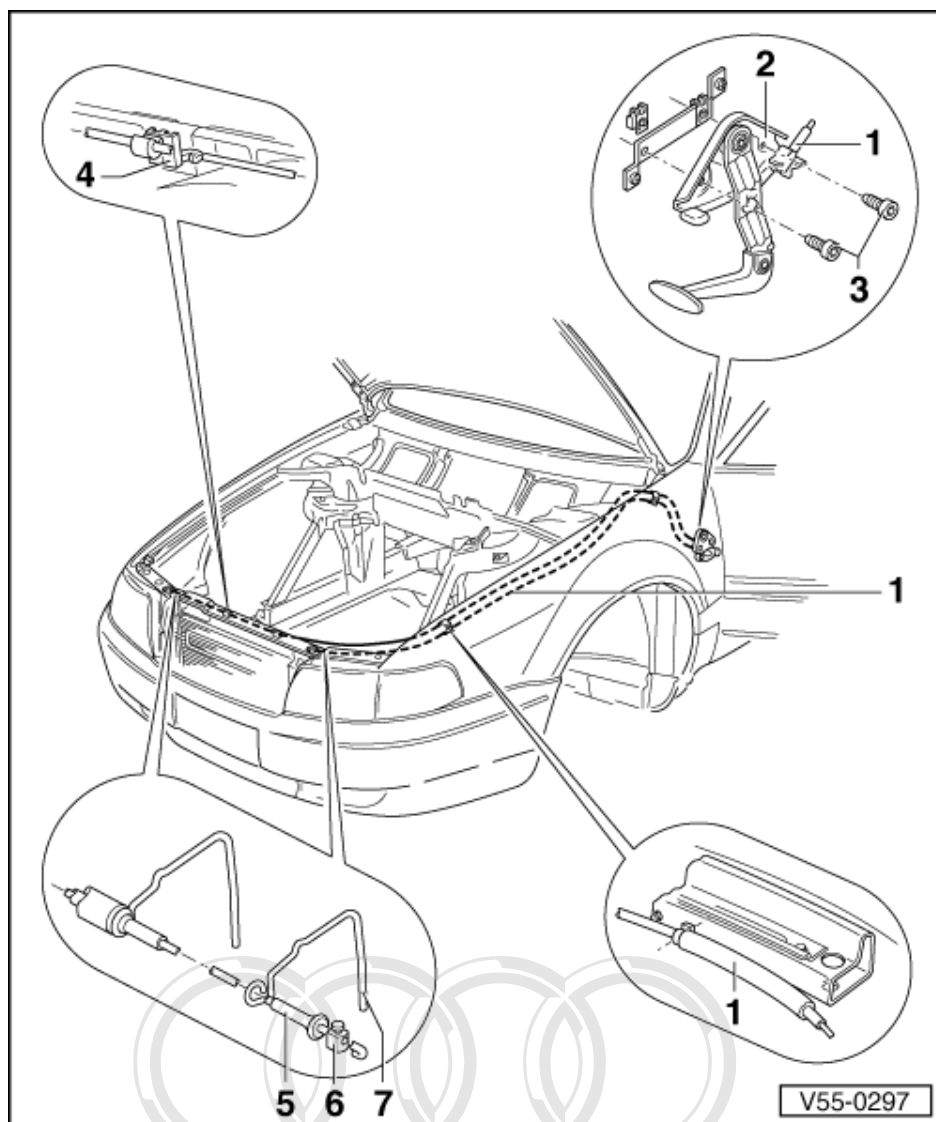


- -> Turn the three rotary catches -4- through 180°.
- Detach radiator grille -2-.

Note:

The guide plates -3- are inserted in the bonnet -1-.

2.5 - Removing and installing bonnet lock cable

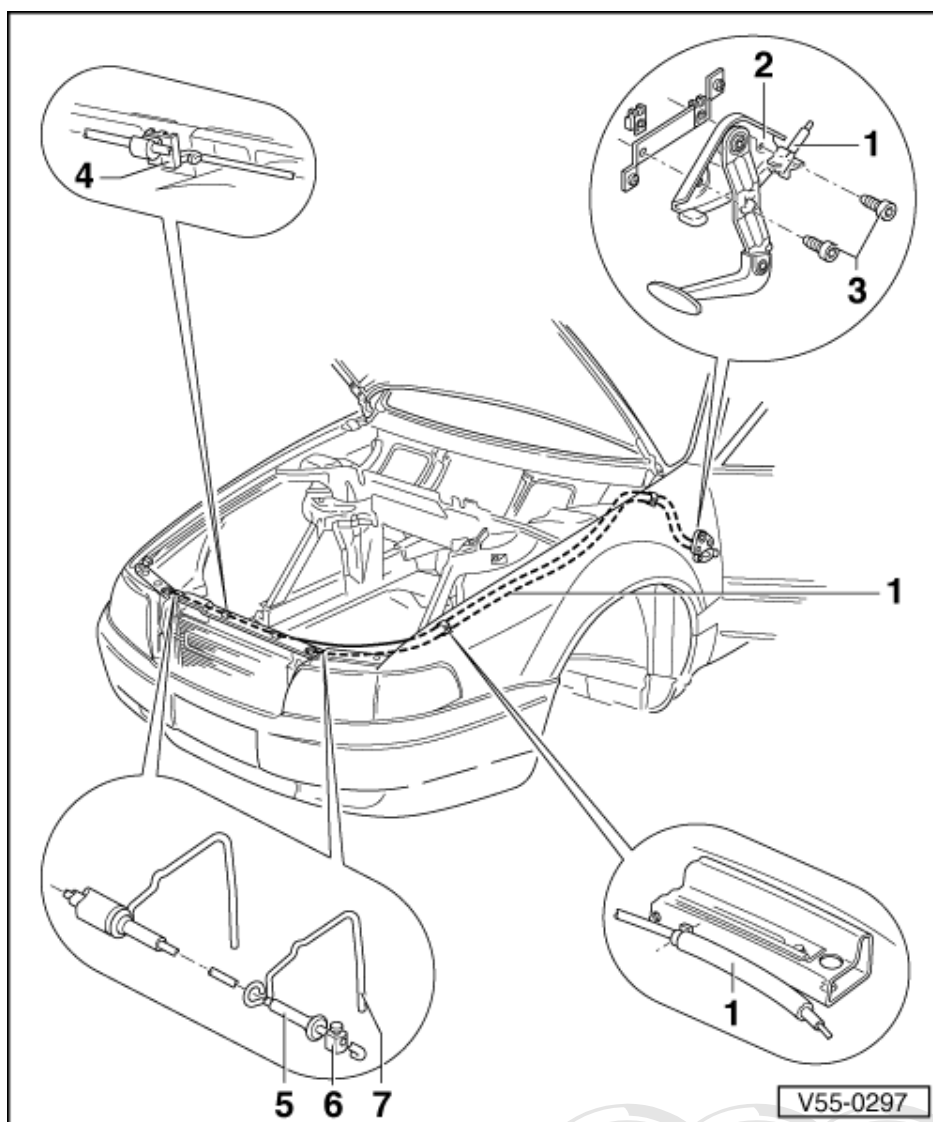


1 Cable for bonnet

- ◆ Removing:
- Removing driver's storage compartment:

=> General Body Assembly, Interior; Repair group 68; Storage compartments, covers; Removing driver's storage compartment Storage compartments, covers Removing driver's storage compartment

- Remove bolts - **3** -.
- Remove clamp fitting -item **6** -.
- Unfasten cable from clip -item **4** -, route through bulkhead, unclip from actuator -item **2** - and disengage.
- ◆ Adjusting:
- Insert cable without pretensioning the locking lever -item **7** - and secure with clamp fitting -item **6** -.

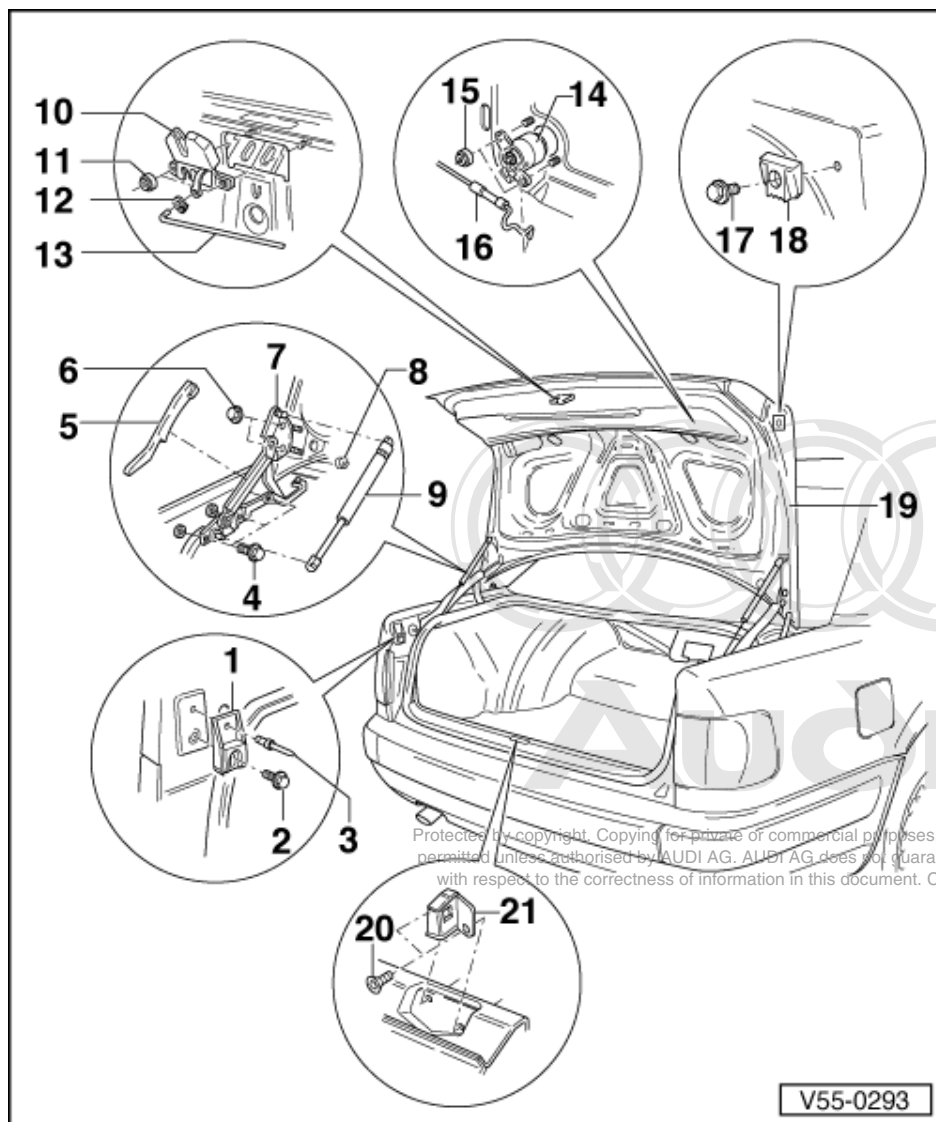


- 2 Actuator**
- 3 Bolt - 55 Nm**
 - ◆ 2 off
- 4 Clip**
 - ◆ 2 off
- 5 Guide sleeve**
- 6 Clamp fitting**
 - ◆ Bend cable around behind clamp fitting
- 7 Locking lever**
 - ◆ For lock pin
 - ◆ Removing =>Page 5

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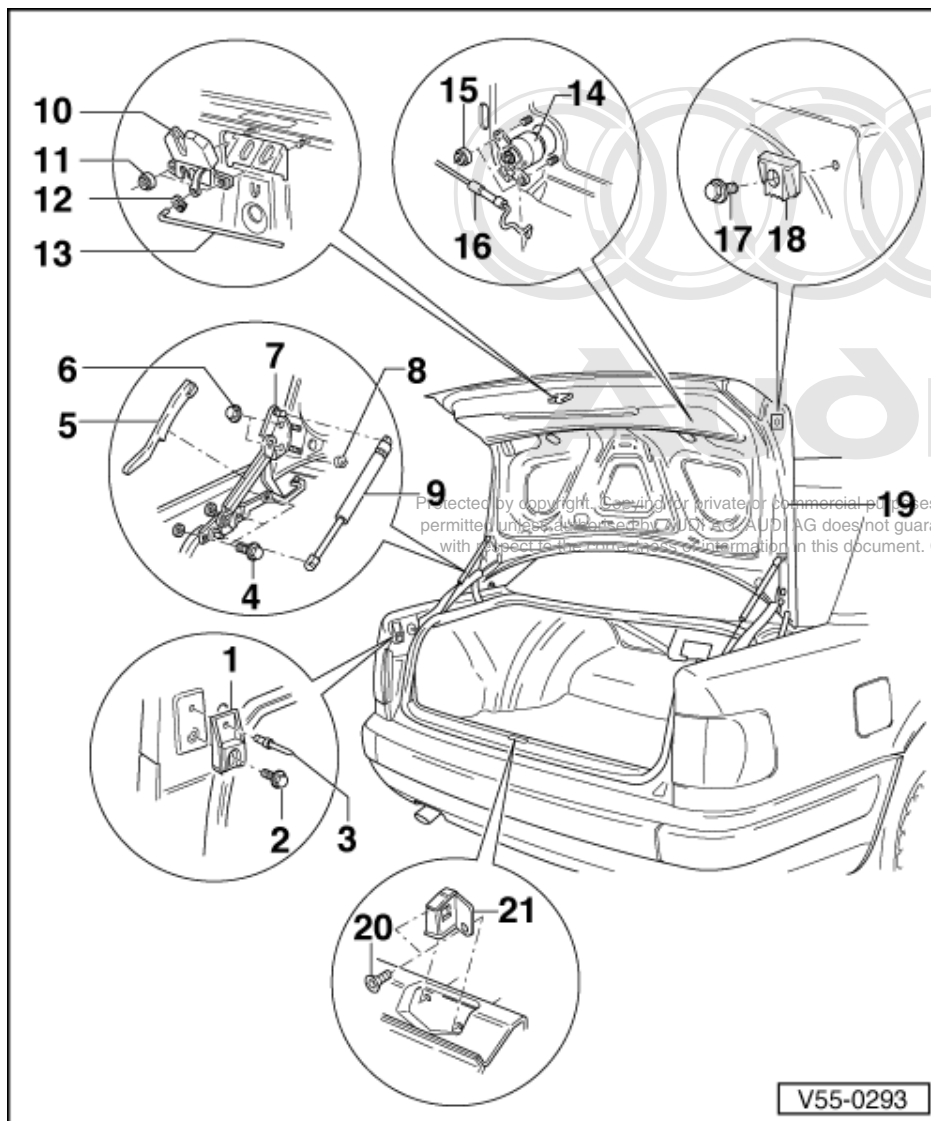
3 - Boot lid

3.1 - Boot lid



3.2 - Removing and installing boot lid

- 1 **Adjusting buffer**
 - ♦ Adjusting => Fig. 2
- 2 **Combi screw - 21 Nm**
- 3 **Tubular rivet**
- 4 **Combi screw - 21 Nm**
 - ♦ 3 off
- 5 **Cable guide**
 - ♦ Different versions on left and right
- 6 **Hexagon nut- 21 Nm**
 - ♦ 2 off



7 Bonnet hinge

8 Stop plate

9 Gas-filled strut

- ♦ Lever off from boot lid hinge
- ♦ Releasing gas => Fig. 1

10 Lock

- ♦ Adjusting => Fig. 3

11 Hexagon nut- 6 Nm

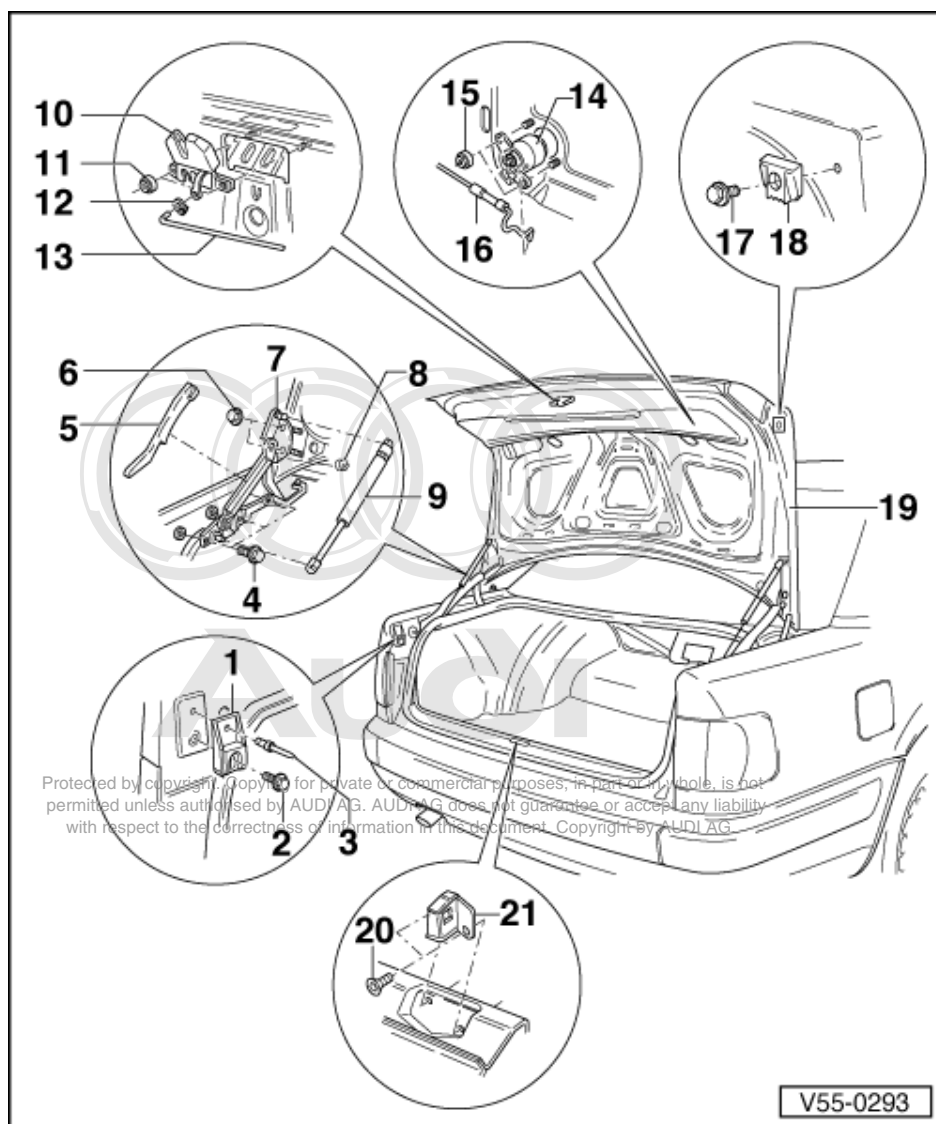
- ♦ 2 off

12 Hinged bushing

13 Operating rod

14 Lock cylinder

- ♦ Removing and installing
=>Page 29.
- ♦ Dismantling => Page 31



15 Nut- 4 Nm

- ◆ 2 off
- ◆ Self-locking
- ◆ Replace

16 Operating rod

17 Bolt -6 Nm

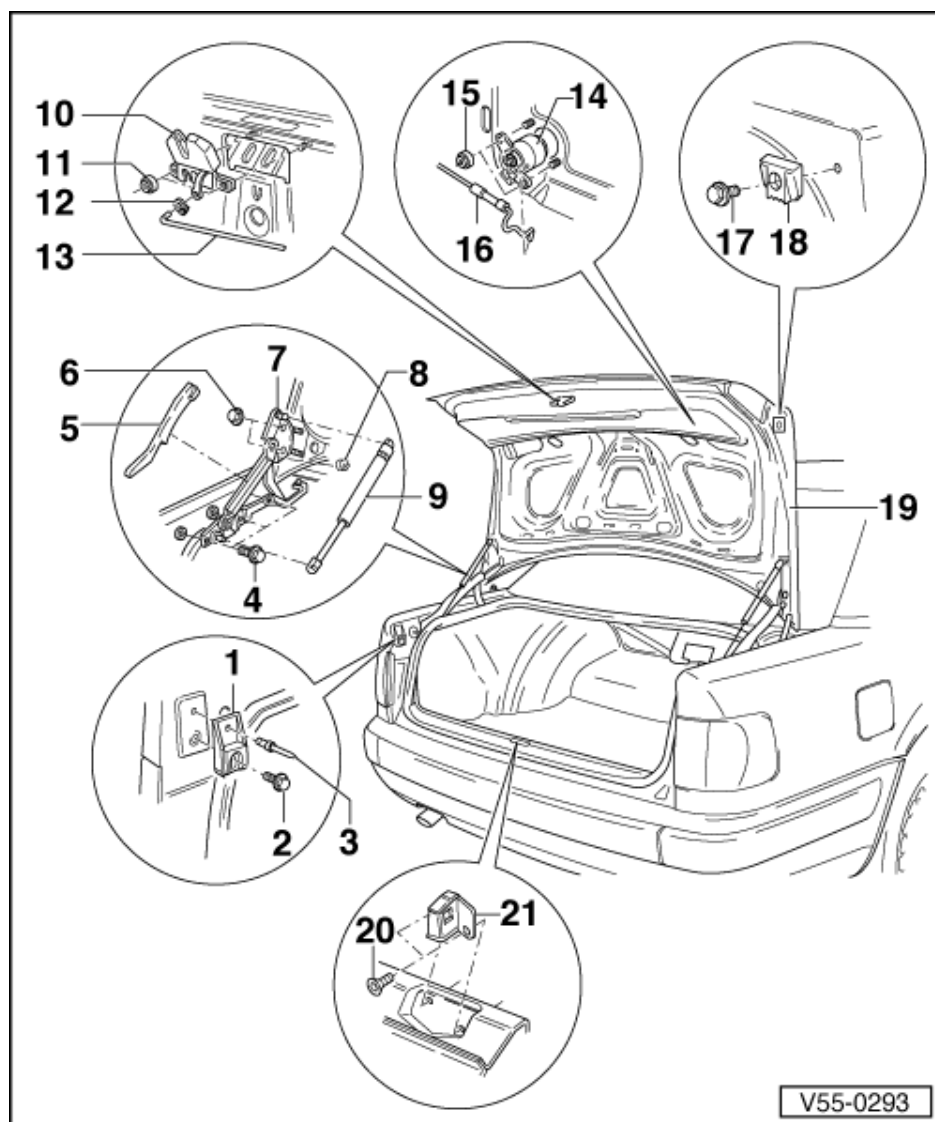
18 Adjusting buffer

19 Boot lid

- ◆ Removing:
 - Open and support boot lid.
 - Removing boot lid trim:

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing boot lid trim Trim panels Removing boot lid trim

- Detach connectors and pull wiring harness out of boot lid.

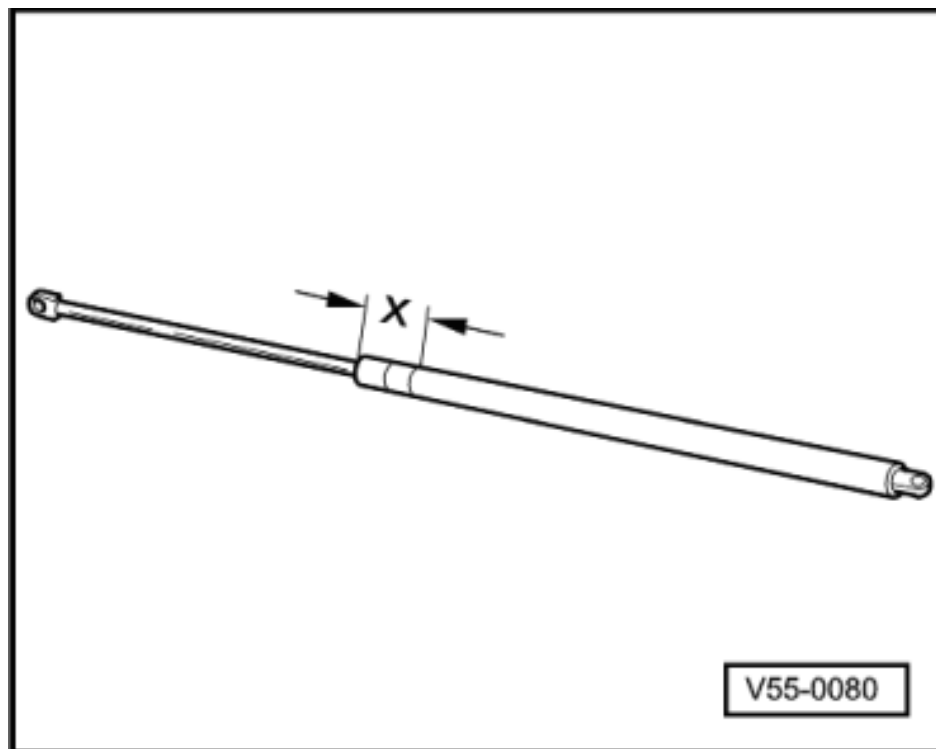


- Lever telescopic strut -item 9 - from boot lid hinge -item 7 - at both sides.
- Unscrew hexagon nut -item 6 - on both sides.
- Detach boot lid.
- ♦ Adjusting:
- Height is adjusted at the front by means of combi bolt-item 4 -.
- Height is adjusted at the rear by moving the striker wedge -item 21 -.
- For longitudinal adjustment, loosen hexagon nut -item 6 -.
- ♦ Adjusting => Page 27

20 Bolt - 6 Nm
21 Locking wedge


Audi

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-> Fig.1 Releasing gas from gas-filled strut

- Clamp gas-filled strut in vice in area x = 50 mm.

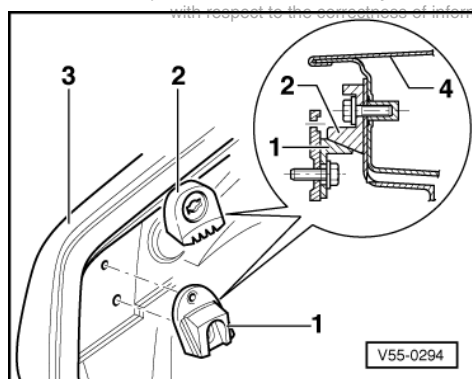
Important
Only clamp the strut in this area. Otherwise there is risk of accident.

- Saw through cylinder of telescopic strut in first third of overall cylinder length - starting from reference edge on piston rod side.

Note:

Goggles must be worn during sawing. It is also appropriate to cover the area around the saw-cut with a cloth to catch any escaping fluid.

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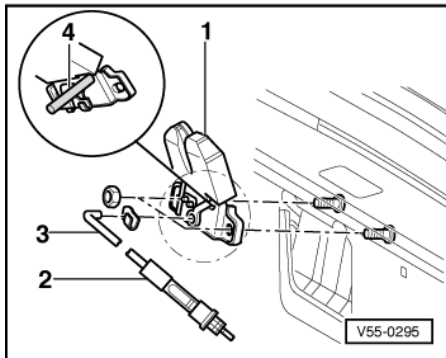


-> Fig.2 Setting adjusting buffer

With the boot lid closed, buffer stop -1- must make slightly pretensioned contact with mating piece -2-.

Note:

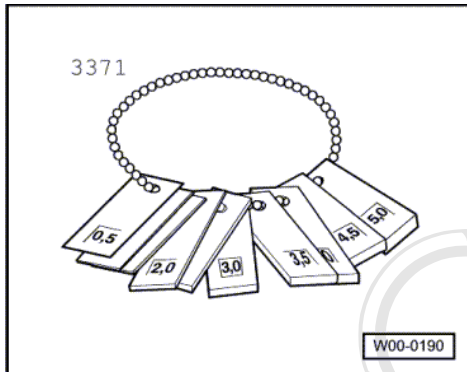
Do not use the buffer stop to adjust the height of the boot lid -4-.



-> Fig.3 Adjusting boot lid lock

- Engage boot lid lock -1-.
- Fix boot lid lock in position with mandrel -4- (e.g. \varnothing 6 mm drill bit).
- Without pretension, engage operating rod -3- at lock cylinder and boot lid lock.
- Engage threaded coupling -2-.
- Remove drill bit from lock.
- Actuate boot lid lock.
 - Length tolerance of boot lid lock/lock cylinder: no more than 2 mm

3.3 - Adjusting boot lid



Special tools, testers and auxiliary items required

- ♦ Special tool 3371

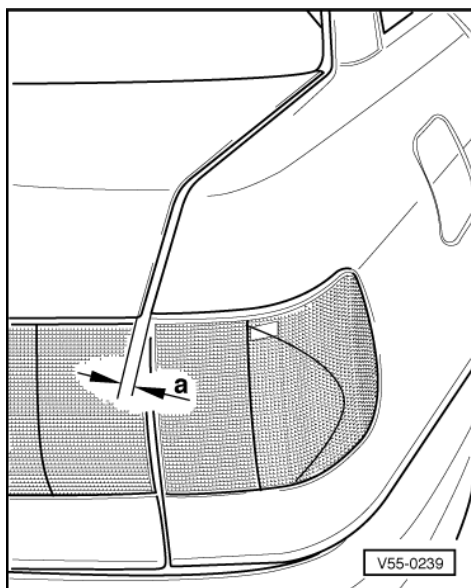
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General Body Assembly, Exterior (Rep. groups 50, 55, 57, 58, 60, 63, 64, 66) -

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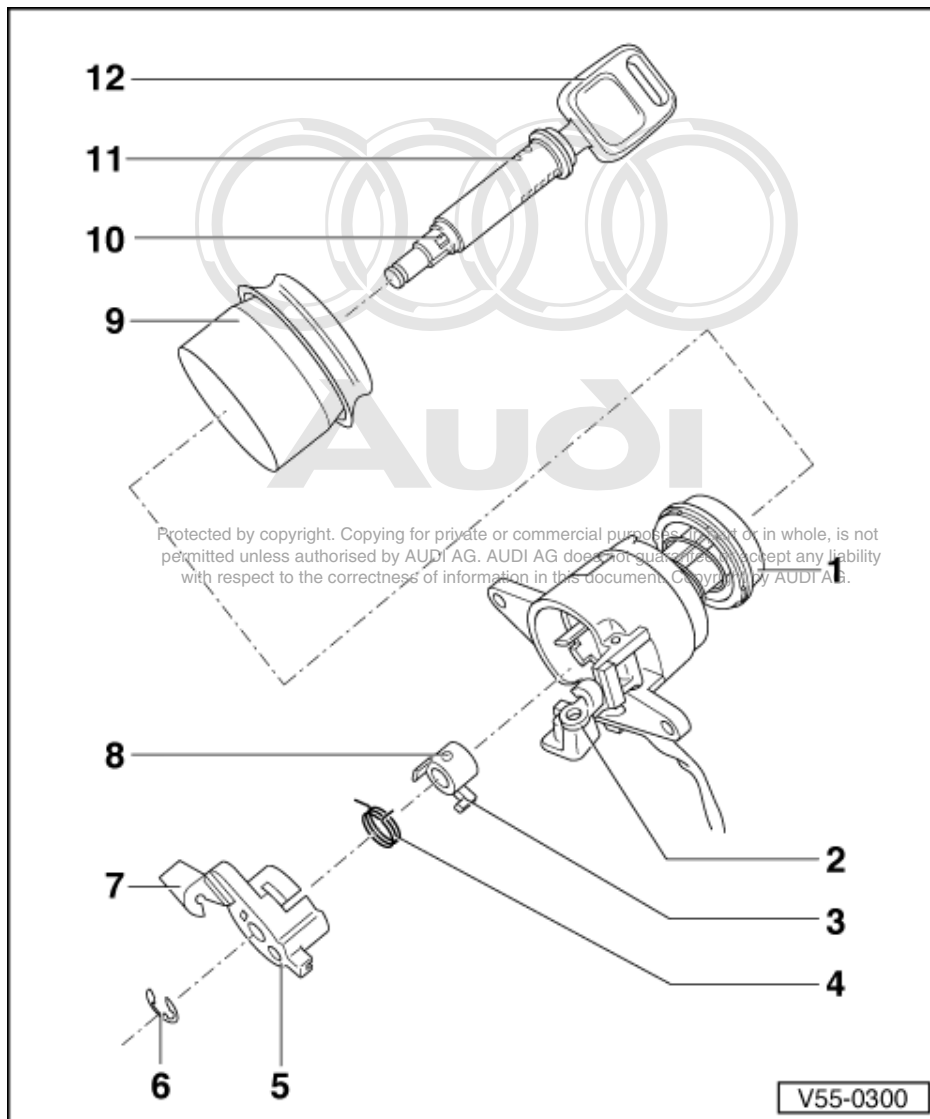


- Set left and right of boot lid to same joint dimension.
 - -> Distance a = 3.5 mm

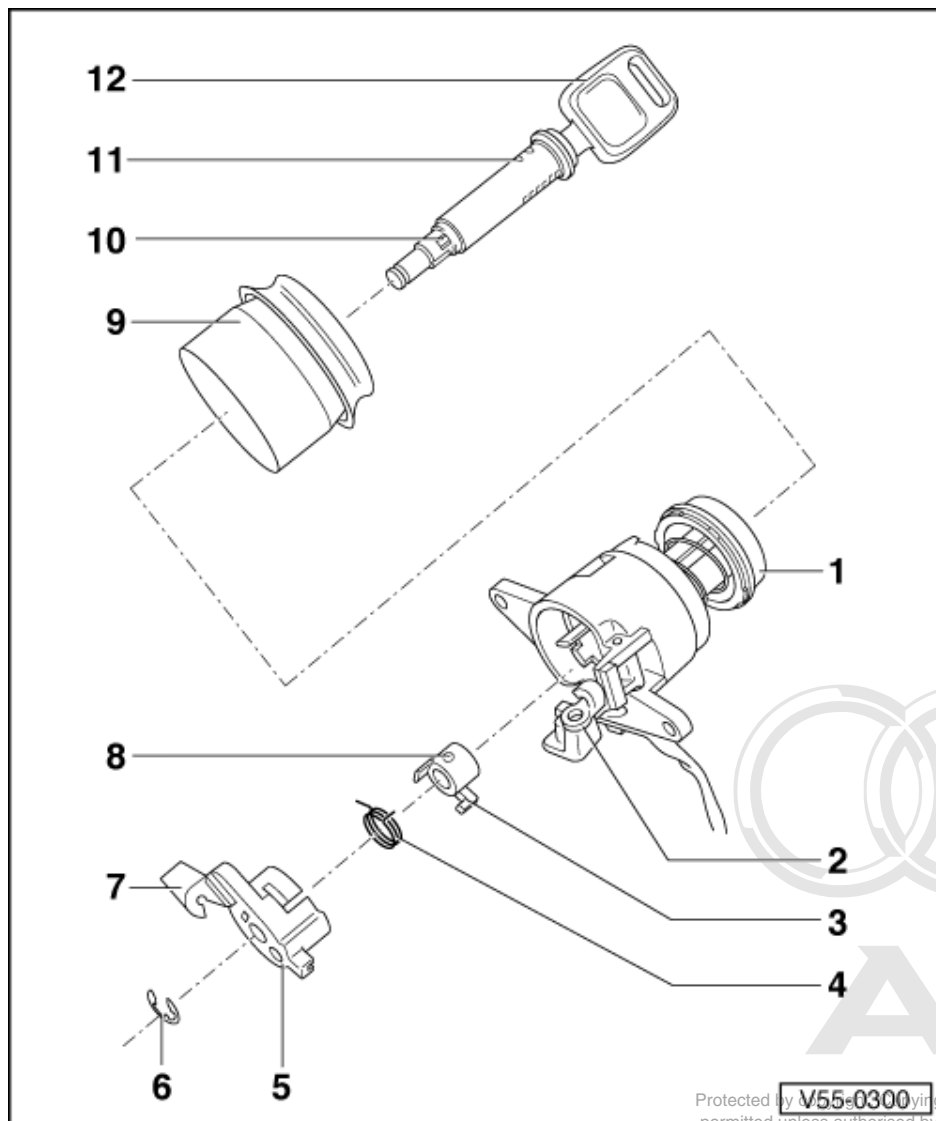


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3.4 - Removing and installing lock cylinder for boot lid lock



- 1 **Housing**
 - ♦ For lock cylinder
- 2 **Clip**
- 3 **Coupling**
 - ♦ Assembling
=>Page 32.
- 4 **Torsion spring**
 - ♦ Installing =>Page 32
- 5 **Actuating arm**
 - ♦ Installing =>Page 32
- 6 **Locking plate**
- 7 **Clip**



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8 Ball

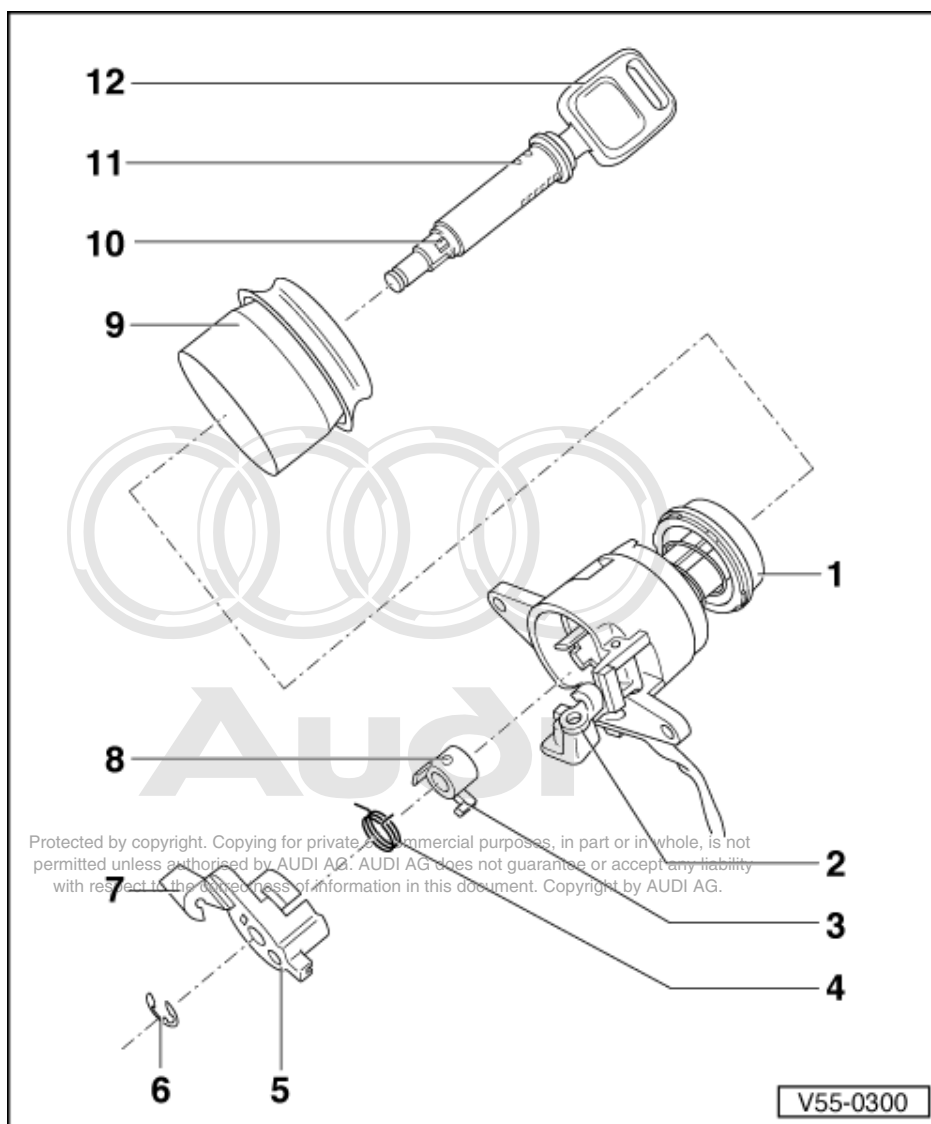
- ◆ 2 off
- ◆ Grease balls on installation
- ◆ During assembly, ensure that the balls do not drop out of holes

9 Guide

- ◆ Cannot be removed without destroying

10 Roller

- ◆ 2 off
 - ◆ Assembling
- =>Page 32 .



11 Lock cylinder

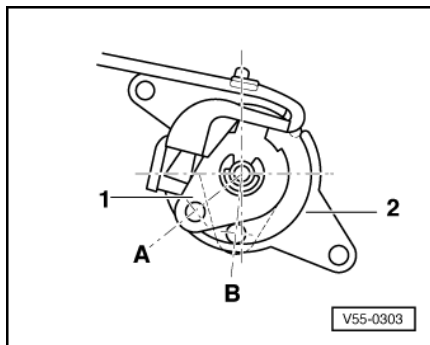
- ◆ Removing:
 - Remove cover from right light in boot lid.
 - Press aside securing clip on operating rods for lock release mechanism and central locking system actuator and take out operating rod.
 - Unscrew nuts at lock cylinder housing.
 - Pull lock cylinder housing inwards to remove it from the light.
- ◆ Dismantling => Page 31

12 Key

3.5 - Dismantling and assembling lock cylinder

Dismantling

- Insert key into the lock cylinder.



- -> Press actuating arm -1- towards lock and lever off lock plate.
- Detach actuating arm and then the torsion spring.
- Pull coupling -item 29 , off lock cylinder.

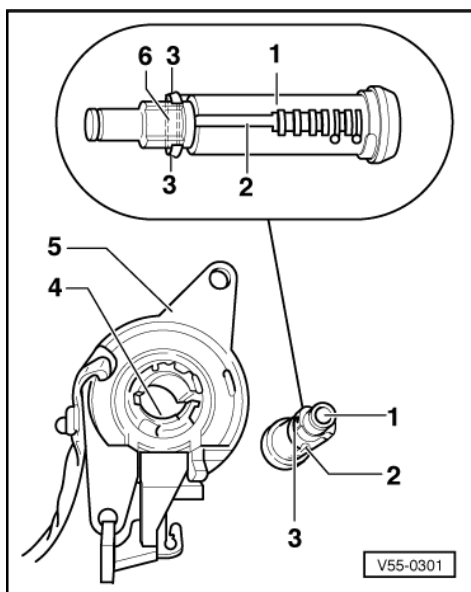
Note:

Rollers -item 30 will drop out when coupling is pulled off.

- Pull lock cylinder out of housing.

Assembling

- Key inserted in lock cylinder.

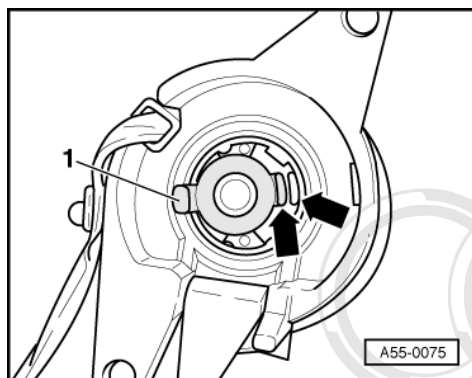


- -> Hold lock cylinder -1- so that groove -2- is facing mechanic.
- Insert compression spring -6- (greased with G 000 400) into the lock cylinder.
- Insert roller -3- (greased with G 000 400) into the bottom of lock cylinder.
- Install lock cylinder -1- vertically in housing -5- from underneath.

Notes:

- ♦ Make sure groove -2- in lock cylinder is opposite guide lug -4- in housing.
- ♦ Make sure roller does not drop out of guide when inserting lock cylinder in housing -5-.
- Press home the lock cylinder, together with key, into the lock cylinder housing, against the spring force.

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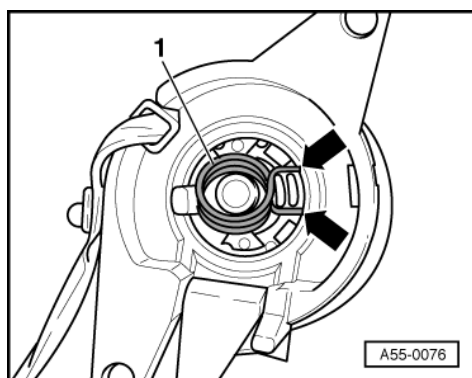


- -> Attach coupling -1- to lock cylinder.

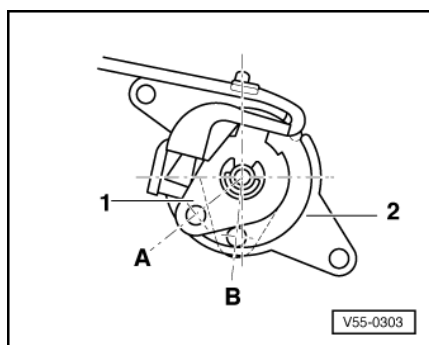
Note:

Coupling must be inserted so that the two guide lugs -arrows- for the torsion spring are facing one another.

- Turn key anti-clockwise as far as the left stop and keep lock cylinder and key pressed into lock cylinder housing, against spring force.
- Insert upper roller into recess which is now free.
- Use a thin screwdriver to press roller into lock cylinder and at the same time press home coupling.



- -> Insert torsion spring -1- so that side faces -arrows- make contact with guide lugs on left and right.



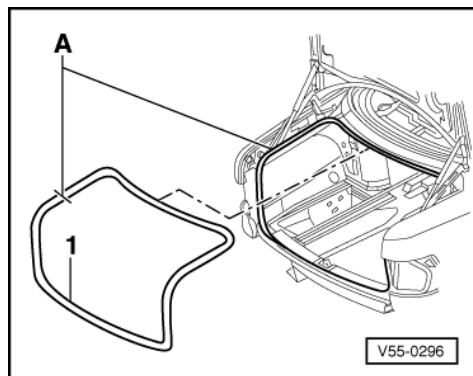
- -> Fit actuating arm -1- in position -A- or -B-:

- A - Open
- B - Closed
- 2 - Lock cylinder housing

- Fit lock plate



3.6 - Installing boot lid seal



- -> Align joint -A- of seal -1- for boot lid with ball stud of left hinge.
- Press on seal.

Note:

Seal is vulcanised in area of joint.



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57 - Front doors/Door components/Central locking system

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

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In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

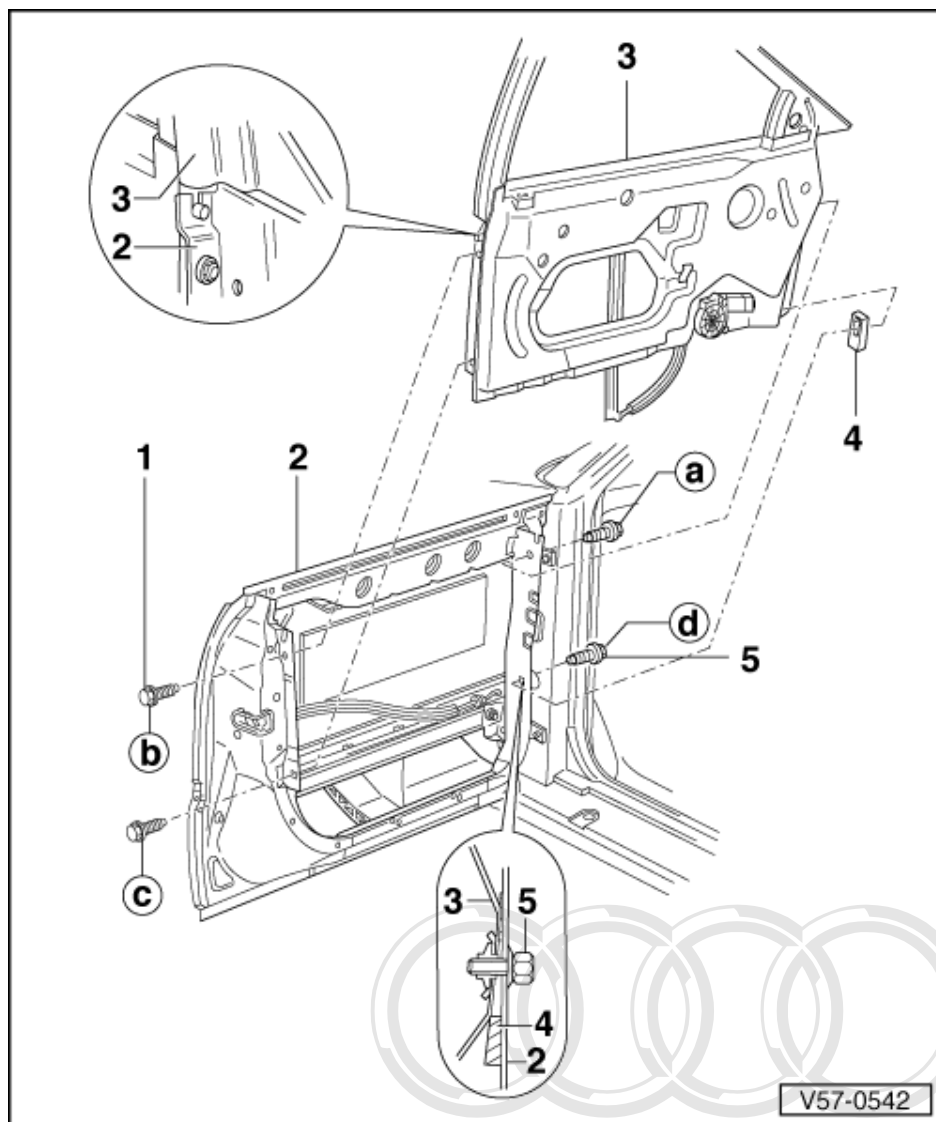
If you are not sure whether used parts can be refitted, always fit new parts.

Important

- ◆ Use only genuine Audi A8 Parts.
- ◆ Accessories must be approved by AUDI AG.
- ◆ Damage resulting from contact corrosion is not covered by the warranty.

2 - Front door

2.1 - Front door



2.2 - Removing and installing door shell and door subframe

- Front door trim removed

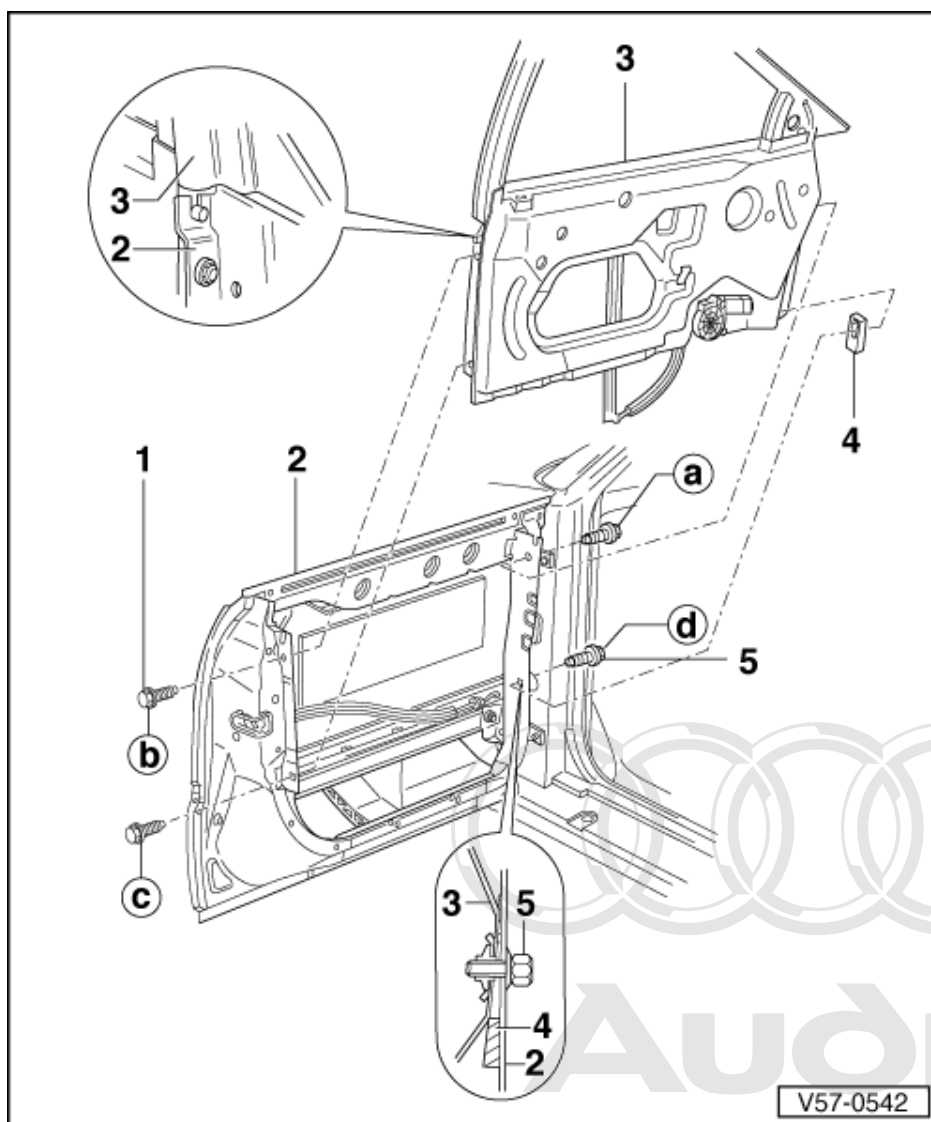
=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
 Front door trim Removing and installing front door trim

1 Hexagon bolt - 30 Nm

- ♦ Note tightening sequence

2 Door shell

- ♦ Removing:
 - Disconnect connectors.
 - Pull central locking system hose off actuator and unclip.
 - Door shell hinges => Fig. 1 and 2.

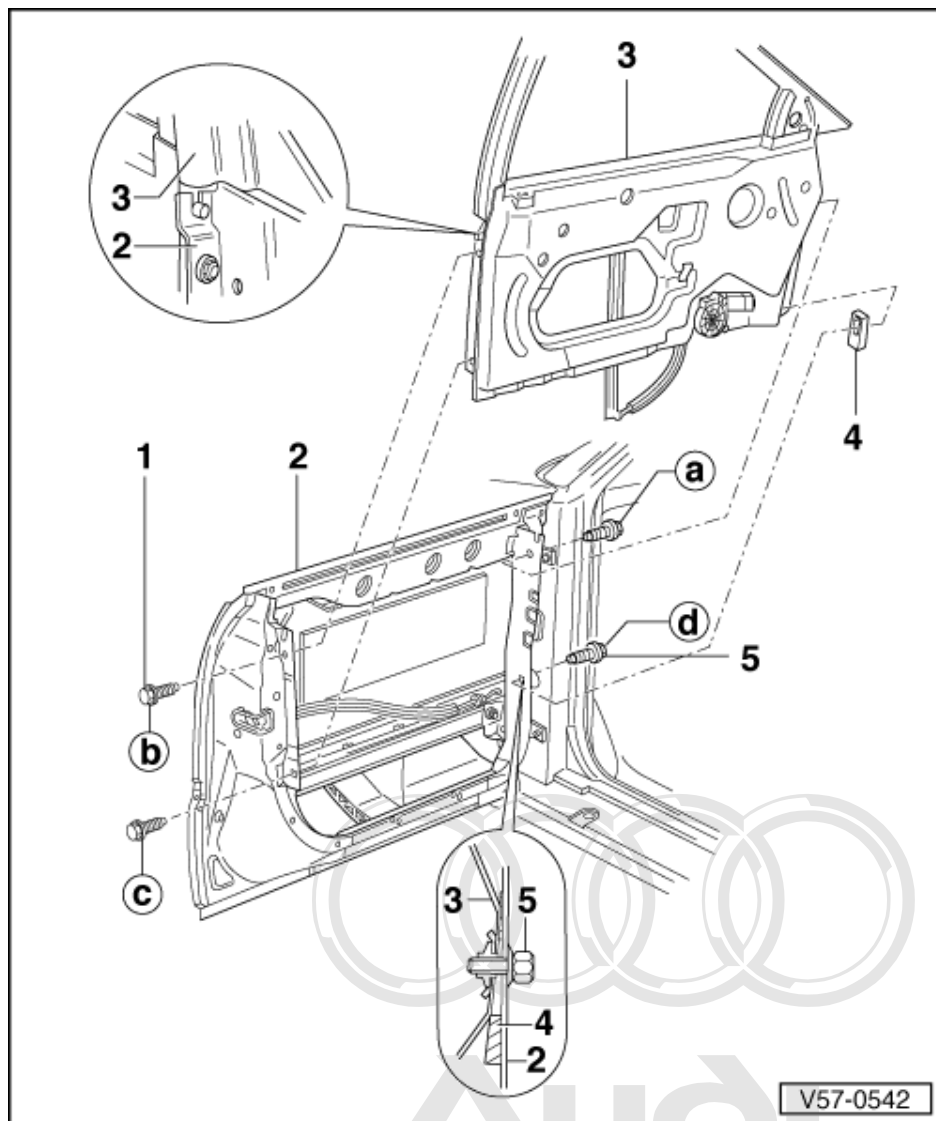


- ♦ Adjusting => Page 70
- ♦ Removing and installing side impact bar => Fig. 4

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3 Door subframe

- ♦ Removing:
 - Unclip Bowden cable for interior door control.
 - Detach connector to window lifter motor
 - Unscrew hexagon bolts -item 1 - and -item 5 - and lift out door subframe.
- ♦ Installing:
 - Start by inserting door subframe in door shell and screw on loosely at top with the shorter hexagon bolts -item 1 - and -item 5 - loosely inserted.



- Insert adjuster -item 4 - and screw in the longer hexagon bolts -item 1 - and -item 5 - at bottom.
- Tighten hexagon bolts -item 1 - and -item 5 - in sequence a, b, c, d.
- ♦ Adjusting => Page 72

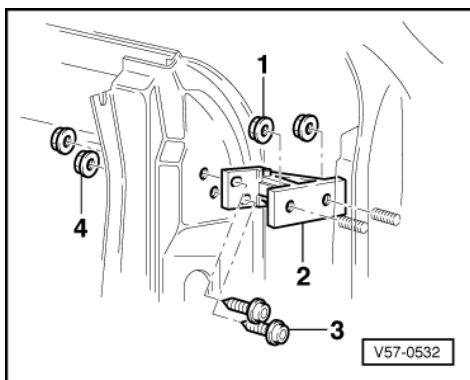
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4 Adjuster

- ♦ Must always be fitted
- ♦ The inclination of the front door at the B pillar can be adjusted by altering the position of adjuster => Page 72

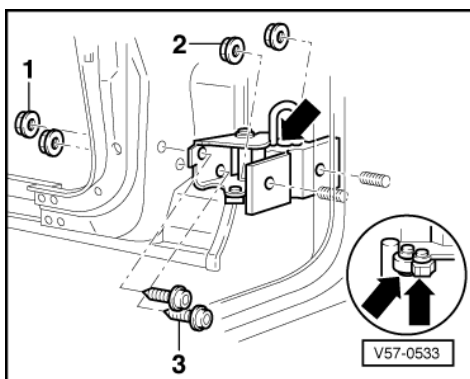
5 Hexagon bolt - 30 Nm

- ♦ Note tightening sequence



-> Fig.1 Upper door hinge

- 1 - Tightening torque: 30 Nm
- 3 - Tightening torque: 30 Nm

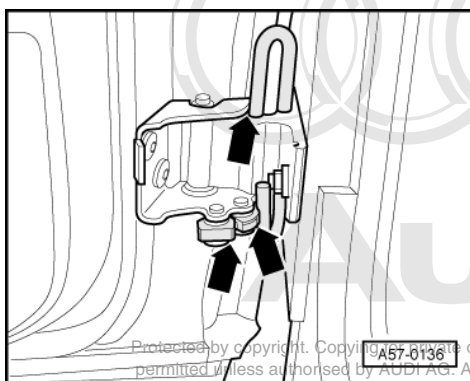


-> Fig.2 Lower door hinge

- 2 - Tightening torque: 30 Nm
- 3 - Tightening torque: 30 Nm

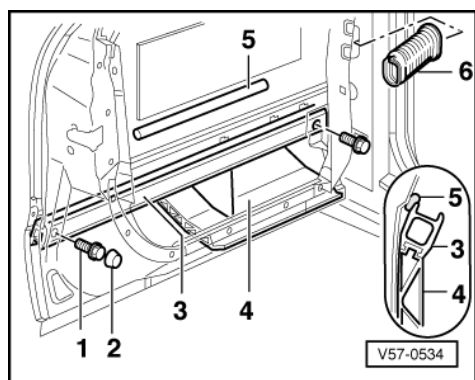
Note:

Lubrication points -arrows- => Fig. 3.



-> Fig.3 Lower door hinge - lubrication points

- Only grease the door arrester at the points shown in the illustration (arrows).
- Lubricant: "G 000 150"



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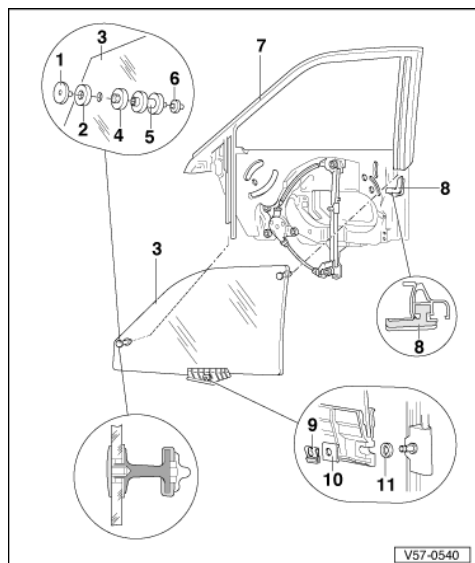
-> Fig.4 Removing and installing side impact bar

- Lever off trim cap -2-.
- Unscrew the three hexagon bolts -1- and detach side impact bar -4-.

Notes:

- ♦ The top -3- and bottom -4- sections are caulked and must not be separated.
- ♦ Butyl cord -5- must always be fitted, renew if necessary.

2.3 - Removing and installing front door window

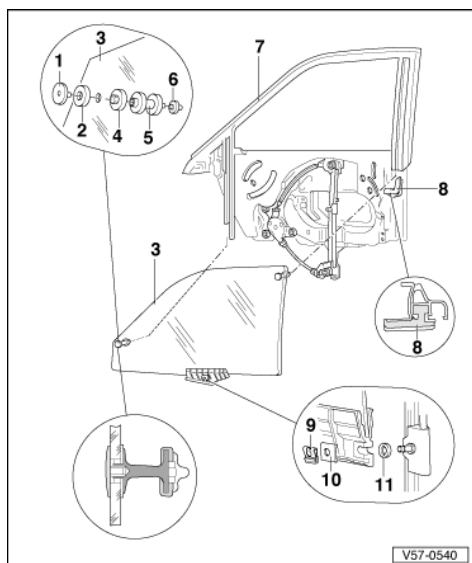


- Front door trim removed

=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
 Front door trim Removing and installing front door trim

- 1 Release and tighten bolt - 2 Nm
- 2 Washer
- 3 Front door window
 - ♦ Removing and installing =>Fig. 1
 - ♦ Adjusting => Fig. 2 and 3
- 4 Centring sleeve
- 5 Guide pin

- ♦ Removing and installing =>Fig. 4



6 Trim cap

7 Door subframe

- ♦ Removing and installing
=>Page 37.

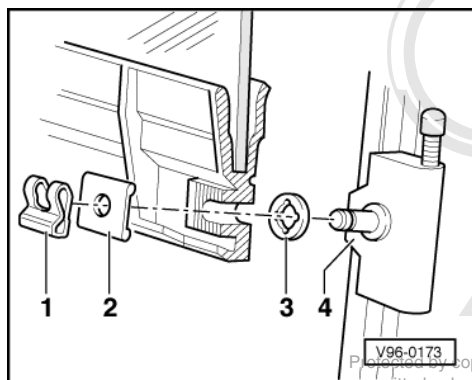
8 Plug

- ♦ After fitting window, insert into guide of door subframe

9 Locking plate

10 Washer

11 Damping washer



-> Fig.1 Removing and installing front door window

- Use a small screwdriver to lift lock plate -1- slightly and push it out of groove of guide pin -4-.
- Detach washer -2-.
- Lift window slightly off guide pin and pull downwards out of guides.

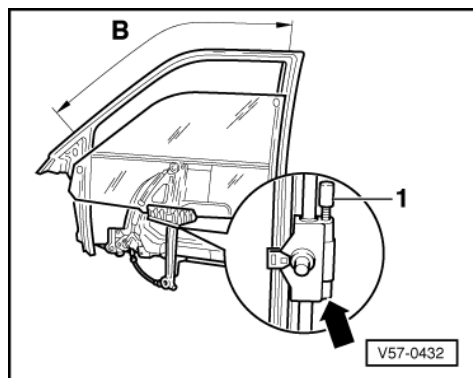
Note:

This causes the guide pin to push the plug out of the window guide.

- Remove damper -3-.
- When installing, align window slot centrally with guide pin -4-, paying attention to contact area at roof frame and A-pillar.

Note:

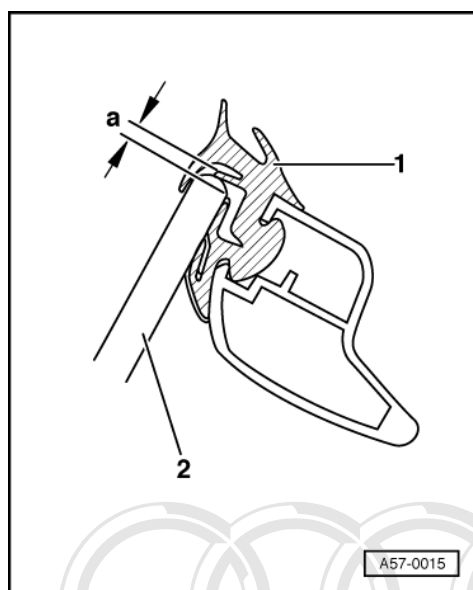
The plug acts as a seal and noise insulator. It must be inserted in the B-pillar window guide again after fitting the window.



-> Fig.2 Adjusting door window

- Adjust upper stop of window lifter -1- with E6 Torx spanner -arrow-.
- Adjust top edge of window with respect to inner sealing lip => Fig. 3 .

B - Contact area of door window on inner sealing lip.



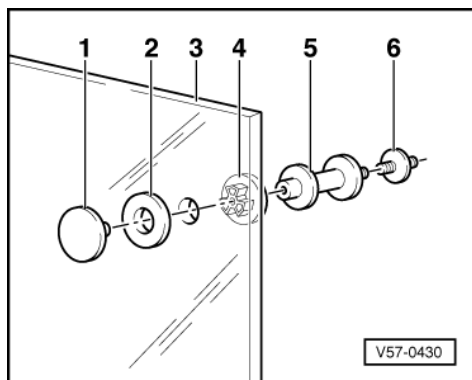
-> Fig.3 Adjusting door window

- Adjust window -2- with door closed.
- Adjust upper stop limit of the window lifter so that inner sealing lip of door window seal -1- contacts over the entire area -B- => Fig. 2 with top edge of window over entire area
 - Dimension a = min. 1.0 mm
- Do not set window too high, as this would result in increased door closing forces.

Note:

It is only guaranteed to have no leaks if sealing lip makes contact 1.0 mm preload.

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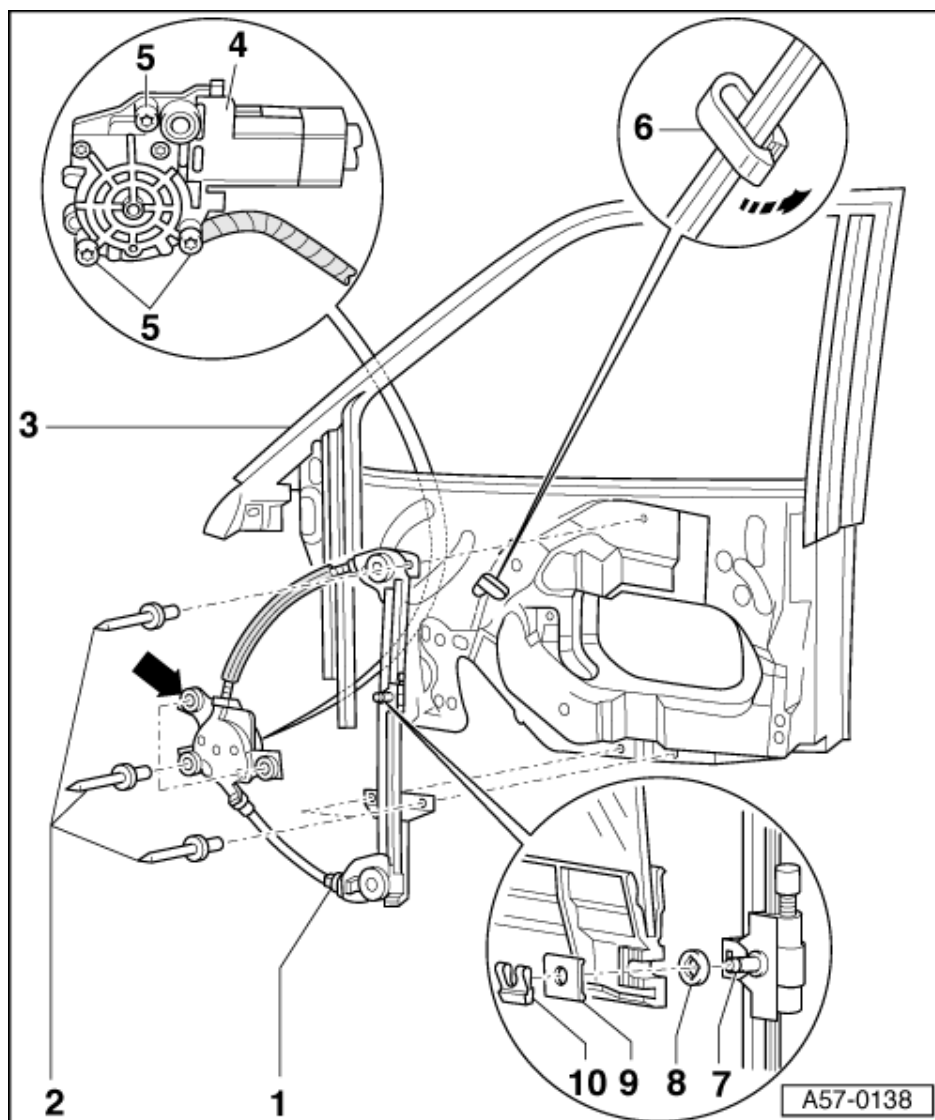


-> Fig.4 Removing and installing locating pin

- Removing door window => Fig. 41
- Drill into centre of bolt -1- with \varnothing 5 mm bit until guide pin -5- drops off.
- Coat thread of new bolt with liquid locking compound D 185 400 A2.
- Screw in new locating pin with centre bush -4-, door window -3-, washer -2- and screw, tightening torque 2 Nm.
- Fit cap -6-.

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2.4 - Removing and installing front window lifter



- Front door trim removed

=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
Front door trim Removing and installing front door trim

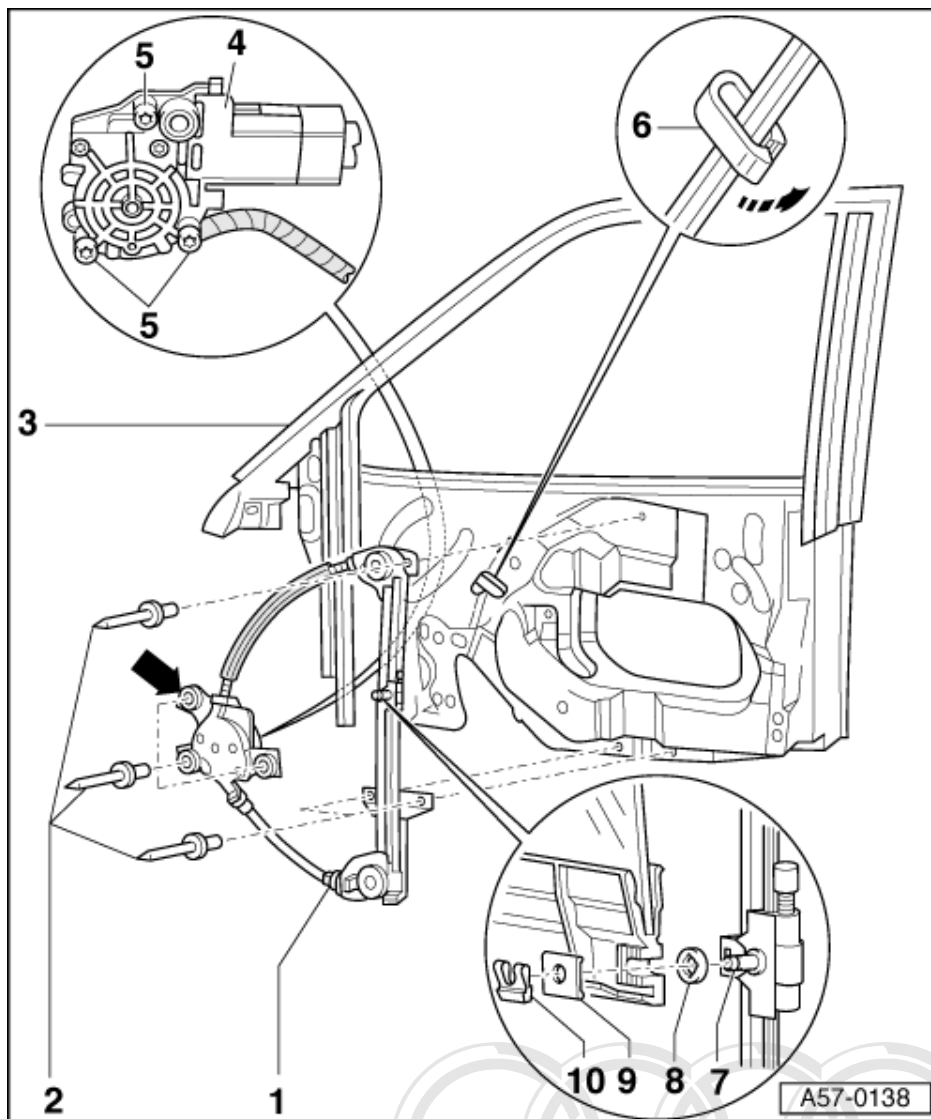
1 Front window lifter

- ♦ To remove, drill heads off rivets -item **2** - and knock out shanks.
- ♦ Start by riveting on window lifter at location marked by arrow

2 Blind rivet

- ♦ 6 off
- ♦ Always use genuine rivets to avoid contact corrosion:

=> Parts List



3 Door subframe

- ♦ Removing and installing
=>Page 37.

4 Motor for window lifter

- ♦ After installing, raise window as far as it will go
- ♦ Then press window lifter switch again for at least 1 second in "close" position to activate automatic down/up function

5 Release and tighten bolt - 10 Nm

- ♦ 3 off

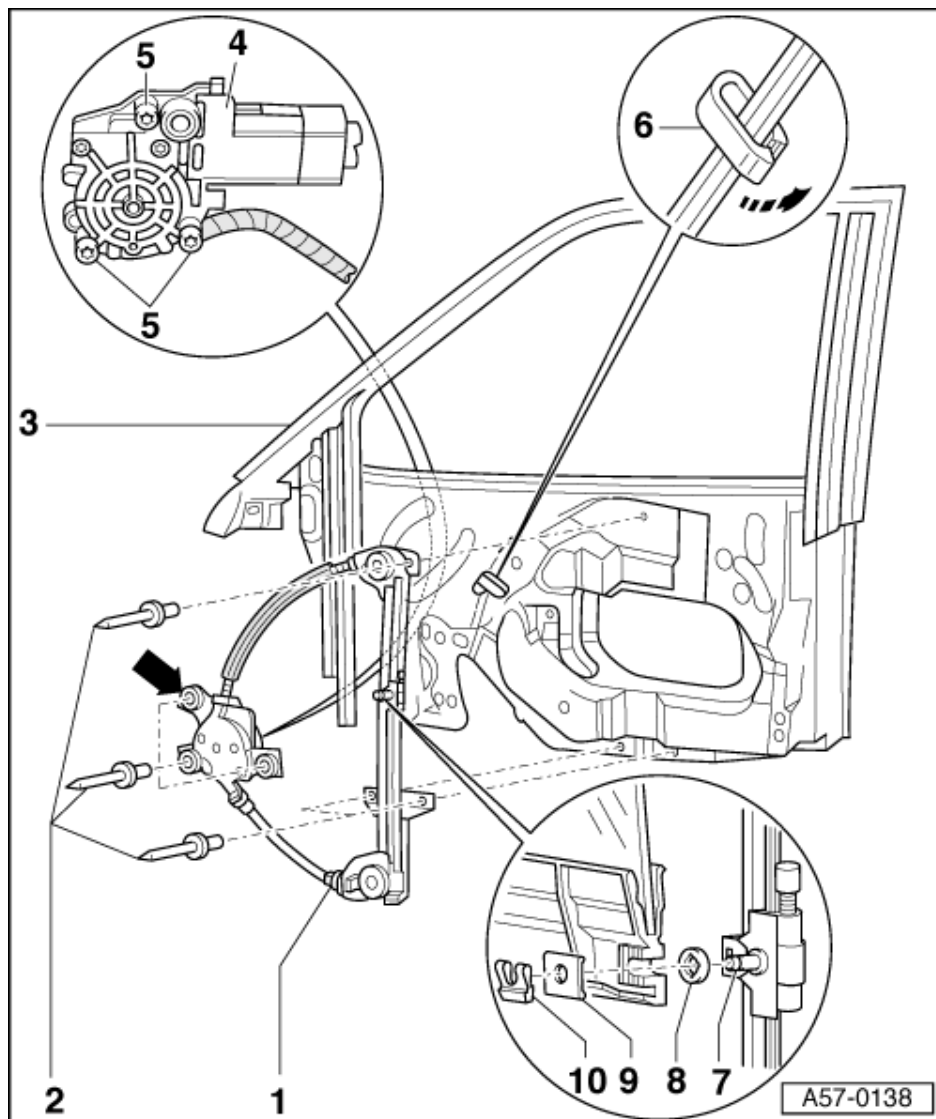
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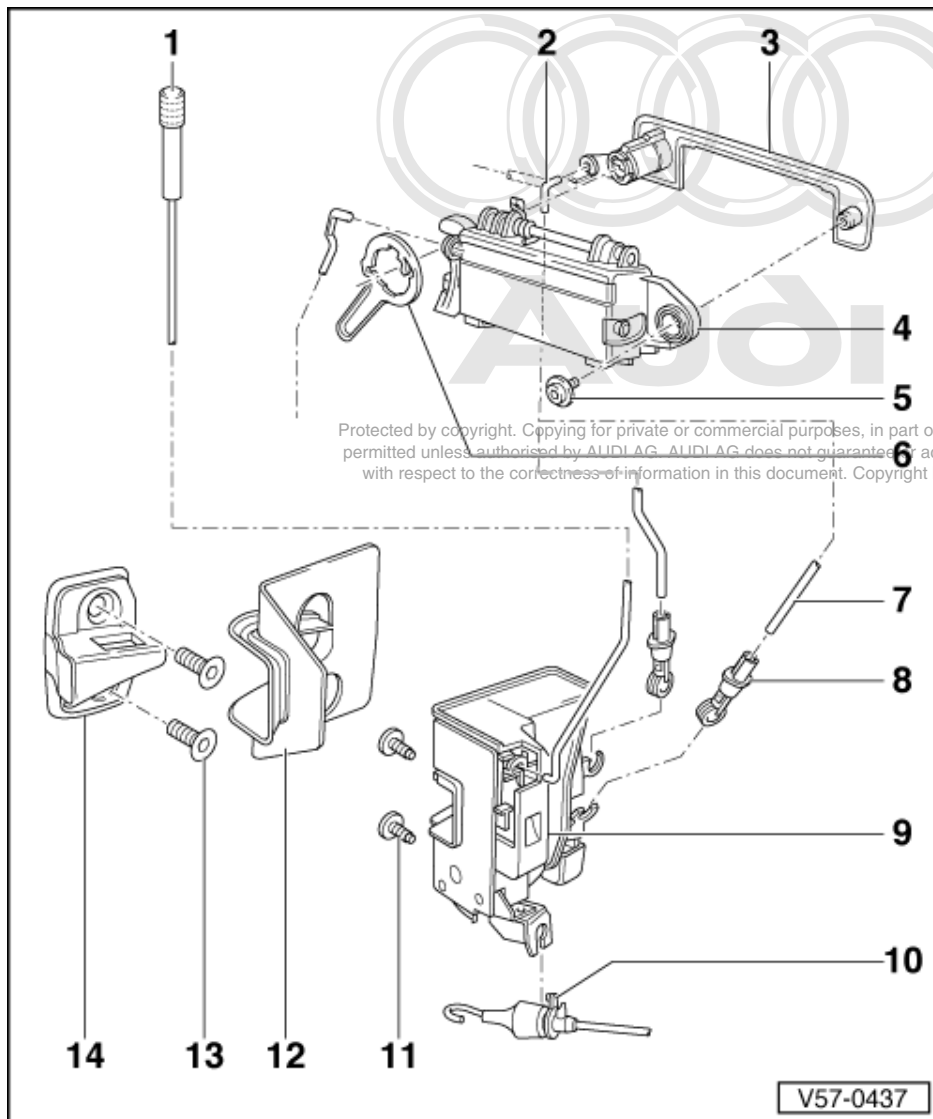


- 6 Clip
♦ Fit window lifter -item 1 - in clip and fasten clip -arrow-
7 Guide pin
8 Damping washer
9 Washer
10 Locking plate



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2.5 - Removing and installing front door lock for profile key with operating elements



Note:

Profile key => Fig. 1

- Front door trim removed

=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
 Front door trim Removing and installing front door trim

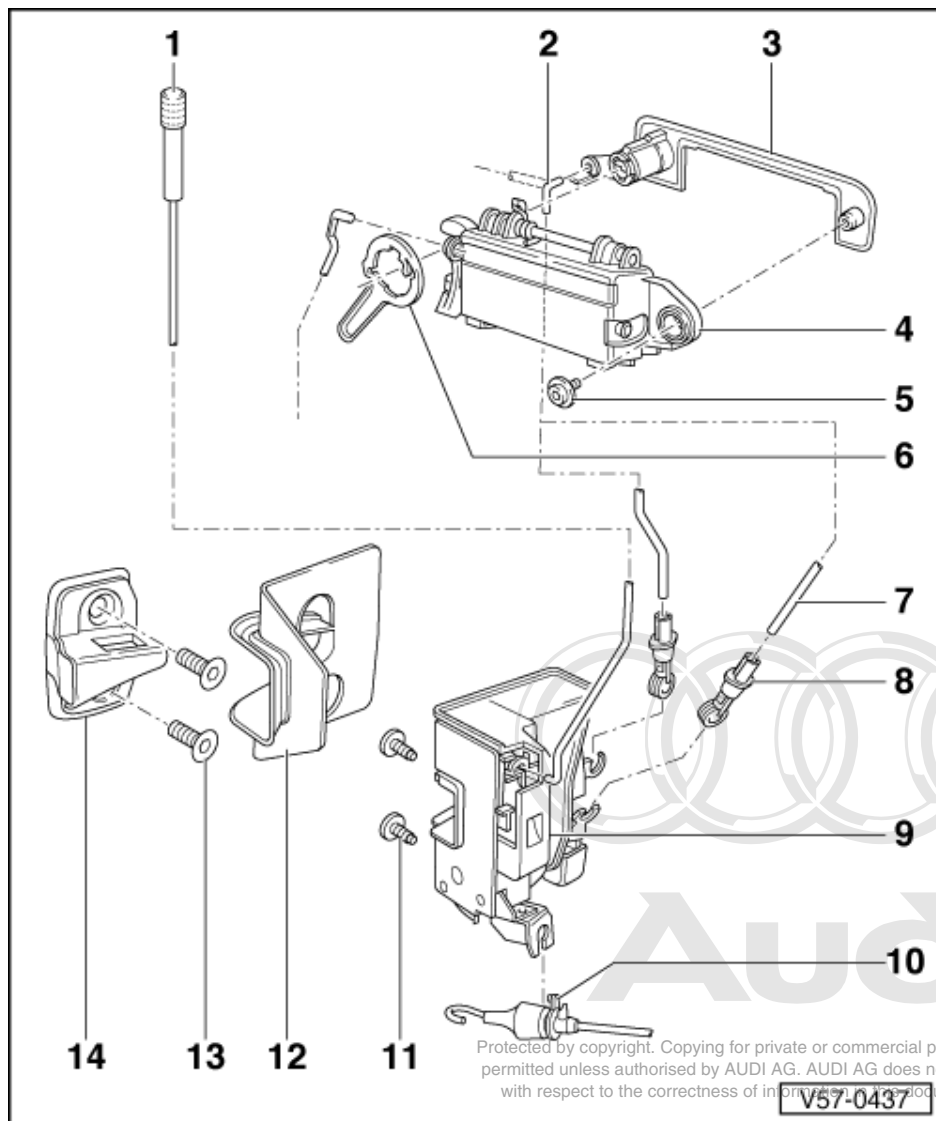
- Door component carrier removed => Page 36.

1 Securing rod

- ♦ Unclip at fastener

2 Lock cylinder securing rod

- ♦ Installing => Fig. 1



3 Outer locking element

- ♦ Removing lock cylinder
=>Page 54.

4 Door handle

- ♦ Removing and installing
=>Page 52.

5 Combi screw - 5 Nm

6 Rotary clip

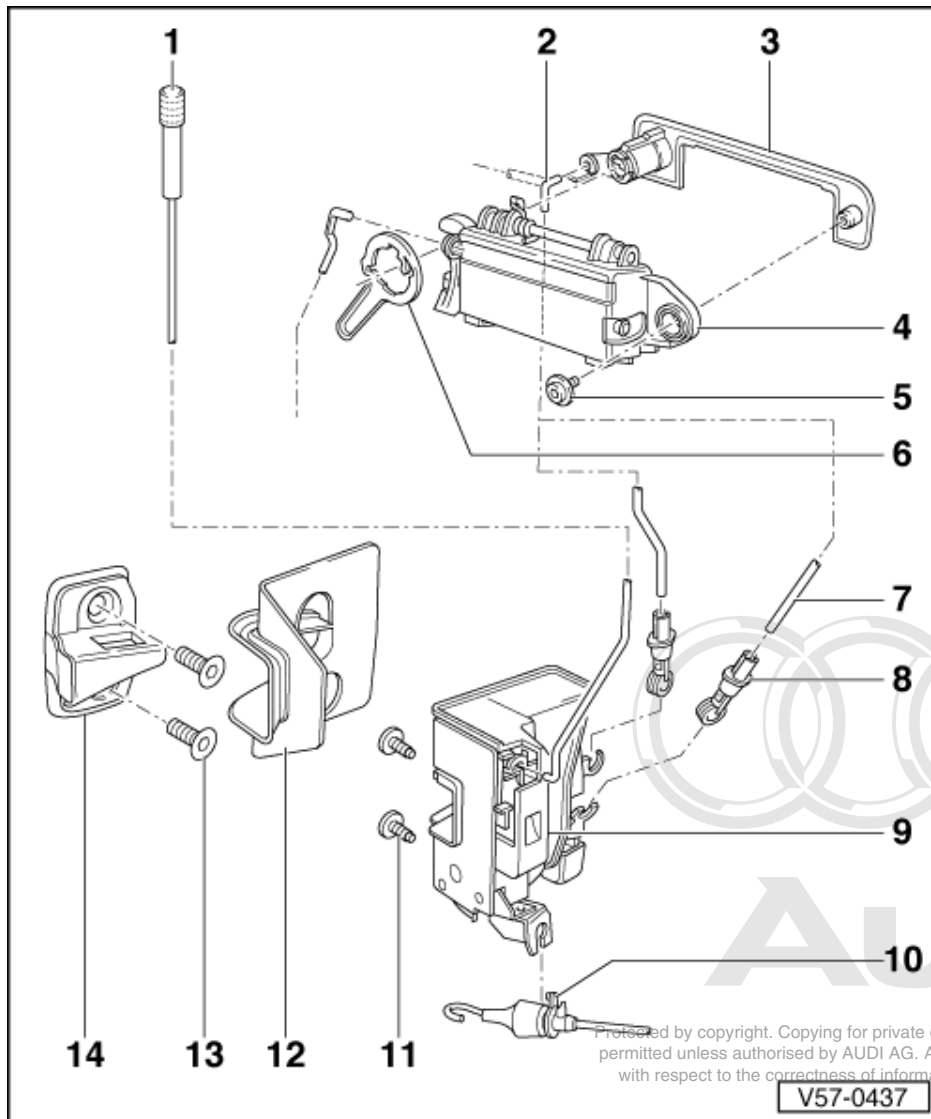
- ♦ To unfasten, swivel to rear (away from direction of travel)

7 Lock operating rod

- ♦ Installing => Fig. 1

8 Operating clip

- ♦ 2 off
- ♦ Disengage lock operating rod; to do so move sleeve downwards



9 Door lock

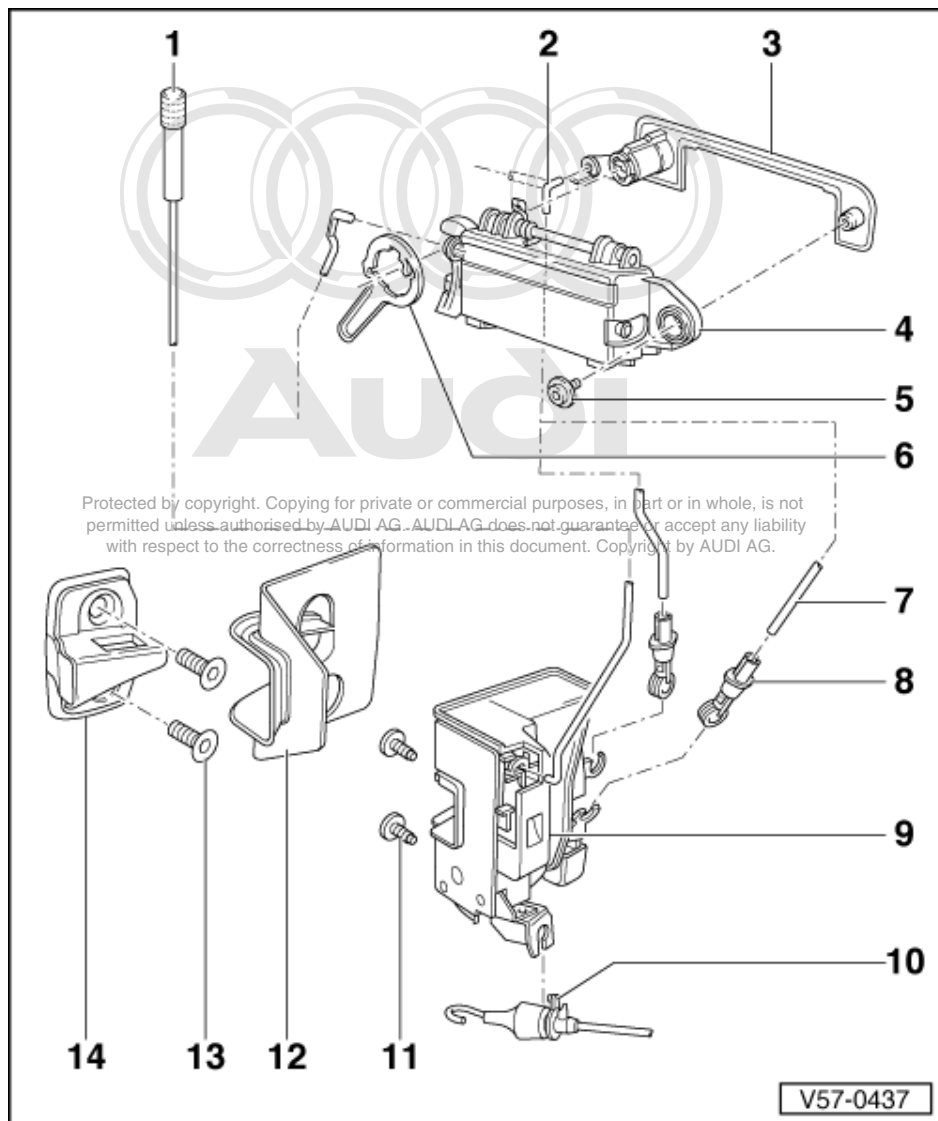
- ◆ Removing:
 - Disengage locking rod, lock operating rod and lock cylinder locking rod.
 - Unscrew combi bolts -item **11** -.
 - Pull hose off central locking system actuator
 - Detach Bowden cable for interior door handle => Fig. **2**

10 Bowden cable for interior door handle

- ◆ Removing and installing =>Fig. **2**

11 Combi screw - 8 Nm

- ◆ 2 off



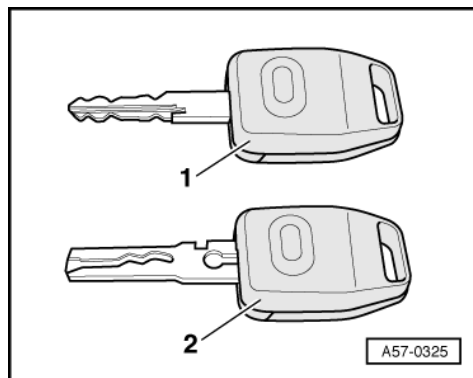
12 Lock base plate

13 Oval-head screw - 16 Nm

- ♦ 2 off

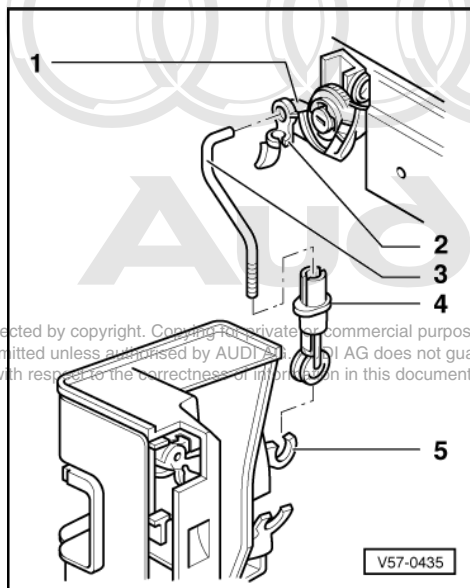
14 Locking wedge

- ♦ Adjusting => Page 72



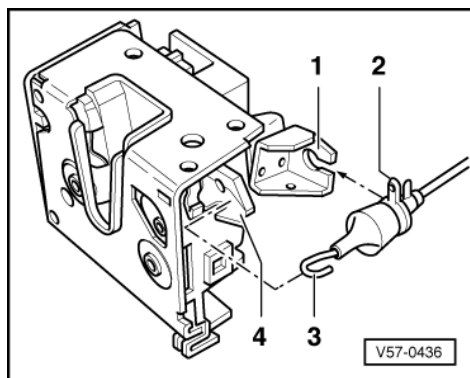
→ Fig.1 Key for profile cylinder

- Key -1- for vehicles with profile cylinder in door lock.



→ Fig.1 Installing lock cylinder securing rod

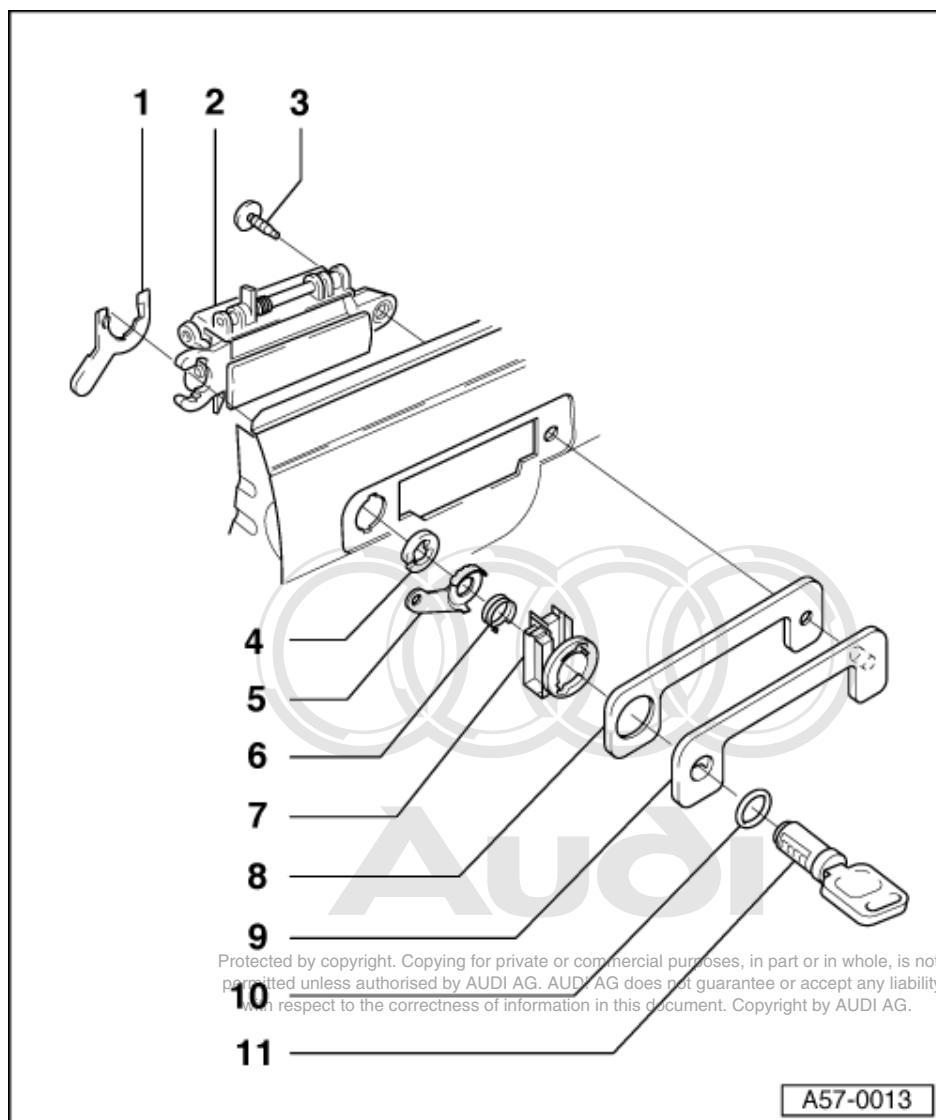
- Clip jointed bushing -2- into operating lever -1-
- Insert lock cylinder securing rod -3- into hinged bush and clip in position.
- Swivel operating clip -4- 1/4 turn (90°), insert into door lock release lever -5- and swivel back upwards.
- Clip lock cylinder locking rod with no play into operating clip, taking care not to strain door lock operating lever.
 - Max. play 1 mm
- Push up sleeve on operating clip.



→ Fig.2 Removing and installing Bowden cable for inside door control

- Disengage hook -3- from operating lever -4-
- Give end piece of Bowden cable a 1/4 of a turn (90°) (lug -2- disengages) and remove downwards from holder -1-
- When installing, note attachment direction of Bowden cable.

2.6 - Removing and installing front door handle



- Front door trim removed

=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
Front door trim Removing and installing front door trim

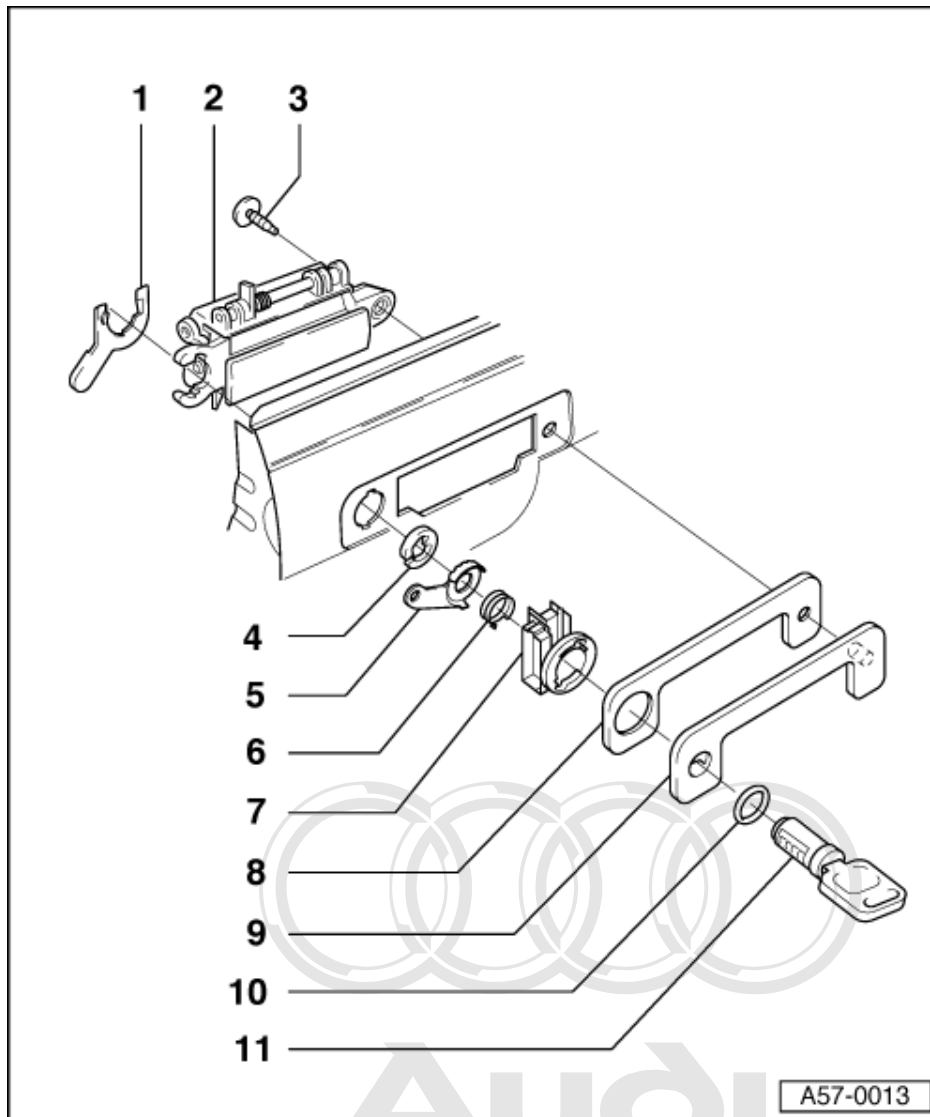
- Door component carrier removed => Page 36 .

1 Rotary clip

- ♦ To unfasten, swivel to rear (away from direction of travel)

2 Door handle

- ♦ Removing:
 - Removing door handle trim to avoid damaging paintwork => Fig. 2 .
 - Remove rotary clip -item 1 - and unscrew combi bolt -item 3 - .



3 Combi screw - 5 Nm

4 Circlip

- ♦ With outer face key (approx. 02.96 ä)

4 - Clip

- ♦ With inner face key (approx. 02.96 ä)

5 Actuating arm

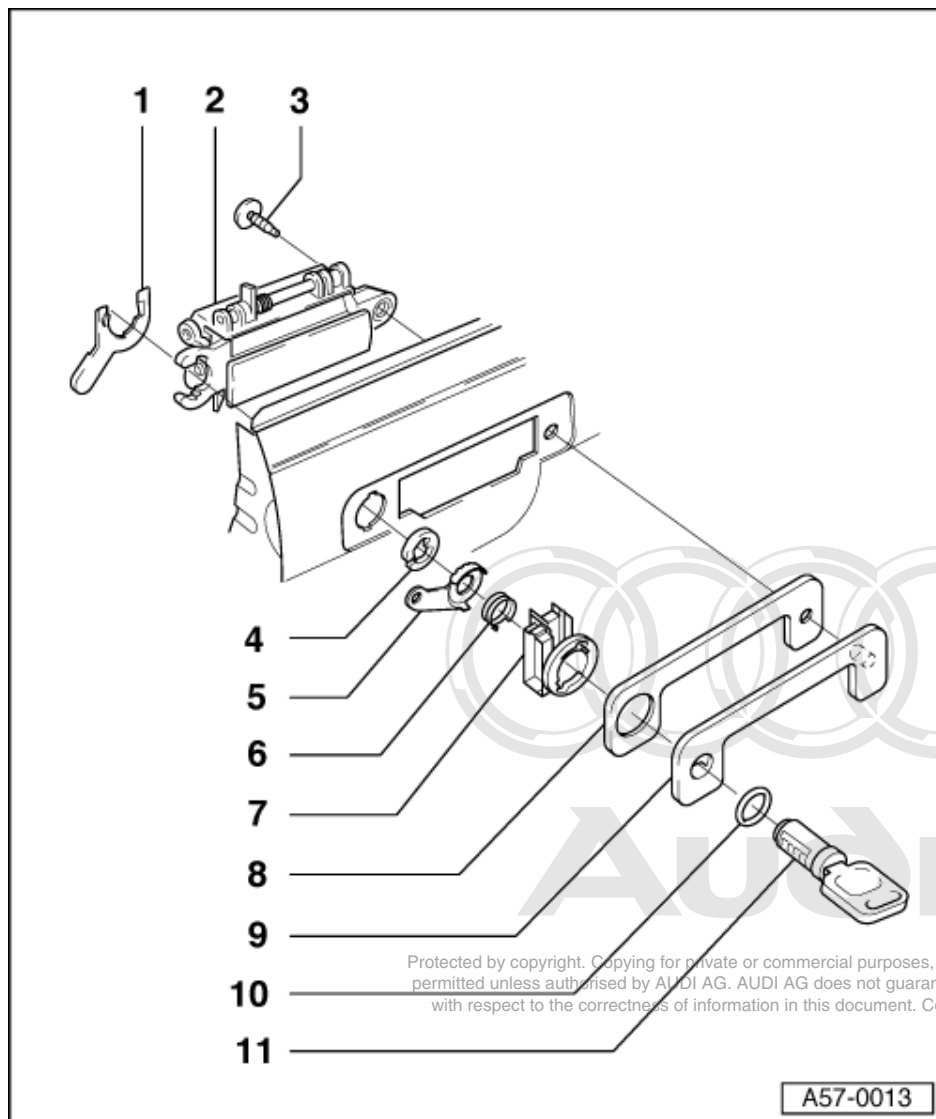
- ♦ Installation position => Fig. 3.
- ♦ In the case of inner face key (approx. 02.96 ä), it cannot be replaced separately.

6 Spring

- ♦ Cannot be renewed separately
- ♦ Installation position => Fig. 1.

7 Housing

- ♦ To remove: Dismantle door handle -item 2 - and lock cylinder -item 11 -



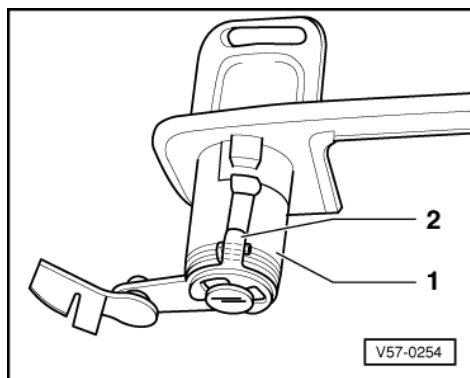
8 Shim plate

9 Panel

10 Sealing ring

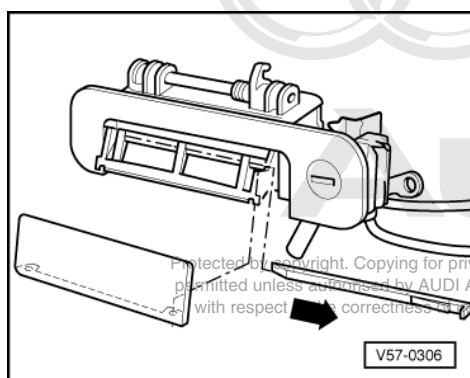
11 Lock cylinder

- ◆ In the case of inner face key (approx. 02.96 ä), it cannot be replaced separately.
- ◆ Remove only with key inserted
 - Lever circlip -item 4 - out of groove of the lock cylinder.
 - Detach driver -item 5 - with spring -item 6 -.
 - Withdraw lock cylinder with key.



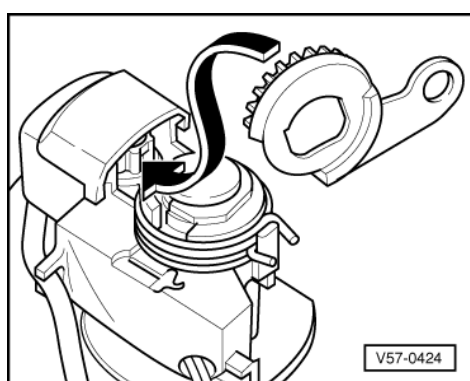
-> Fig.1 Installation position of spring

- ◆ Ends of spring -1- must be to the left and right (respectively) of the operating lever -2- when under tension.
- ◆ Operating lever and lock cylinder are constantly pushed into the centre position by the pre-loading.



-> Fig.2 Removing cover for door handle

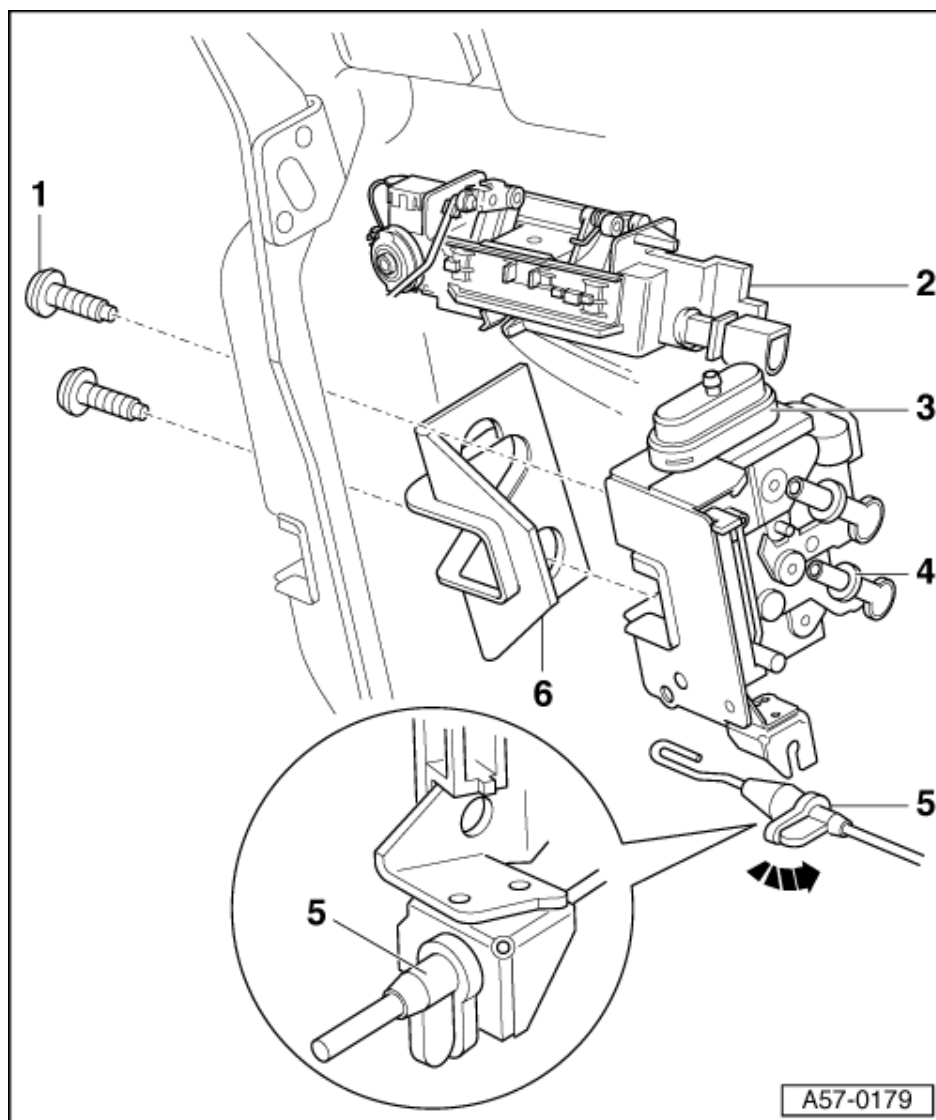
- Pull up door handle.
- Use small screwdriver to lever fastening strip out of door handle in direction of arrow and pull out.
- Remove door handle cover.



-> Fig.3 Installation position of actuating arm

To ensure that the central locking system and/or anti-theft alarm operate properly, the half-closed pitch of the actuating arm must coincide with the half tooth of the microswitch gear.

2.7 - Removing and installing front door lock for inner face key with operating elements



Note:

Inner face key => Fig. 1

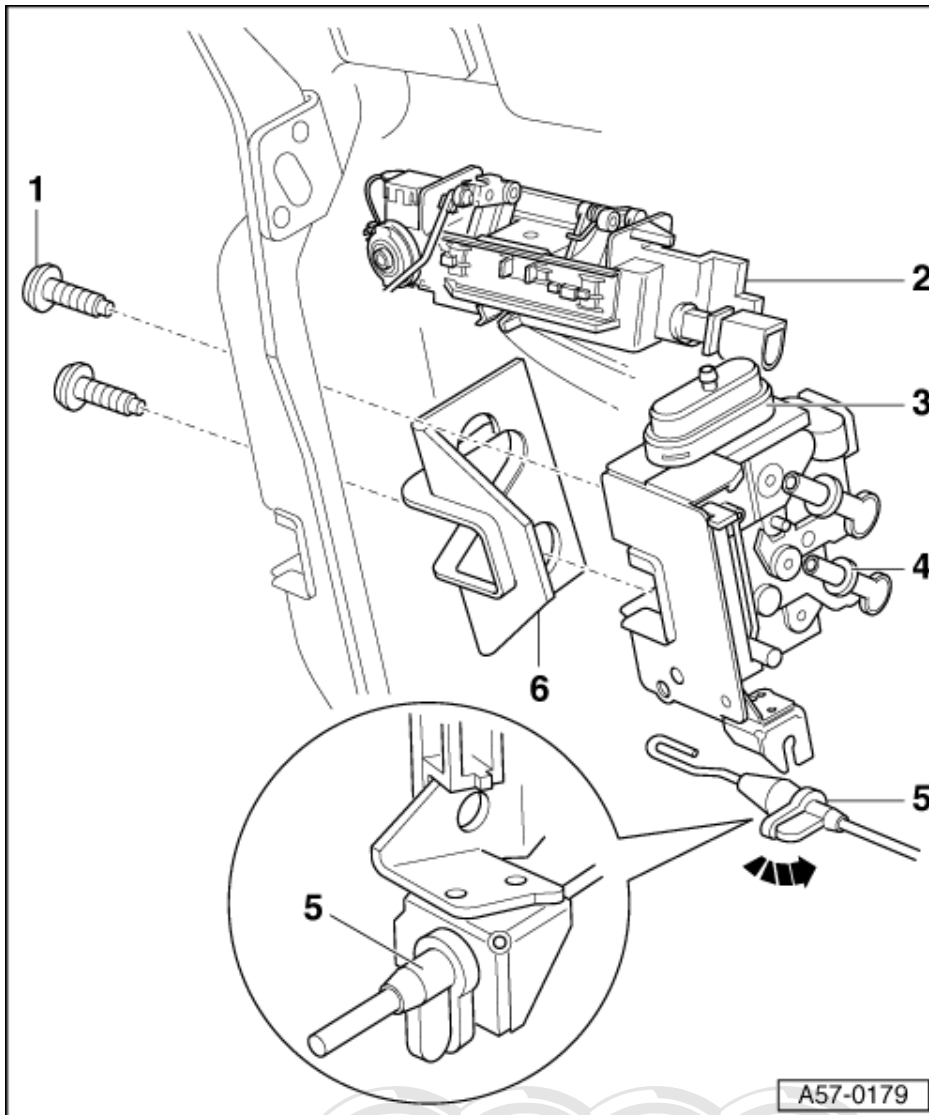
- 1 Bolt (2x)**
 - ♦ Tightening torque 9.5 Nm.
- 2 Door handle**
 - ♦ Removing and installing => Page 65
- 3 Door lock**
 - ♦ Removal:
 - ♦ Remove door trim

=> General Body Assembly, Interior; Repair group 70

- Door subframe removed.
- Remove cover for door lock => Page 58 .
- Unclip retaining and operating rods

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=>Page 61 .



- Detach connecting hose from actuator for central locking system.
- Unscrew bolts -1-.
- Remove door lock and lock base plate -2-
- ◆ Installation:
- Install in reverse order.

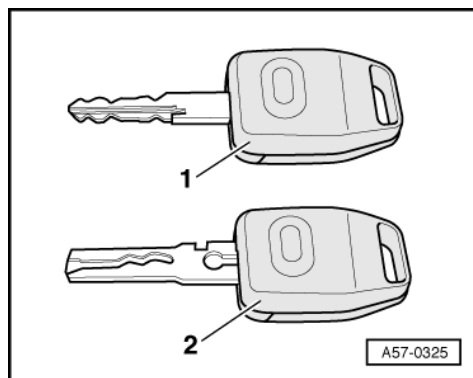
4 Operating clip

- ◆ Installing => Page 61 .

5 Bowden cable for interior door handle

- ◆ Removal:
- Door sub-frame removed.
- Remove cover for door lock =>Page 60 .
- Release Bowden cable (shown released in magnified view), unclip downwards and disengage from door lock.
- ◆ Installation:
- Install in reverse order.

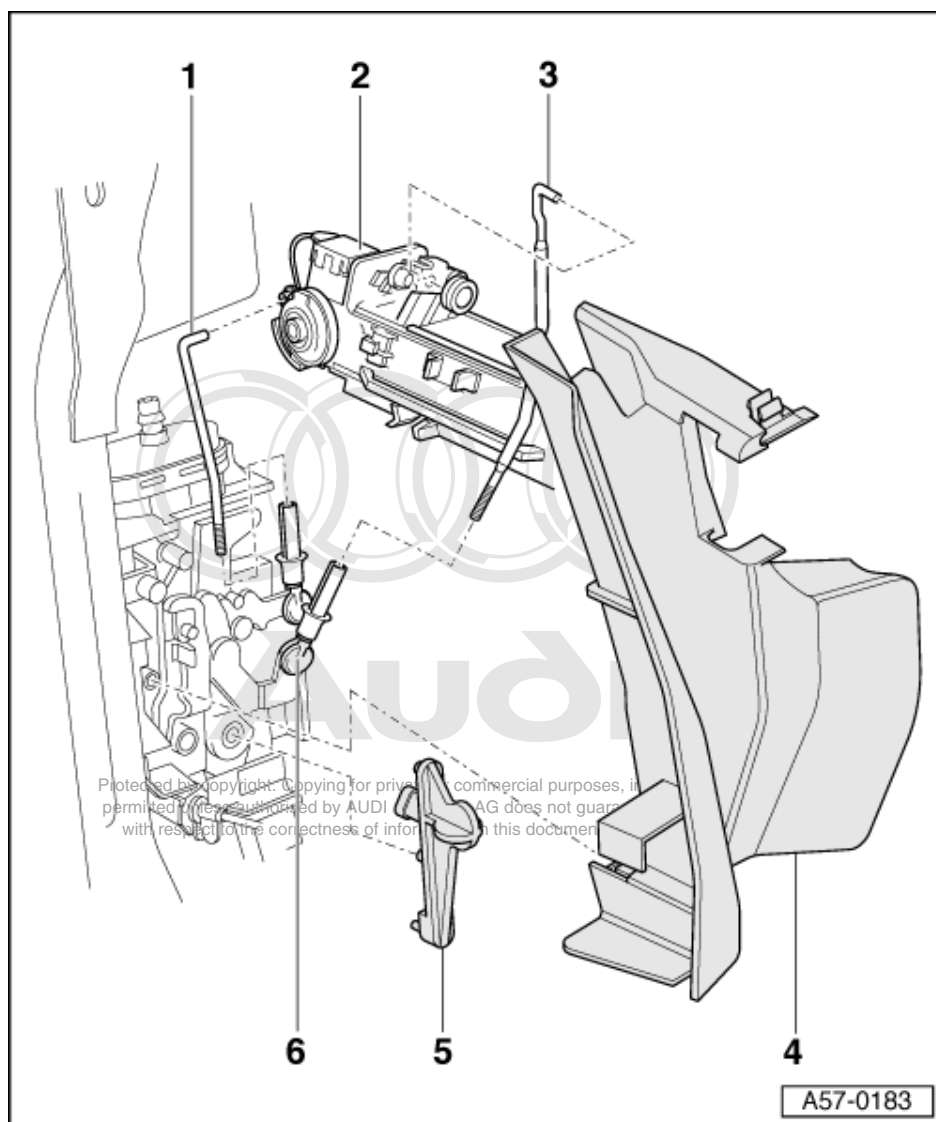
6 Lock base plate



-> Fig.1 Inner face key

- Key -2- for vehicles with inner face cylinder in door lock.

2.8 - Removing and installing cover for door lock



1 Lock cylinder securing rod

- ◆ Clip in bushing on release lever.

2 Door handle

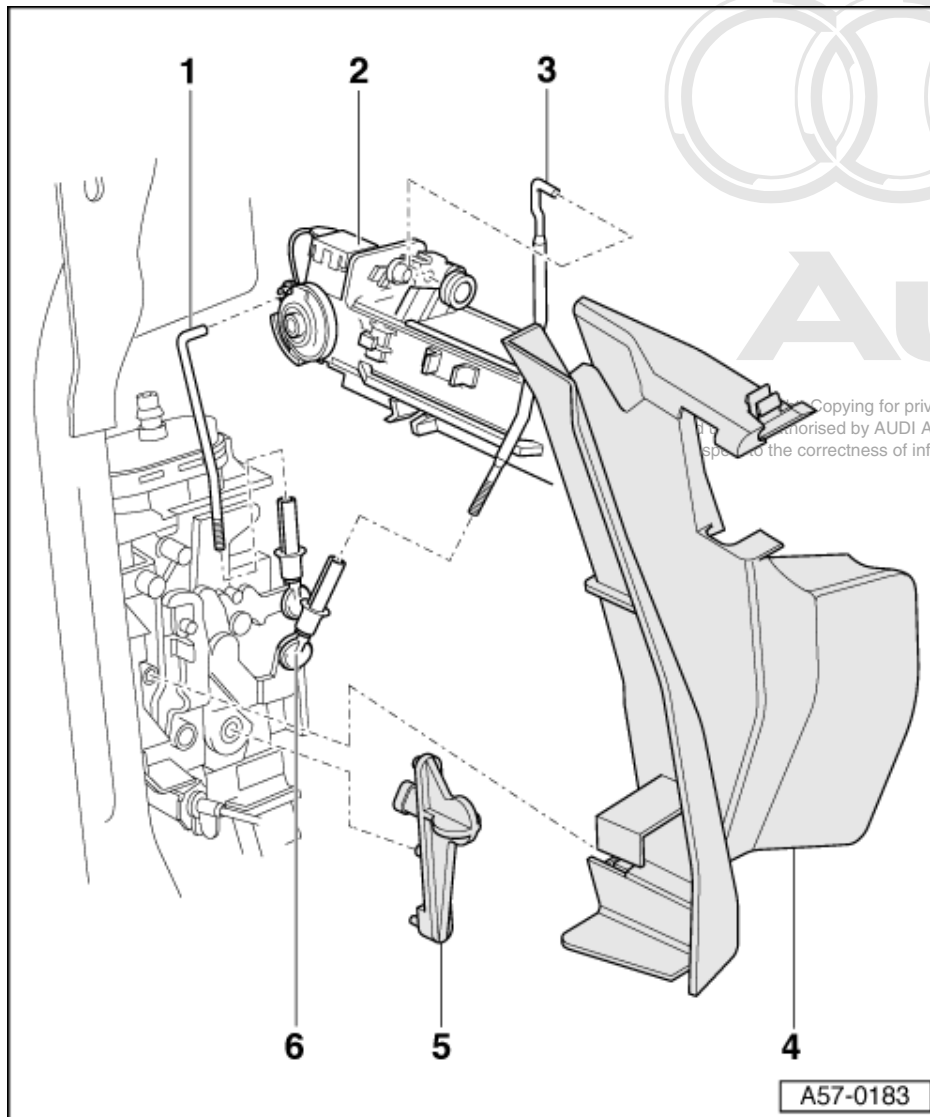
- ♦ Removing and installing => Page 65

3 Door lock operating rod

- ♦ Adjustment depth for securing rod in operating clip => Fig. 3

4 Door lock cover

- ♦ To remove, first unclip at top, then remove from door lock to rear at bottom.



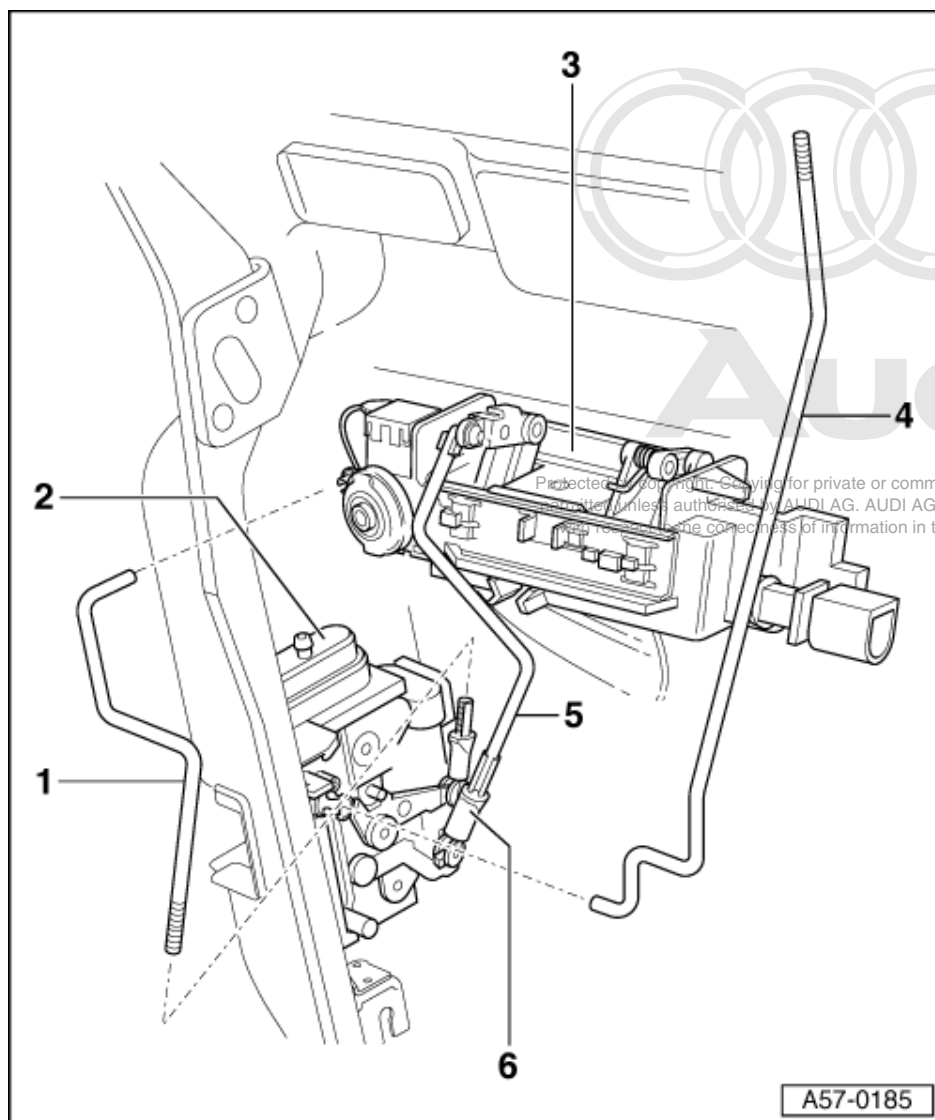
5 Installation pin

- ♦ Only fitted in new parts - serves as locating aid.
- ♦ Only remove door lock once operating rod has been installed.

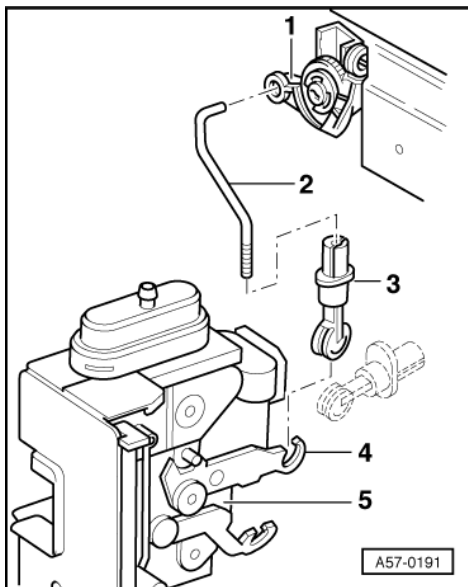
6 Operating clip

- ♦ Attaching in door lock => Page 61

2.9 - Removing and installing operating rods for front door lock

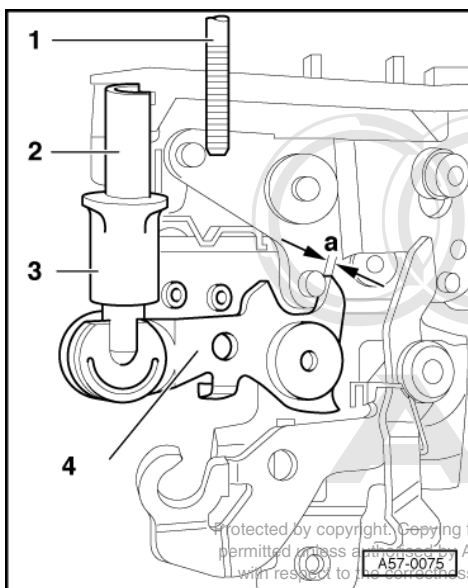


- 1 Lock cylinder securing rod**
 - ♦ Installing => Page **61** .
- 2 Door lock**
- 3 Door handle**
 - ♦ When removing the door handle, the retaining rod and operating rod -5- must be detached from the door handle.
- 4 Operating rod**
 - ♦ Unclip from door lock to remove.
- 5 Operating clip**
 - ♦ Installing => Page **61** .



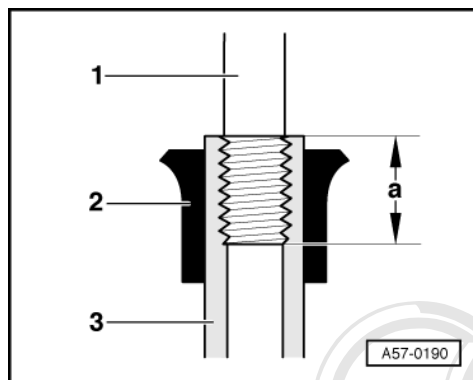
-> Fig.1 Removing and installing retaining rod for lock cylinder

- Insert and clip retaining rod -2- for lock cylinder in bushing on release lever -1-.
- Tilt operating clip -3- at 90° (not visible in illustration), insert in release lever -4- and then swivel upwards.
- Clip retaining rod -2- in operating clip -3-.
- Do not strain locking lever -4- on door lock -5- (max. play at locking lever 1 mm => Fig. 2)
- Push sleeve on operating clip -3- upwards.



-> Fig.2 Adjusting play for locking lever

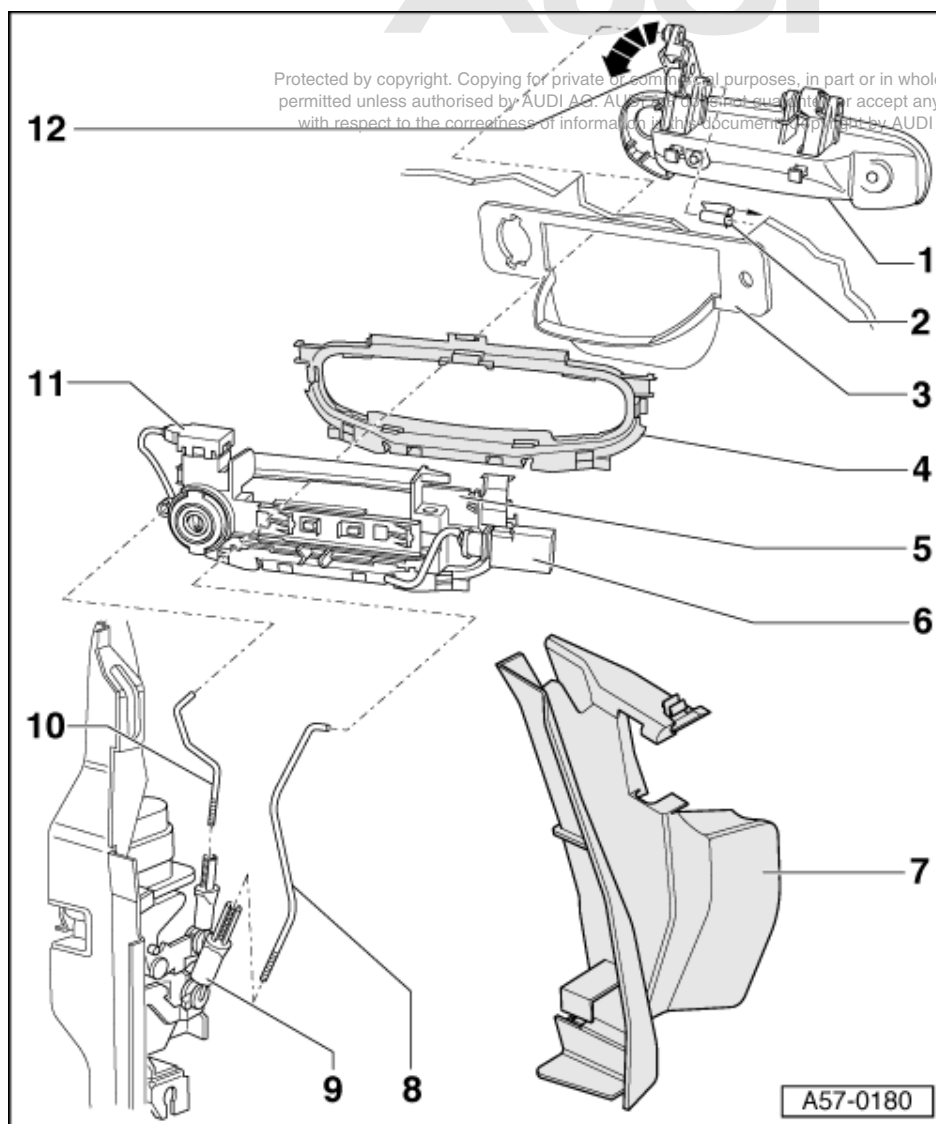
- Enter securing rod -1- in operating clip -2- such that dimension -a- at locking lever -4- is approx. 1 mm.
- Dimension -a- = 13mm (adjustment depth of retaining rod) must be observed => Fig. 3



-> Fig.3 Adjustment depth for retaining rod

- When correctly adjusted, dimension -a- of retaining rod must be $13\text{mm} \pm 3\text{mm}$.
- After adjustment is complete, push the sliding sleeve -2- upwards from actuation clip -3-.

2.10 - Front door handle Assembly overview



9 Operating clip

- ♦ Installation =>Page 61 .

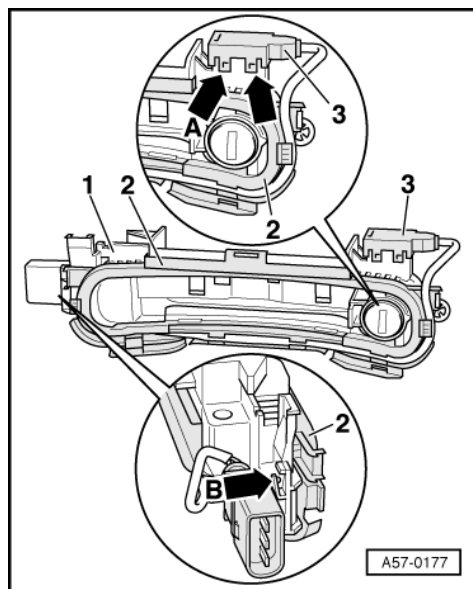
10 Lock cylinder securing rod

- ♦ Installation =>Page 61

11 Microswitch

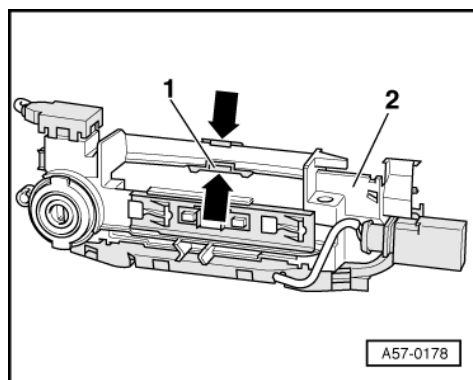
- ♦ Vehicles with anti-theft alarm only.
- ♦ Removing and installing => Fig. 1 .

12 Hinged lever



-> Fig.1 Removing and installing microswitch

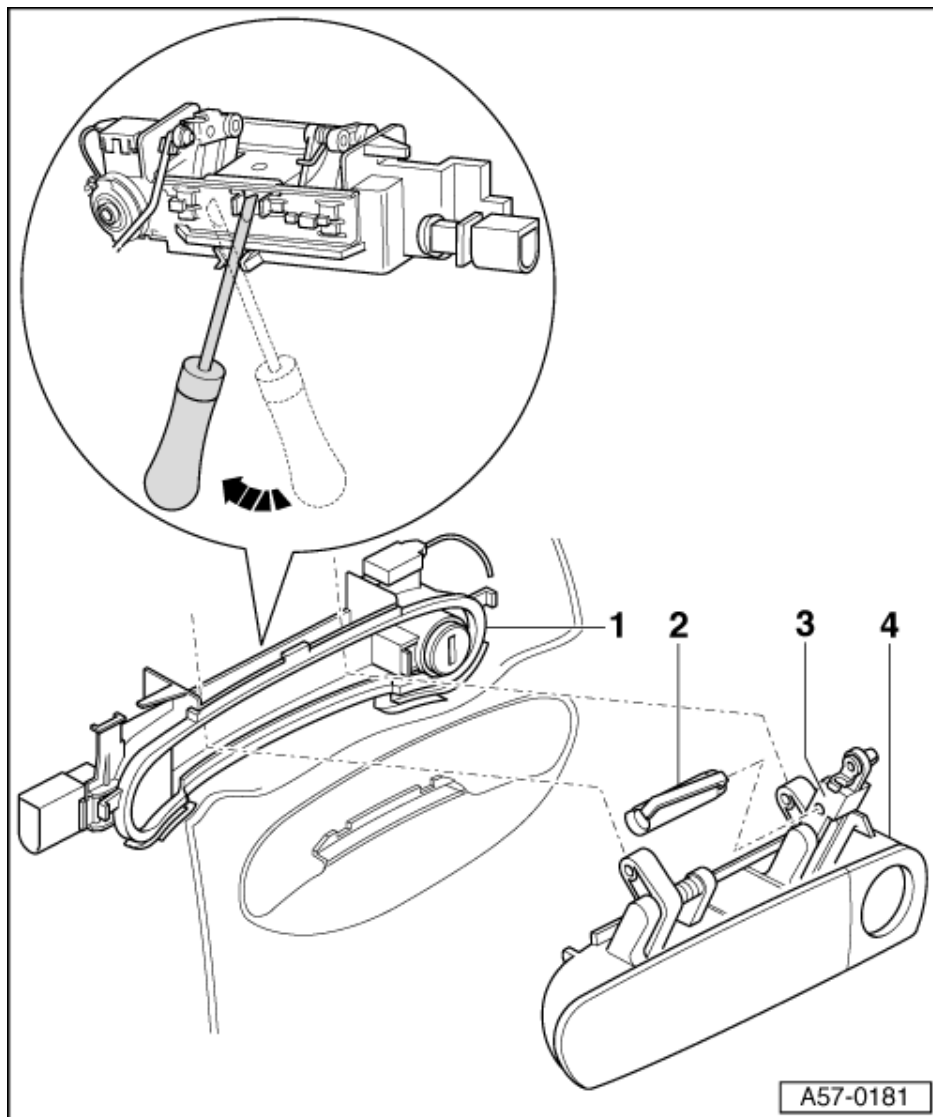
- Door handle mount -1- removed.
- Carefully release catches -arrows A- and detach microswitch -3- upwards.
- Push catch -arrow B- back and remove connector from mount by pushing upwards.
- Remove connector cable from seal -2-.
- Ensure when installing that the cable is fully inserted into seal as shown.



-> Fig.2 Removing and installing door handle seal

- Unclip and detach seal to remove.
- When installing, the seal must engage fully in mount -arrow- to guarantee absence of leaks.

2.11 - Removing door handle



1 Door handle mount

- ◆ The lock cylinder is part of mount and cannot be replaced separately.

2 Locking pin

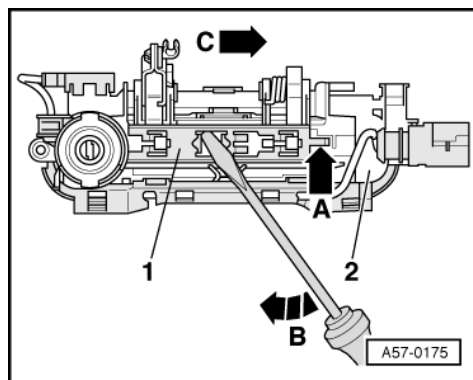
- ◆ Hinged lever must fully engage in spring catch when installing.

3 Hinged lever

4 Door handle

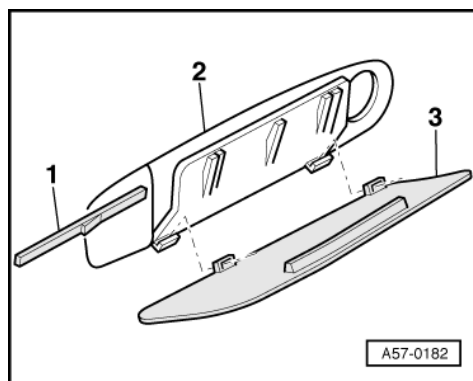
- ◆ Door trim and door subframe removed prior to removal of door handle.
- ◆ Remove locking pin -2- and fold up hinged lever -3- to remove.
- ◆ Release slide on door handle mount -1- using a screwdriver => Fig. 1.
- ◆ Detach mount for door handle and lock cylinder with door handle.

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-> Fig.1 Releasing mount for door handle

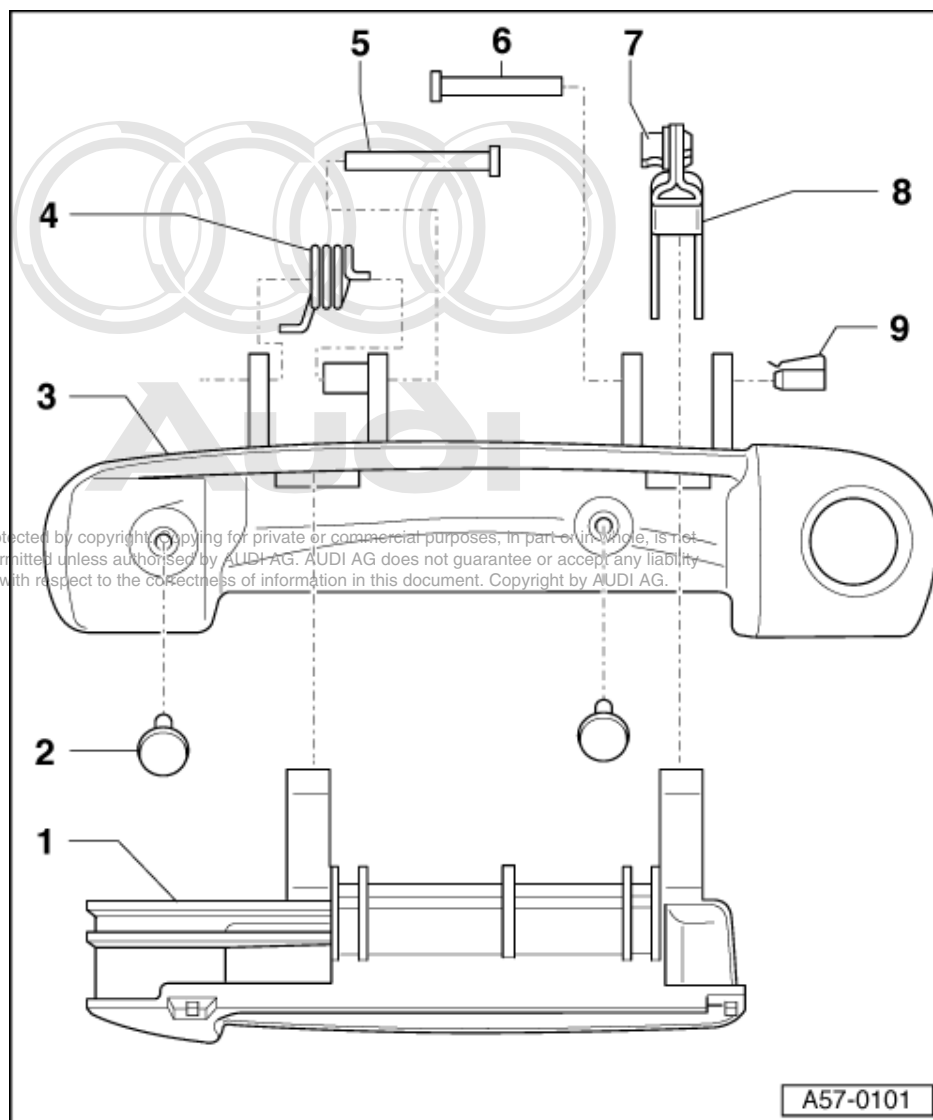
- Use small screwdriver to release catch for slide, -arrow A- by raising it slightly.
- Release slide -1- in direction of arrow -C- using a screwdriver which must be pushed in direction of arrow -B-.



-> Fig.2 Removing cover

- To remove, pull up door handle -2- push out catch -1- in axial direction with small screwdriver and detach trim -3-.

2.12 - Front door handle pre-assembly



Note:

Replacement door handles must be painted and pre-assembled prior to installation.

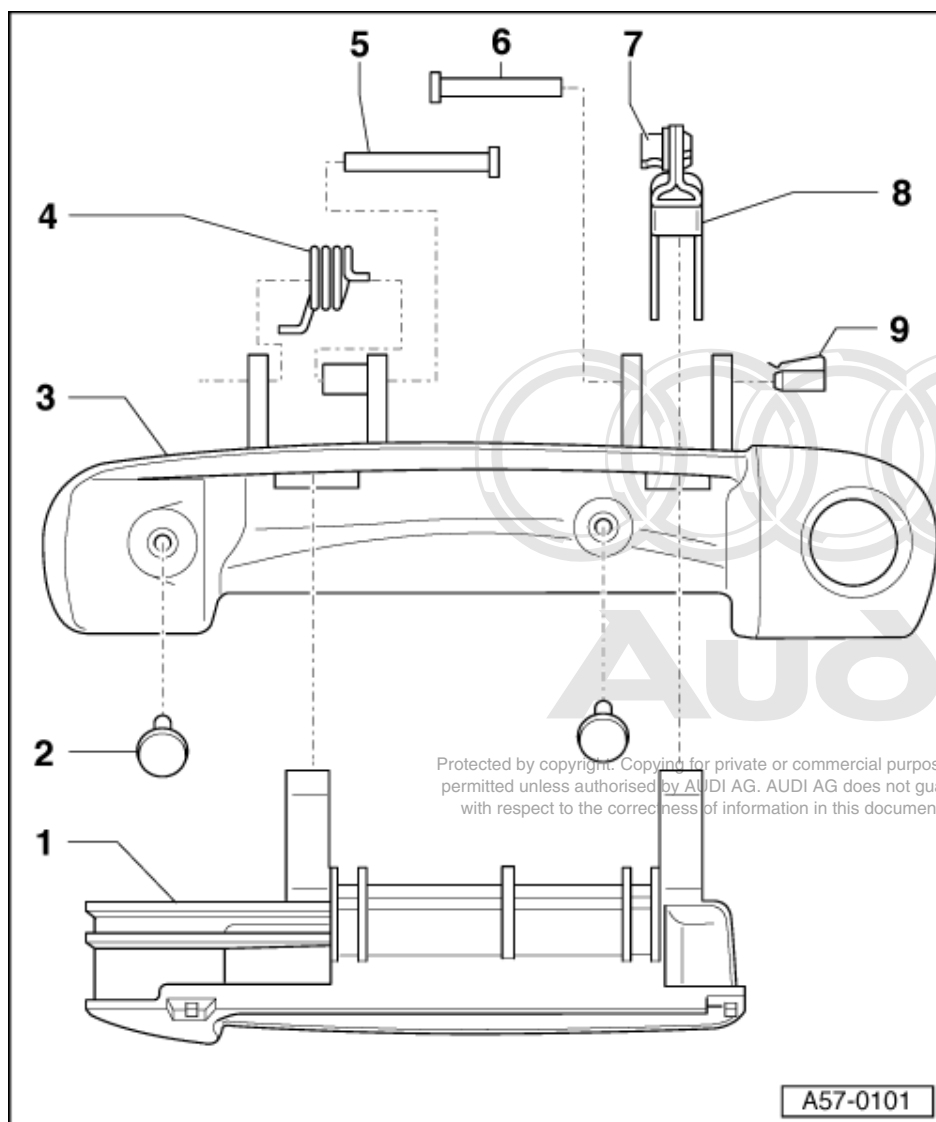
1 Door handle

- ◆ For assembly insert spring -4- in mount.
- ◆ For pre-assembly insert door handle in mount -3- and push on hinged lever -8-.
- ◆ Insert pivot pins -5- and -6- and caulk with centre punch as shown in Fig. 1 .
- ◆ Insert spring -4- as shown in Fig.2.

2 Buffer

- ◆ Insert after painting.

3 Door handle mount



4 Spring

- ◆ Installation position => Fig. 2 .
- ◆ Lubricate spring with grease
Lubricate G 052 745 A3.

5 Pivot pin

- ◆ Note different lengths.
- ◆ Caulking => Fig. 1 .

6 Pivot pin

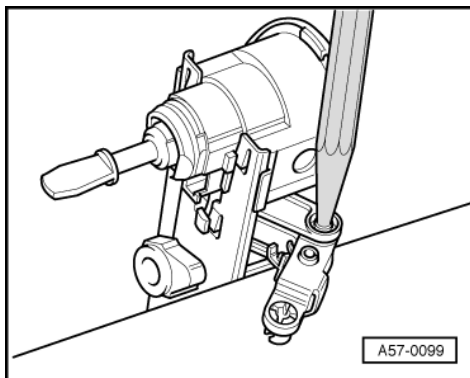
- ◆ Note different lengths.
- ◆ Caulking => Fig. 1 .

7 Clip

8 Hinged lever

9 Locking pin

- ◆ Assembly => Fig. 3 .

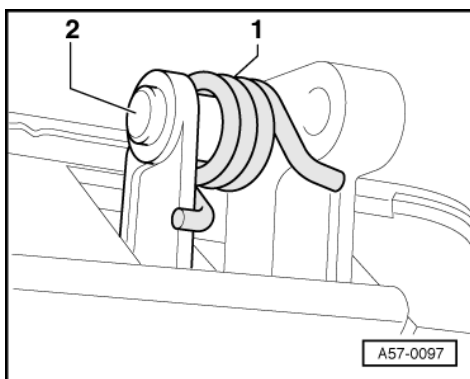


-> Fig.1 Caulking pivot pin

Note:

Before caulking pivot pins, protect painted surfaces with fabric adhesive strip.

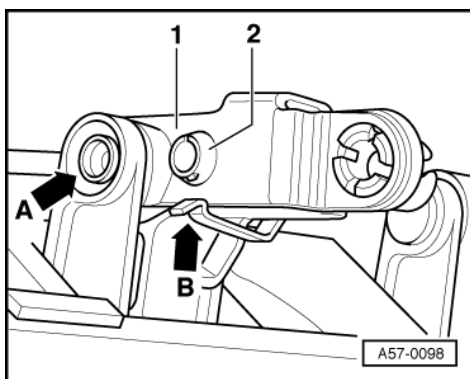
- Place pre-assembled door handle on a firm base (e.g. vice jaws).
- Secure pivot pins by tapping gently with a centre punch to stop them falling out.
- Check freedom of movement of hinged lever after caulking.



-> Fig.2 Installation position of spring

- Fit spring -1- as shown.
- Lubricate with G 052 745 A3.
- Pivot pin -2-

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-> Fig.3 Installation of locking pin

- Use improvised tool to fully insert locking pin.
- Spring clip at locking pin, -arrow B- must engage behind hinged lever.

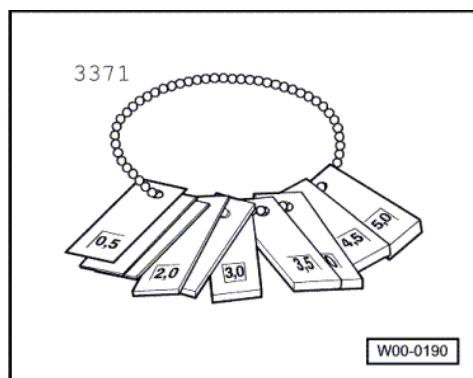
- Arrow -A- = caulked pivot pin.

3 - Adjusting door - adjustment sequence

3.1 - Adjusting door - adjustment sequence

3.2 - I - Adjusting door shell

- Front door trim removed:



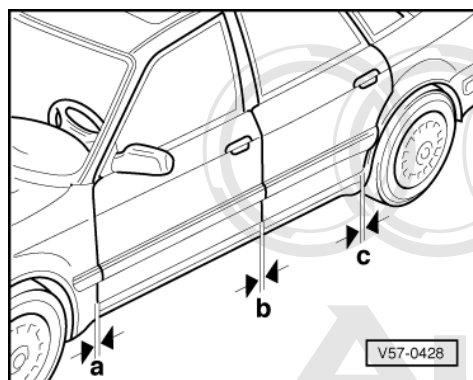
=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
Front door trim Removing and installing front door trim

Special tools, testers and auxiliary items required

- ♦ Special tool 3371

Note:

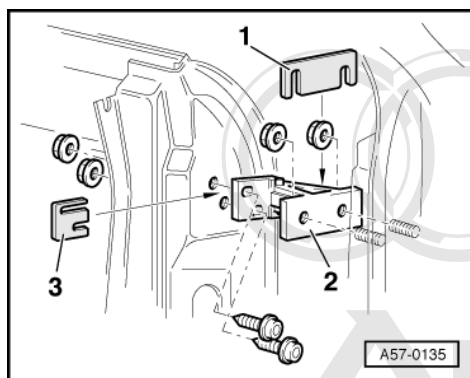
Rear door shell must have already been adjusted => Page **105**.



- ♦ -> Dimension a = 3.5 - 0.5 mm
- ♦ Dimension b = 4.5 - 0.5 mm
- ♦ Dimension c = 3.5 - 0.5 mm

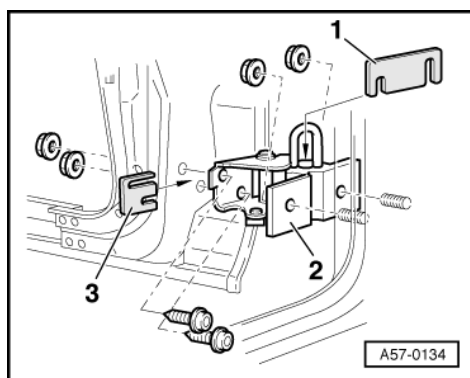
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1. Joint dimensions



-> Upper door hinge:

- ◆ Unscrew nuts at hinge -2-, move door with hinge (oversize holes in hinge)
- or
- ◆ Loosen bolts at hinge -2-, insert packing plate -3-
- ◆ Tightening torque 30 Nm

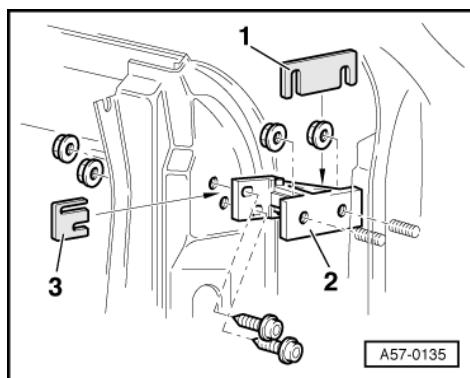


-> Lower door hinge:

- ◆ Unscrew nuts at hinge -2-, move door with hinge (oversize holes in hinge)
- or
- ◆ Loosen bolts at hinge -2-, insert packing plate -3-
- ◆ Tightening torque 30 Nm

2. Adjusting to the body contour

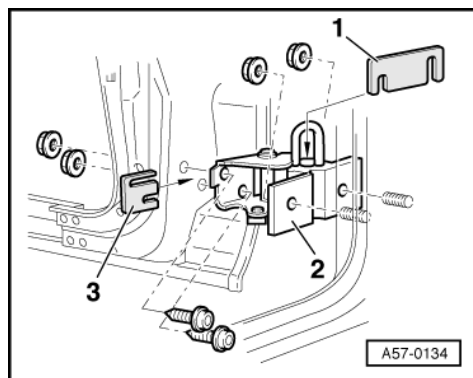
Note:



Adjustment in front door area is made at hinge; in rear door area by moving striker wedge.

-> Upper door hinge:

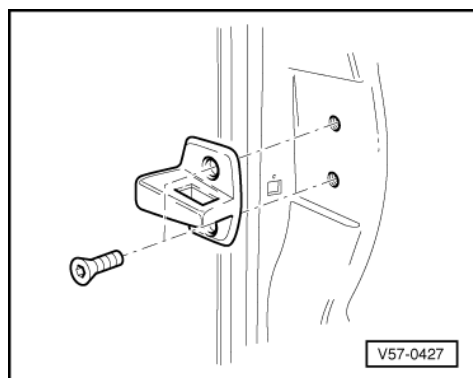
- ♦ Loosen bolts at hinge -2-, move door (oversize holes in hinge)
- ♦ Tightening torque 30 Nm



-> Lower door hinge:

- ♦ Loosen bolts at hinge -2-, move door (oversize holes in hinge)
- ♦ Tightening torque 30 Nm

Adjustment by means of striker wedge:



- -> Loosen Torx bolts.
- Move striker wedge until door shell is flush with bodywork contour.
- Tighten Torx bolts to 16 Nm.

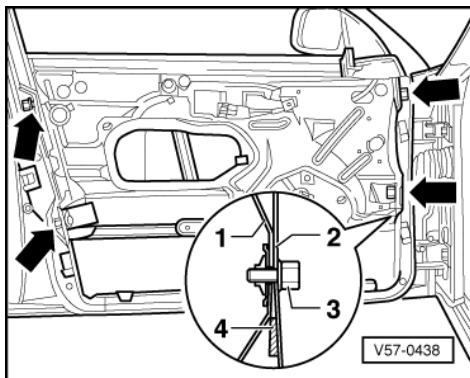
3.3 - II - Adjusting door subframe

Note:

The inclination of the front door at the B pillar can be adjusted by altering the position of adjuster. If, for example, the rear area of door projects too far at the bottom, the adjuster must be pushed further up. The bottom of the door consequently slopes towards the centre of the vehicle and the top of the door leans outwards.

- Door shell adjusted => Page 70 onwards.

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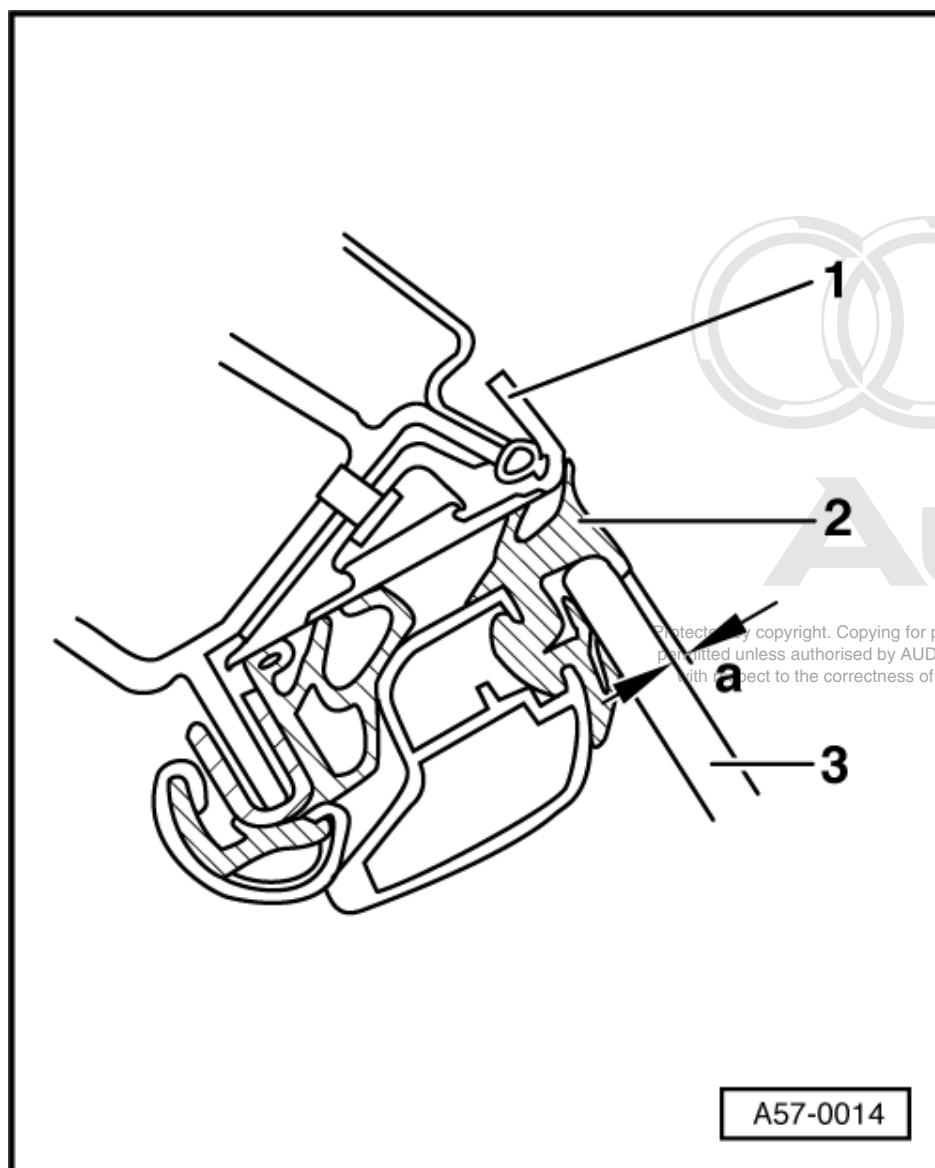


- -> Adjusting wedge -4- must always be installed.
- Release -3- bolts -arrows-.
- Close door.
- Slightly tighten the top screws from inside while a second fitter presses the door component carrier against the roof and the pillar (the force used to push the carrier must overcome the counteracting forces resulting from the rubber seal).
- Push adjuster -4- upwards until it makes contact with surfaces of door shell -2- and subframe -1-.
- Tighten bolts to 30 Nm.



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Check dimension for door subframe



-> The outer sealing lip -2- must be flush along the pillar and roof trim strip -1-.

Gap between roof trim strip and door window -3-:

- ♦ Dimension $a = 2.5 \pm 1 \text{ mm}$

4 - Central locking

4.1 - Central locking

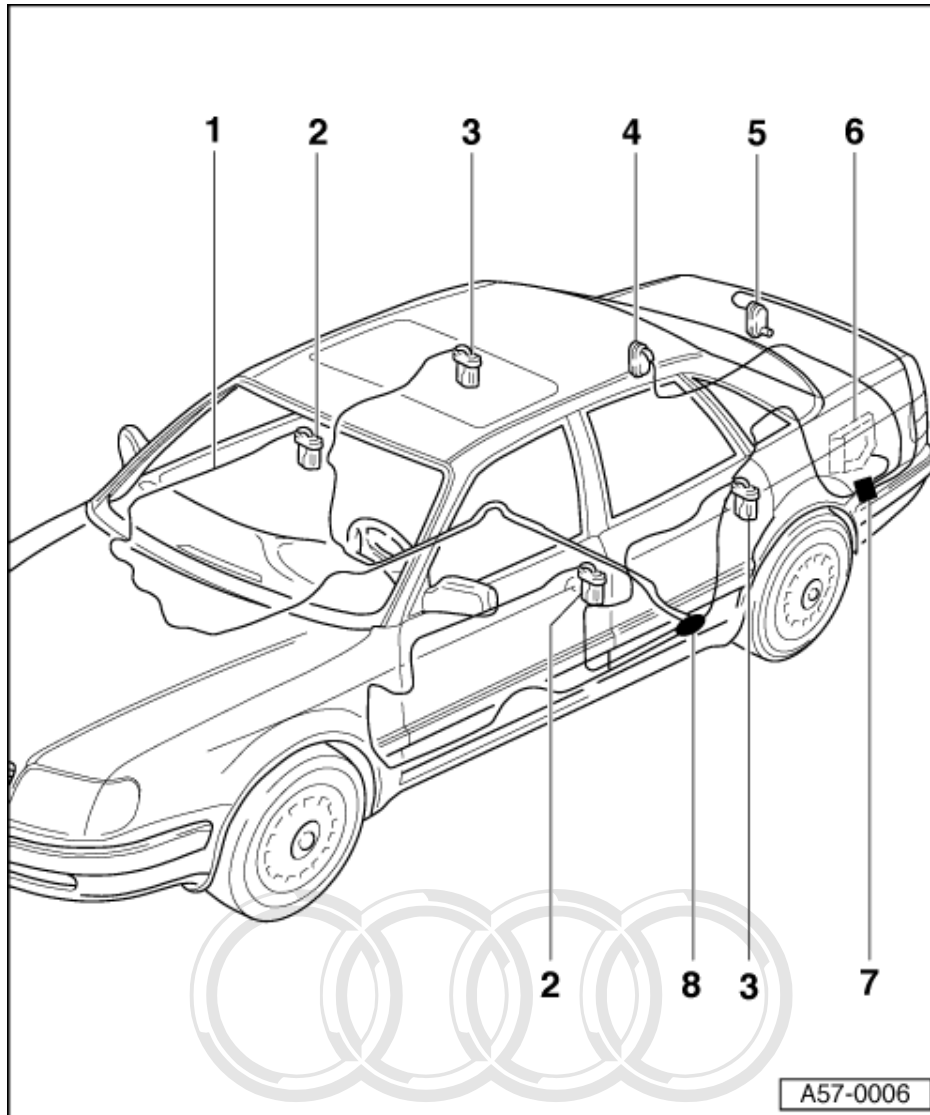
Notes:

- ♦ If the vehicle has parked for a long period and the central locking pump is replaced, the central locking must be repeatedly actuated before the central locking system is fully operational.
- ♦ If the system is intact, all locks must be locked after approx. 2 seconds. If the pump runs for more than 5 seconds, there is a leak in the system. If the system is leaking, the pump must not run for more than 30 seconds before the control unit in the central locking system pump switches the pump off.

- ♦ All actuators, as well as the front and rear junctions, are provided with special connectors which engage on insertion.
- ♦ Additional information

=> "Current Flow Diagrams, Electrical Fault-finding and Fitting Locations" binder

4.2 - Central locking system - exploded view



1 Pressure line

2 Front left/right door actuator

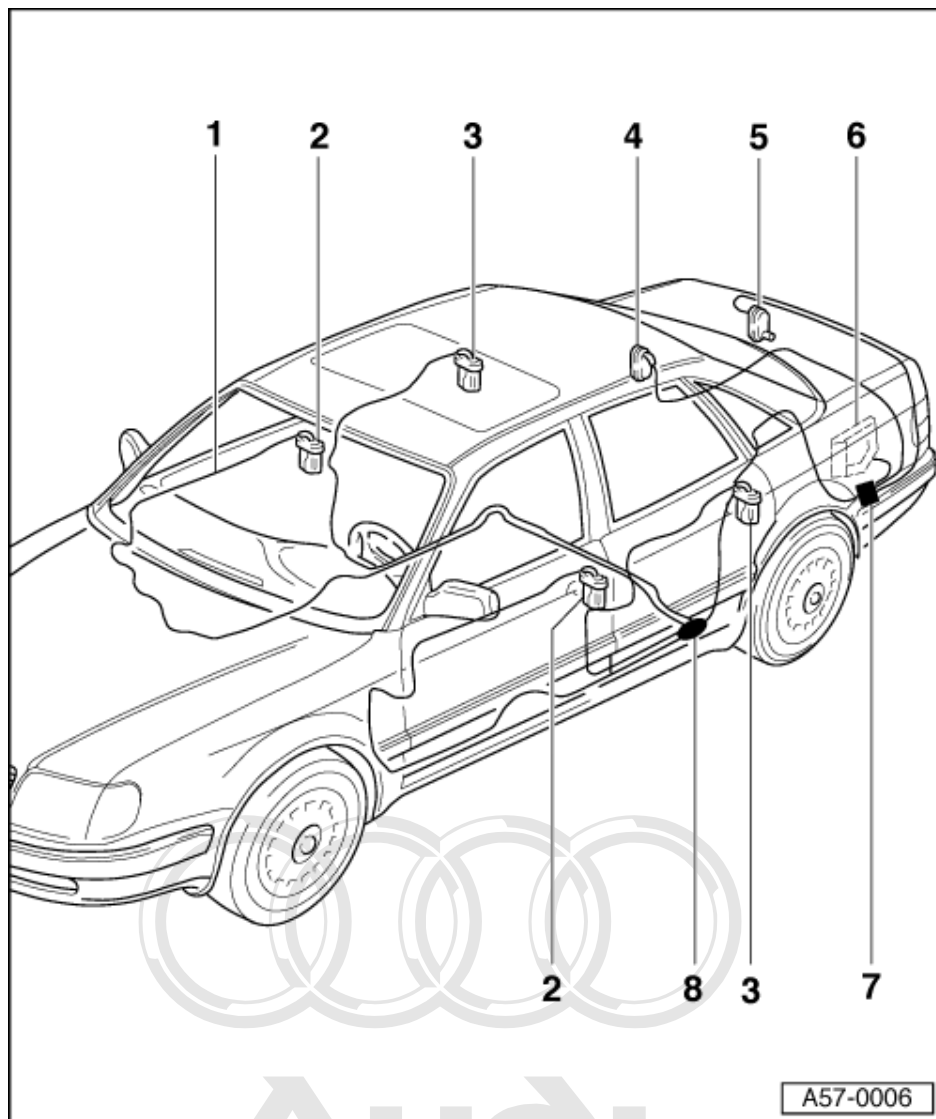
- ♦ Removing and installing =>Fig. 2
- ♦ Disengaging Bowden cable for interior door mechanism
=>Page 51.

3 Control element for rear door, left/right

- ♦ Removing and installing =>Fig. 3
- ♦ Disengaging Bowden cable for interior door mechanism
=>Page 51.

4 Control element for fuel flap

- ♦ Removing and installing =>Fig. 4



5 Boot lid actuator

- ◆ Removing and installing => Fig. 5
- ◆ Pipe routing => Fig. 6

6 Central locking system pump

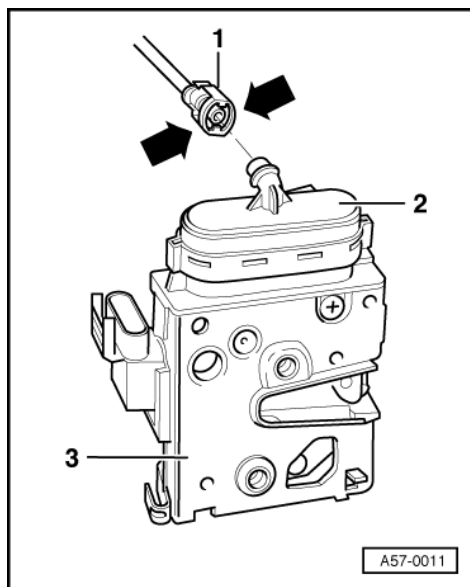
- ◆ Removing and installing => Fig. 7

7 Rear junction

- ◆ Permanently connected to lines, except line to boot lid
- ◆ Detaching connector to boot lid => Fig. 1

8 Front junction

- ◆ Permanently connected to pipes except pipe to rear junction
- ◆ Detaching connector to rear junction
=> Fig. 1



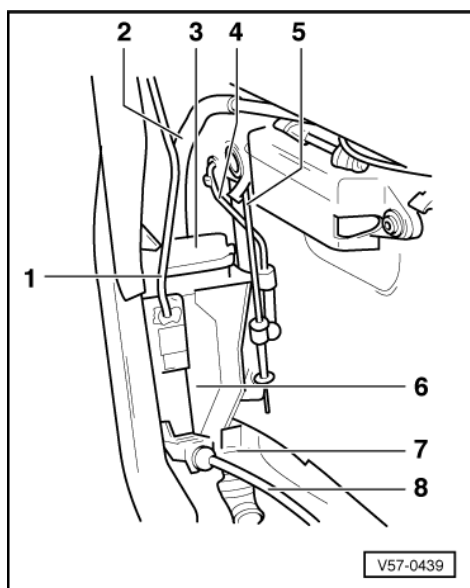
-> Fig.1 Unplugging connector

Note:

Connectors -1- on control elements -2- and on connector at points indicated by arrows are secured by a catch.

- Squeeze connector together at arrows to release catch.
- Detach connector.

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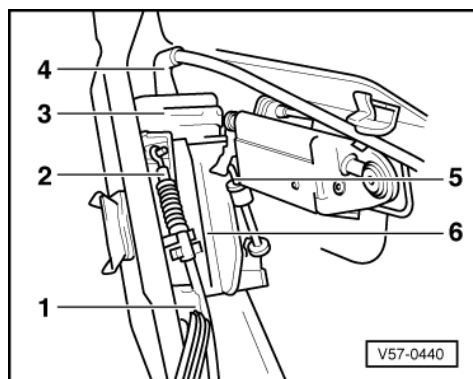
-> Fig.2 Removing and installing front door actuator

- Removing front door trim:

=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
Front door trim Removing and installing front door trim

- Remove door subframe =>Page 36
- Disengage locking rod -1-.
- Unclip lock operating rod -5-.
- Unclip securing rod for lock cylinder -4-.

- Unscrew combi bolts of door lock -6- (8 Nm).
- Release pressure line connection -2- and detach from actuator -3- => Fig. 1
- Detach connector -7-.
- Disengaging Bowden cable for inside door mechanism -8- => Page 51 .



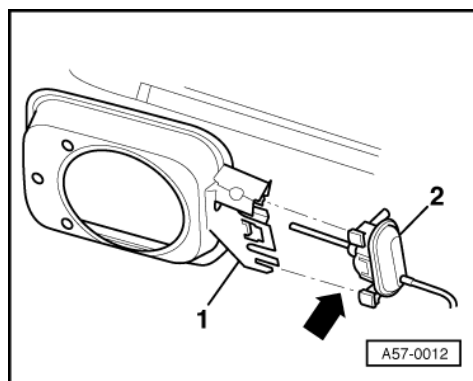
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-> Fig.3 Removing and installing rear door actuator

- Removing rear door trim:

=> General Body Assembly, Interior; Repair group 70; Rear door trim; Removing and installing rear door trim
 Rear door trim Removing and installing rear door trim

- Remove door subframe =>Page 82
- Unclipping and disengaging lock operating rod -5- => Page 51 .
- Unclip Bowden cable -2-.
- Unscrew combi bolts of door lock -6- (8 Nm).
- Release pressure line connection -4- and detach from actuator -3- => Fig. 1
- Disengaging Bowden cable for inside door mechanism -1- => Page 51 .

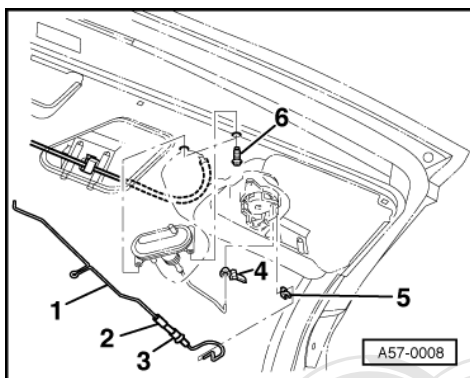


-> Fig.4 Removing and installing tank filler flap actuator

- Removing boot trim:

=> General Body Assembly, Interior; Repair group 70; Trims; Removing boot trim Trims Removing boot trim

- Press retainer tab -arrow- and pull actuator -2- to the rear to remove from holder.

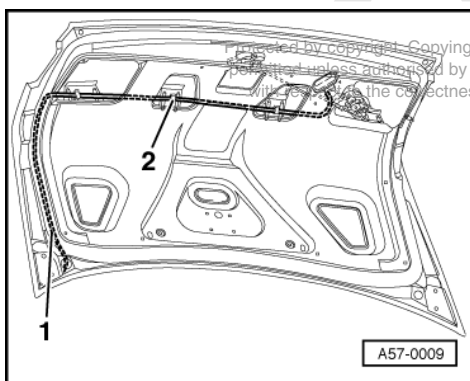


→ Fig.5 Removing and installing boot lid actuator

- Removing boot lid trim:

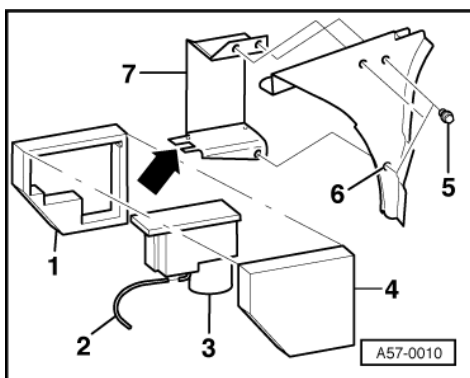
=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing boot lid trim Trim panels Removing boot lid trim

- Disengage operating rod from clip -4-.
- Unscrew bolts -6- (2 Nm).
- Detach hose from actuator



→ Fig.6 Line routing in boot lid

- Clip line -1- for central locking system into holders -2-.





-> Fig.7 Removing and installing central locking pump

Note:

The central locking system pump is located in the boot on the left-hand side, behind the side panel.

- Removing rear left boot trim:

=> General Body Assembly, Interior; Repair group 70; Trims; Removing boot trim Trims Removing boot trim

- Bend down tabs -arrow- and pull the central locking system pump -3- out towards the rear to remove from bracket -7-
- Open up insulation -1- and -4- and take out pump.
- Detach line -2- from pump.
- Unscrew bolts -5- to remove bracket.

Note:

After installing central locking system pump, tabs -arrow- of bracket must always be bent back up again.



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58 - Rear doors/Door components

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

Important

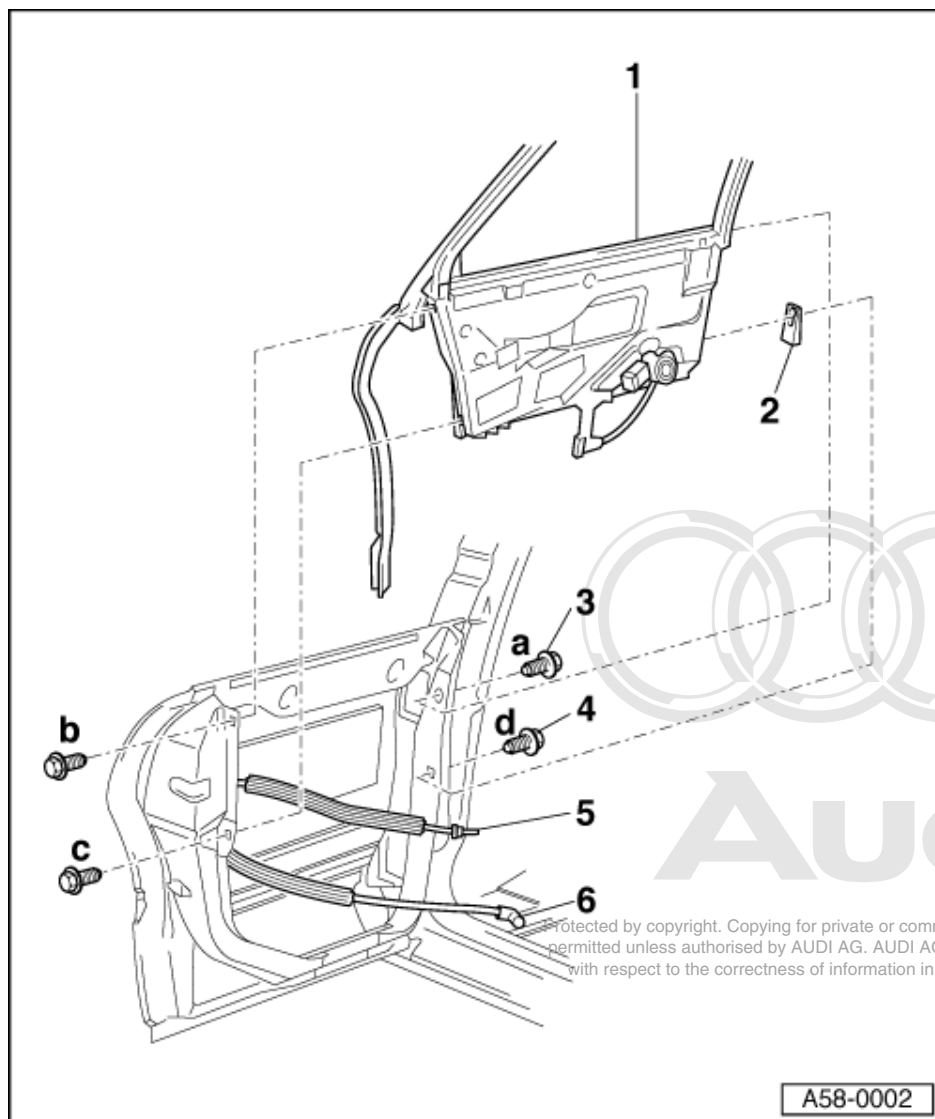
- ◆ **Use only genuine Audi A8 Parts.**
- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**


Audi

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2 - Rear door

2.1 - Rear door



2.2 - Removing and installing door shell and door component carrier

Note:

Door shell hinges

=> Fig. 1 and 2.

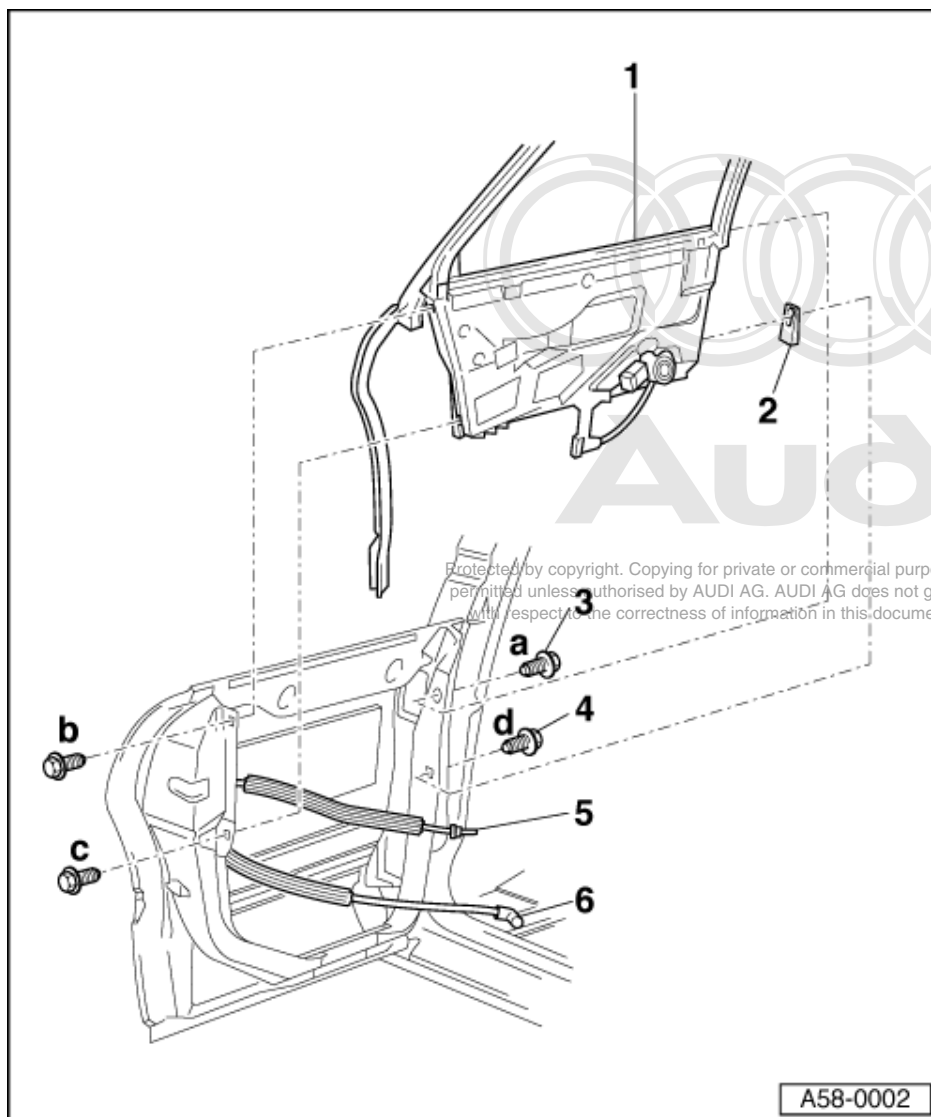
- Rear door trim removed:

=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
 Rear door trims Removing and installing rear door trim

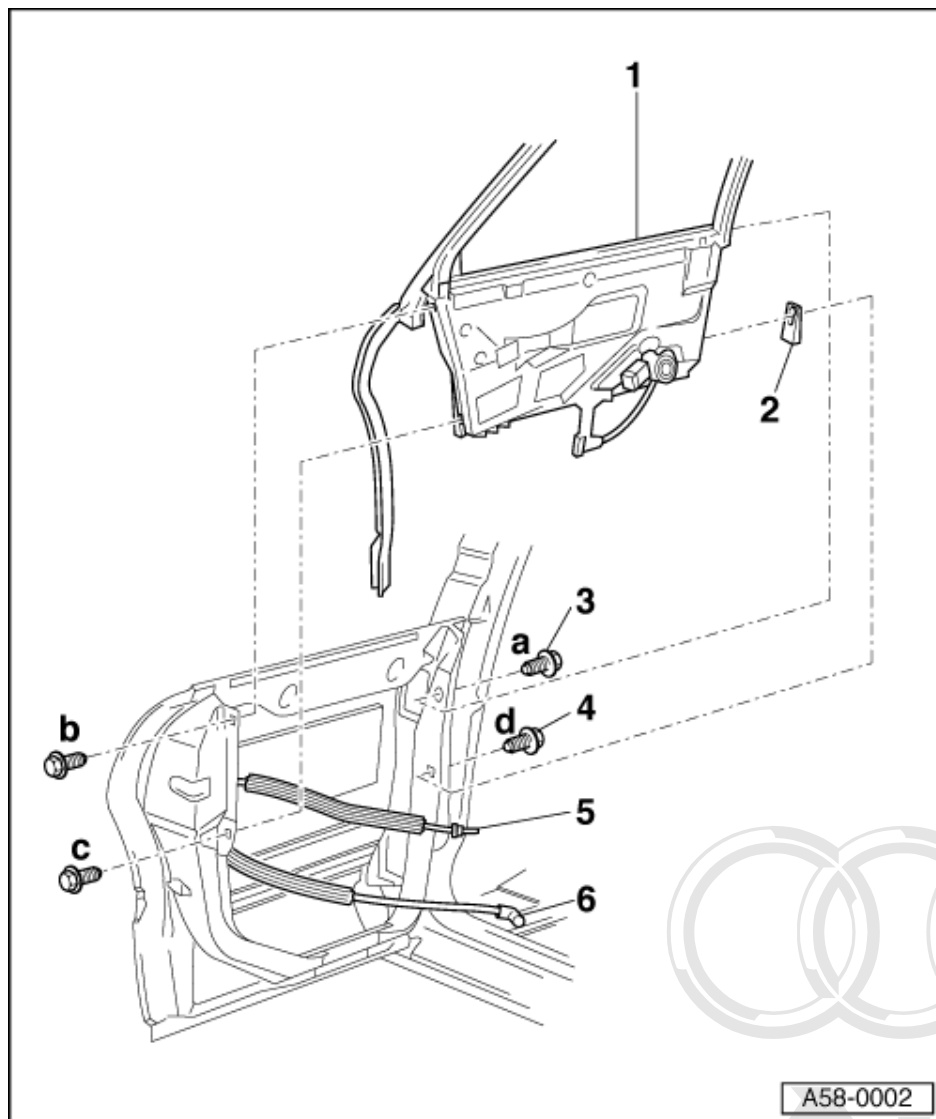
1 Door subframe

- ♦ Removing:

- Unclip Bowden cable for interior door control.



- Disengaging and unclipping Bowden cable for locking door => Page 97 .
- Detach connector to window lifter motor
- Unscrew hexagon bolts -item 3 - and -item 4 - and lift out door subframe.
- ◆ Installing:
- Start by inserting door subframe in door shell and screw on loosely at top with the shorter hexagon bolts -item 3 - .
- Insert adjuster -item 2 - and screw in the longer hexagon bolts -item 4 - at bottom.
- Tighten hexagon bolts -item 3 - and -item 4 - in sequence a, b, c, d.
- ◆ Adjusting => Page 108



2 Adjuster

- ♦ Must always be fitted
- ♦ The inclination of the rear door at the B pillar can be adjusted by altering the position of adjuster => Page 108

3 Hexagon bolt - 30 Nm

- ♦ Note tightening sequence

4 Hexagon bolt - 30 Nm

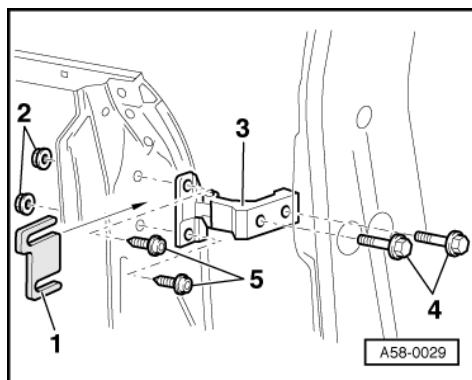
- ♦ Note tightening sequence

5 Bowden cable for interior door handle

6 Bowden cable

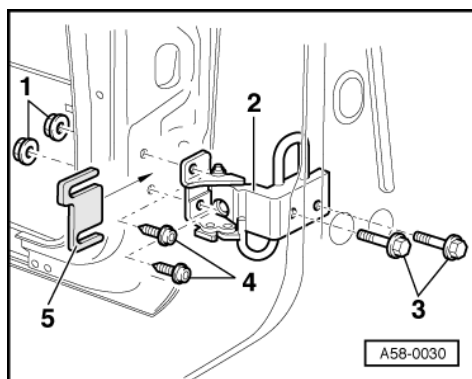
- ♦ For locking door
- ♦ Disengaging => Page 97

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-> Fig.1 Upper door hinge

- 4 - Tightening torque: 30 Nm
- 5 - Tightening torque: 30 Nm

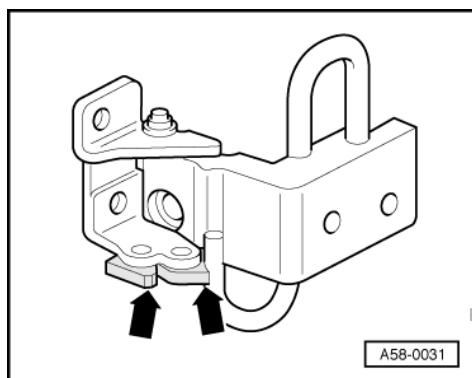


-> Fig.2 Lower door hinge

- 3 - Tightening torque: 30 Nm
- 4 - Tightening torque: 30 Nm

Note:

Lubrication points => Fig. 3.

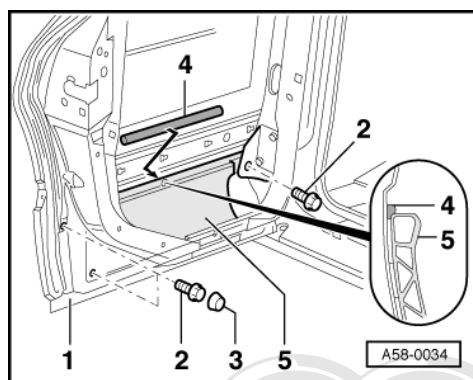


-> Fig.3 Lower door hinge - lubrication points

- Only grease the door arrester at the points shown in the illustration (arrows).
- Lubricant: "G 000 150"



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-> Fig.4 Removing and installing side impact bar

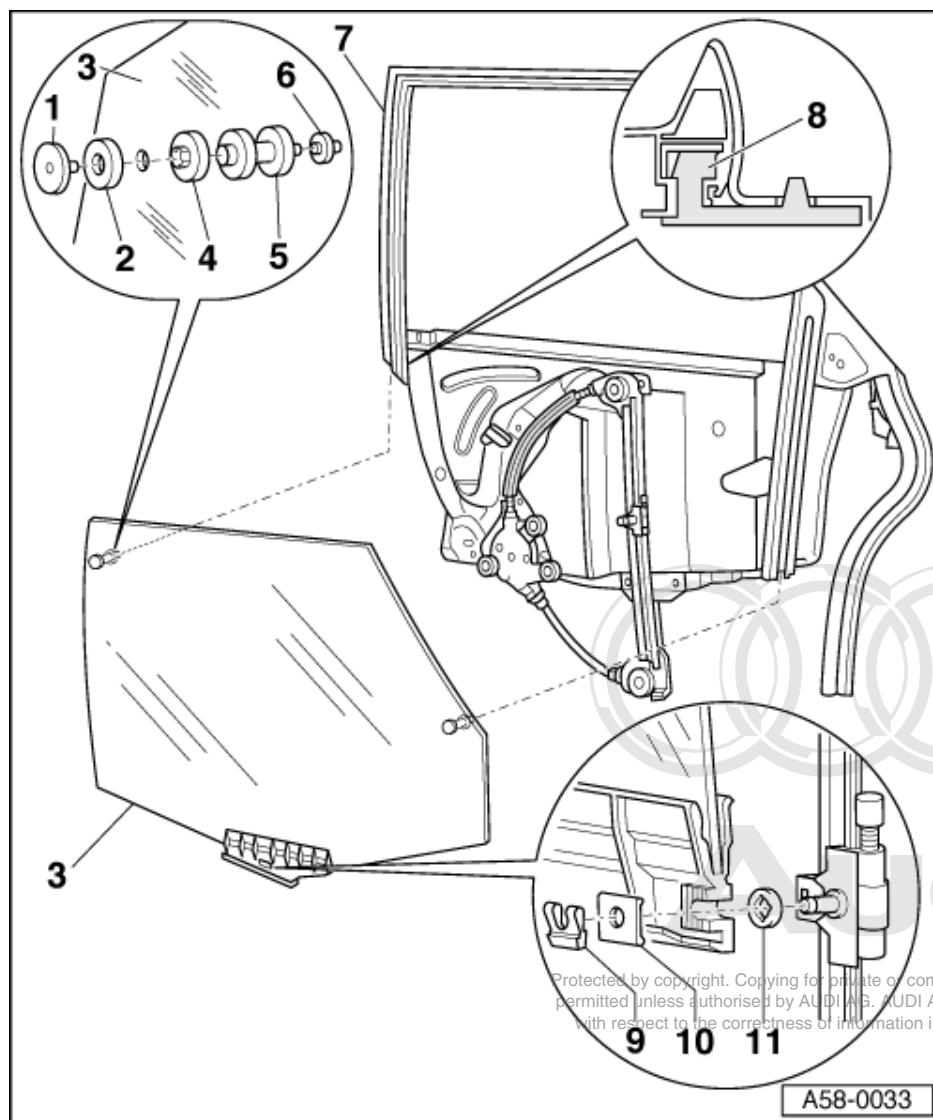
- Lever off trim cap -3-.
- Unscrew the three hexagon bolts -2- and take side impact bar -5- out of door shell -1-.

Note:

Butyl cord -4- must always be fitted, renew if necessary.

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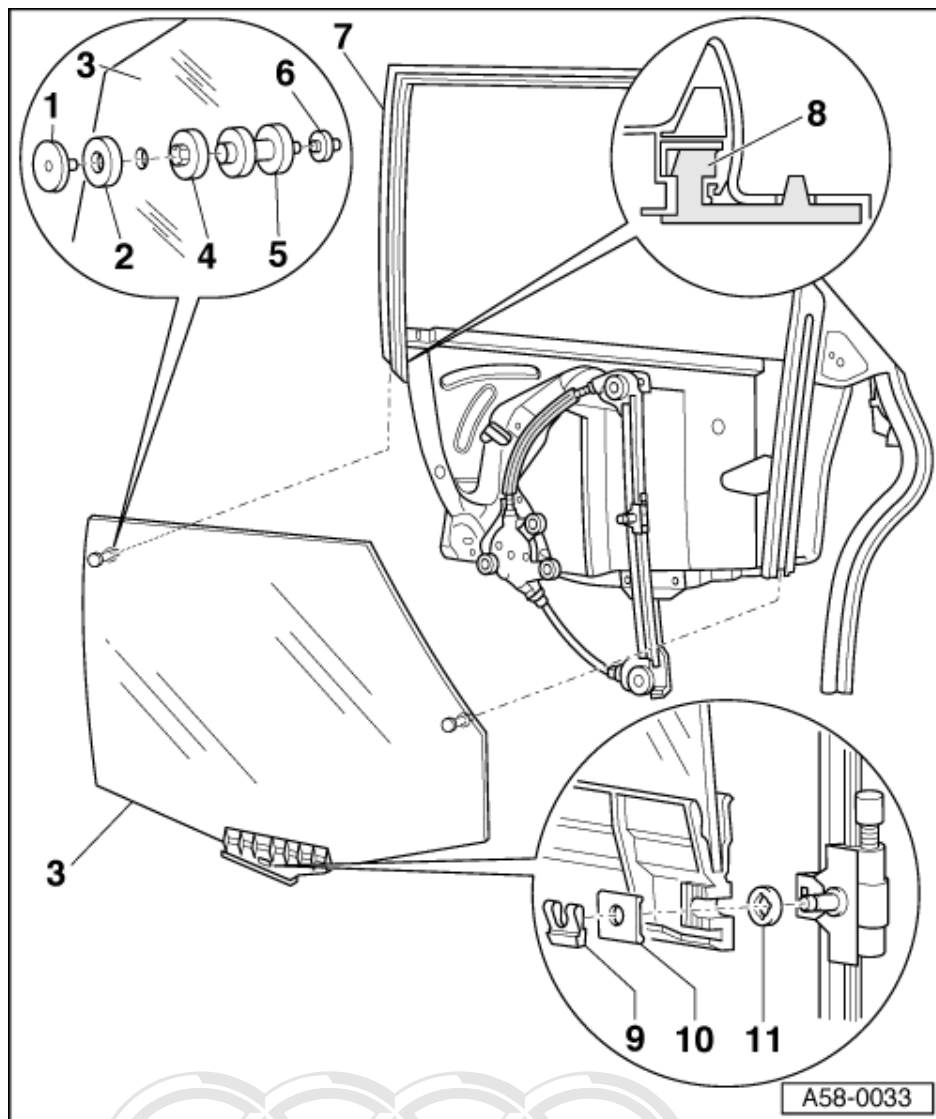
2.3 - Removing and installing rear door window



- Rear door trim removed:

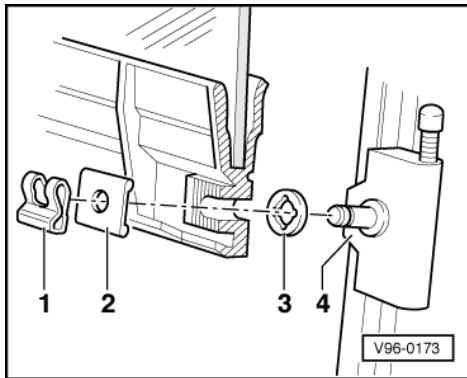
=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
Rear door trims Removing and installing rear door trim

- 1 Release and tighten bolt - 2 Nm
- 2 Washer
- 3 Rear door window
 - ♦ Removing and installing => Fig. 1
 - ♦ Adjusting => Fig. 2 and 3
- 4 Centring sleeve



- 5 Guide pin
 - ◆ Removing and installing =>Fig. 4
- 6 Trim cap
- 7 Door subframe
 - ◆ Removing and installing
=>Page 82.
- 8 Plug
 - ◆ After fitting window, insert into guide of door subframe
- 9 Locking plate
- 10 Washer
- 11 Damping washer

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-> Fig.1 Removing and installing rear door window

- Use a small screwdriver to lift lock plate -1- slightly and push it out of groove of guide pin -4-.
- Detach washer -2-.
- Lift window slightly off guide pin and pull downwards out of guides.

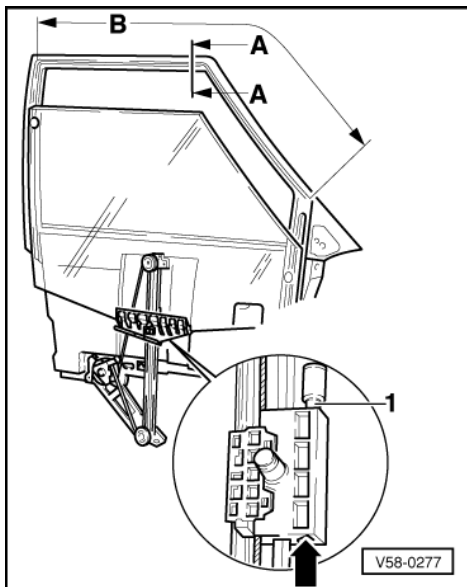
Note:

This causes the guide pin to push the plug out of the window guide.

- Remove damper -3-.
- When installing, align window slot centrally with guide pin -4-, paying attention to contact area at roof frame and C-pillar.

Note:

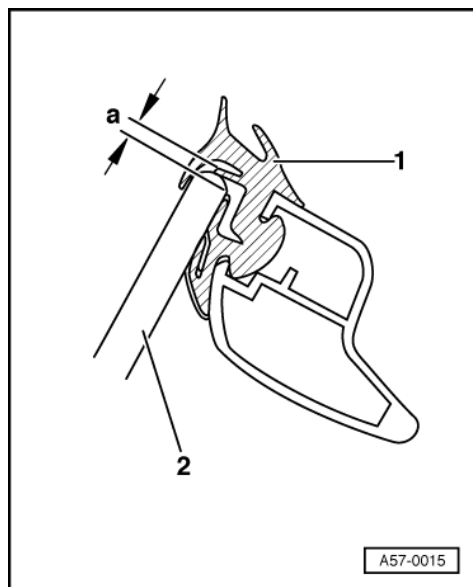
The plug acts as a seal and noise insulator. It must be inserted in the B-pillar window guide again after fitting the window.



-> Fig.2 Adjusting door window

- Adjust upper stop of window lifter -1- with E6 Torx head -arrow-.
- Section A - A => Fig. 3
- B - Contact area of door window on inner sealing lip.

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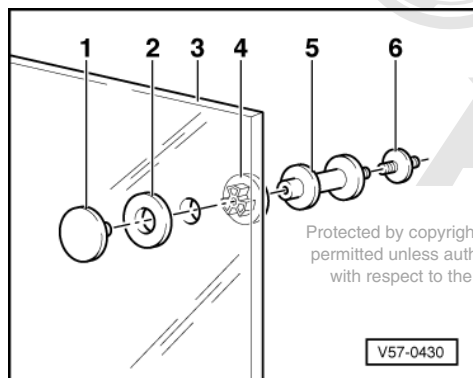


-> Fig.3 Adjusting door window

- Adjust window -2- with door closed.
- Adjust upper stop limit of the window lifter so that inner sealing lip of door window seal -1- contacts over the entire area -B- => Fig. 2 with top edge of window over entire area -B- => Fig. 2
 - Dimension a = min. 1.0 mm
- Do not set window too high, as this would result in increased door closing forces.

Note:

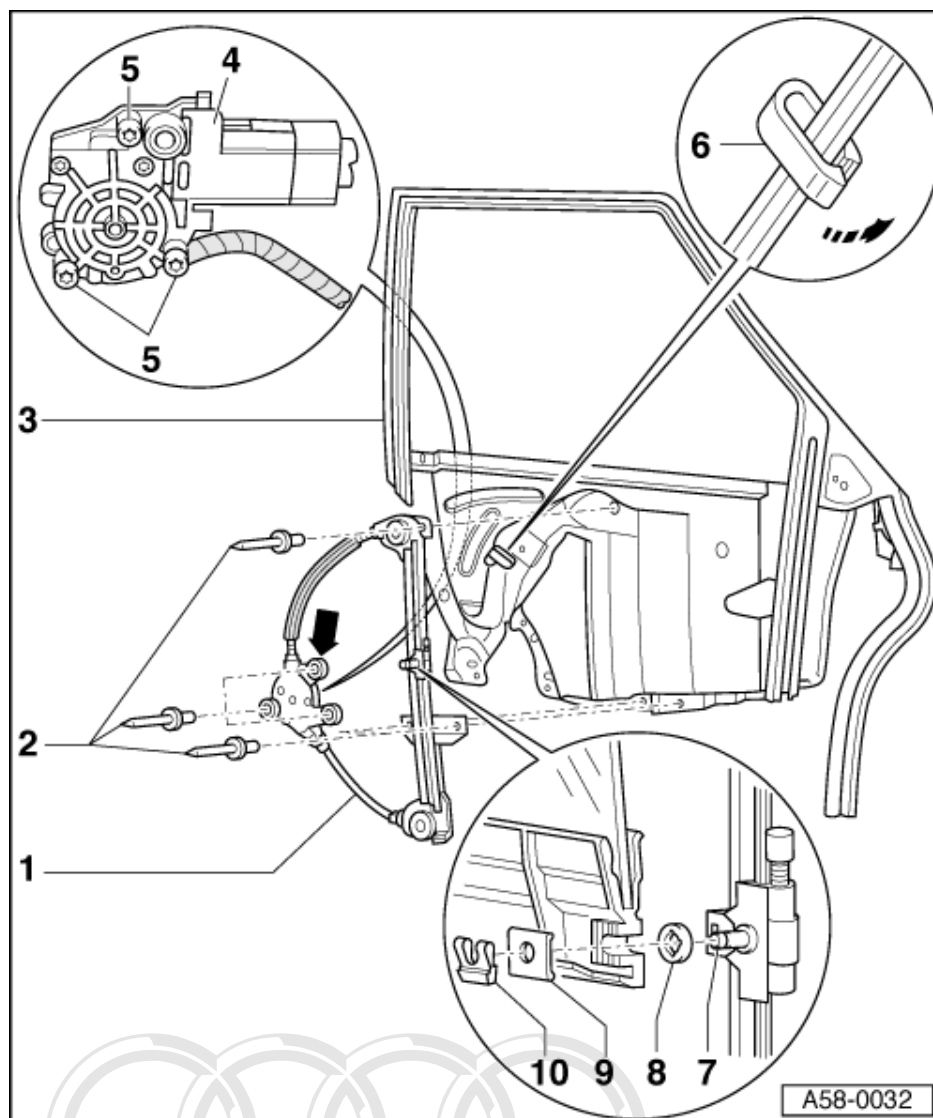
It is only guaranteed to have no leaks if sealing lip makes contact 1.0 mm preload.



-> Fig.4 Removing and installing locating pin

- Removing door window => Fig. 89 .
- Drill into centre of bolt -1- with \varnothing 5 mm bit until guide pin -5- drops off.
- Coat thread of new bolt with liquid locking compound D 185 400 A2.
- Screw in new locating pin with centre bush -4-, door window -3-, washer -2- and screw, tightening torque 2 Nm.
- Fit cap -6-.

2.4 - Removing and installing rear window lifter



- Rear door trim removed:

=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
Rear door trims Removing and installing rear door trim

1 Rear window lifter

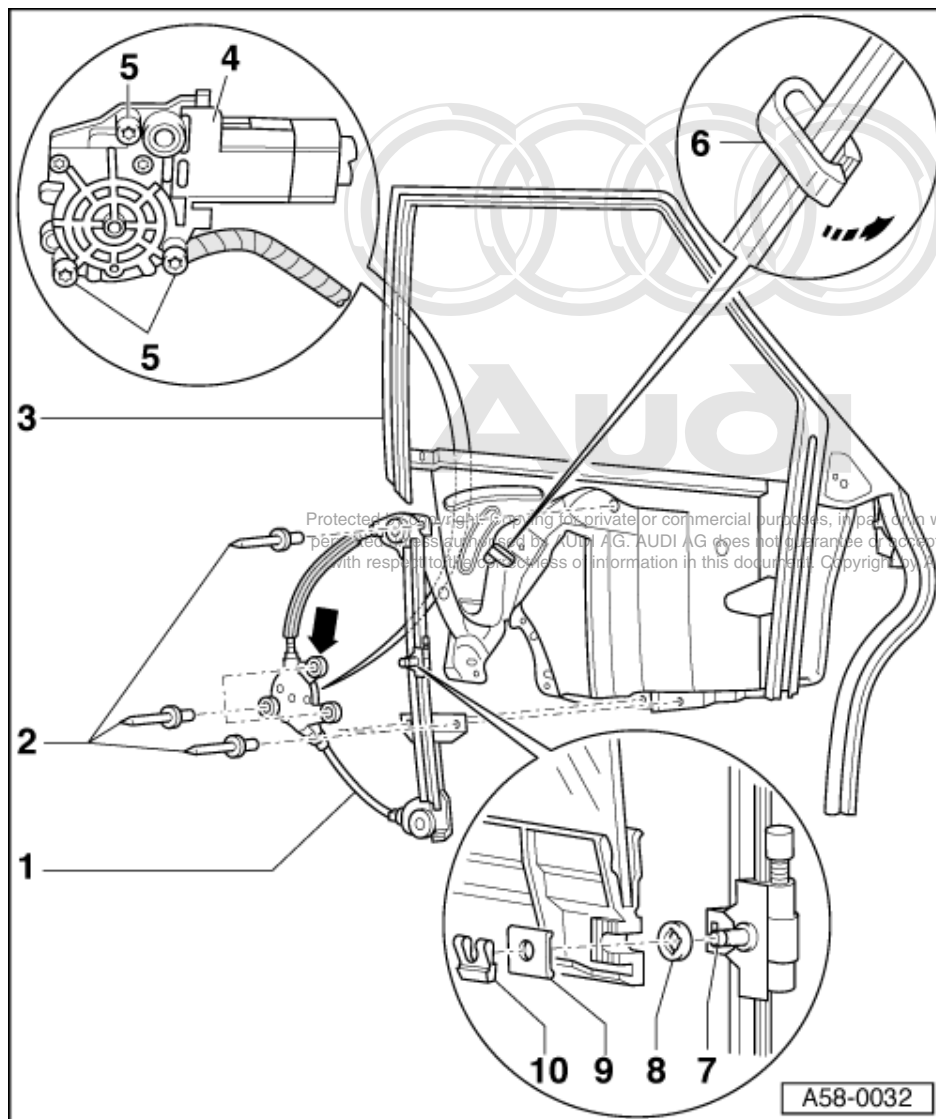
- ♦ To remove, drill heads off rivets -item 2 - and knock out shanks.
- ♦ Start by riveting on window lifter at location marked by arrow

2 Blind rivet

- ♦ 6 off
- ♦ Always use genuine rivets to avoid contact corrosion

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=> Parts List



3 Door subframe

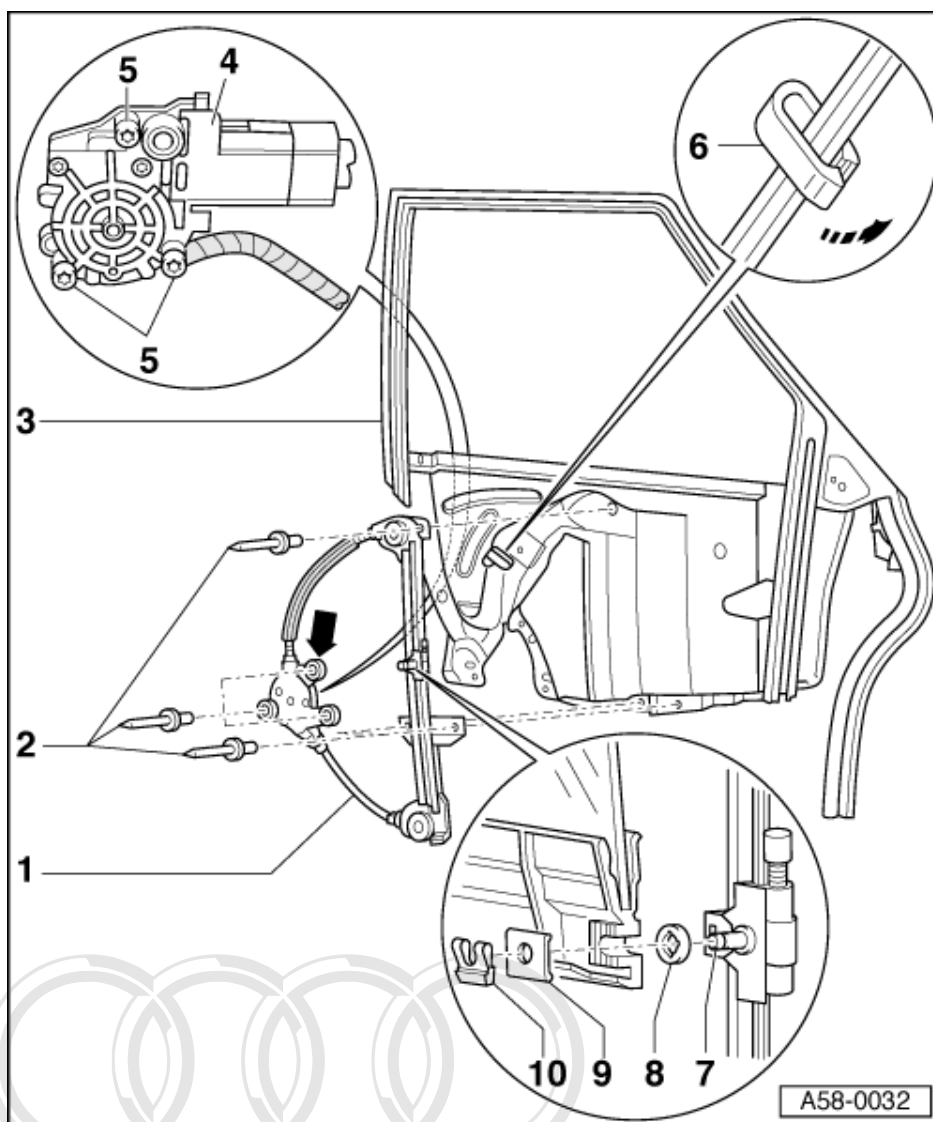
- ♦ Removing and installing
=>Page 82.

4 Motor for window lifter

- ♦ Detaching connector
=> Fig. 1
- ♦ After installing, raise window as far as it will go
- ♦ Then press window lifter switch again for at least 1 second in "close" position to activate automatic down/up function

5 Release and tighten bolt - 10 Nm

- ♦ 3 off



6 Clip

- ♦ Fit window lifter -item **1** - in clip and fasten clip -arrow-

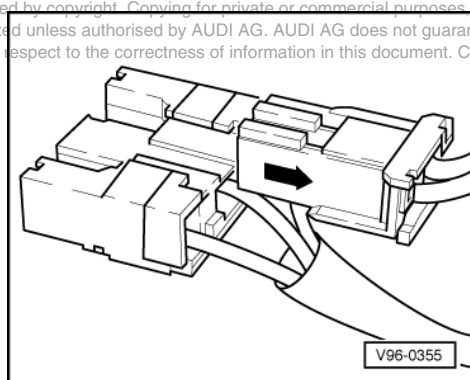
7 Guide pin

8 Damping washer

9 Washer

10 Locking plate

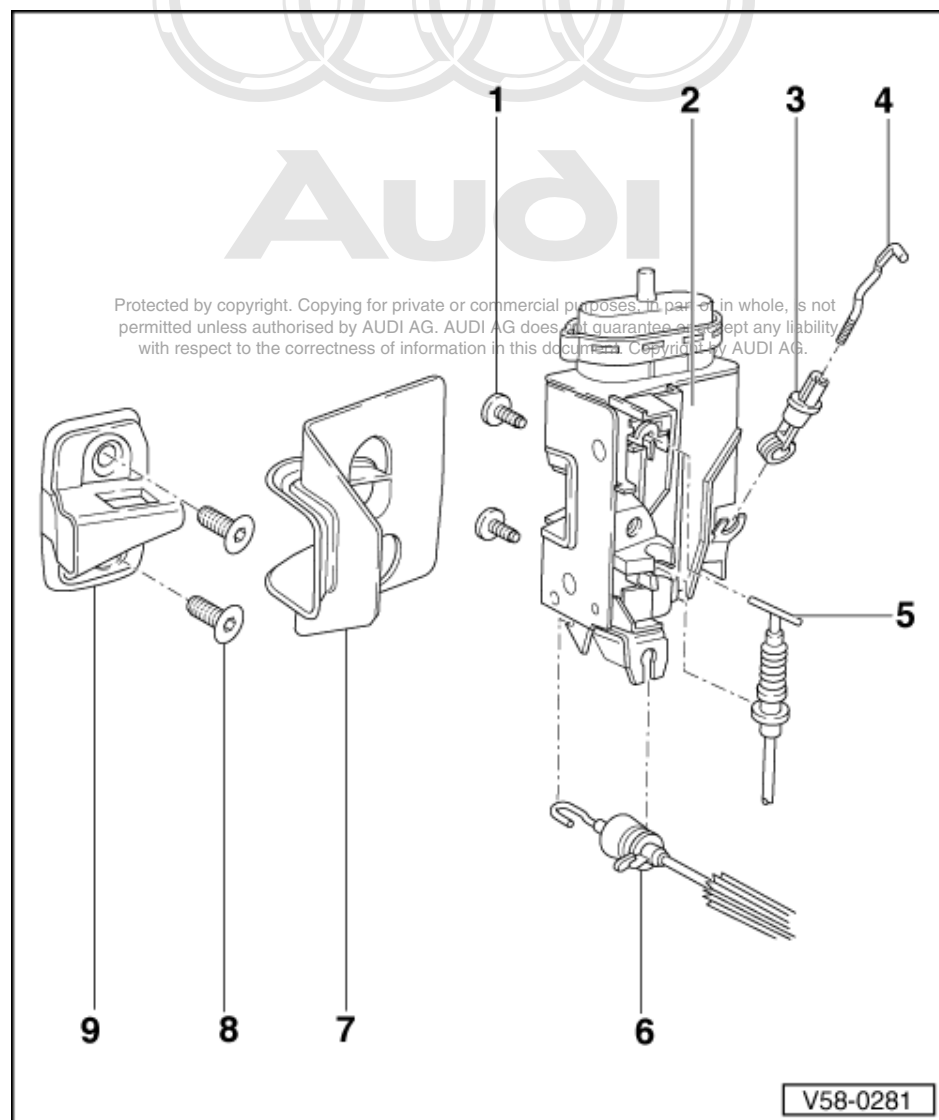
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-> Fig.1 Unplugging connector

- Unclip the two-pin connector to rear (arrow) to remove from three-pin connector.

2.5 - Removing and installing rear door lock with operating elements



- Rear door trim removed:

=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
 Rear door trims Removing and installing rear door trim

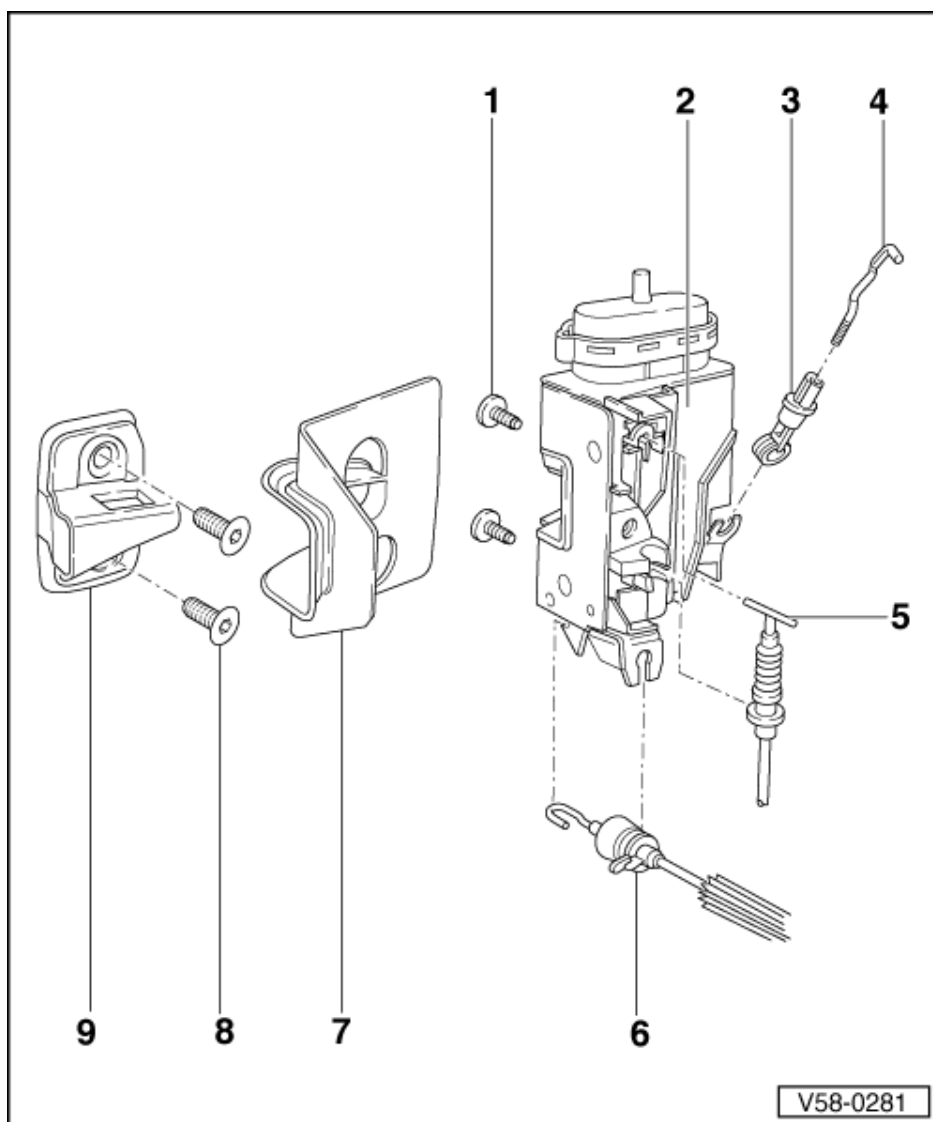
- Door component carrier removed => Page 82 .

1 Combi screw - 8 Nm

- ◆ 2 off

2 Door lock

- ◆ Removing:
 - Detach operating rod -item 4 -.
 - Disengage Bowden cable -item. 5 -.



- Unscrew combi bolts -item **1** -.
- Pull hose off actuator
- Disengaging Bowden cable for interior door mechanism -item **5** -
=>Fig. **1** .

3 Operating clip

4 Operating rod

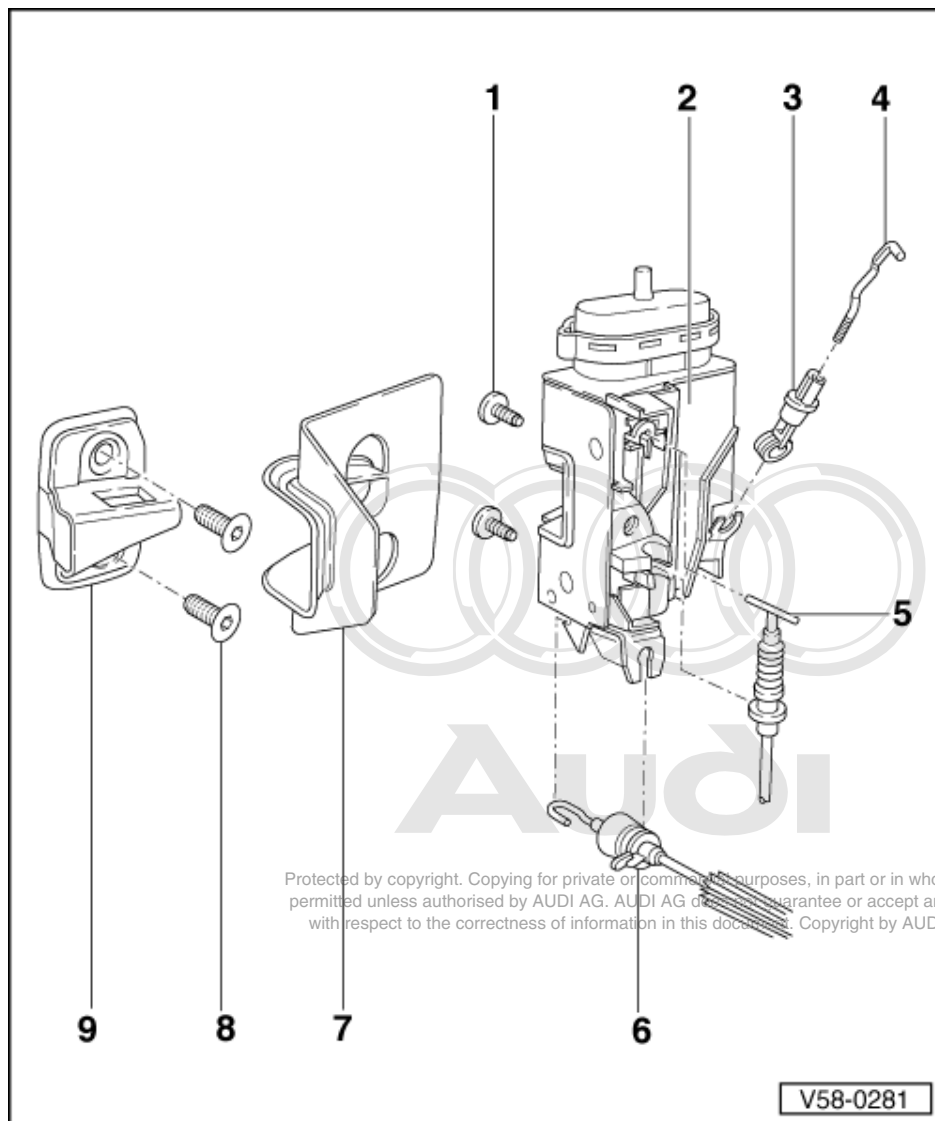
5 Bowden cable

- ♦ Removing and installing =>Fig. **2**
- ♦ Disengaging from hinged lever => Fig. **3**
- ♦ Removing hinged lever => Fig. **4**

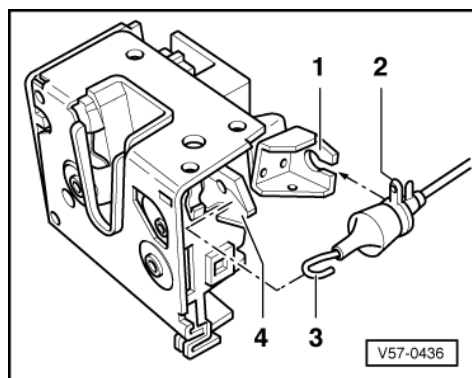
6 Bowden cable for interior door handle.

- ♦ Removing and installing =>Fig. **1**

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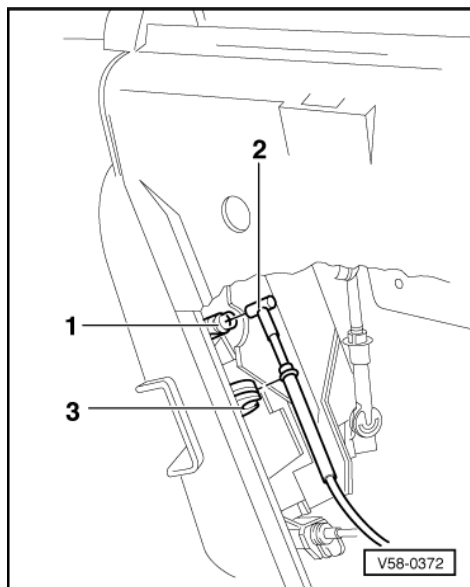


- 7 Lock base plate**
- 8 Oval-head screw - 16 Nm**
 - ♦ 2 off
- 9 Locking wedge**
 - ♦ Adjusting => Page **107**



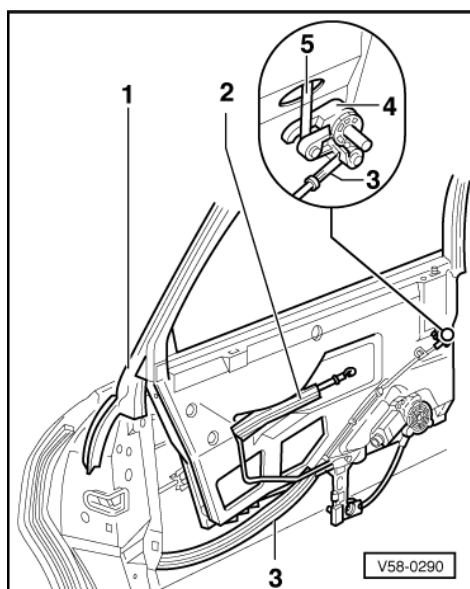
➔ Fig.1 Removing and installing Bowden cable for inside door control

- Removing door lock=> Page 94 .
- Disengage hook -3- from operating lever -4-
- Give end piece of Bowden cable a 1/4 of a turn (90°) (lug -2- disengages) and remove downwards from holder -1-
- When installing, note attachment direction of Bowden cable.



➔ Fig.2 Removing and installing Bowden cable for door locking

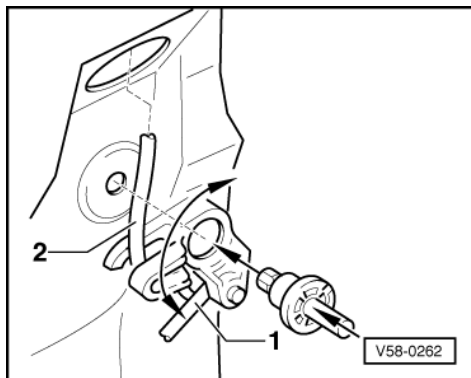
- Unclip Bowden cable -2- from holder -1-.
- Press Bowden cable out of support bracket -3-.



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➔ Fig.3 Detaching Bowden cable for door locking from hinged lever

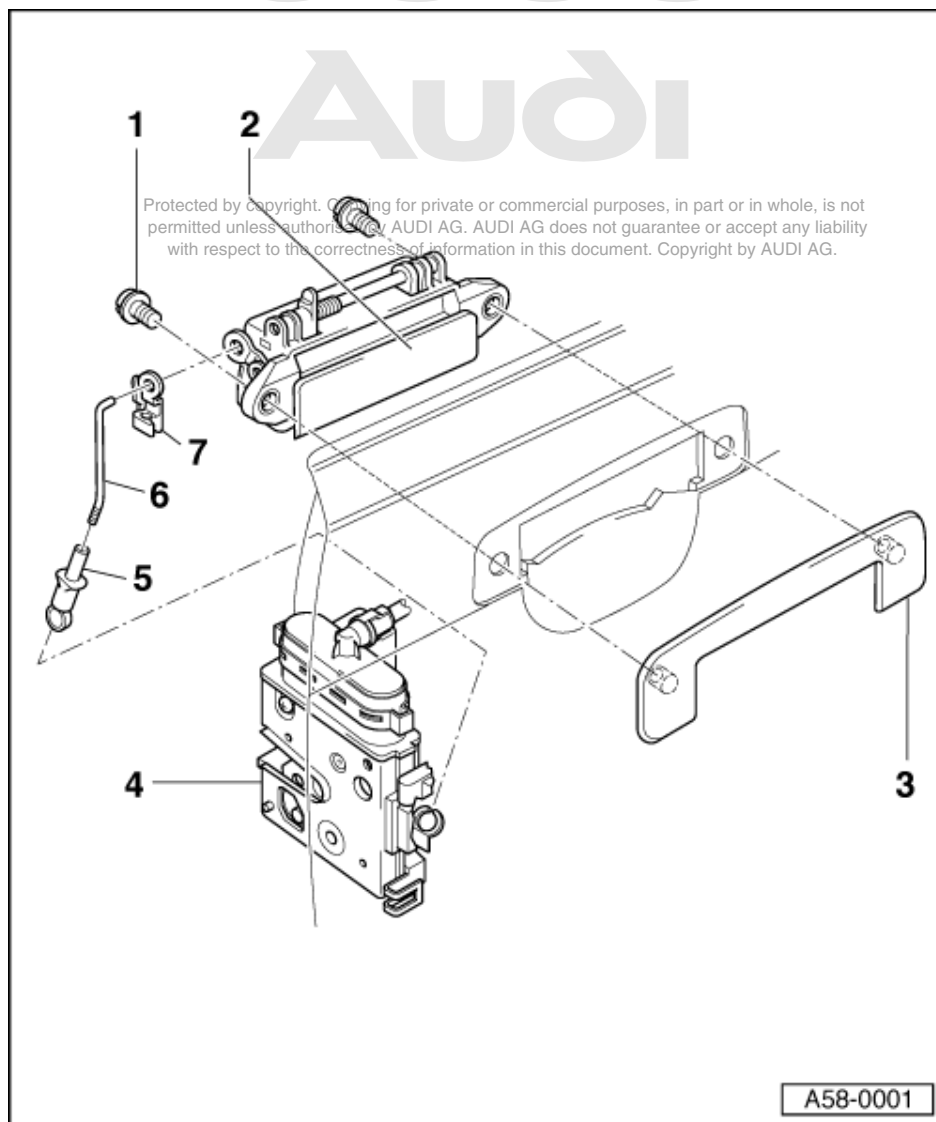
- Unfasten Bowden cable -3- from clips.
- Turn hinged lever -4- and disengage Bowden cable.



-> Fig.4 Removing hinged lever

- Swivel hinged lever in direction of arrow.
- Detach Bowden cable -1- and securing rod -2-.
- Press pin out of expanding clip.
- Remove hinged lever.

2.6 - Removing and installing rear door handle (vehicles with profile lock)



- Rear door trim removed:

=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
Rear door trims Removing and installing rear door trim

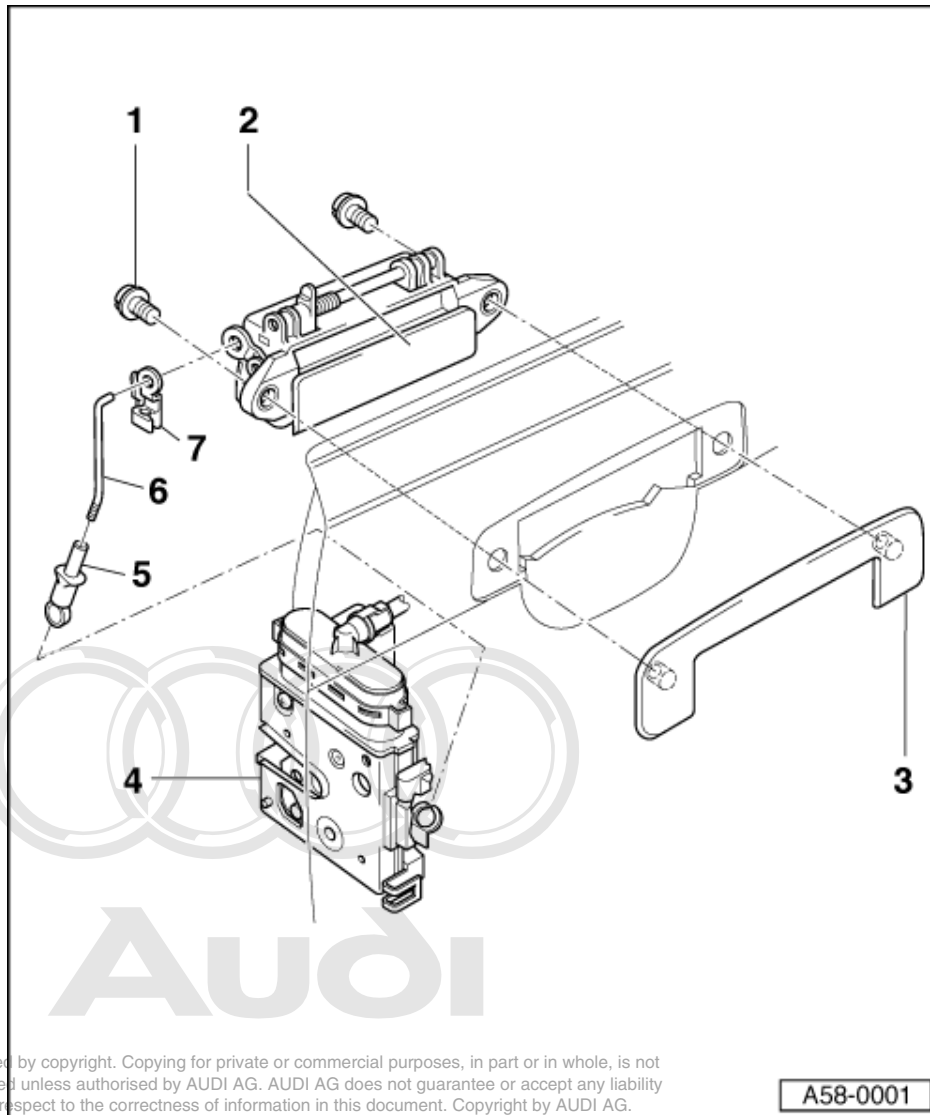
- Door component carrier removed => Page 82 .

1 Oval-head screw - 3 Nm

- ♦ 2 off

2 Door handle

- ♦ Removing:
- Removing door handle trim to avoid damaging paintwork => Fig. 1 .



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A58-0001

- Detach operating rod -item 6 - from operating clip -item 5 - and hinged bush -item 7 -.
- Unscrew oval-head screws -item 1 -; detach trim -item 3 - and door handle.

3 Panel

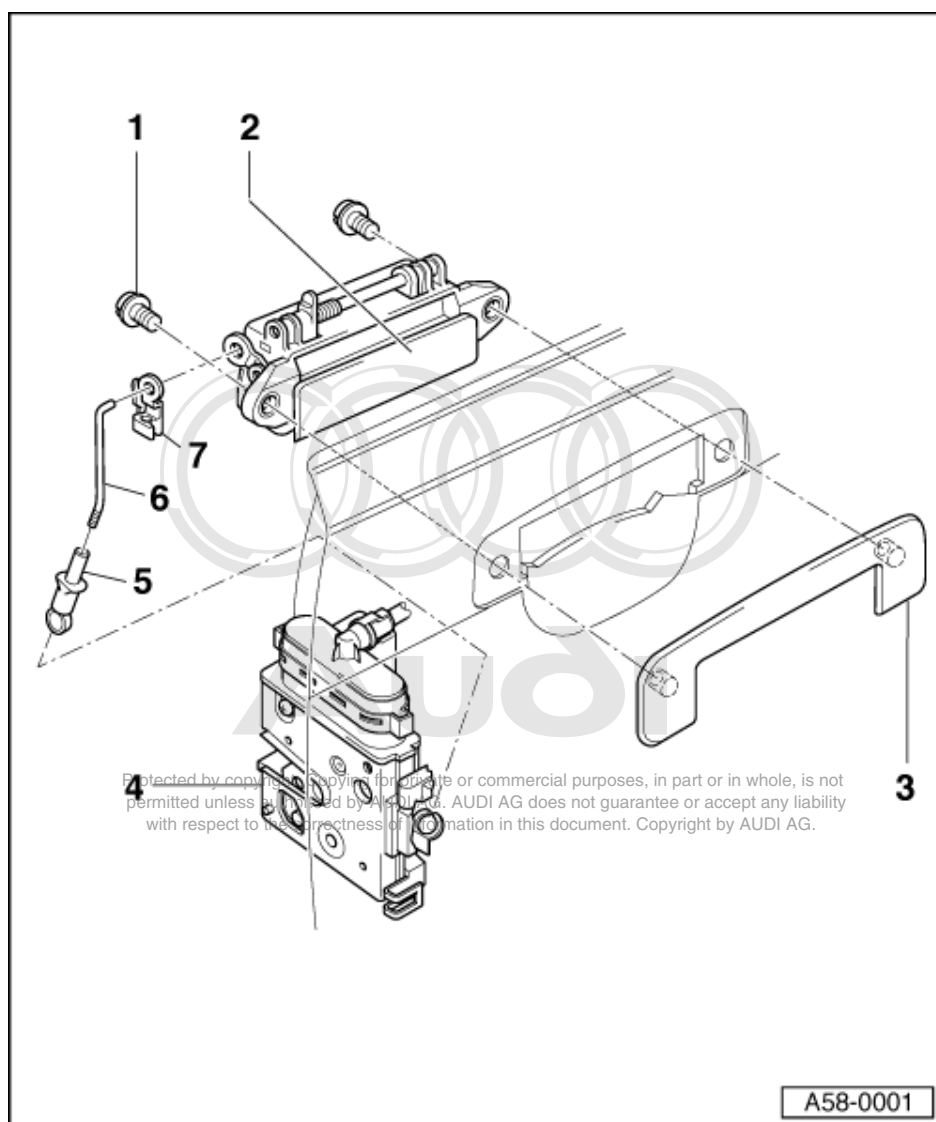
4 Door lock

5 Operating clip

6 Operating rod

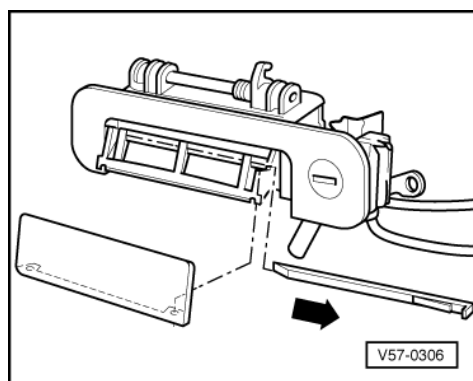
- ♦ Removing:
- Swivel hinged bush -item 7 - and detach operating rod.

- Push sleeve on operating clip -item **5** - downwards. Push out operating rod.



- ◆ Installing:
 - Set clearance between door handle and door lock by turning operating rod in operating clip.
 - The release lever must not be pre-tensioned during adjustment. Play between release lever and operating element max. 1 mm.

7 Hinged bushing



➔ Fig.1 Removing cover for door handle

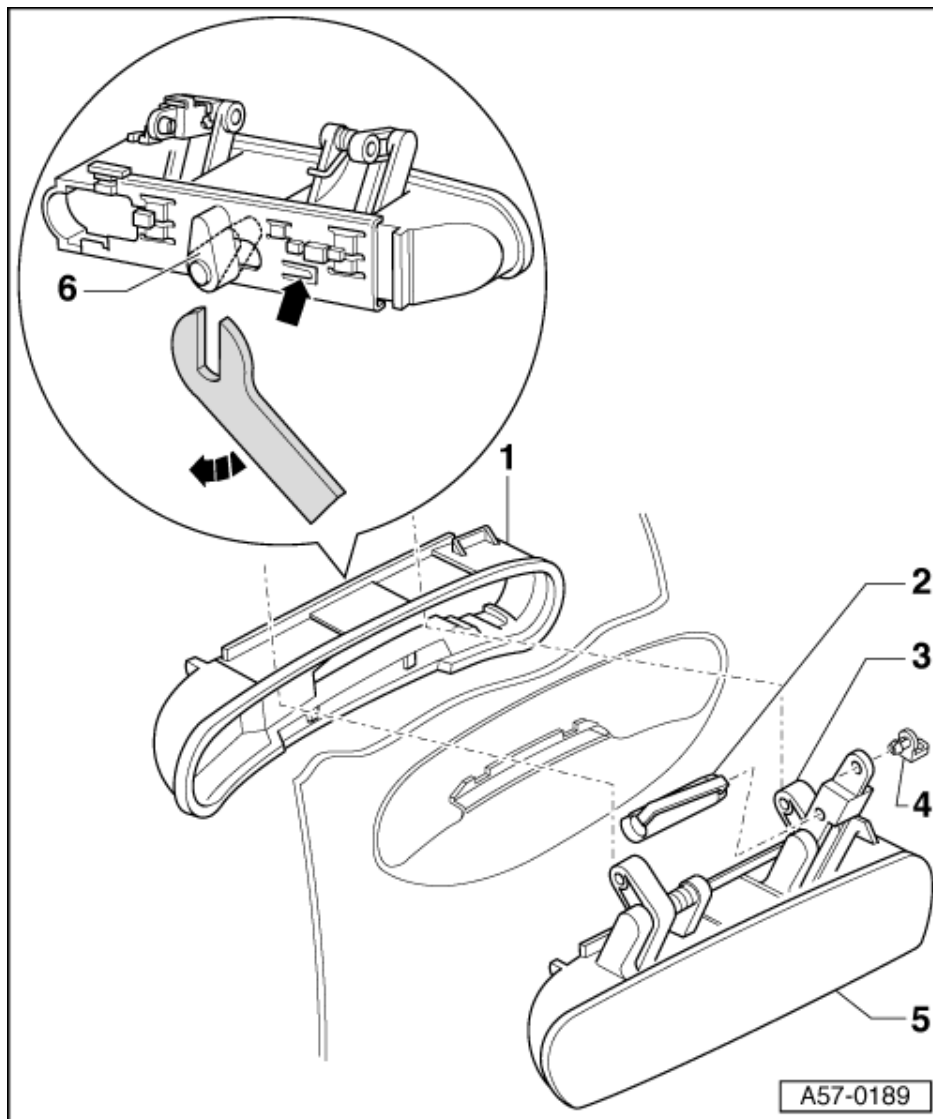
- Pull up door handle.
- Use small screwdriver to lever fastening strip out of door handle in direction of arrow and pull out.
- Remove door handle cover.

Note:

Figure shows driver's side door handle.

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2.7 - Removing and installing rear door handle (vehicles with inner face lock)



1 Door handle mount

- ◆ Remove door handle by releasing with open-ended wrench.

2 Locking pin

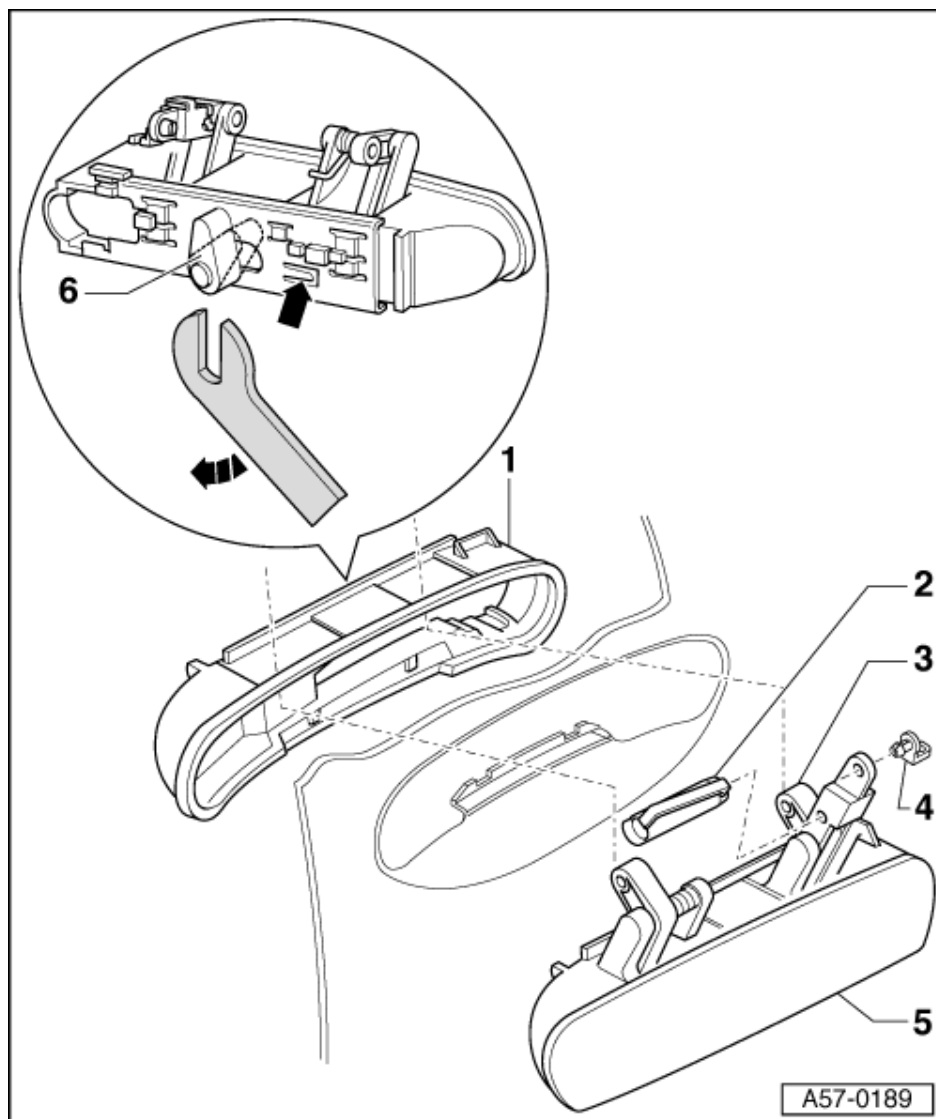
- ◆ Hinged lever must fully engage in spring catch when installing.

3 Hinged lever

4 Clip

- ◆ Unclip operating rod for door lock here when removing door handle -5-.

=>Page 103 .

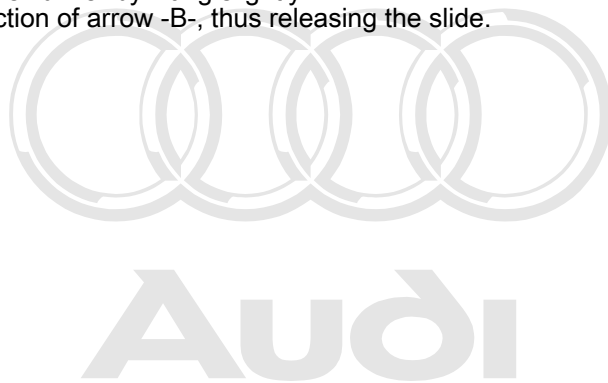


5 Door handle

- ◆ Removing
 - Door trim and door sub-frame removed.
 - Detach operating rod from hinged lever=>Page 103 .
 - Release catch -arrow -A- for slide with a small screwdriver by lifting slightly.
 - With an open-ended wrench, turn cam -6- in direction of arrow -B-, thus releasing the slide.

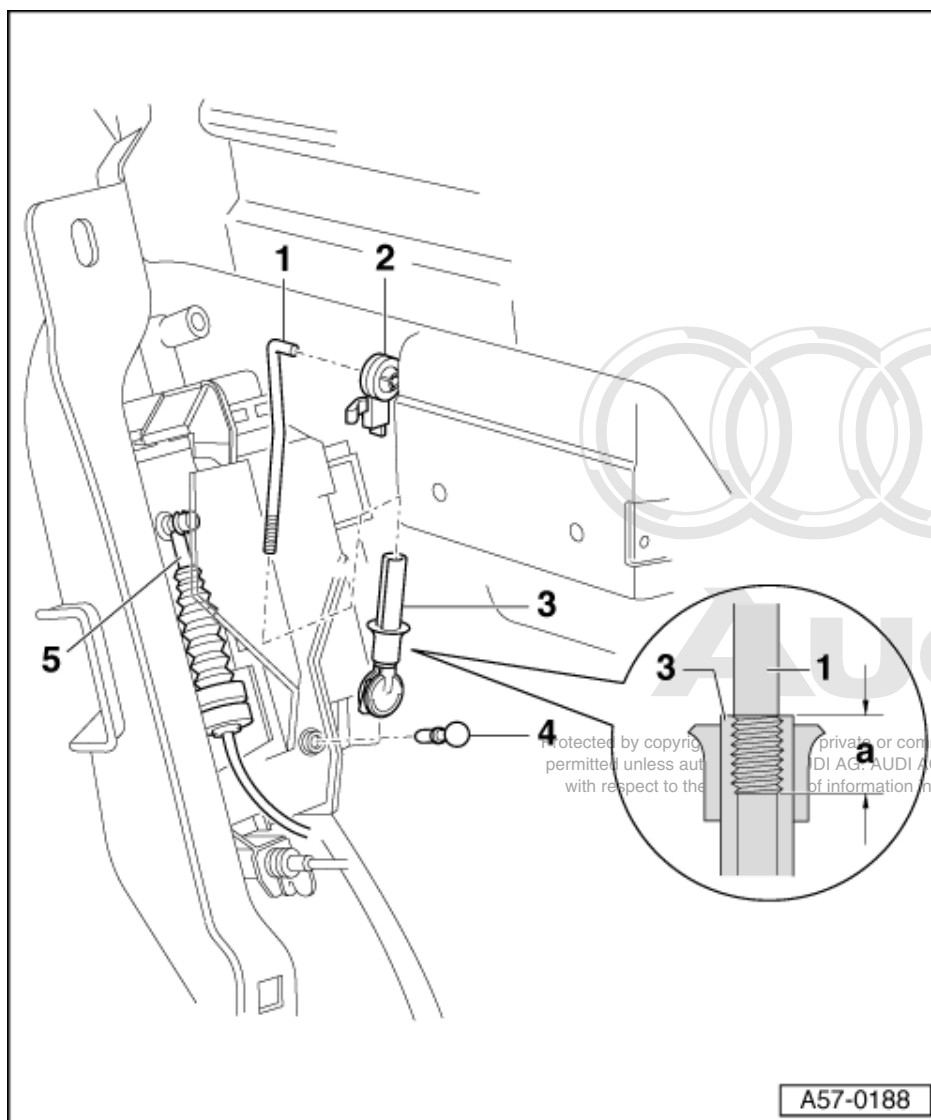
6 Cam

- ◆ To release door handle mount.



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2.8 - Removing and installing operating rods for rear door lock

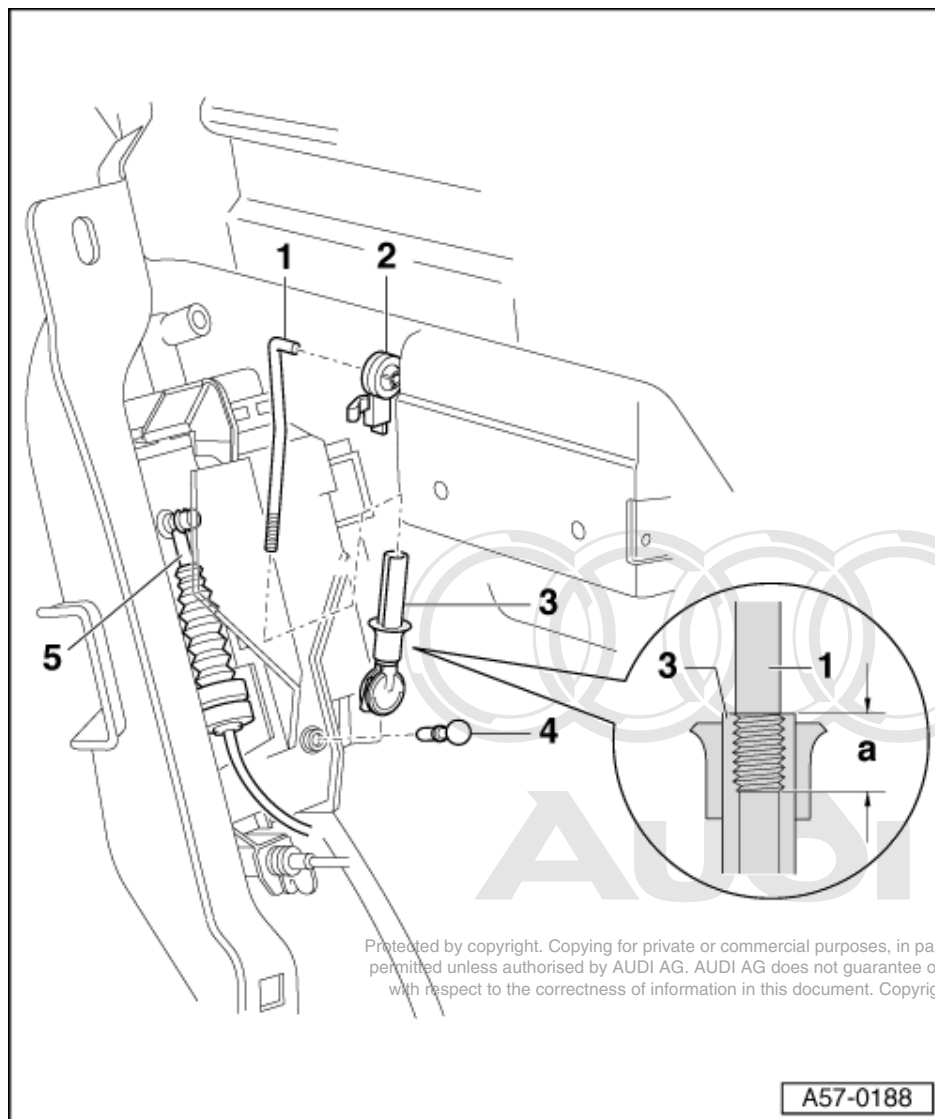


7 Operating rod

- ◆ Adjusting:
 - Insert operating rod in hinged bushing -2-.
 - Clip operating rod into operating clips -3- without straining door lock release lever (max. play 1.5 mm).
 - Push sleeve onto operating clip -4-.
 - Clipping-in length -4a- 13 ± 3 mm.
 - Do not remove locating pin -4- from door lock until operating rod has been installed.

8 Hinged bushing

9 Operating clip



10 Locating pin

- ♦ Only available for replacement part, locates the basic setting.
- ♦ Do not remove until operating rod -1- has been installed.

1 Bowden cable for door locking

- ♦ Removing and installing => Fig. 2 .

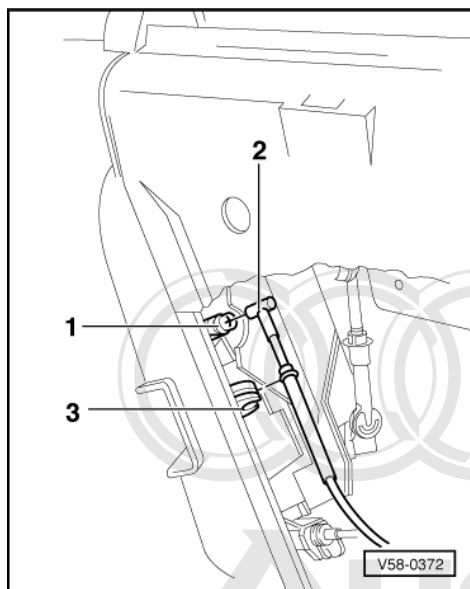


Fig.2 Bowden cable for door locking

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- To remove, unclip Bowden cable -2- from holder -1- and press out of support bracket -3-.

2.9 - Rear door handle pre-assembly

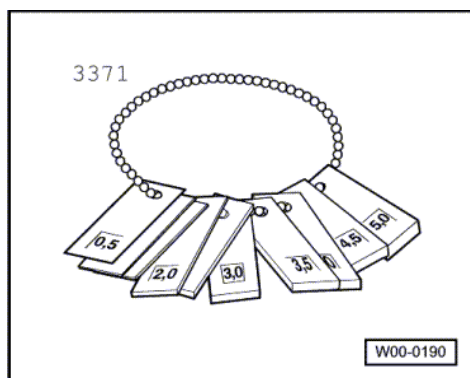
- Pre-assembly of the rear door handle is the same as for the front door handle =>Page 67 .

3 - Adjusting door - adjustment sequence

3.1 - Adjusting door - adjustment sequence

3.2 - I - Adjusting door shell

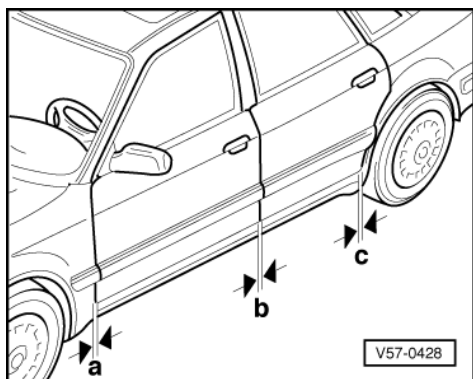
- Rear door trim removed:



=> General Body Assembly, Interior; Repair group 70; Rear door trims; Removing and installing rear door trim
Rear door trims Removing and installing rear door trim

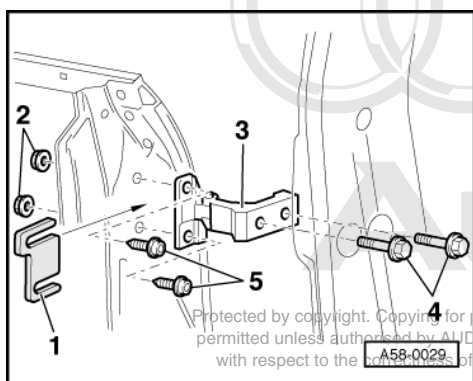
Special tools, testers and auxiliary items required

- ♦ Special tool 3371



- ♦ -> Dimension a = 3.5 - 0.5 mm
- ♦ Dimension b = 4.5 - 0.5 mm
- ♦ Dimension c = 3.5 - 0.5 mm

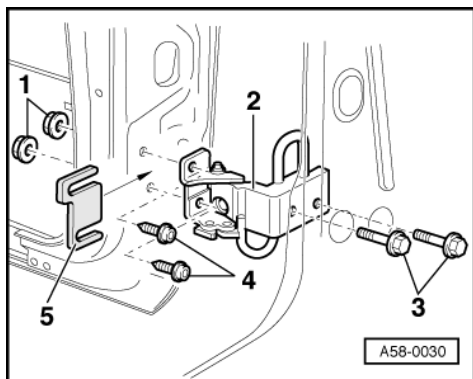
1. Joint dimensions



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-> Upper door hinge:

- ♦ Loosen bolts -4-, move door with hinge -3- (oversize holes in B-pillar).
- or
- ♦ Loosen bolts -5-, insert packing plate -1-
- ♦ Tightening torque 30 Nm



-> Lower door hinge:

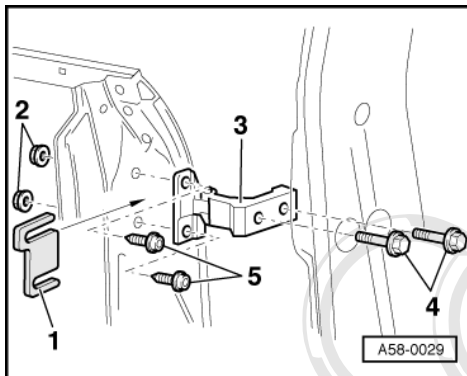
- ◆ Loosen bolts -3-, move door with hinge -2- (oversize holes in B-pillar).

or

- ◆ Loosen bolts -4-, insert packing plate -5-
- ◆ Tightening torque 30 Nm

2. Adjusting to the body contour

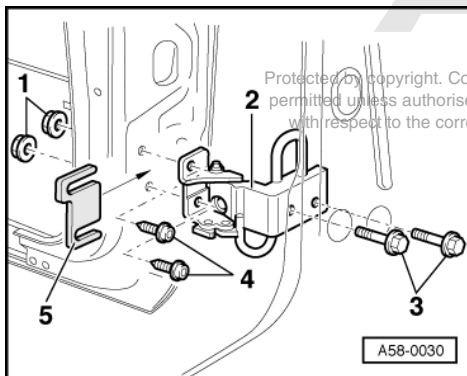
Note:



Adjustment in front door area is made at hinge; in rear door area by moving striker wedge.

-> Upper door hinge:

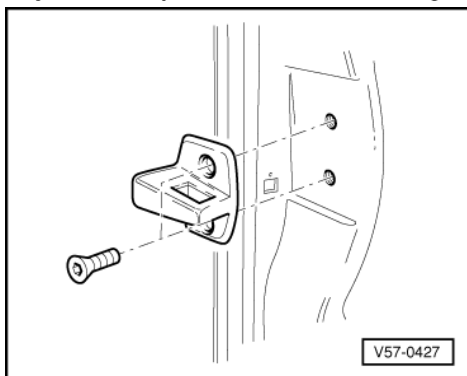
- ◆ Loosen bolts -5-, move door (oversize holes in hinge)
- ◆ Tightening torque 30 Nm



-> Lower door hinge:

- ◆ Loosen bolts -4-, move door (oversize holes in hinge)
- ◆ Tightening torque 30 Nm

Adjustment by means of striker wedge:





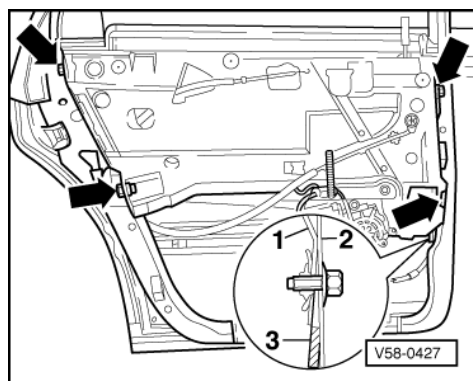
- -> Loosen Torx bolts.
- Move striker wedge until door shell is flush with bodywork contour.
- Tighten Torx bolts to 16 Nm.

3.3 - II - Adjusting door subframe

Note:

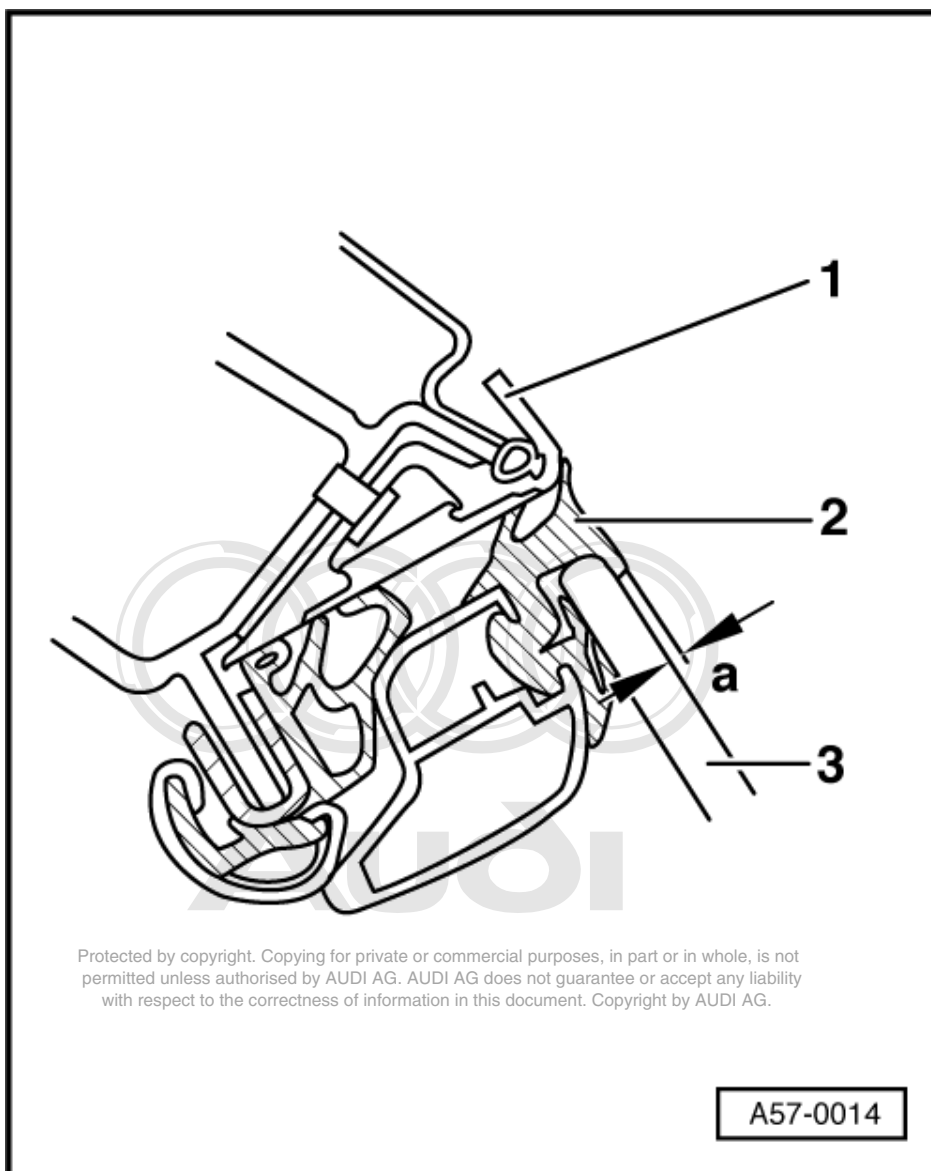
The inclination of the door in the vicinity of the C-pillar can be adjusted by moving the adjusting wedge. If, for example, the rear area of door projects too far at the bottom, the adjuster must be pushed further up. The bottom of the door consequently slopes towards the centre of the vehicle and the top of the door leans outwards.

- Door shell adjusted => Page 105 onwards.



- -> Adjusting wedge -3- must always be installed.
- Loosen bolts (arrows).
- Close door.
- Slightly tighten the top screws from inside while a second fitter presses the door component carrier against the roof and the pillar (the force used to push the carrier must overcome the counteracting forces resulting from the rubber seal).
- Push adjuster -3- upwards until it makes contact with surfaces of door shell -2- and subframe -1-.
- Tighten bolts to 30 Nm.

Check dimension for door subframe



-> The outer sealing lip -2- must be flush along the pillar and roof trim strip -1-.

Gap between roof trim strip and door window -3-:

- ◆ Dimension a = 2.5 ± 1 mm



60 - Sliding/tilting roof

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

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In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

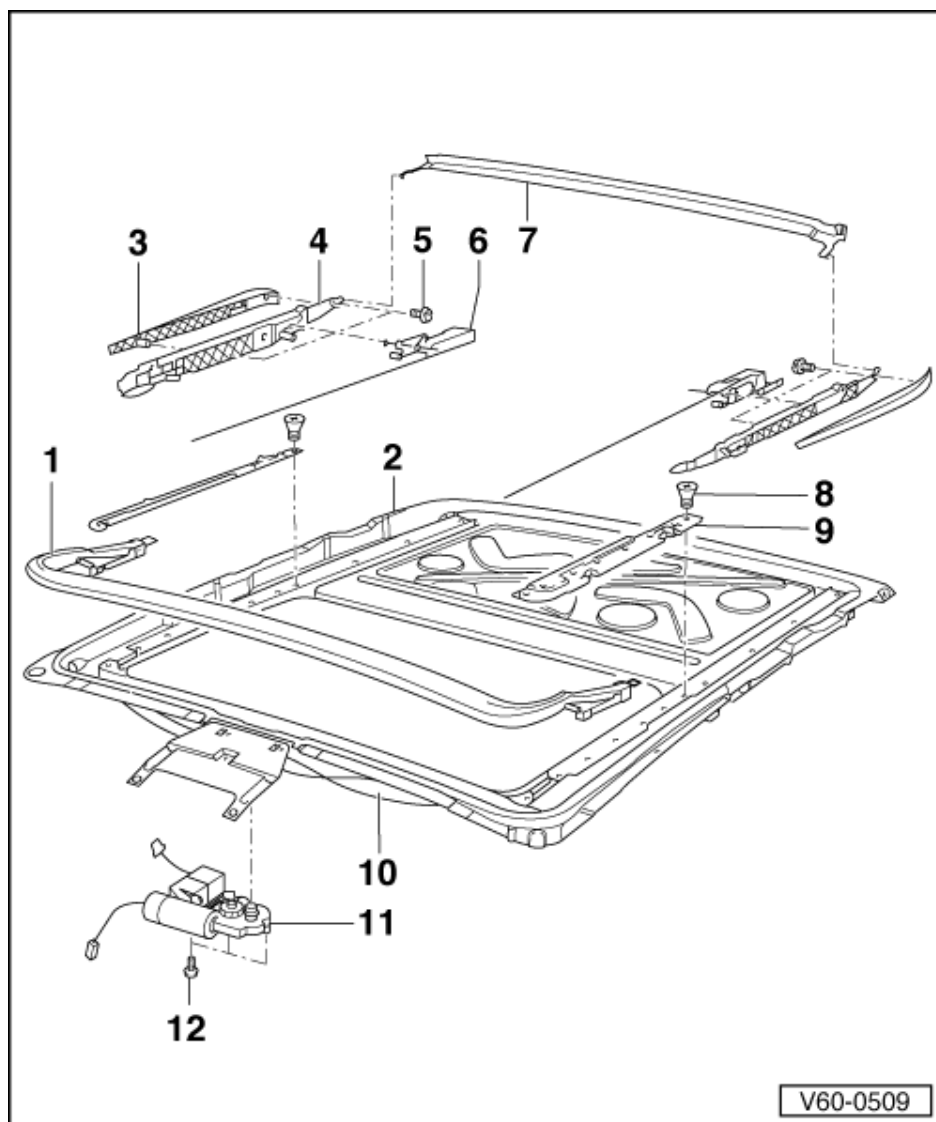
If you are not sure whether used parts can be refitted, always fit new parts.

Important

- ♦ Use only genuine Audi A8 Parts.
- ♦ Accessories must be approved by AUDI AG.
- ♦ Damage resulting from contact corrosion is not covered by the warranty.



- ♦ To adjust, tilt sun roof panel and press trim upwards until it makes contact with panel seal; tighten bolts -item **5** - to 1 Nm.



4 Guide plate

- ♦ Removing and installing
=>Page **123**.

5 Oval-head screw - 1 Nm

6 Rear guide with cable

- ♦ To remove, take out sun roof panel => Page **114** and remove guide strip -item **9** -.

7 Drain channel

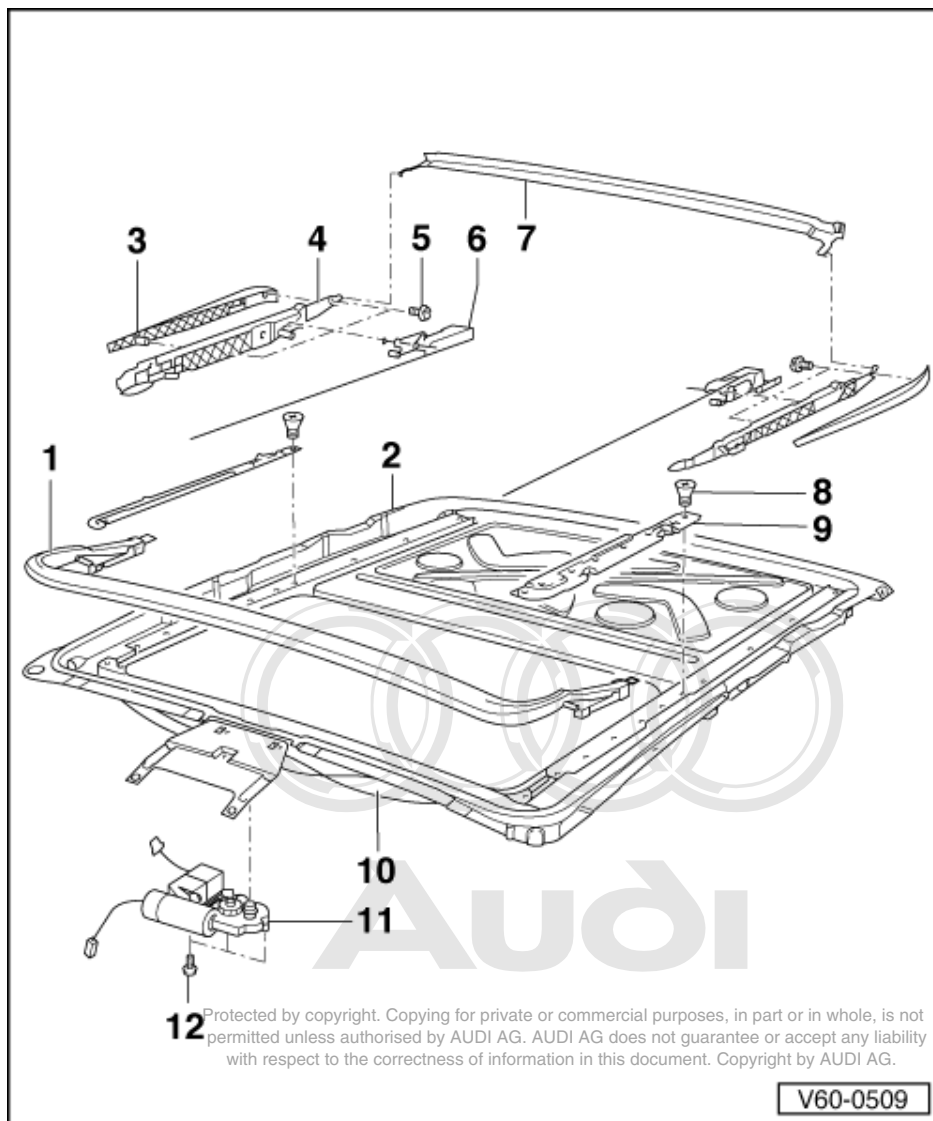
- ♦ Removing guide plate to take out rain channel => Page **123**
- ♦ On vehicles with glass panel, disengage limiting strap at rain channel

8 Countersunk screw - 2 Nm

9 Guide strip

- ♦ Remove to remove guide plate

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10 Guide tube

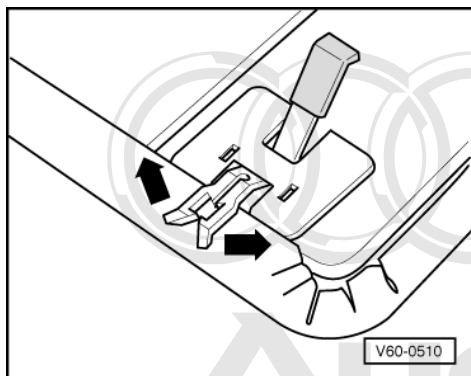
11 Sun roof motor

- ♦ Removing and installing
=>Page 121 .
- ♦ Adjusting zero setting
=>Page 122 .

12 Combi screw - 3 Nm

- ♦ 3 off

2.3 - Removing and installing sun roof panel - aluminium and solar panel



Removing

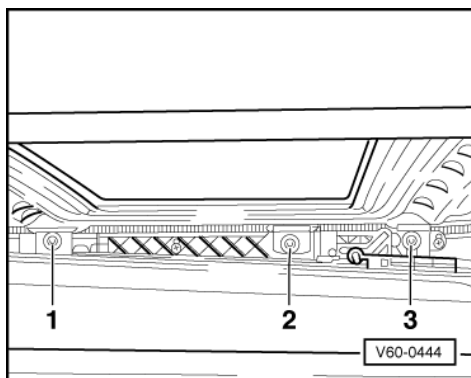
- Open sun roof approx. 10 cm towards the rear.
- -> Press apart fasteners on left and right (arrows) and slide sun roof headliner to rear.

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Note:

Fig. shows fastener from inside of sun roof headliner.

- Close sun roof.



- -> Unscrew bolts -1-, -2- and -3- on tilt mechanism on both sides (4.5 Nm).
- Lift off sun roof panel.

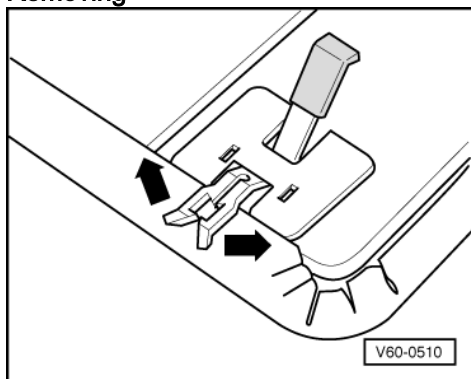
Installing

Installation is carried out in the reverse order; note the following:

- Adjusting sun roof panel => Page 125 .

2.4 - Removing and installing sun roof headliner - aluminium and solar panel

Removing

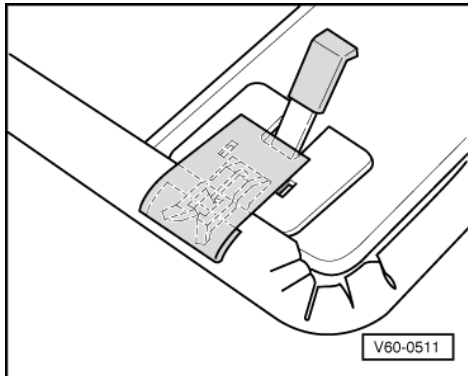


- Open sun roof approx. 10 cm towards the rear.
- -> Press apart fasteners on left and right (arrows) and slide sun roof headliner to rear.

Note:

Fig. shows fastener from inside of sun roof headliner.

- Close sun roof.



- -> Bind adhesive tape on around left and right fasteners to stop fasteners engaging in sun roof panel with sun roof tilted.

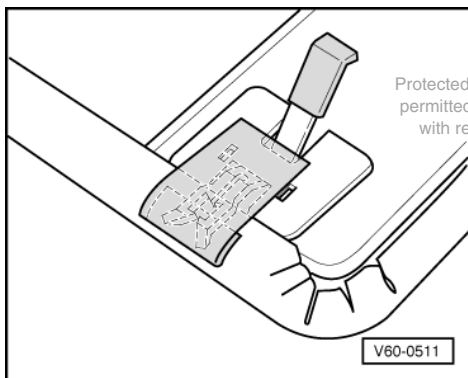
Note:

With sun roof tilted, fasteners at sun roof headliner must not engage in sun roof panel, as otherwise sun roof cannot be closed without damaging mechanism.

- Close sun roof, tilt it and push sun roof headliner forwards as far as it will go.
 - Fasteners cannot now engage
- Press sun roof headliner over rain channel and remove towards the rear through sun roof opening.

Installing

Note:



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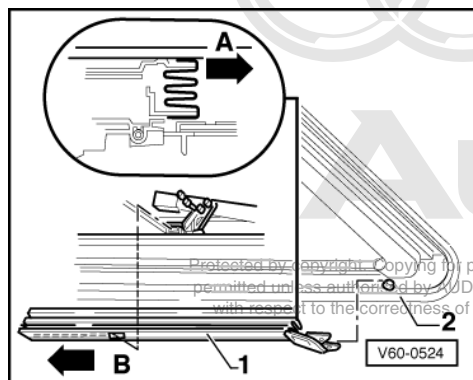
-> Before installing sun roof headliner with sun roof panel fitted, mask fasteners on sun roof headliner with adhesive tape.

- Tilt sun roof
- Insert sun roof headliner through sun roof opening, slide forwards as far as it will go in the guides, and press back over rain channel.
- Slide sun roof headliner to rear.
- Remove adhesive tape.
- Close sun roof.

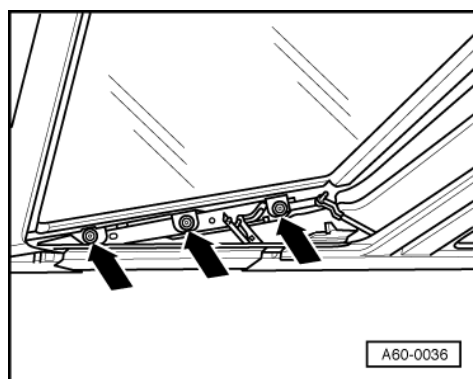
- Slide sun roof headliner forwards until fasteners engage in sun roof panel.

2.5 - Removing and installing sun roof panel - glass panel

Removing



- Slide sun roof headliner to rear as far as it will go.
- Tilt sun roof
- -> Pull out inner trim -1- at top of panel between glass and inner panel, in direction of arrow -A-.
- Unclip inner trim from pin at front of panel -2- and slide to rear -arrow B- to remove from clip guide.
- Detach the inner cover towards the centre of the vehicle.



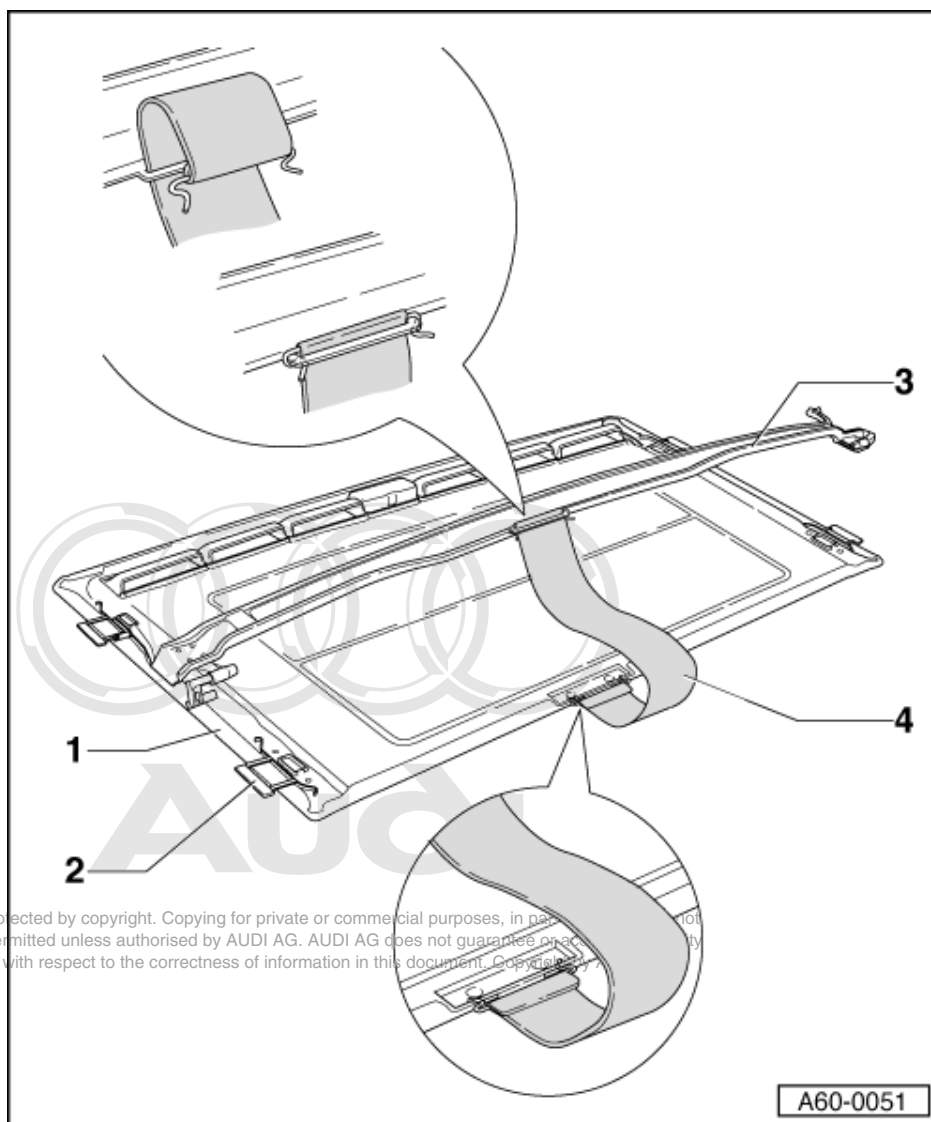
- -> Unscrew bolts -arrows- at tilt mechanism on both sides (4.5 Nm).
- Lift off sun roof panel.

Installing

Installation is carried out in the reverse order; note the following:

- Adjusting sun roof panel => Page 125 .

2.6 - Removing and installing sun roof headliner - glass panel



1 Sun roof headliner

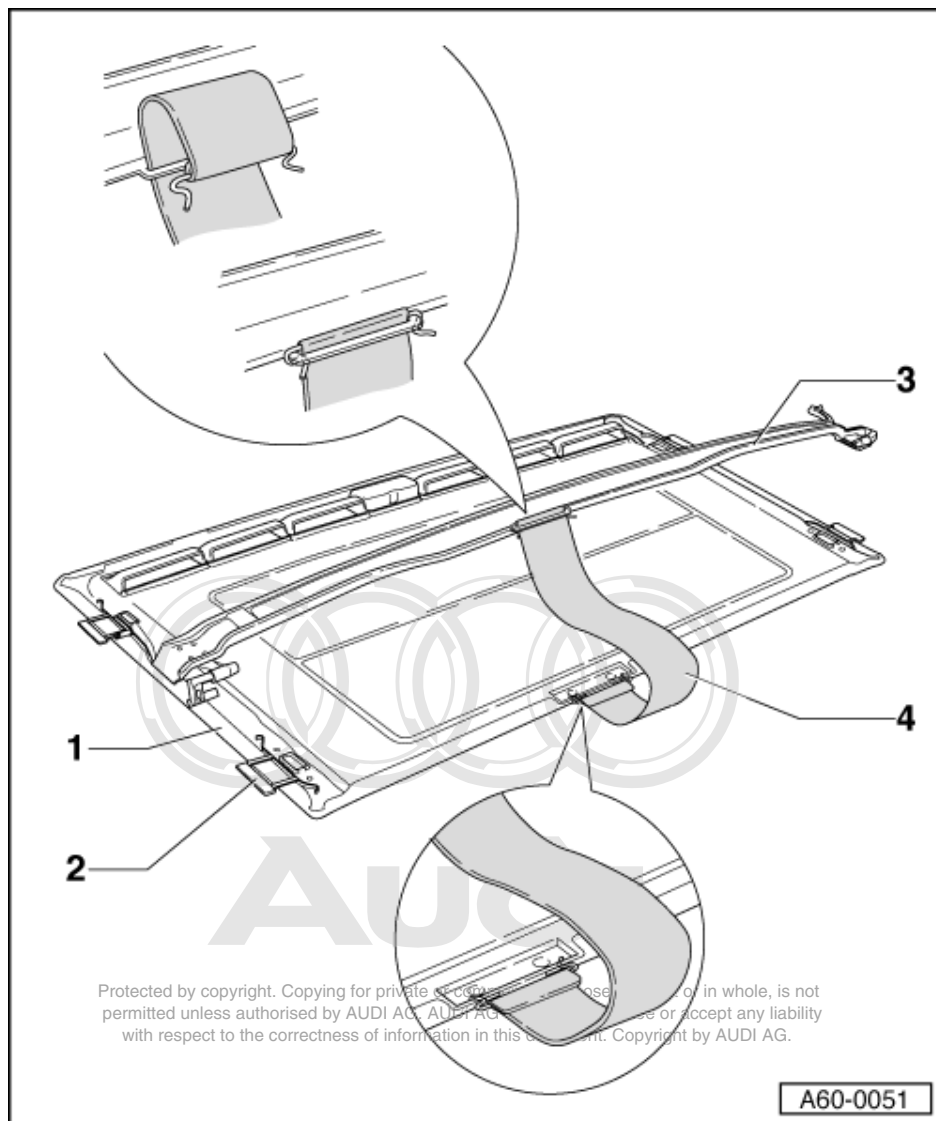
- ♦ Glass panel removed
- ♦ Press slides -item 2 - on one side out of guide towards centre of vehicle and lift off sun roof headliner.

2 Slide

- ♦ Pull out of clips of sun roof headliner -item 1 -

3 Drain channel

- ♦ Removing guide plate to take out rain channel => Page 123
- ♦ Disengage limiting strap at rain channel

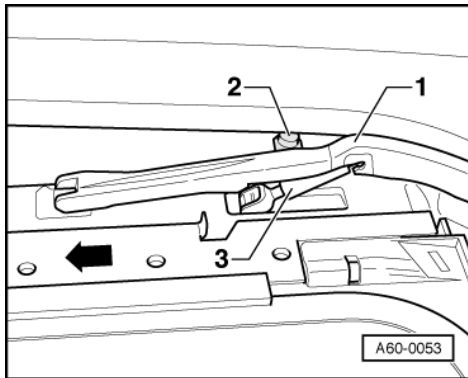


4 Check arm

- ◆ No replacement part
- ◆ Slide limiting strap at rain channel -item **3** - from underneath through eyelet and attach spring as shown
- ◆ Insert spring at sun roof headliner -item **1** -

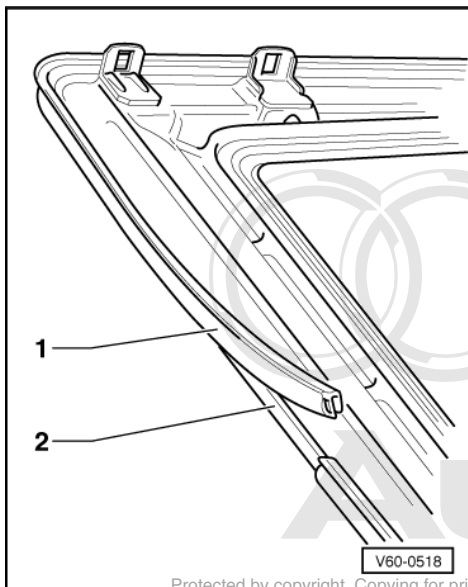
2.7 - Removing and installing wind deflector

- Move sun roof to rear as far as it will go.



- -> Push wind deflector -1- to rear in direction of arrow and press it out of holder.
- Press wind deflector towards centre of vehicle until stop -2- beneath sun roof opening is exposed.
- Lift wind deflector with spring -3- out of sun roof opening.
- When installing, make sure spring engages properly in frame.

2.8 - Removing and installing seal for sun roof panel



- Sun roof panel removed.

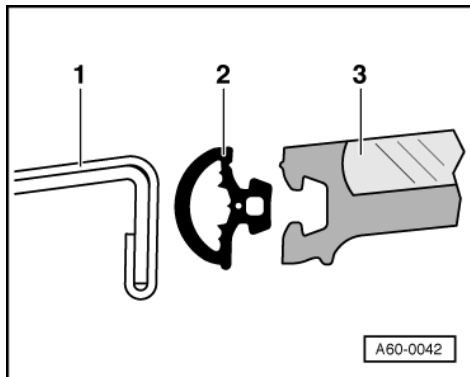
Vehicles with aluminium panel

- -> Detach seal -1- and remove residual adhesive.
- Coat panel flange -2- with D 002 100 adhesive on inside only.

Note:

Never cut the panel seal. If necessary, excess length must be offset by compressing on both sides.

Vehicles with solar or glass panel:



- -> Pull panel seal -2- out of sun roof panel -3-
- Press new panel seal into sun roof panel -3-, starting from centre of rear edge of sun roof panel.

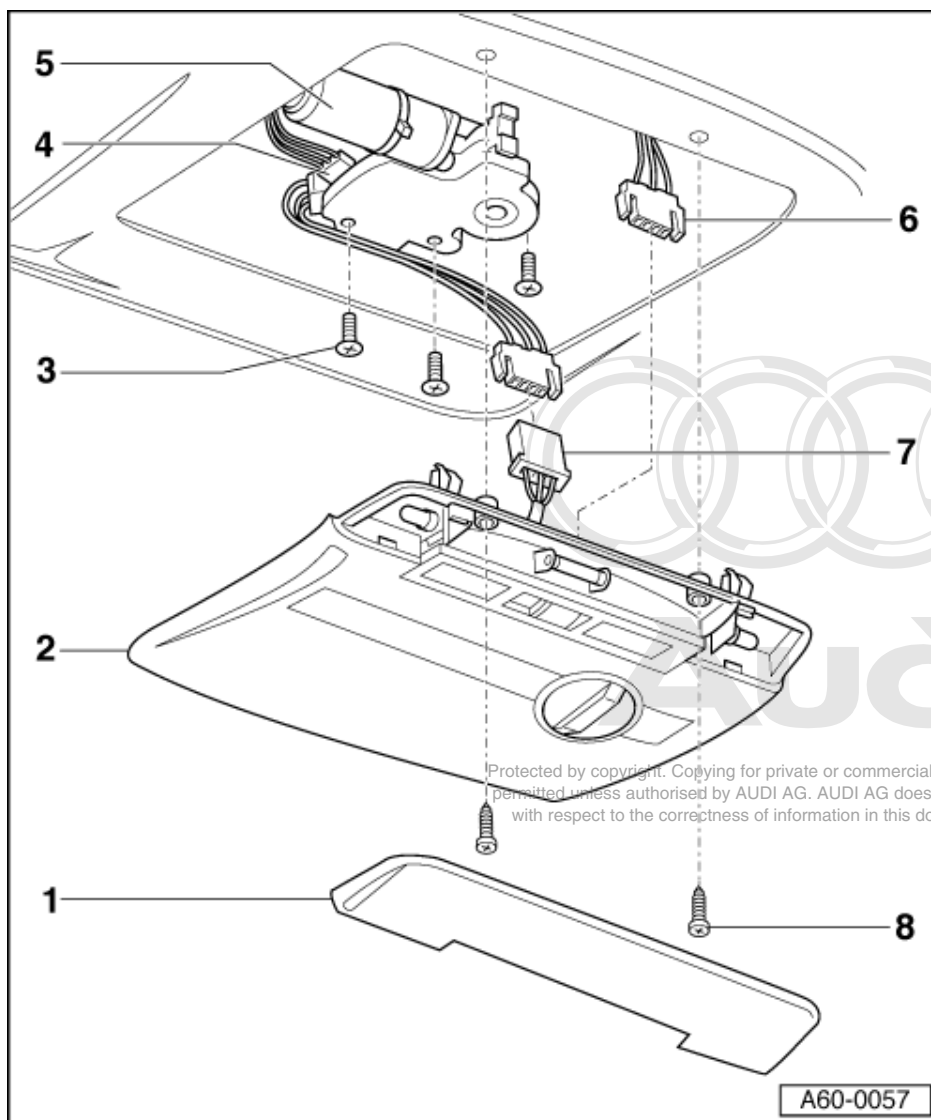
Note:

To facilitate installation of seal, lubricate edge of sun roof panel with soap solution.



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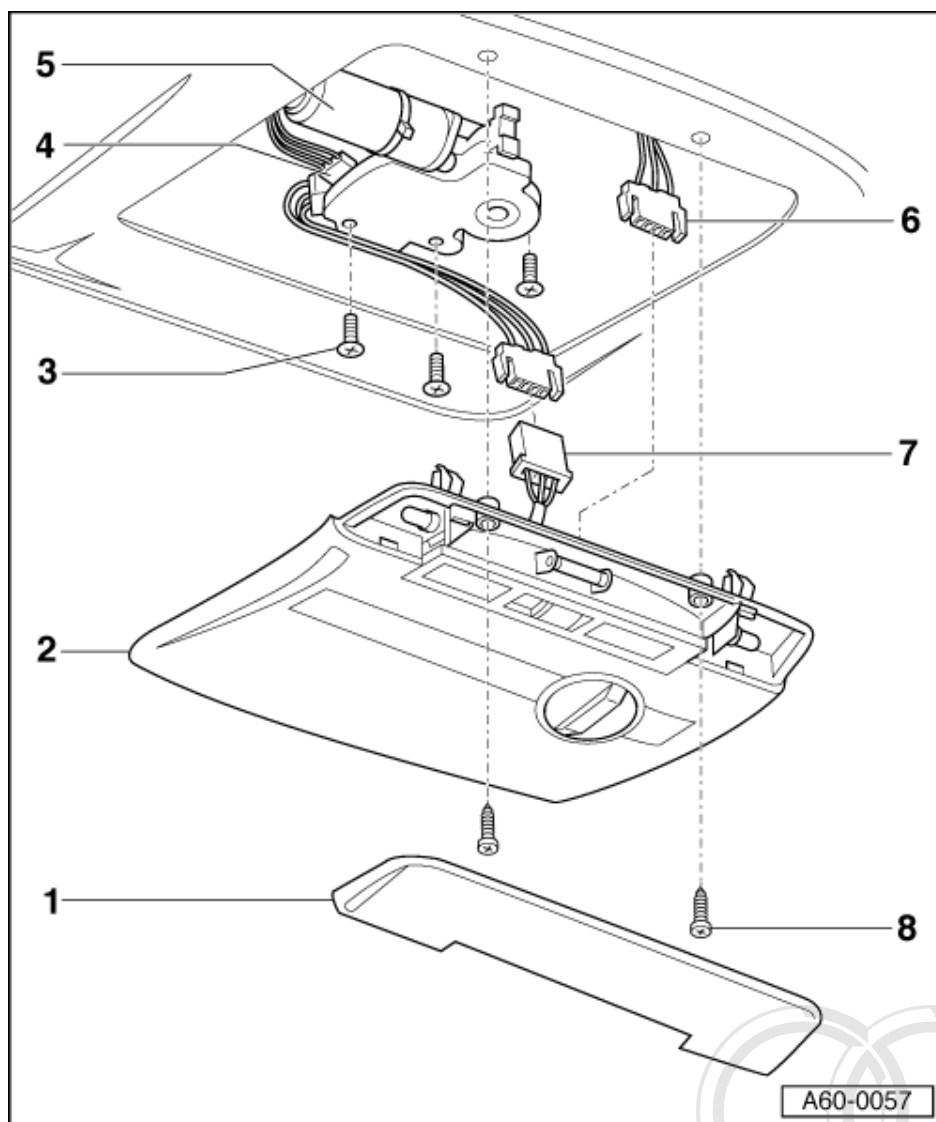
2.9 - Removing and installing sun roof motor



Note:

Sun roof motor must only be removed and installed with roof closed, i.e. only when cable drive and sun roof motor are in the zero setting.

- 1 Cover**
 - ◆ For interior light
 - ◆ Unclip downwards
- 2 Cover**
 - ◆ For sun roof motor
 - ◆ Loosen bolts - **8** - and pull forwards out of clips
- 3 TORX-bolt - 3 Nm**
 - ◆ 3 off



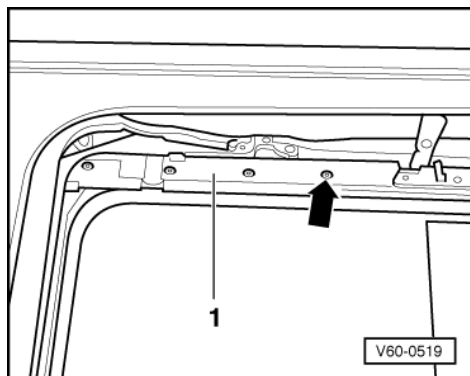
- 4 Connector
 - ◆ At sun roof motor
 - ◆ Detach
- 5 Sun roof motor
- 6 Connector
 - ◆ For interior light
 - ◆ Detach
- 7 Connector
 - ◆ For sun roof motor
 - ◆ Detach
- 8 Bolt
 - ◆ 2 off

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2.10 - Adjusting zero setting of motor

- Sun roof motor removed, wiring connected.
- Move rotary control to "roof closed" position.
- Motor runs into zero position and cuts out automatically.
- Install motor in this position with sun roof closed.

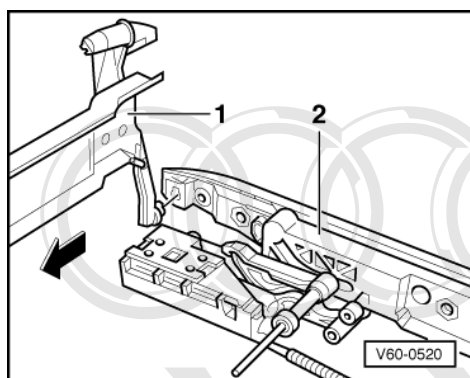
2.11 - Removing and installing guide plate with cable



- Sun roof panel removed.
- Sun roof motor removed.

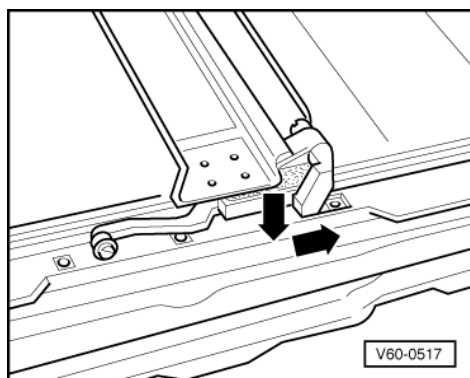
Removing

- Slide guide plate backwards into guide rail, pressing evenly on both sides.
- -> Unscrew (2 Nm) bolts at guide strip.
- Detach guide strip.
- Push guide plate forwards out of guide rail.



- Unscrew bolts on left and right at trim panels and detach trim panels.
- -> Lever out clips of rain channel -1- on left and right in guide plate.
- Raise rain channel, in the guide plate -2-, and pull out in direction of arrow.

On vehicles with glass panel, disengage limiting strap at rain channel.
Pull out guide plate with cable.



Installing

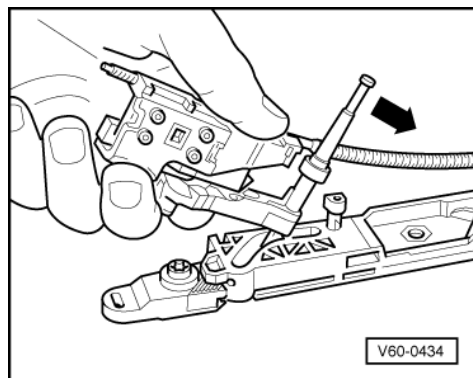
Installation is carried out in the reverse order; note the following:

Note:

Fit rain channel before installing guide plates.

- -> Insert rain channel into frame in direction of arrow and push in towards rear.

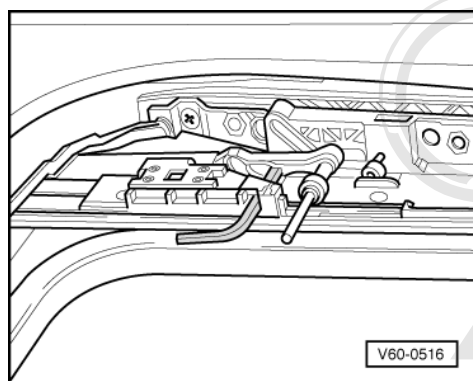
2.12 - Removing rear guide from guide plate / installing



- -> Move rear locator to centre position and push off in direction of arrow.
- When installing, insert rear guide in centre position of guide plate, taking care to keep it straight, and drive in by tapping gently with hammer.

2.13 - Testing and adjusting guide plate zero-setting

- Sun roof motor removed.



- -> Slide guide plate -2- backwards on both sides.
- Use 4 mm Allen key to lock guide plate and rear guide -1- with cable in zero setting.

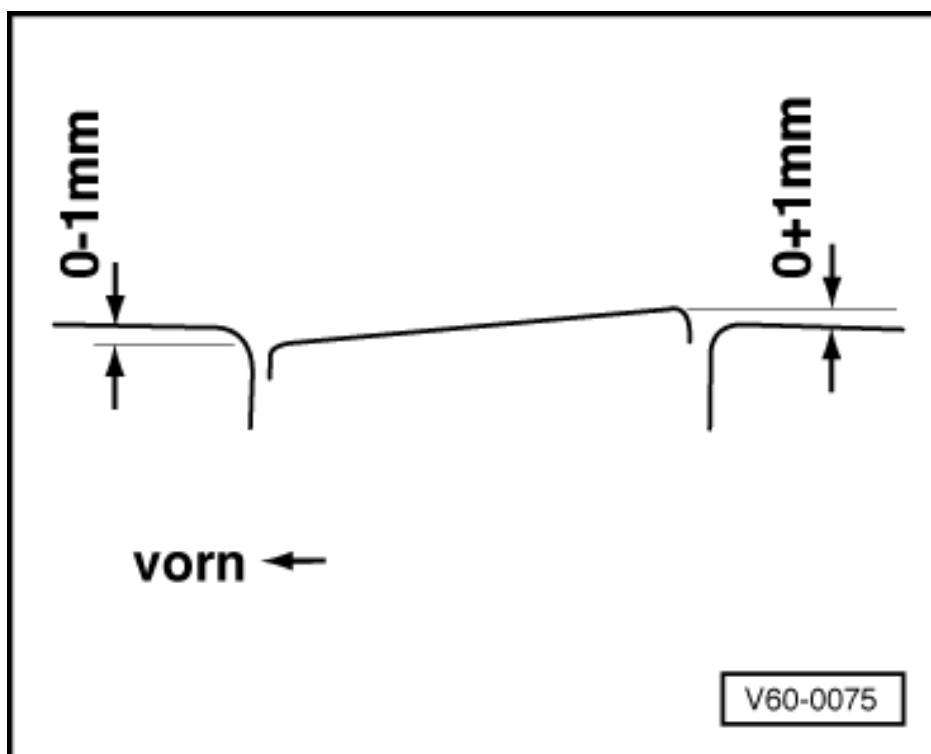
Note:

With hexagon socket wrenches inserted left and right, push rear locator and guide plate back to stop limit to prevent play.

- Install motor at zero setting.

2.14 - Adjusting height of sun roof panel

- Adjust the height at the front and rear, as shown, to prevent wind noise.

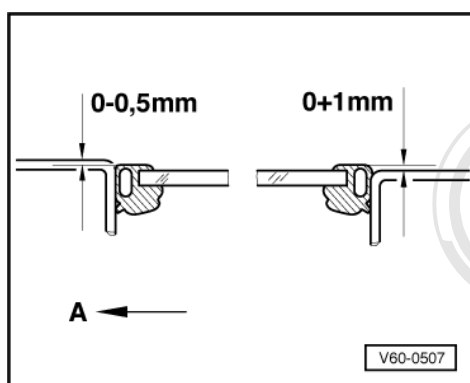


- Check height adjustment in each case at end of roof-opening radii towards centre of vehicle.

Notes:

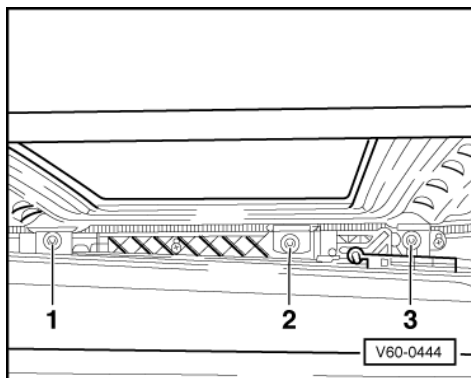
- ♦ At no point should the sun roof panel be higher than the roof at the front, or lower at the rear.
- ♦ To adjust the height, always move sun roof forwards from open position.

-> Vehicles with aluminium panel

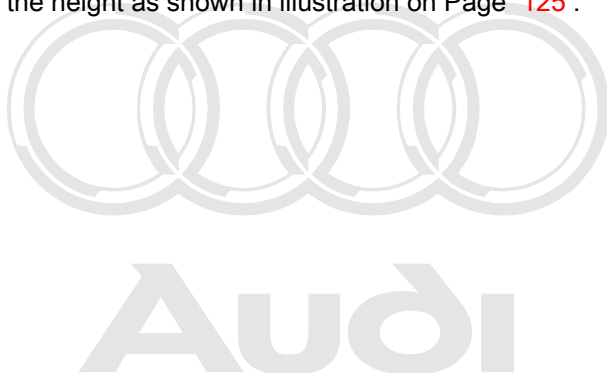


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-> Vehicles with glass or solar panel



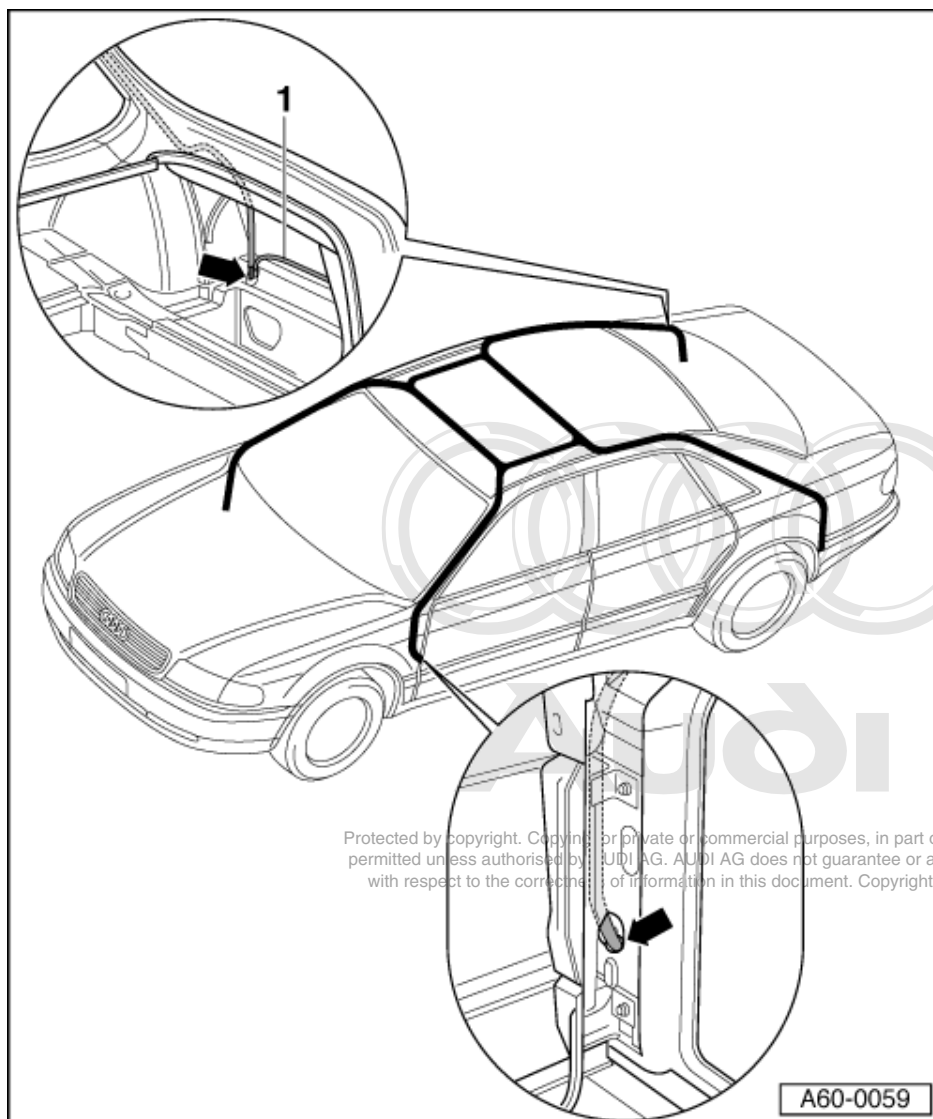
- -> To adjust height at front, loosen screws -1- and -2- (4.5 Nm).
- To adjust height at rear, loosen bolts -2- and -3- (4.5 Nm).
- Adjust the height as shown in illustration on Page **125** .



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3 - Cleaning water drain hoses

3.1 - Cleaning water drain hoses



Note:

A shop-built tool made from a speedometer drive cable (forming an approx. 2300 mm long probe) is suitable for cleaning purposes. This is fully twisted.

Front water drain hoses

Front water drain hoses run in the A-pillars and end above the bottom hinge of the front doors -arrow-. Cleaning is carried out from the sun roof opening.

Rear water drain hoses

The rear water drain hoses run in the D-pillars and end behind the wheel housings -arrow- (on the right with battery vent hose -1-). Cleaning is performed from the lower end of the tube.



63 - Bumpers

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

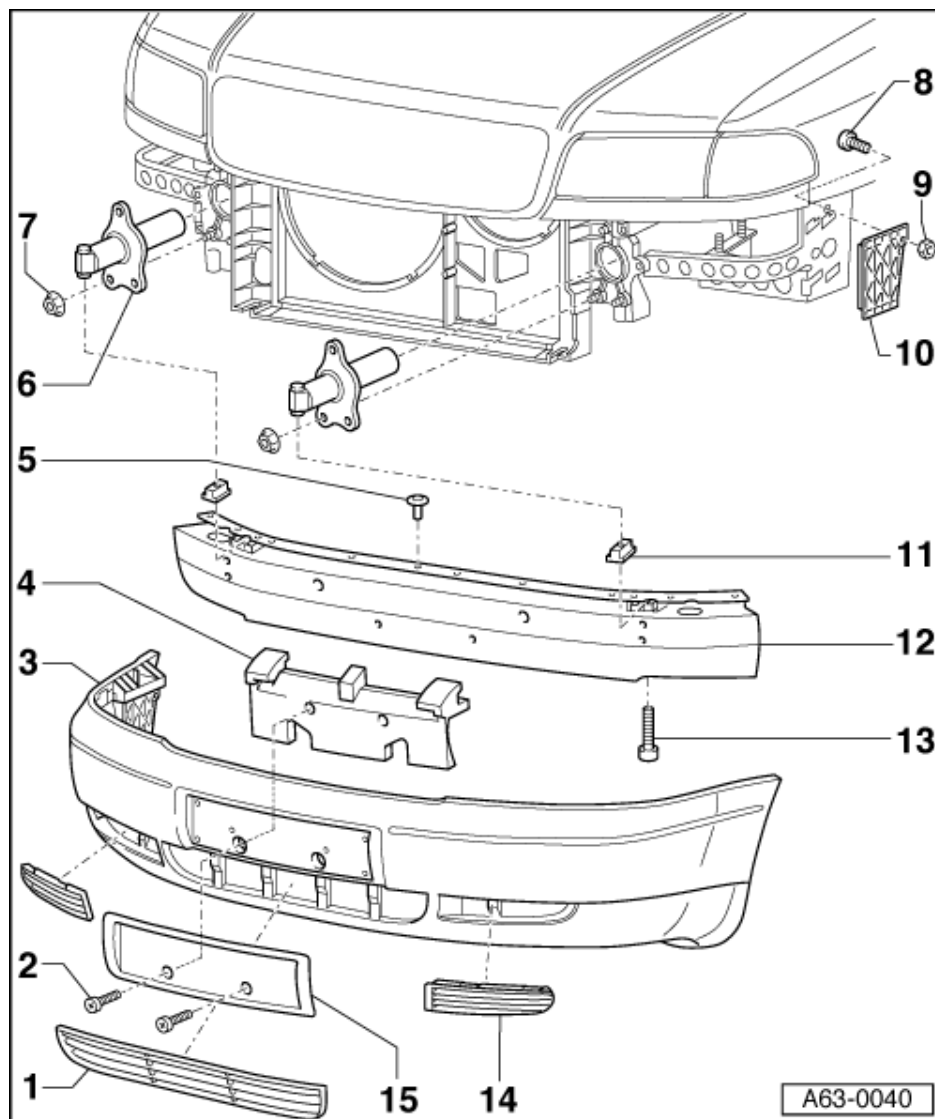
Important

- ◆ **Use only genuine Audi A8 Parts.**
- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**

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2 - Front bumper

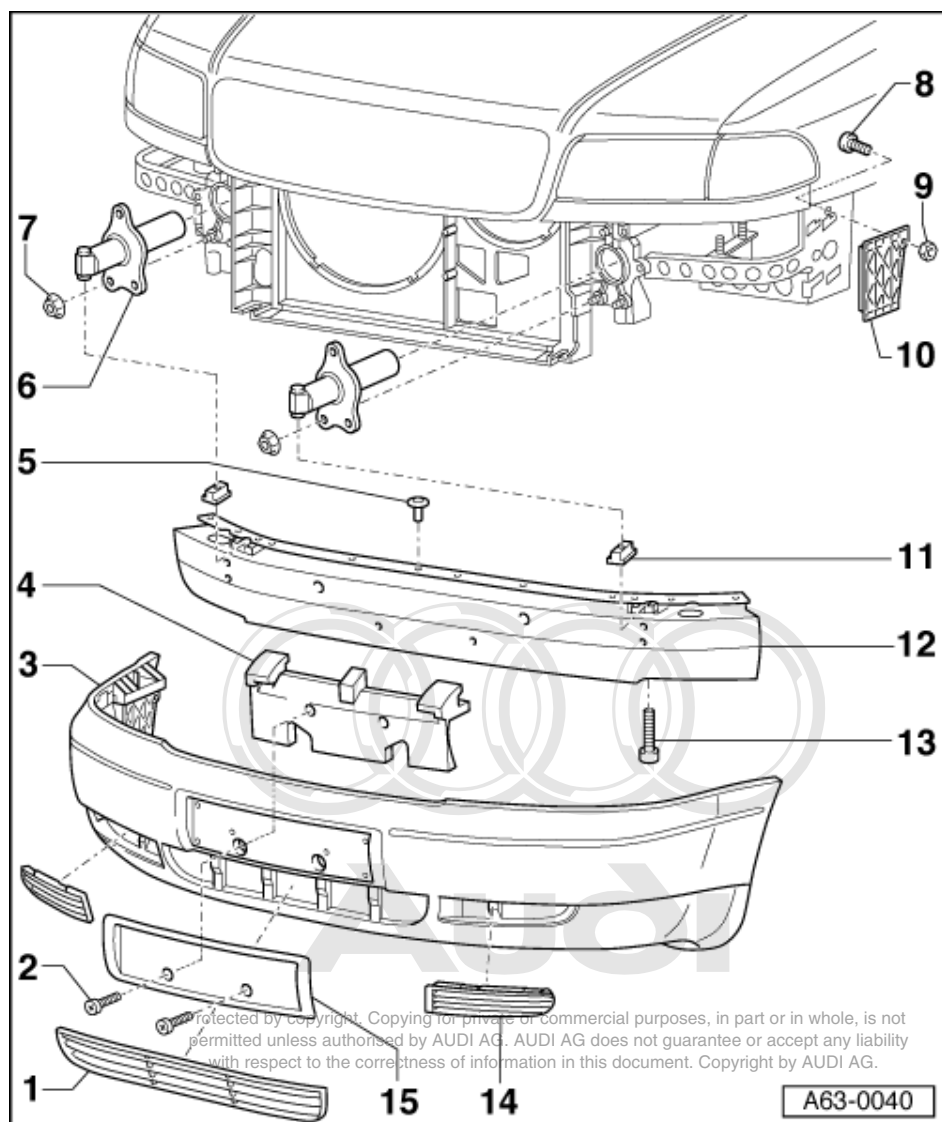
2.1 - Front bumper



2.2 - Single-piece front bumper(without foglamps)- Exploded view

- 1 Centre air duct grille
- 2 Oval-head screw - 1 Nm
 - ♦ 2 off
- 3 Bumper cover
 - ♦ Removing and installing
=>Page 133 .
- 4 Filler piece
- 5 Expanding clip
 - ♦ 18 off

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6 Impact absorber

- ◆ 2 off
- ◆ Removing:
 - Remove bumper: =>Page 131 .
 - Removing pressure switch:

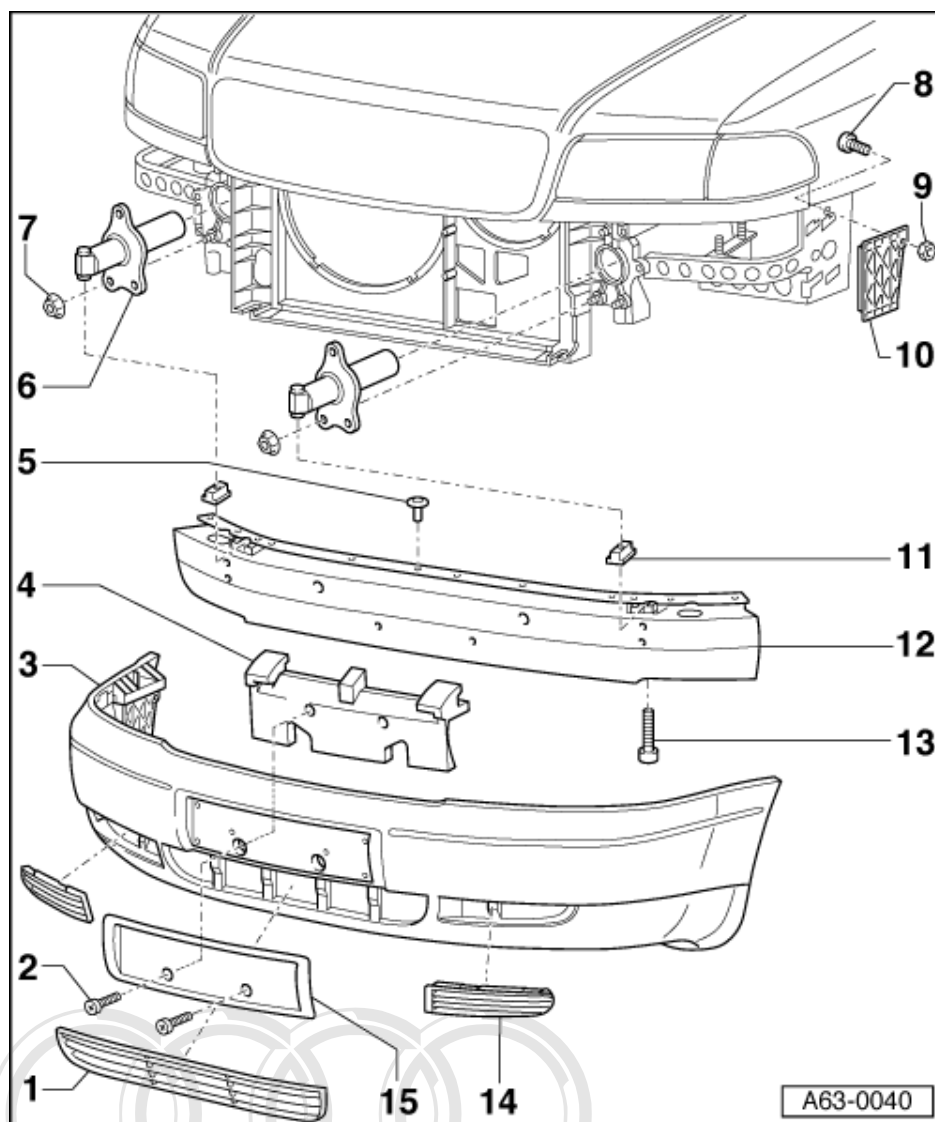
=> Air Conditioner; Repair group 87; Servicing refrigerant circuit Servicing refrigerant circuit

- Unscrew nuts/bolts -item 7 - and pull out impact absorber.
- ◆ Checking => Page 159

7 23 Nm

- ◆ 3 off
- ◆ Up to model year 1994: Nuts
- ◆ Model year 1995 onwards: Bolts

8 Release and tighten bolt - 12 Nm



9 Nut

10 Bracket

- ♦ Different versions on left and right
- ♦ Adjusting => Page 132

11 Nut

12 Bumper mount

- ♦ Removing:
- Remove bumper: =>Page 131 .
- Unfasten expanding clip -item. 5 -.

♦ Adjusting => Page 133

13 Cheese-head bolt - 65 Nm

14 Air duct grille

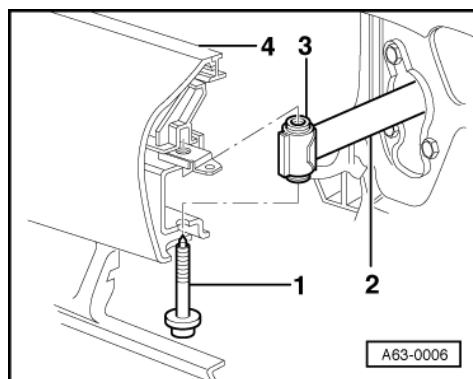
15 Number plate holder

- ♦ Removing and installing
- =>Page 134 .

2.3 - Removing and installing front bumper

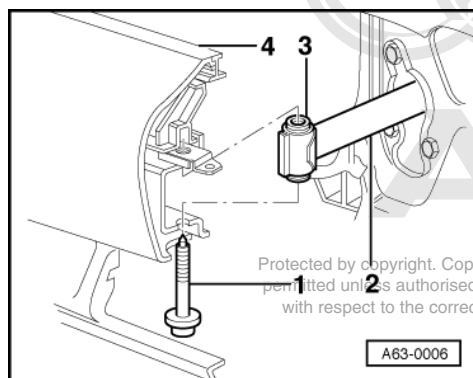
- Remove noise insulation =>Page 10 .
- Unclip air duct grilles on left and right.
- On right side, unclip air duct for alternator at bumper cover.

- On vehicles with headlight washer system, use hose clamp 3094 to pinch off hose at T-piece on the right side.
- Pull hose off T-piece.
- Detach the three clips in front area of wheel-housing liner and unfasten the two nuts at wheel housing.



- -> Remove screw -1-.
- Remove bumper -4- to front.

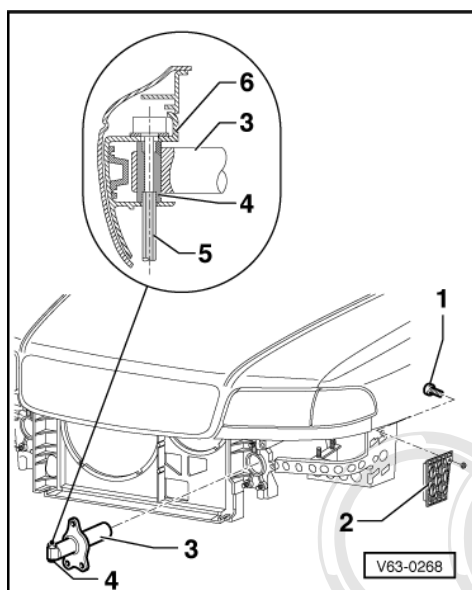
2.4 - Adjusting front bumper



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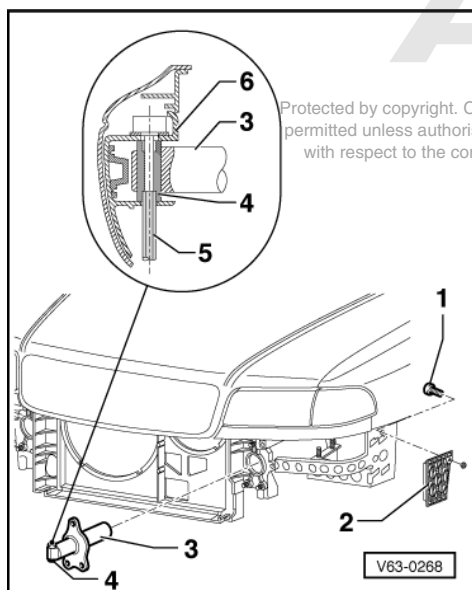
Adjusting height at impact absorber

- Unclip air duct grilles on left and right.
- -> Remove screw -1-.



- -> Insert Allen key -5- through opening for air duct grille into threaded bushing -4-.
- Adjust threaded bushing -4- up or down in impact absorber -3-.

Adjusting height at bracket



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- -> Loosen bolt -1- of bracket -2- several turns.
- Adjust height of bumper in relation to wing by moving bracket to front or rear.

2.5 - Removing and installing front bumper cover

- Bumper removed.
- Removing jets on vehicles with headlight washer system

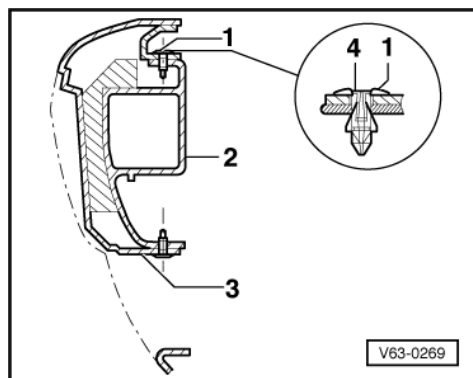
=> Electrical system; Repair group 92; Servicing headlight washer system; Removing and installing headlight washer system jets Servicing headlight washer system Removing and installing headlight washer system jets



Audi A8 1994 ➤

General Body Assembly, Exterior (Rep. groups 50, 55, 57, 58, 60, 63, 64, 66) -

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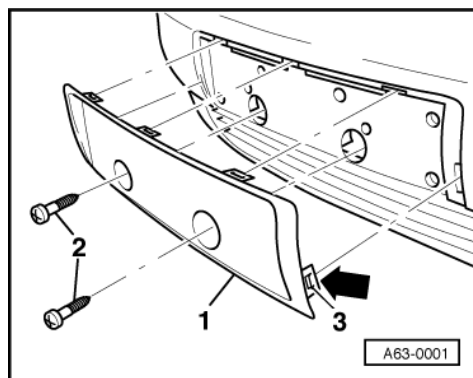


- -> Press out pins -4- of expanding clips -1- and pull out expanding clips.
- Lift bumper mount -2- out of bumper cover -3-.

Note:

Pins must be heard to engage in expanding clips when installing.

Removing and installing number plate holder

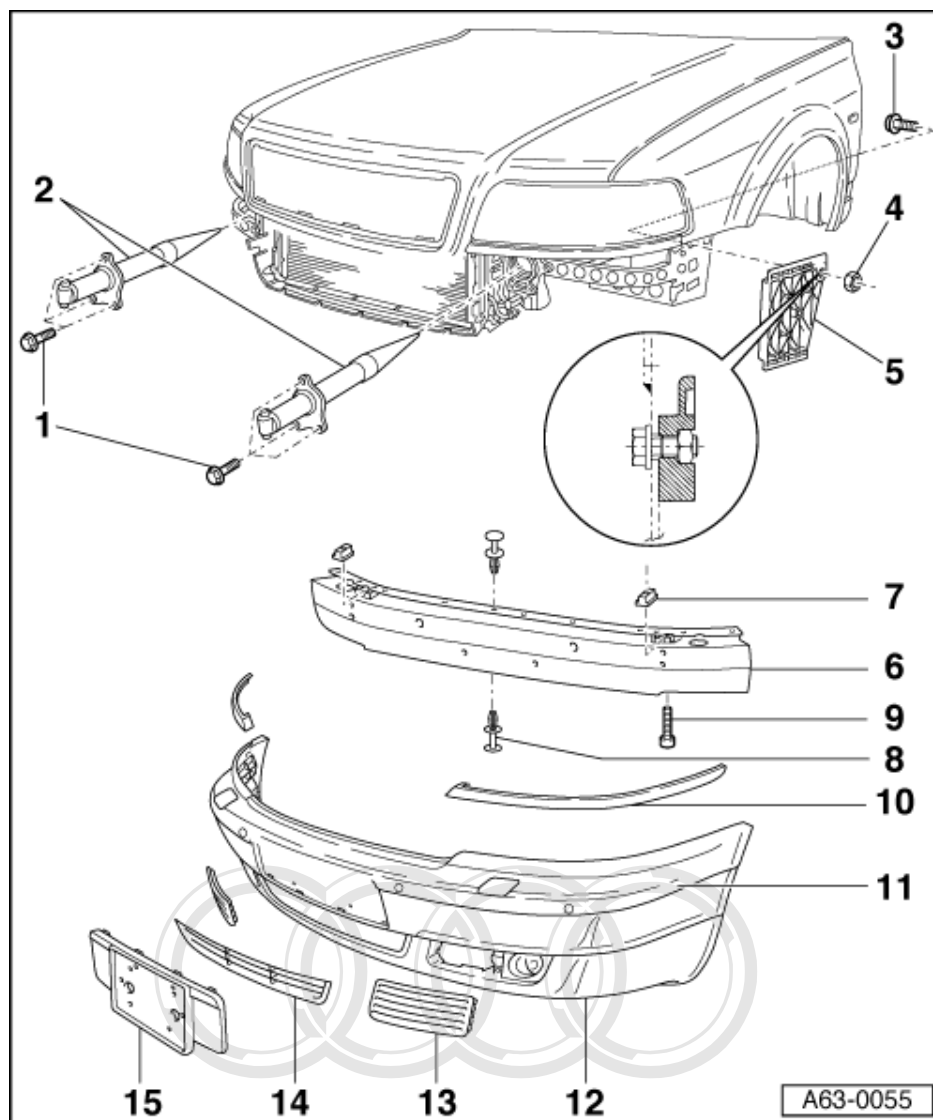


- -> Unscrew bolts -2-.
- Press in retainer tabs -3- (5 off) in direction of arrow.
- Pull out number plate holder -1-.



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2.6 - Two-piece front bumper(with foglamps) - Exploded view



1 Hexagon bolt

- ♦ 21 Nm

2 Impact absorber

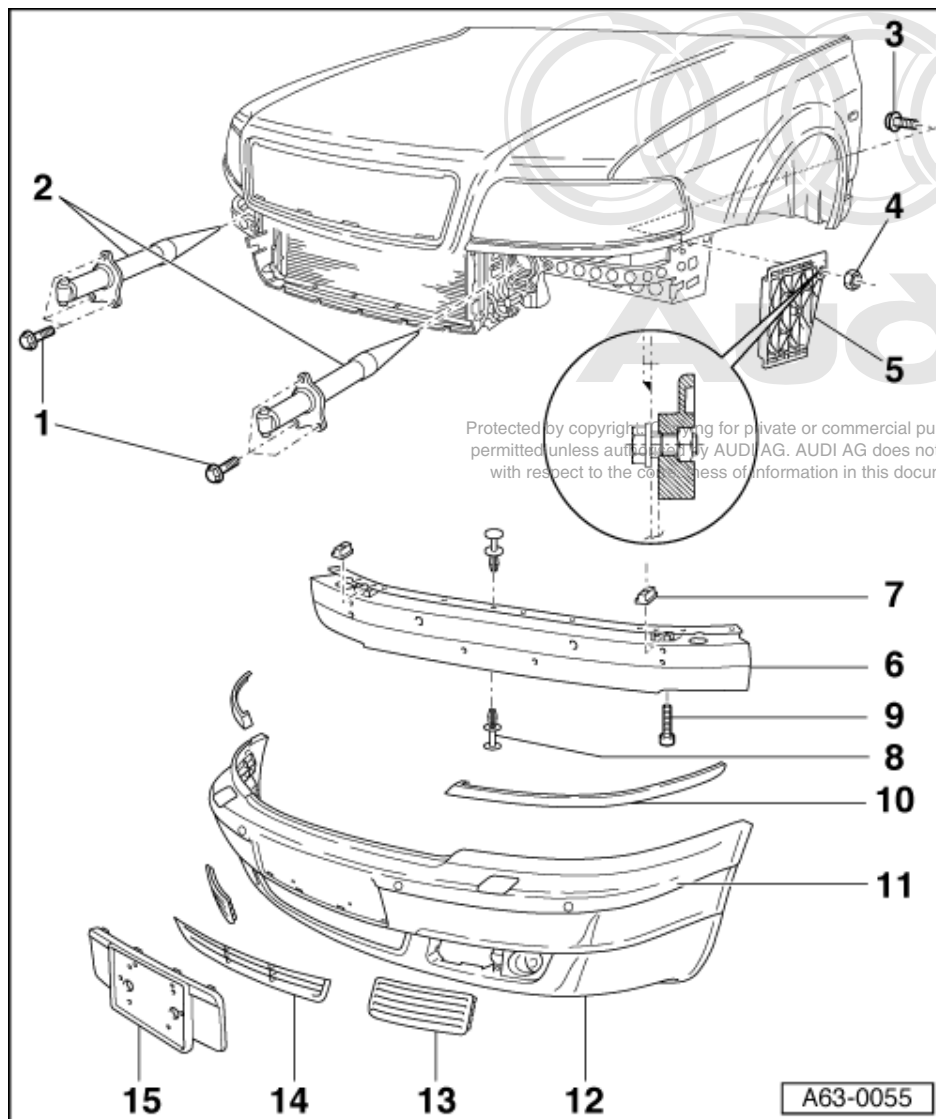
- ♦ 2 off
- ♦ Removing;
- Remove bumper => Page 131.
- Removing pressure switch.

=> Air Conditioner; Repair group 87; Servicing refrigerant circuit Servicing refrigerant circuit

- Remove the hexagon bolts -1- and pull out the impact absorber.
- ♦ Checking => Page 159

3 Hexagon bolt

- ♦ 10 Nm



4 Hexagon nut

5 Bracket

- ♦ Different versions on left and right
- ♦ Adjusting => Page 132

6 Bumper mount

- ♦ Removing:
- Bumper removed
- Unfasten expanding clip -item. 5 -.

7 Nut

8 Expanding clip

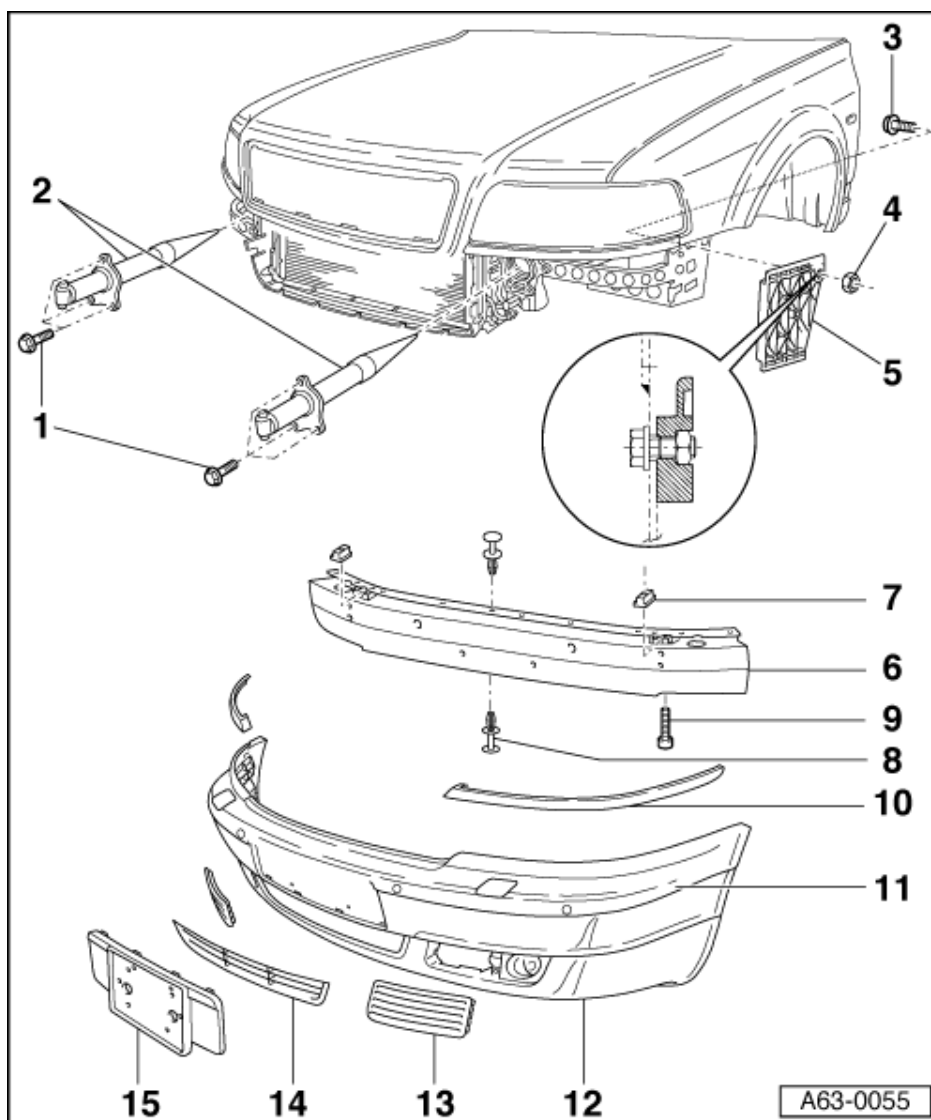
- ♦ 18 off
- ♦ Unclip =>Page 143

9 Hexagon bolt

- ♦ 65Nm

10 Trim strip

- ♦ Removing and installing => Page 141



11 Bumper cover

12 Front spoiler

- ♦ Can be replaced separately.
- ♦ Removing and installing => Page 141

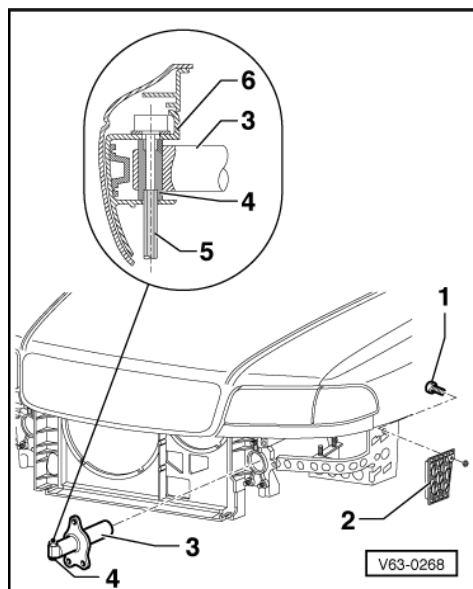
13 Outer air duct grille

14 Centre air duct grille

15 Number plate holder



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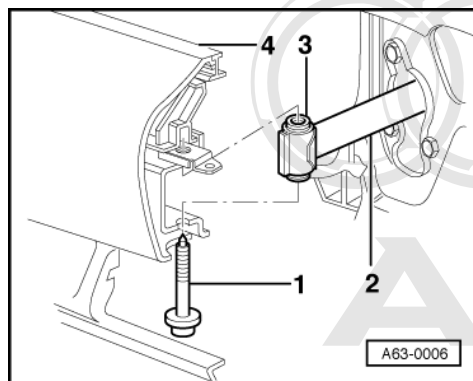


-> Fig. 1 Adjusting height at bracket

- Loosen bolt -1- of bracket -2- several turns.
- Adjust height of bumper in relation to wing by moving bracket to front or rear.

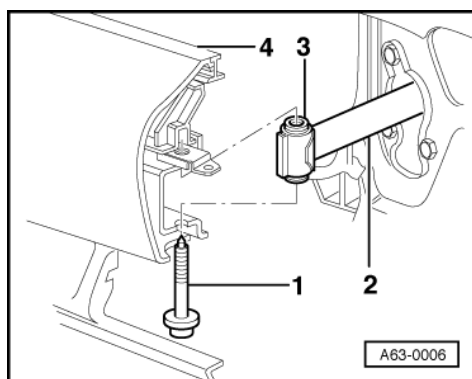
2.7 - Removing and installing front bumper

- Noise insulation removed.
- Unclip air duct grilles on left and right.
- On right side, unclip air duct for alternator at bumper cover.
- On vehicles with headlight washer system, use hose clamp 3094 to pinch off hose at T-piece on the right side.



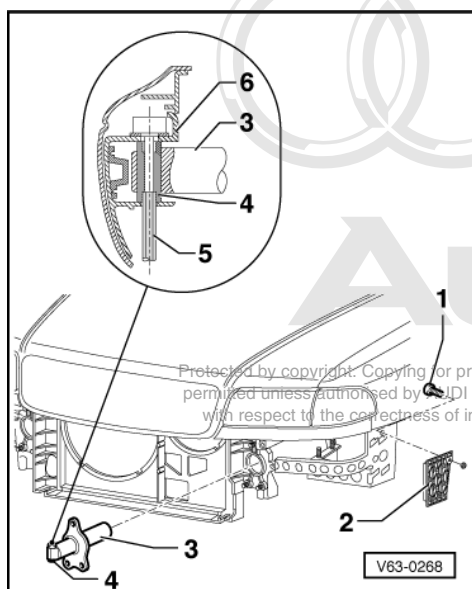
- Pull hose off T-piece.
- Detach the three clips in front area of wheel-housing liner and unfasten the two nuts at wheel housing.
- -> Remove screw -1-.
- Remove bumper -4- to front.

2.8 - Adjusting front bumper



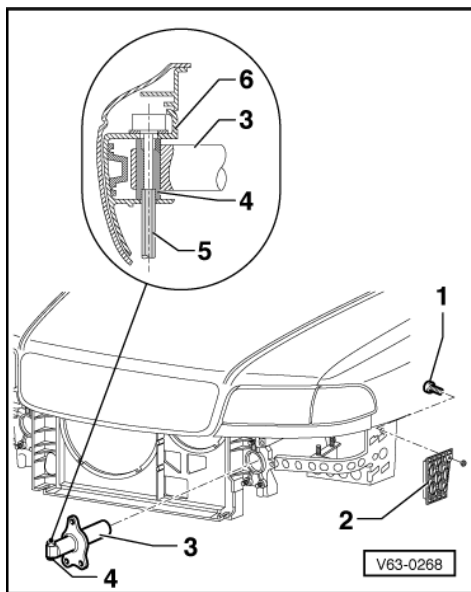
Adjusting height at impact absorber

- Unclip air duct grilles on left and right.
- -> Remove screw -1-.

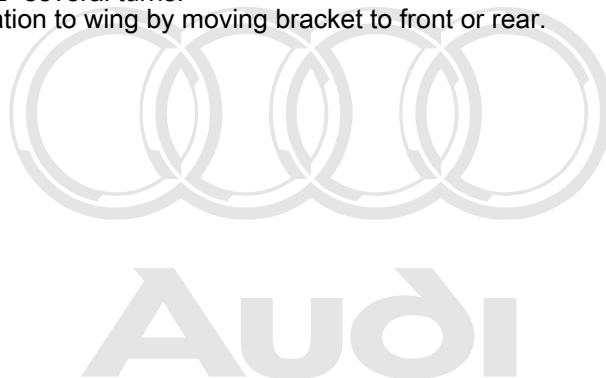


- -> Insert Allen key -5- through opening for air duct grille into threaded bushing -4-.
- Adjust threaded bushing -4- up or down in impact absorber -3-.

Adjusting height at bracket

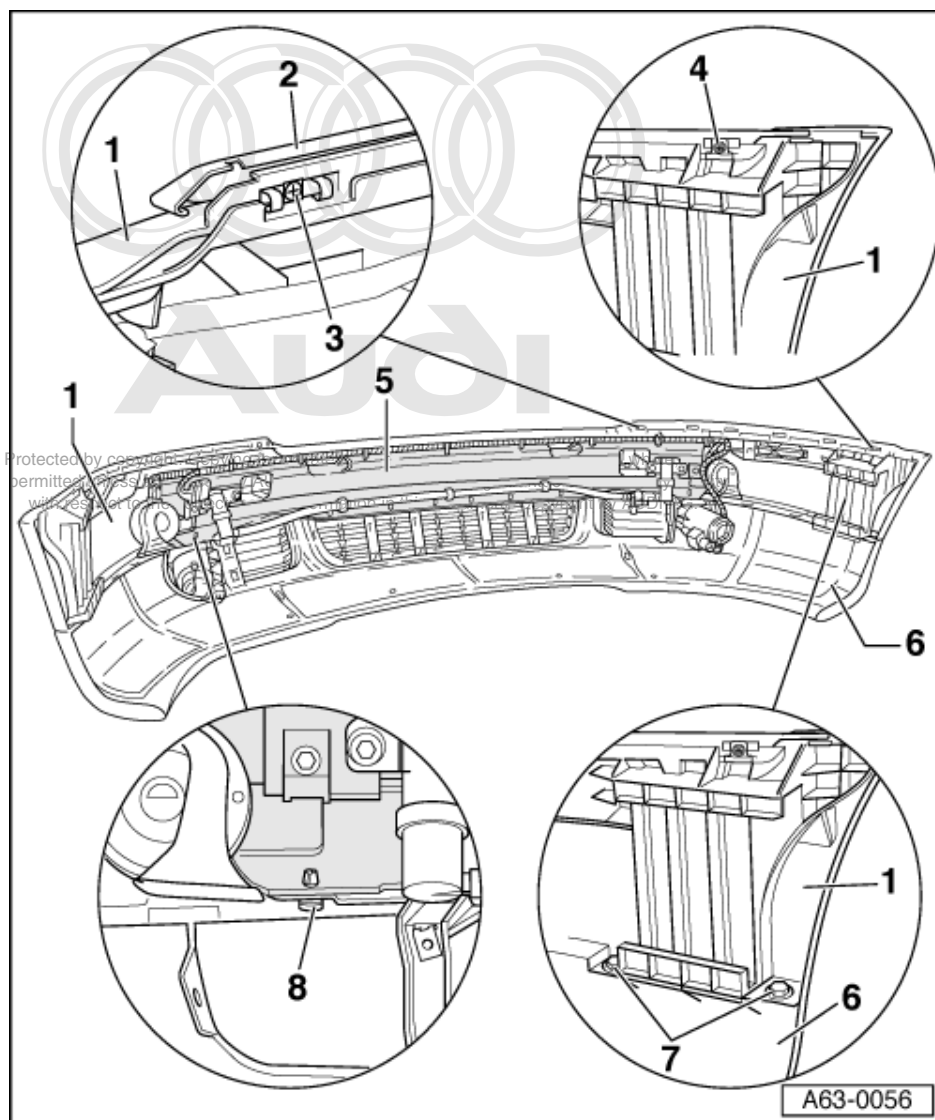


- -> Loosen bolt -1- of bracket -2- several turns.
- Adjust height of bumper in relation to wing by moving bracket to front or rear.



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2.9 - Front trim strip and spoiler Assembly overview



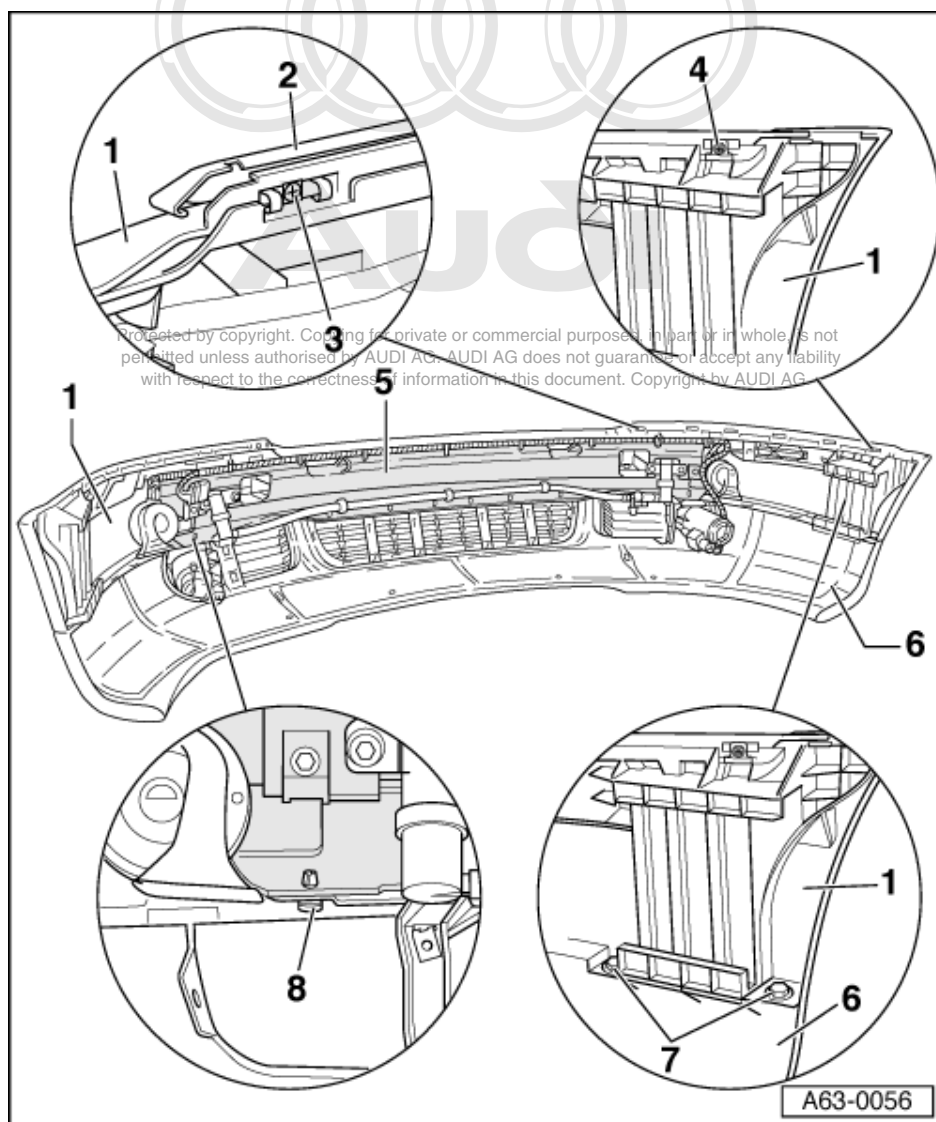
1 Bumper cover

2 Trim strip

- ◆ The bumper must be removed before detaching.
- Remove cross-head screws -3- and -4- to detach.
- Release the catches of the fasteners and detach forwards together with the trim strip =>Page 143 .
- ◆ Push the fasteners into the bumper cover before installing the trim strip.

3 Cross-head screw

4 Cross-head screw



5 Bumper mount

- ◆ Removing.
- Remove the clips -8- from the top and bottom => Fig. 1

6 Spoiler

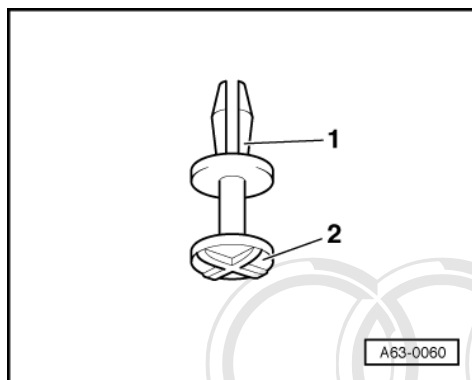
- ◆ Removing.
- Bumper removed.
- Unscrew hexagon bolts -7-.
- Remove the clips -8- from the bottom => Fig. 1

7 Hexagon bolt

- ◆ 21 Nm

8 Clip

- ◆ 15 off

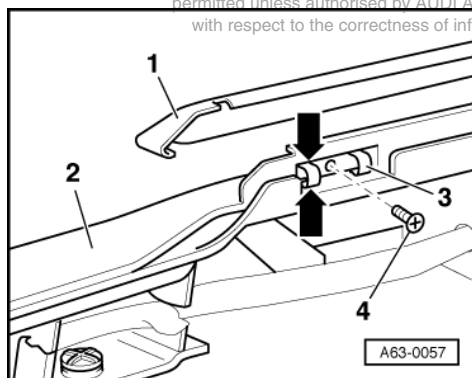


➔ Fig.1 Clip for bumper cover

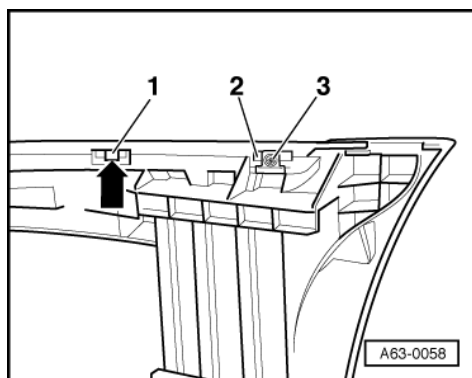
- To remove, pull out the locking pin -2- as shown.
- Pull out the clip -1- from the bumper cover.
- To install, press the clip in the bumper and secure by pushing in the locking pin.

2.10 - Remove front trim strip

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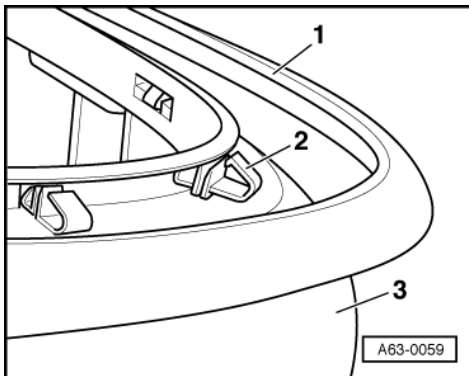


- Bumper removed.
- ➔ Remove the cross-head screw -4-.
- Press the fastener -3- together slightly using pliers and push out of the bumper cover -2- together with the trim strip.

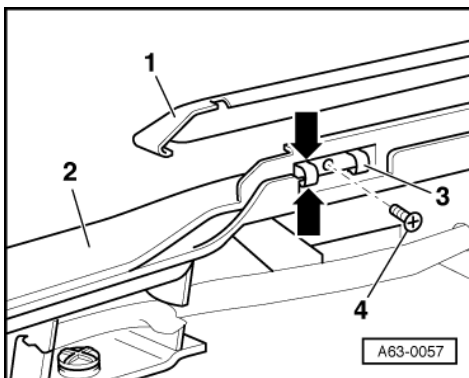


- Remove cross-head screw -3-.
- ➔ Press the catches of the fastener -2- together using pliers and push out of the bumper cover together with the trim strip.
- Release the fasteners -1- and push them completely out of the bumper cover together with the trim strip.

2.11 - Installing front trim strip



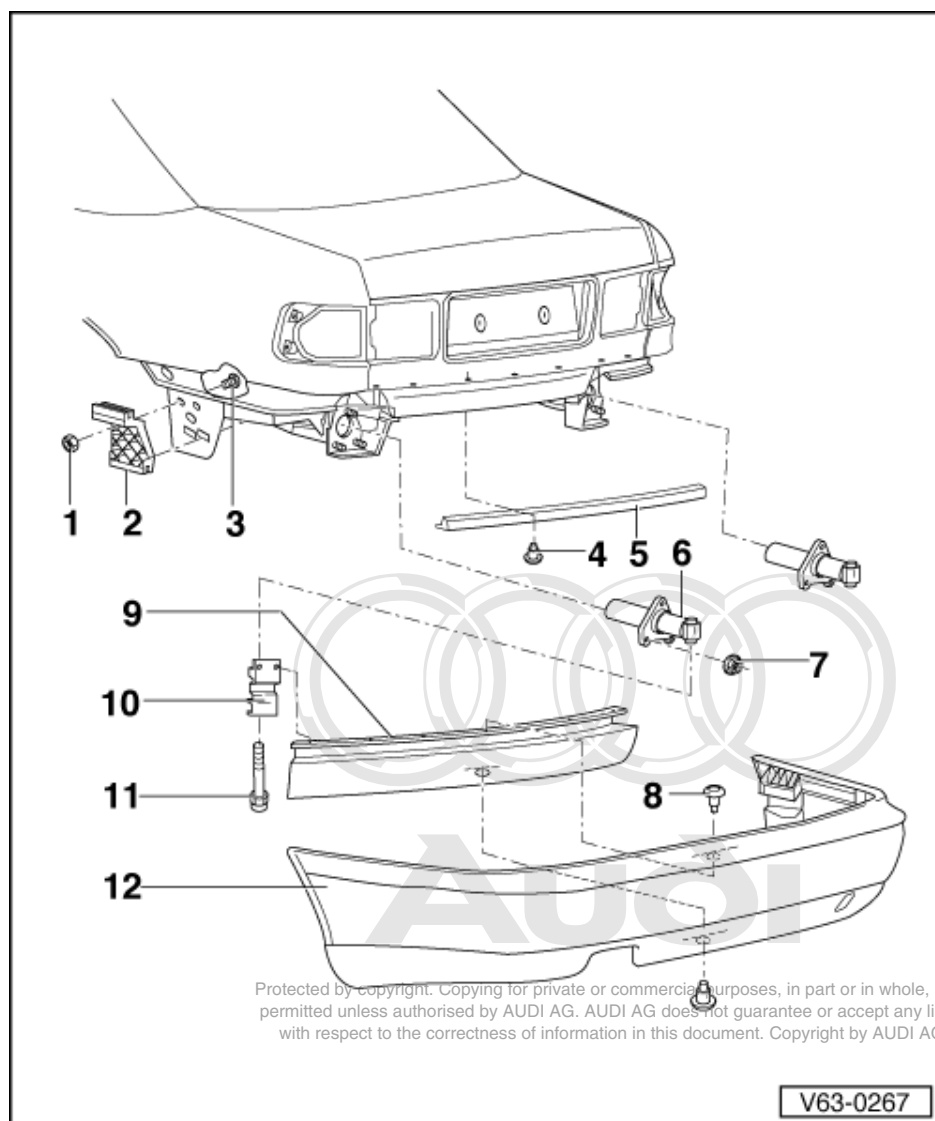
- -> First press the fasteners -2- into the bumper cover.
- Press the trim strip -1- onto the fasteners.
- The fasteners must engage audibly.



- -> Screw the cross-head screws -4- back into the fasteners -3-.

3 - Rear bumper

3.1 - Rear bumper

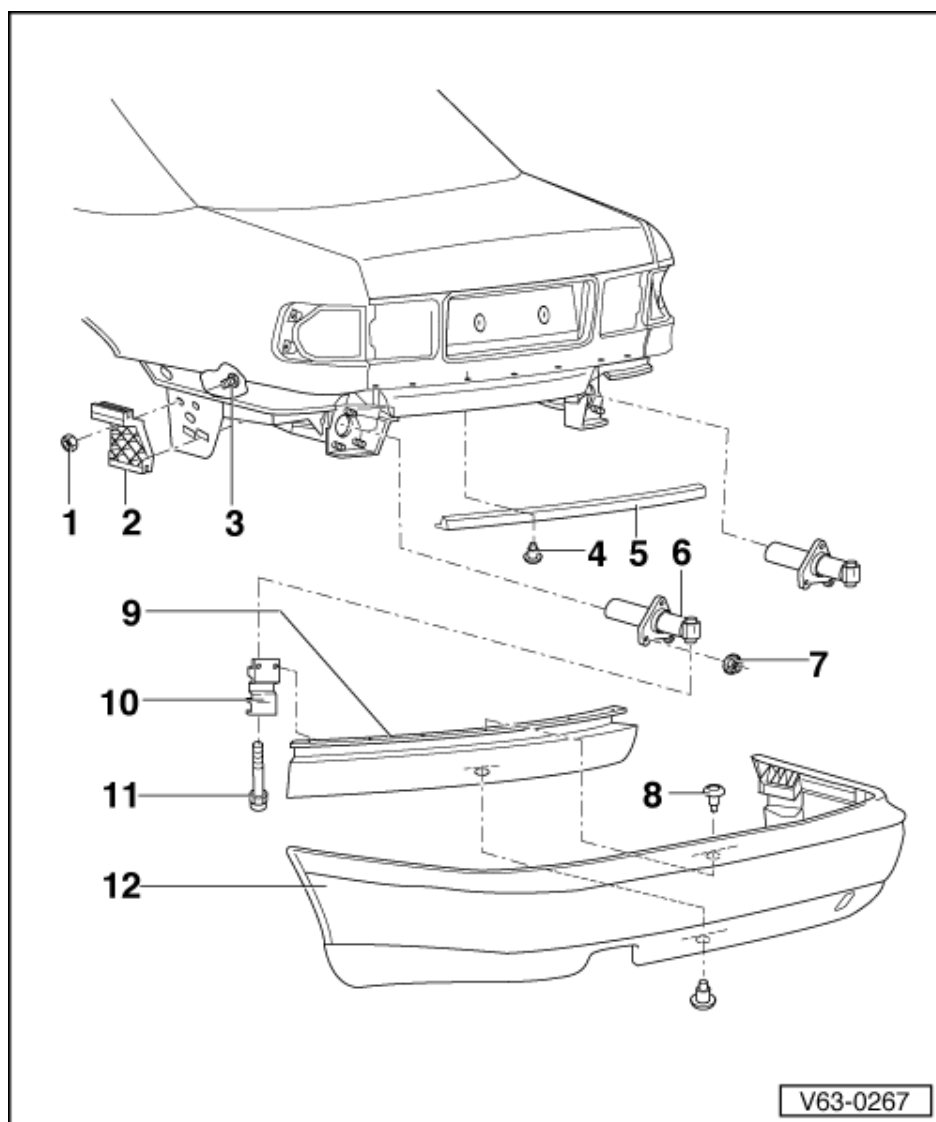


3.2 - Single-piece rear bumper- Exploded view

- 1 Nut
 - ♦ 2 off
- 2 Bracket
 - ♦ Adjusting => Page 148
- 3 Release and tighten bolt -12 Nm
 - ♦ 2 off
 - ♦ Unscrew on inside of boot
 - ♦ Remove grommet
 - ♦ Right bolt only accessible after removing battery:

=> Electrical System; Repair group 27; Battery; Removing and installing battery Battery Removing and installing battery

4 Release and tighten bolt -2.5 Nm



5 Cover

- ◆ For rear cross member
- ◆ Detaching bumper to remove and install =>Page 148

6 Impact absorber

- ◆ Removing:
 - Remove bumper: =>Page 148 .
 - Unscrew nuts/bolts -item 7 - and pull out impact absorber.
- ◆ Checking => Page 159

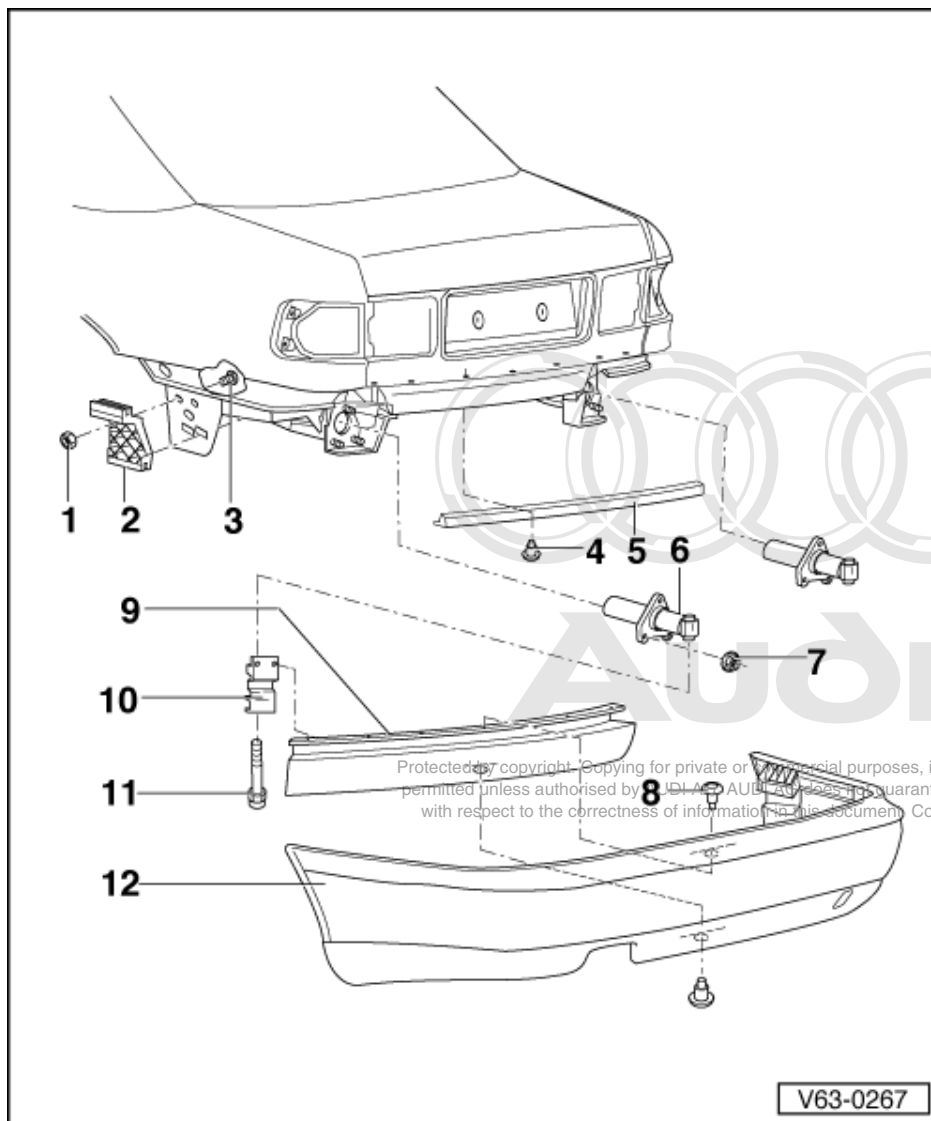
7 23 Nm

- ◆ 3 off
- ◆ Up to model year 1994: Nuts
- ◆ Model year 1995 onwards: Bolts

8 Expanding clip

- ◆ 18 off

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9 Bumper mount

- ◆ Removing:
 - Remove bumper: => Page 148 .
 - Unfasten expanding clips -item. 8 -.
- ◆ Adjusting => Page 148

10 Bracket

- ◆ To renew square nut in bracket, bend open/squeeze together aluminium retaining strip

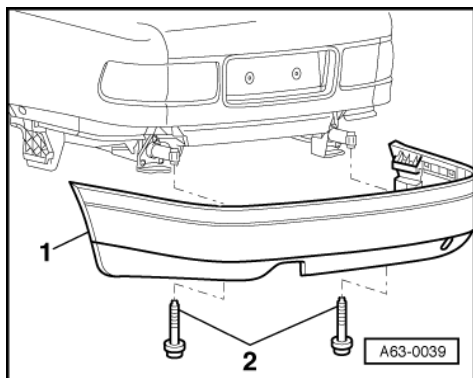
11 Cheese-head bolt - 65 Nm

- ◆ Right bolt only accessible after removing underbody cover panels
=>Page 215 .

12 Bumper cover

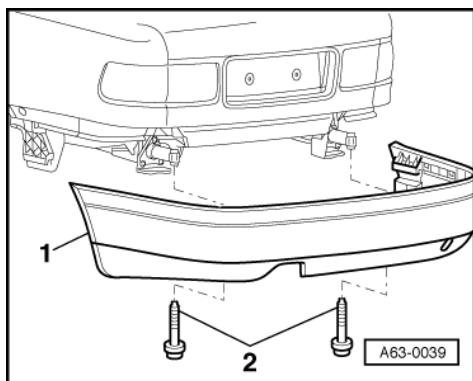
- ◆ Removing and installing
=>Page 149 .

3.3 - Removing and installing rear bumper



- Removing underbody cover panels
=>Page 215.
- On vehicles with parking aid, pull connectors off parking aid senders.
- -> Unscrew bolts -2-.
- Remove bumper -1- to rear.

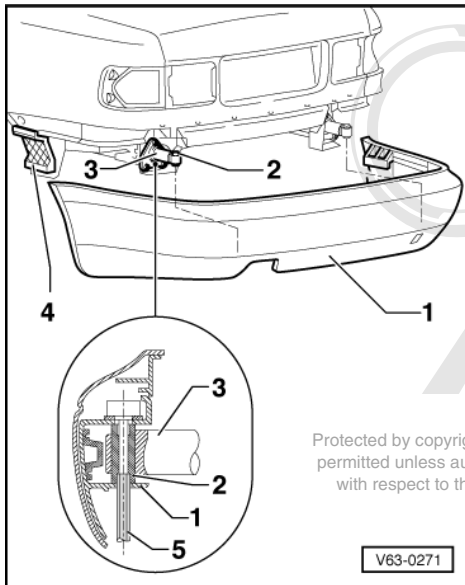
3.4 - Adjusting rear bumper



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Adjusting height at impact absorber

- Removing centre underbody cover panels
=>Page 215
- -> Unscrew bolts -2-.



- -> Insert Allen key -5- into threaded bushing -2-.
- Adjust threaded bushing -2- up or down in impact absorber -3-.

Adjusting height at bracket

- Removing battery:

=> Electrical System; Repair group 27; Battery; Removing and installing battery Battery Removing and installing battery

- Removing rear cross panel trim and boot side trim:

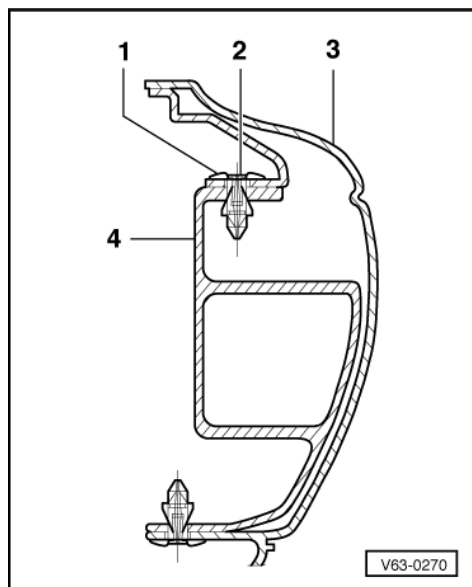
=> General Body Assembly, Interior; Repair group 70; Trim Panels; Removing and installing rear cross-panel trim Trim Panels Removing and installing rear cross-panel trim

=> General Body Assembly, Interior; Repair group 70; Trims; Removing boot trim Trims Removing boot trim

- Detach rubber cover and loosen bolts of bracket -4- several turns.
- Adjust height of bumper in relation to wing by moving bracket to front or rear.

3.5 - Removing and installing rear bumper cover

- Bumper removed.



- Removing parking aid senders on vehicles with parking aid:

=> Electrical System; Repair group 94; Exploded view of parking aid; Removing and installing parking aid senders Exploded view of parking aid Removing and installing parking aid senders

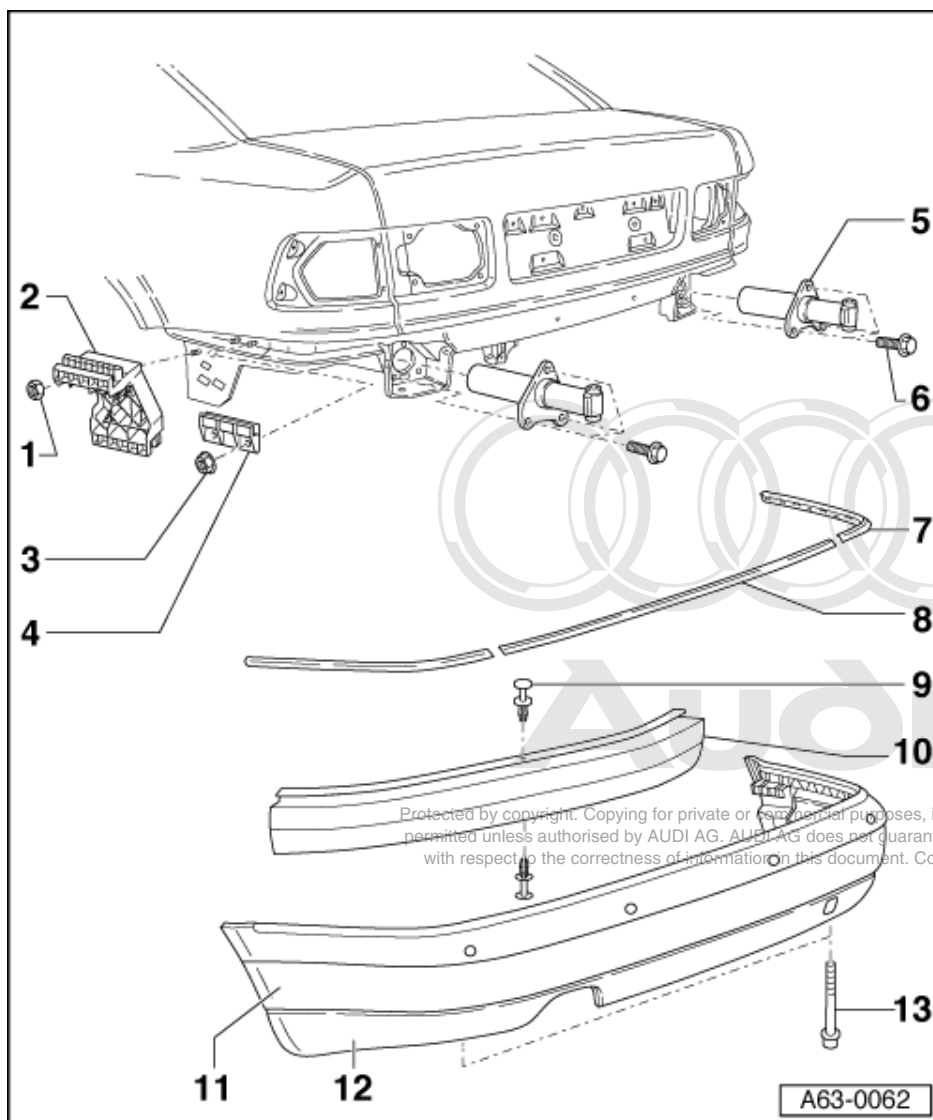
- -> Press out pins -2- of expanding clips -1- and pull out expanding clips.
- Lift bumper mount -4- out of bumper cover -3-.

Note:

Pins must be heard to engage in expanding clips when installing.

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3.6 - Two-piece rear bumper- Exploded view



1 Nut

- ♦ 2 off

2 Bracket

- ♦ Adjusting => Page 148

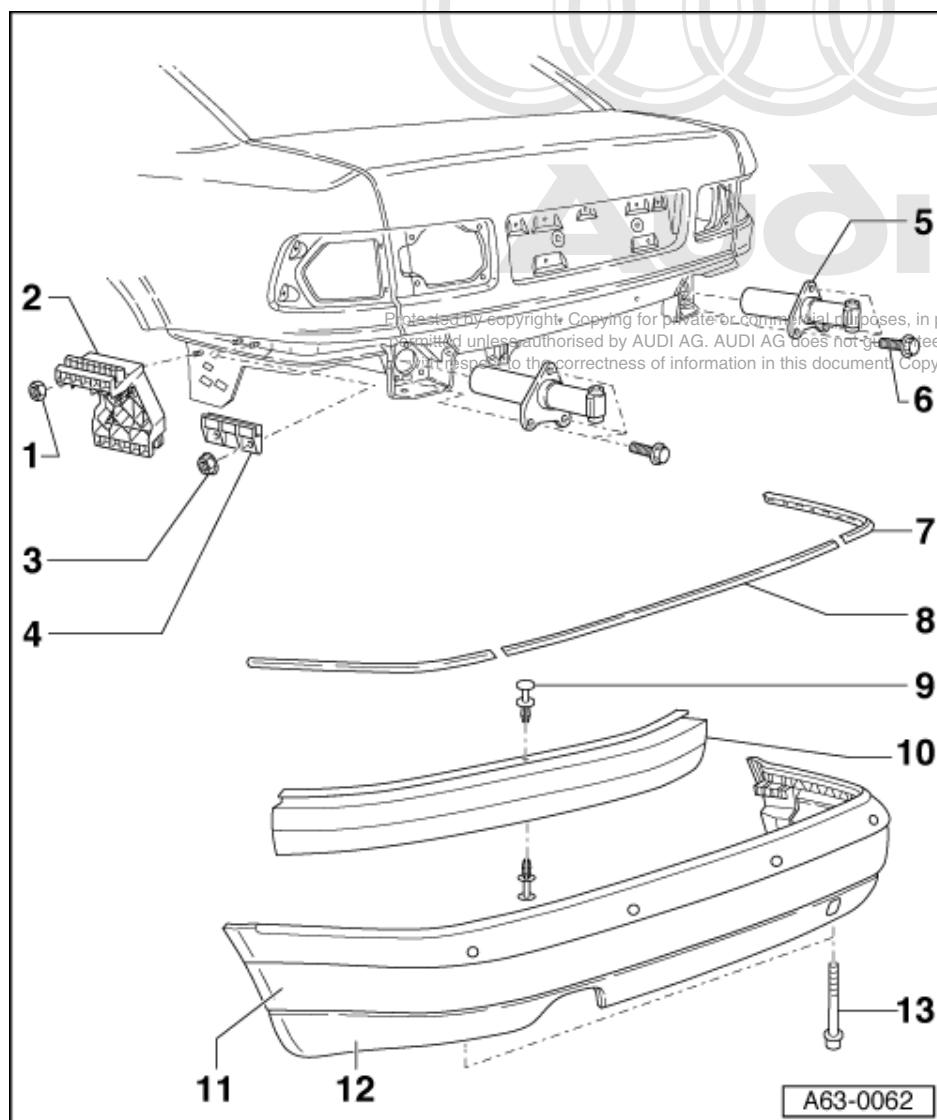
3 Bolt

- ♦ 12Nm
- ♦ 2 off
- ♦ Unscrew on inside of boot
- ♦ Remove grommet
- ♦ Right bolt only accessible after removing battery:

=> Electrical System; Repair group 27; Battery; Removing and installing battery Battery Removing and installing battery

4 Slide

- ♦ Removing => Fig. 1



5 Impact absorber

- ◆ Removing:
 - Bumper removed.
 - Remove the hexagon bolts -6- and pull the impact absorber from the longitudinal member.
- ◆ Checking => Page 159 .

6 Hexagon bolts

- ◆ 23 Nm

7 Right trim strip

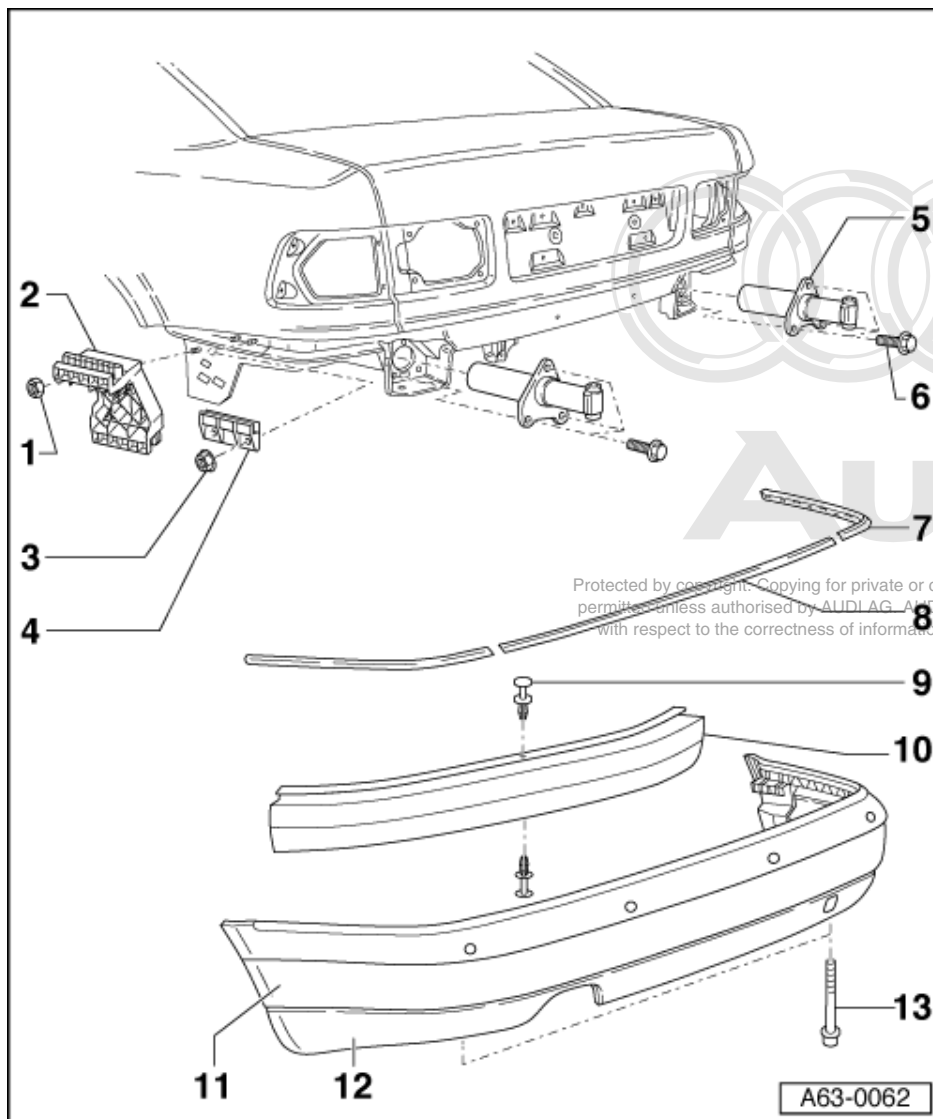
- ◆ Removal and installation are performed as for the front trim strips => Page 143 .

8 Centre trim strip

- ◆ Detach left and right trim strips before removal.

9 Clip

- ◆ Unclip in order to remove bumper mount => Page 143 .



10 Bumper mount

- ◆ Removing:
 - Bumper removed.
 - Remove expanding clips
- ◆ Adjusting => Page 148

11 Bumper cover

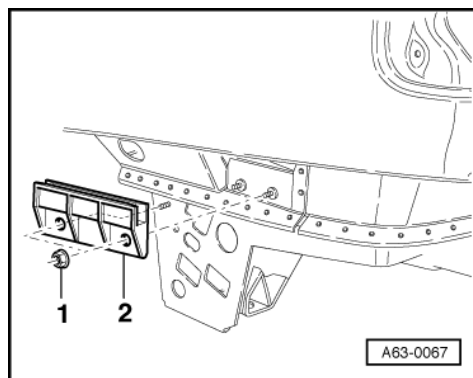
- ◆ Can be replaced separately.

12 Rear spoiler

- ◆ Can be replaced separately.
- ◆ Removing and installing => Page 155

13 Cheese-head bolt

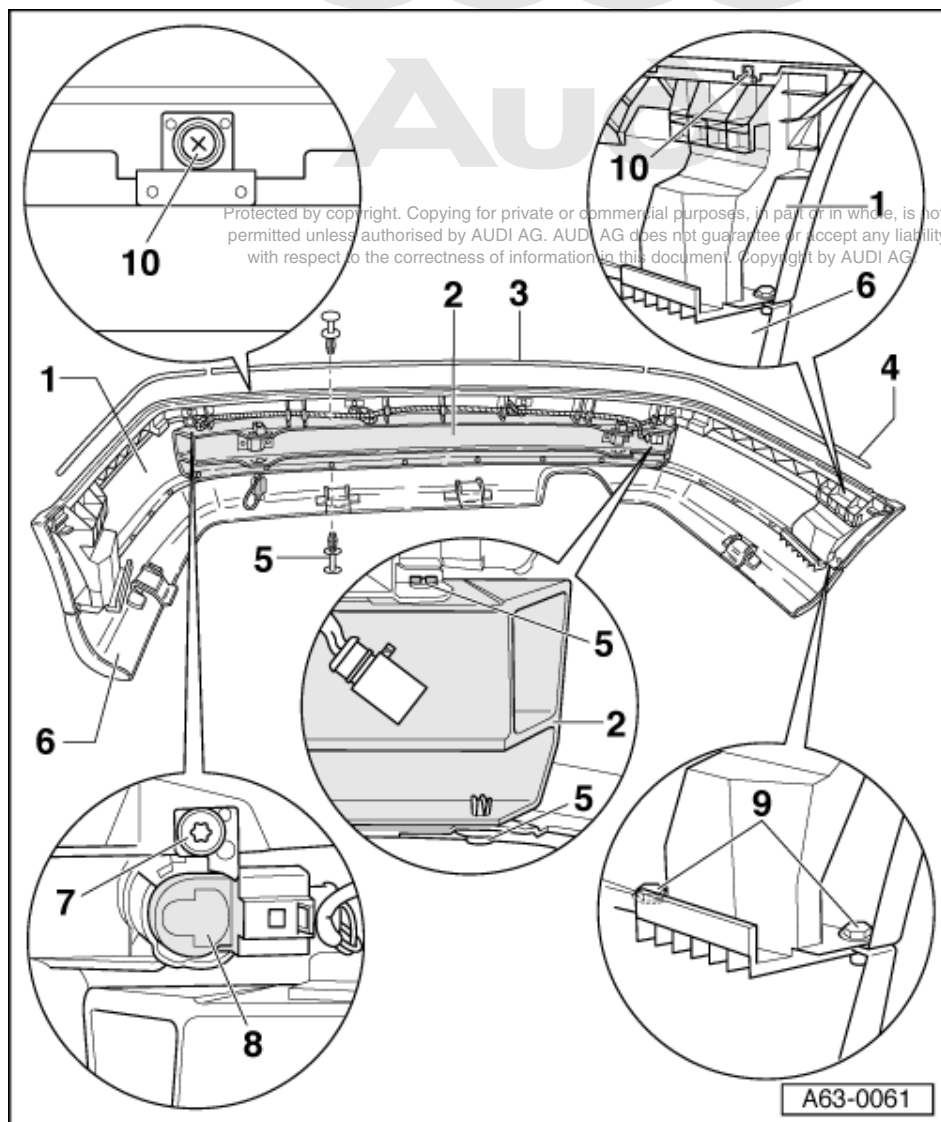
- ◆ 65 Nm



-> Fig. 1 Removing slide

- Bumper removed
- Unscrew the hexagon nuts -1- and remove the slide.
- Tighten hexagon nuts to 2 Nm when installing.

3.7 - Rear trim strip and spoiler Assembly overview

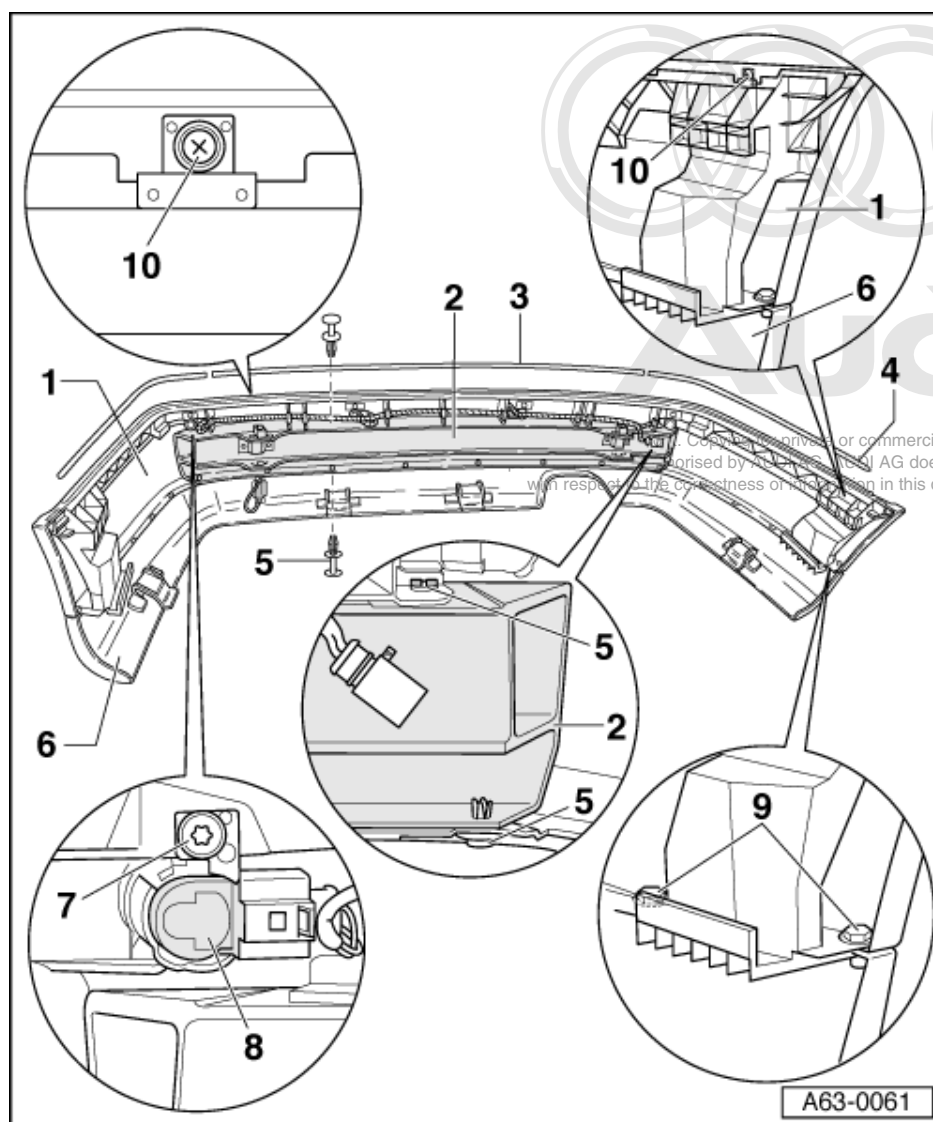


1 Bumper cover

- ◆ Can be replaced separately.
- Bumper removed.
- Remove the clips -5- from the upper side => Fig. 1
- Unscrew hexagon bolts -9-.
- Release the catches from the bumper cover and remove the cover.

2 Bumper mount

- ◆ Removing:
- Bumper removed.
- Detach expanding clip -5- and remove the bumper mount from the cover and the spoiler.



3 Centre trim strip

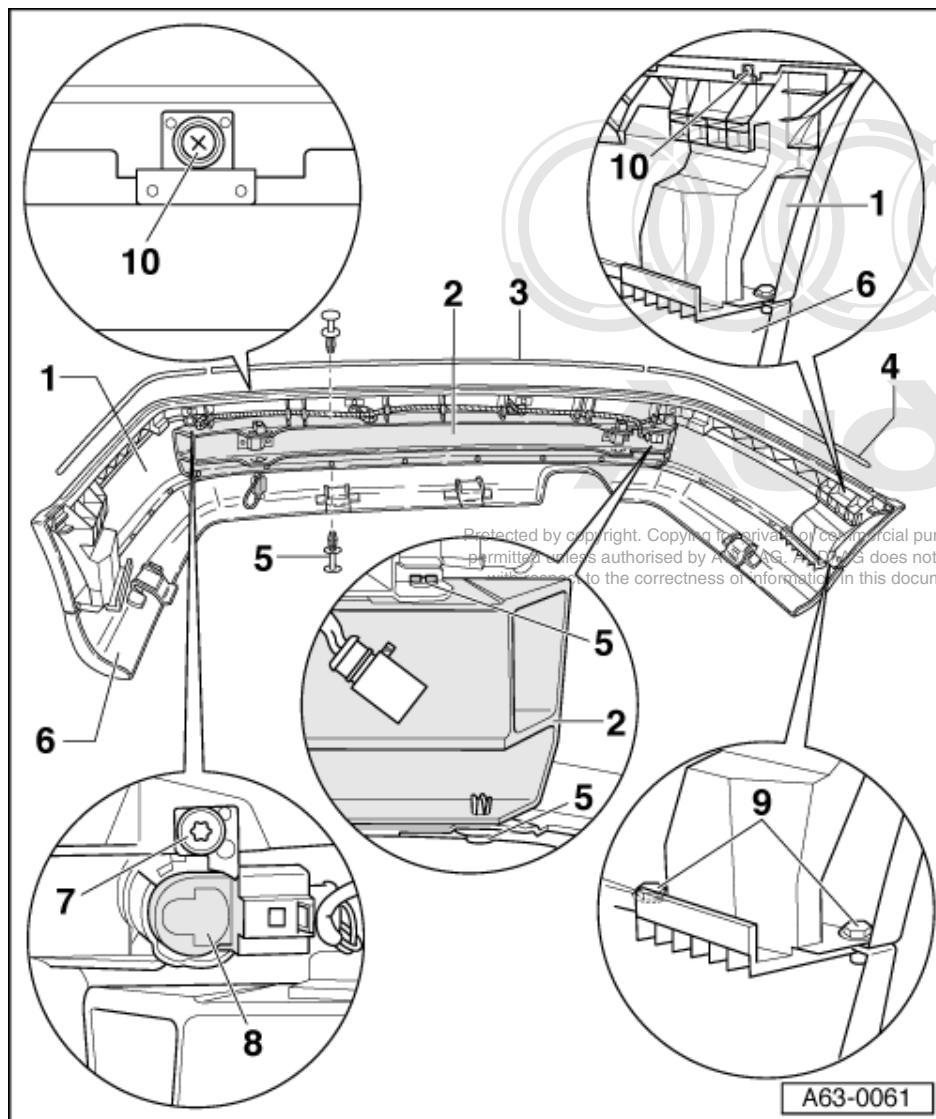
- ◆ Remove left and right trim strips first, in order to prevent scratches.
- Remove the cross-head screws -10- at both ends of the trim strip.
- Press the catches of the fastener together using pliers and push out of the bumper cover together with the trim strip.

4 Left trim strip

- ◆ Removal and installation are performed as for the front trim strips.

5 Expanding clip

- ◆ 18 off
- ◆ Unclipping => Fig. 1



6 Rear spoiler

- ◆ Can be replaced separately.
- Bumper removed.
- Unscrew hexagon bolts -9-.
- Remove the clips -5- from the bottom => Fig. 1
- Release the catches from the cover and detach the spoiler.

7 Torx bolt

- ◆ 1 Nm

8 Ultrasonic sensor

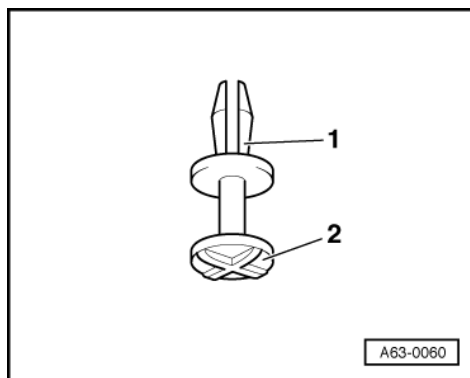
- ◆ Bumper removed
- Unplug connectors and remove bolt -7-.
- Push the catches apart slightly and remove the sensor.

9 Hexagon bolt

- ◆ 21 Nm

10 Cross-head screw

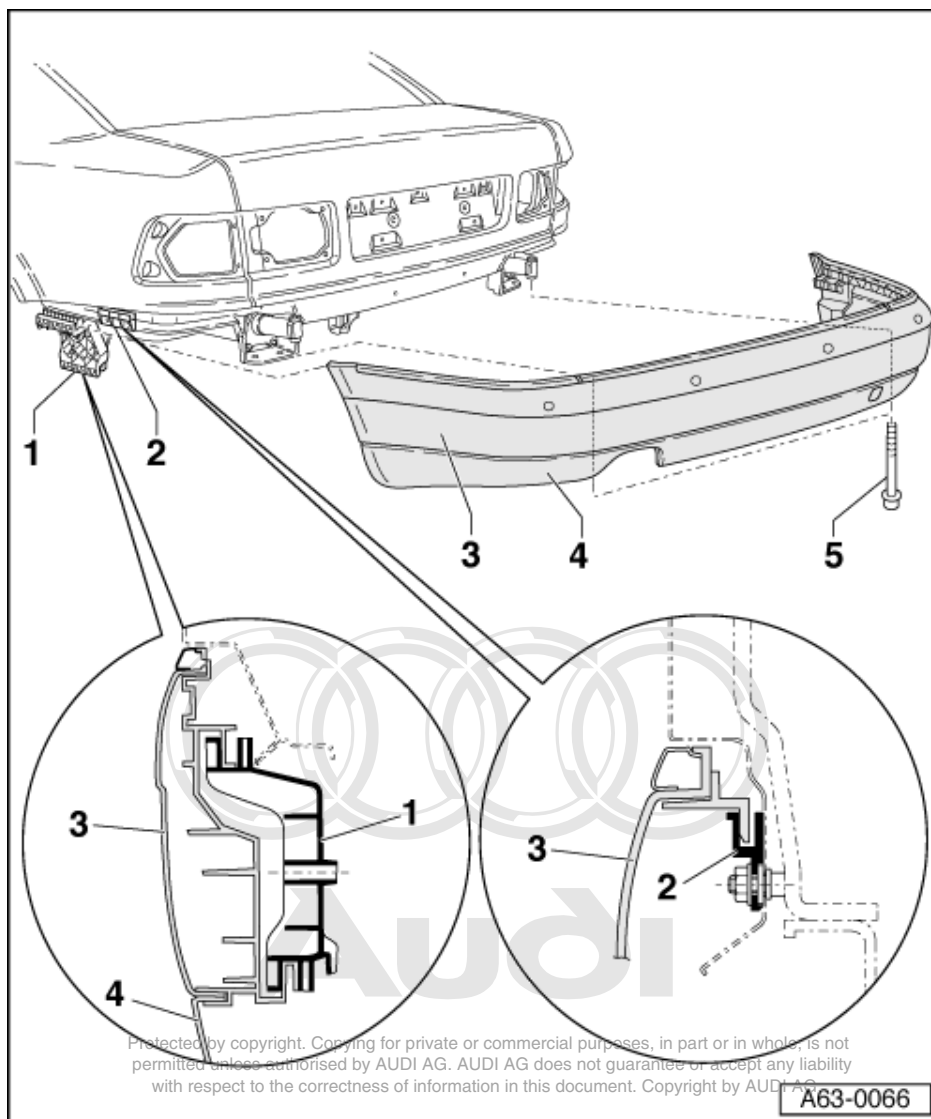
- ◆ 1 Nm



→ Fig.1 Clip for bumper cover

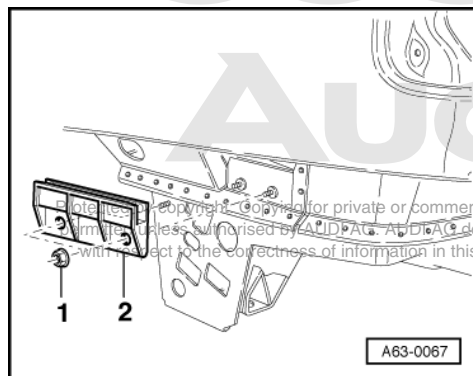
- To remove, pull out the locking pin -2- as shown.
- Pull out the clip -1- from the bumper cover.
- To install, press the clip in the bumper and secure by pushing in the locking pin.

3.8 - Installing rear bumper



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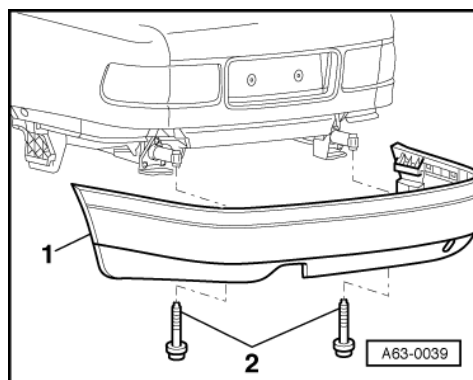
- 1 Bracket**
- 2 Slide**
 - ♦ Removing and installing => Fig. 1
- 3 Bumper cover**
 - ♦ Push the bumper cover into the slider -2- and into the bracket -1- as shown in the illustration details.
 - ♦ The bumper cover must be inserted into the slider -2- and into the bracket -1-.
 - ♦ Tighten the cheese-head bolt -5- to 65 Nm.
- 4 Rear spoiler**
 - ♦ Can be replaced separately.
- 5 Cheese-head bolt**
 - ♦ 65 Nm



-> Fig.1 Removing and installing slider

- Remove hexagon bolts -1- and detach slider.
- When installing, tighten hexagon nuts to 10 Nm.

3.9 - Adjusting rear bumper



Adjusting height at impact absorber

- Centre underbody cover panels removed.
- -> Unscrew bolts -2-.

4 - Checking impact absorber

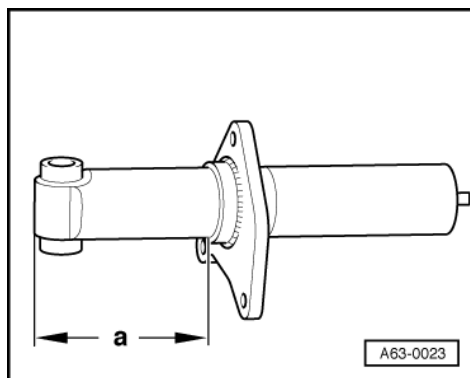
4.1 - Checking impact absorber

Note:

Impact absorbers always have to be checked if there are doubts about their re-useability.

Test step I

- Carry out visual inspection:



- -> Impact absorber not broken or bent
- No escape of gel
- Length of impact absorber: Dimension a = 126 ± 1 mm
- Visible traces of retraction less than 30 mm:
- Re-use impact absorber.
- Visible traces of retraction more than 30 mm:
- Carry out functional test => Test step II, Page 160

Notes:

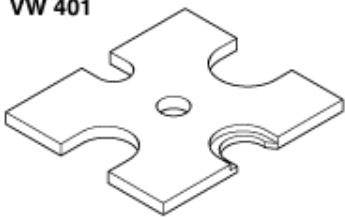
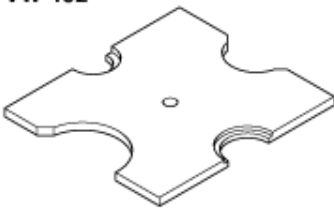
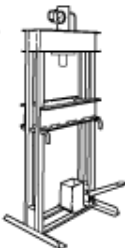
- ♦ A broken threaded sleeve can be renewed separately.
- ♦ External traces of an oil-like substance are from the preservative applied by the manufacturer.



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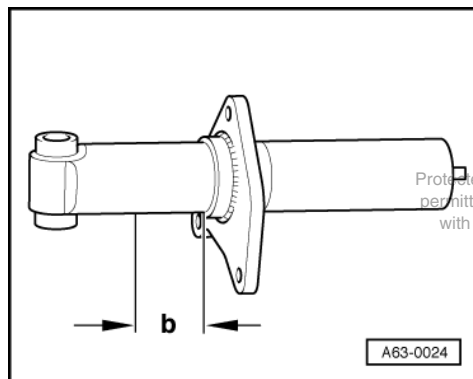
Audi Edition 05.1998

VW 401 	VW 402 
V.A.G 1290 A 	
	G63-0001

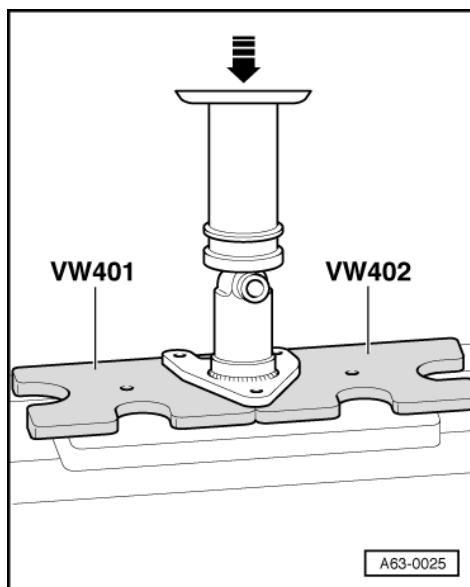
Test step II

Special tools, testers and auxiliary items required

- ♦ Special tool VW 401
- ♦ Special tool VW 402
- ♦ V.A.G 1290 A



- -> Make mark above collar at impact absorber.
- Dimension b = 45 mm



- -> Clamp impact absorber in press V.A.G 1290A and compress impact absorber as far as mark.

Note:

There are no specifications regarding pressing-in rate and force.

- Slacken off the press.
- Re-use impact absorber if it attains its original length after max. 10 minutes.
- Renew impact absorber if it does not attain its original length within 10 minutes.

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64 - Glazing

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

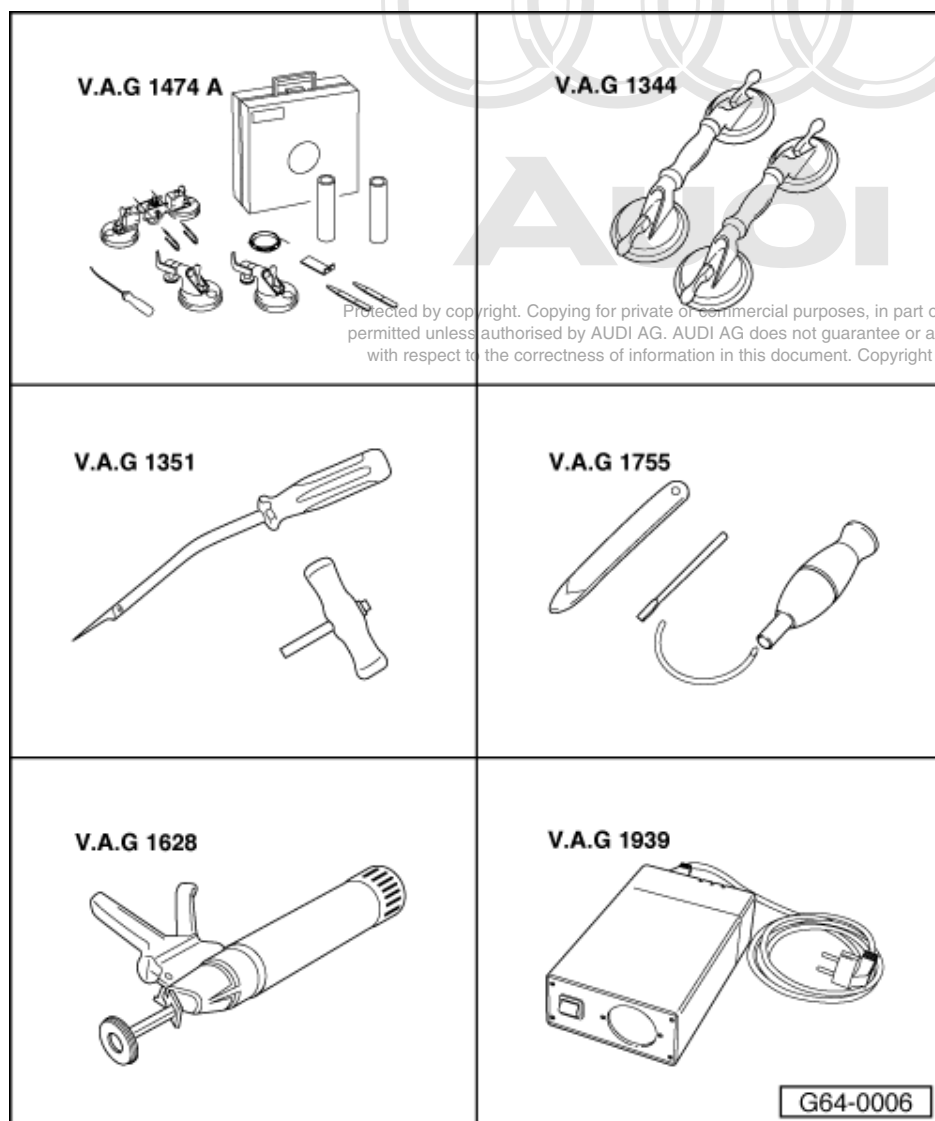
Important

- ◆ **Use only genuine Audi A8 Parts.**
- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**

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2 - Flush-bonded windows

2.1 - Flush-bonded windows

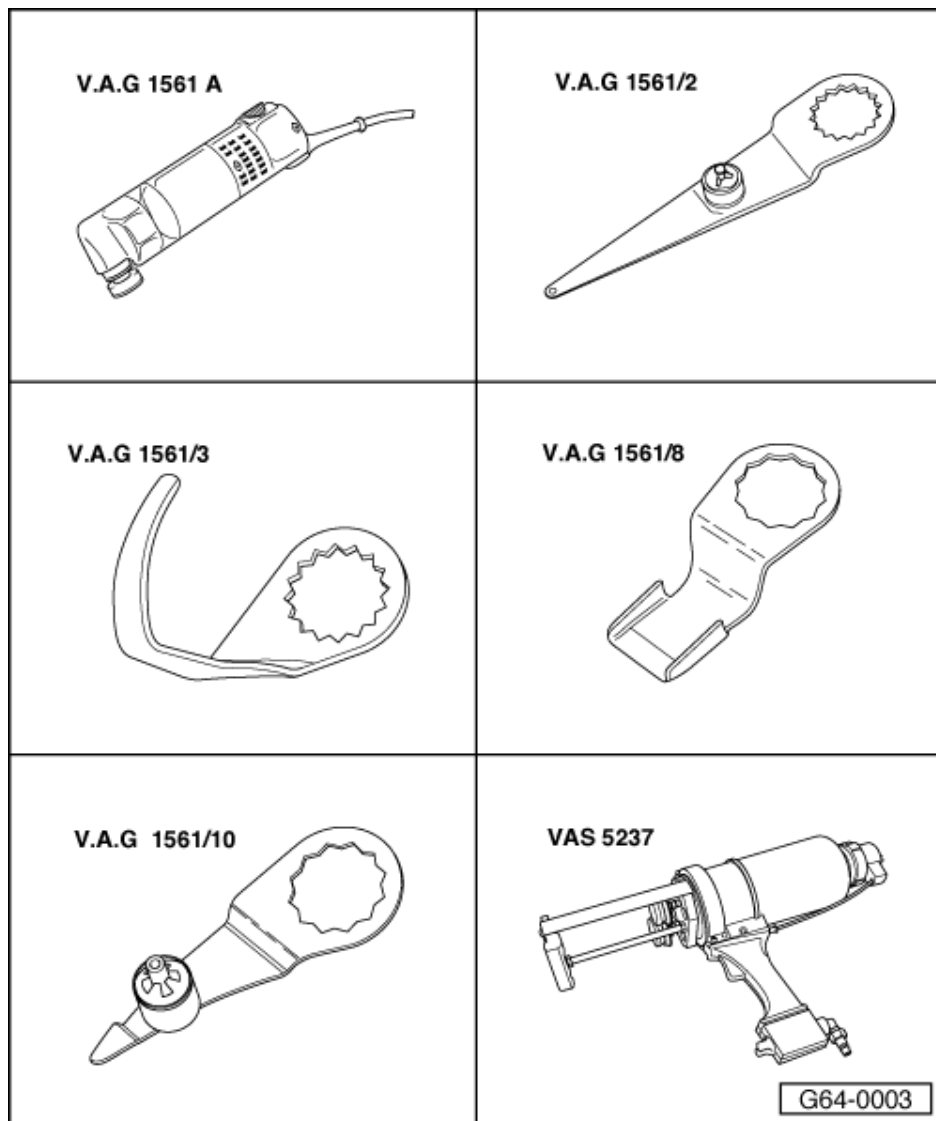


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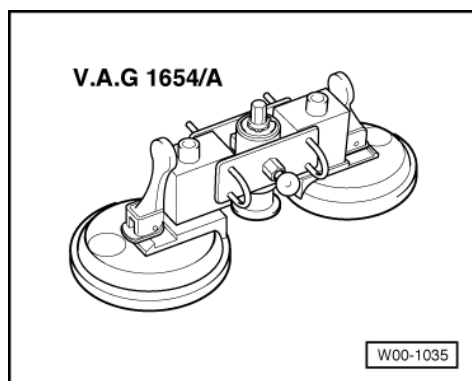
2.2 - Removing and installing flush-bonded windows - general

Special tools and workshop equipment required

- ◆ V.A.G 1474 A Cutting device for flush bonded windows
- ◆ V.A.G 1344 Suction lifter
- ◆ V.A.G 1351 Cutting tool
- ◆ V.A.G 1755 Window removal kit
- ◆ V.A.G 1628 Hand cartridge gun
- ◆ V.A.G 1939 Cartridge heater



- ♦ V.A.G 1561 A Electric cutter
- ♦ V.A.G 1561/2 Cutting blade
- ♦ V.A.G 1561/3 Cutting blade
- ♦ V.A.G 1561/8 Scraper
- ♦ V.A.G 1561/10 Cutting blade
- ♦ VAS 5237 Double cartridge compressed air pistol



- ♦ -> Reel V.A.G 1654 A



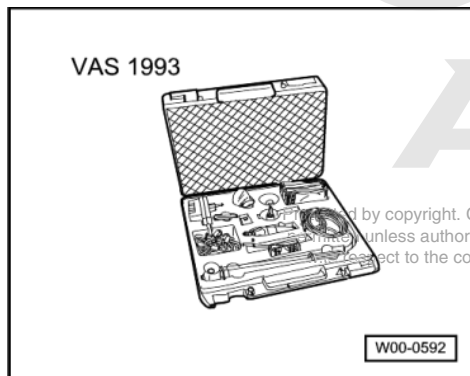
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Notes:

- ◆ Protective film V.A.G 1474/7 must be used to protect the dash panel when removing the windscreen.
- ◆ When removing with an electric cutter, mask window opening with fabric-reinforced adhesive tape.
- ◆ Deburr tube at front to avoid damaging paintwork.

Important
Follow the manufacturer's safety and usage instructions when handling materials.

2.3 - Repair work using special tool VAS 1993



Repair work using VAS 1993

Notes:

- ◆ -> Windscreens damaged by stone impact can be repaired using the windscreen repair set VAS 1993.
- ◆ The damaged areas must not exceed a certain size, and must not be within the main field of view.
- ◆ Further details can be found in the usage instructions provided with each set.

2.4 - Materials

- 2 component window adhesive DA 004 600 A2 1), 2)	
- 1 component window adhesive DH 009 100 03 3), 4)	
- Glass primer/paint primer	D 009 200 02
- Cleaning solution	D 009 401 04
- Primer applicator	D 009 500 25
- Adhesive remover	D 002 000 10
- Cutting cord	357 853 999
- Cutting wire	357 845 955

- 1) Observe minimum setting time =>Page 166
- 2) Double cartridge pistol VAS 5237 must be used for applying this material.
- 3) Heat according to manufacturer's instructions with cartridge heater V.A.G 1939
- 4) Miniature 110 ml cartridge for sealing and/or for when the 400 ml cartridge is insufficient



2.5 - Minimum setting times.

Important For safety reasons, when installing windscreen and rear windows, use only non-conductive 2-component adhesive with the designations listed below. The vehicle is only safe to operate after the minimum setting times have elapsed, and must not be operated until then.

Type of window	Vehicle	Adhesive sealant	Curing time in hours
Windscreen	with/without airbag	DA 004 600 A2	3
Rear window		DA 004 600 A2	3
Side windows		DH 009 100 03	3

Cleaning off adhesive sealant

Adhesive remover D 002 000 10 is the recommended cleaning agent. Always follow the safety instructions.

Important

When cleaning from inside the vehicle passenger compartment, the window just fitted must not be pressed outwards.

Paint surfaces:

- Clean painted surface with a dry cloth. Remove residual dirt with adhesive remover D 002 000 10.

Plastic trim:

- Allow adhesive sealant to set (approx. 1 hour) and then detach.

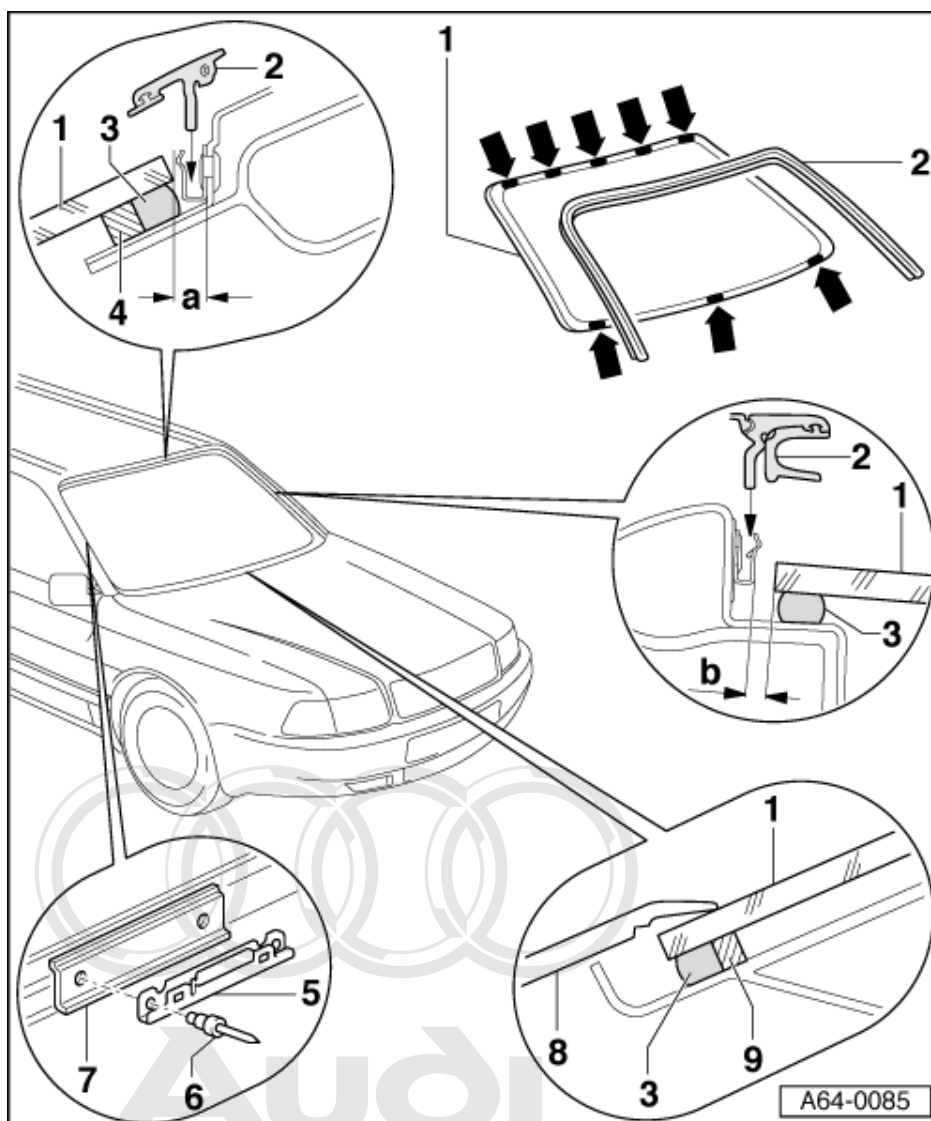
2.6 - Touching up windows with sealant

- Allow leaky area to dry and clean the area.
- Apply and spread adhesive sealant on leaky area between window pane and panel flange.
- Allow adhesive sealant to flash off.
- Apply water to check for leaks.
- Carry out a visual inspection from inside the vehicle.

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3 - Removing and installing windscreen: Exploded view

3.1 - Removing and installing windscreen: Exploded view



1 Windscreen

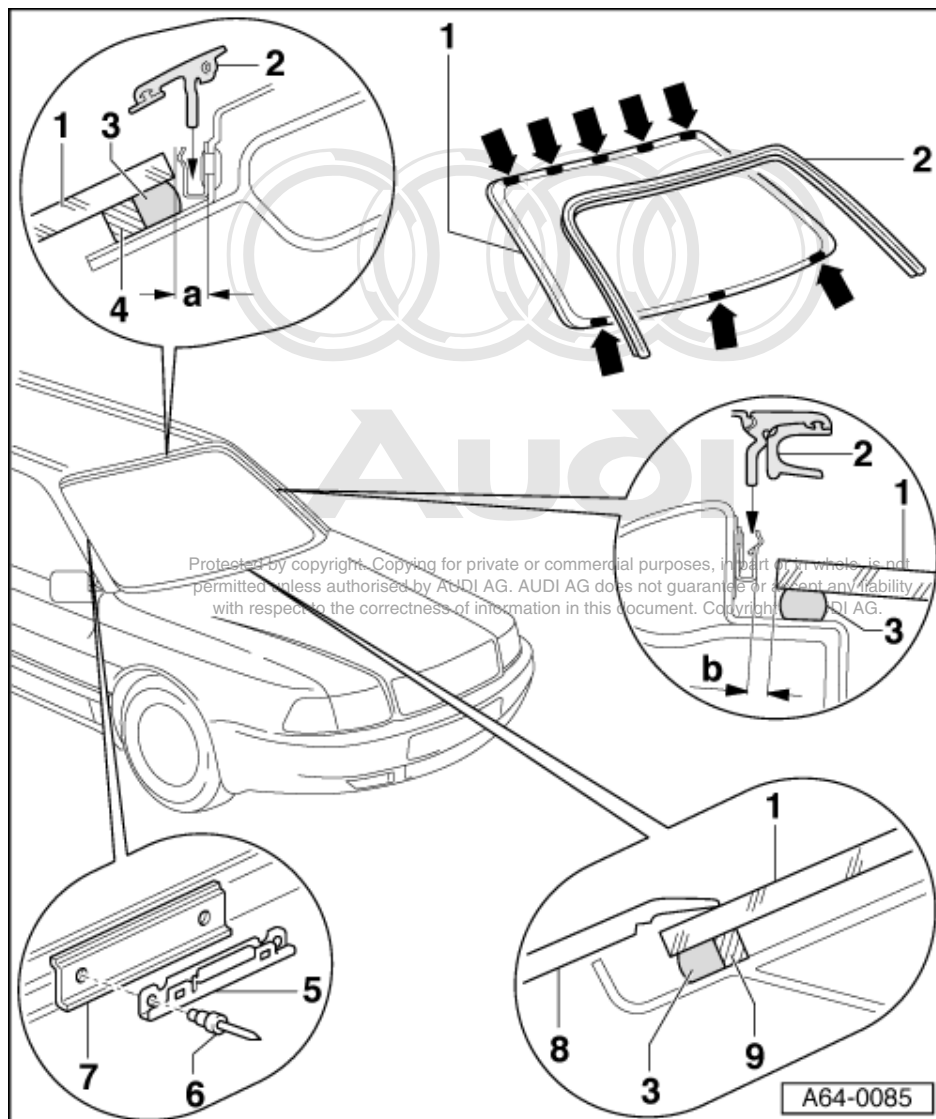
- ◆ Removing => Page 170
- ◆ Installing => Page 173
- ◆ Distance between windscreen and roof frame -a- = 7 mm

Note:

Stickers (e.g. for airbag) attached to windscreen must be affixed in same position on new windscreen.

2 Trim strip

- ◆ Pull upwards out of fasteners -item 5 -
- ◆ When installing, make sure trim strip engages in fasteners
- ◆ When installing a new trim strip in model year 1994 vehicles, check that these are also engaged in the outer fasteners.
- ◆ If the trim strip does not engage, the fasteners must be repositioned inwards => Fig. 2 .



3 Adhesive bead

- ♦ Bead cross-section and distance from edge of window =>Page 174 .

4 Upper spacer

- ♦ 5 off
- ♦ Starting from corners of windscreen, bond on five spacers -arrows- at equal distances

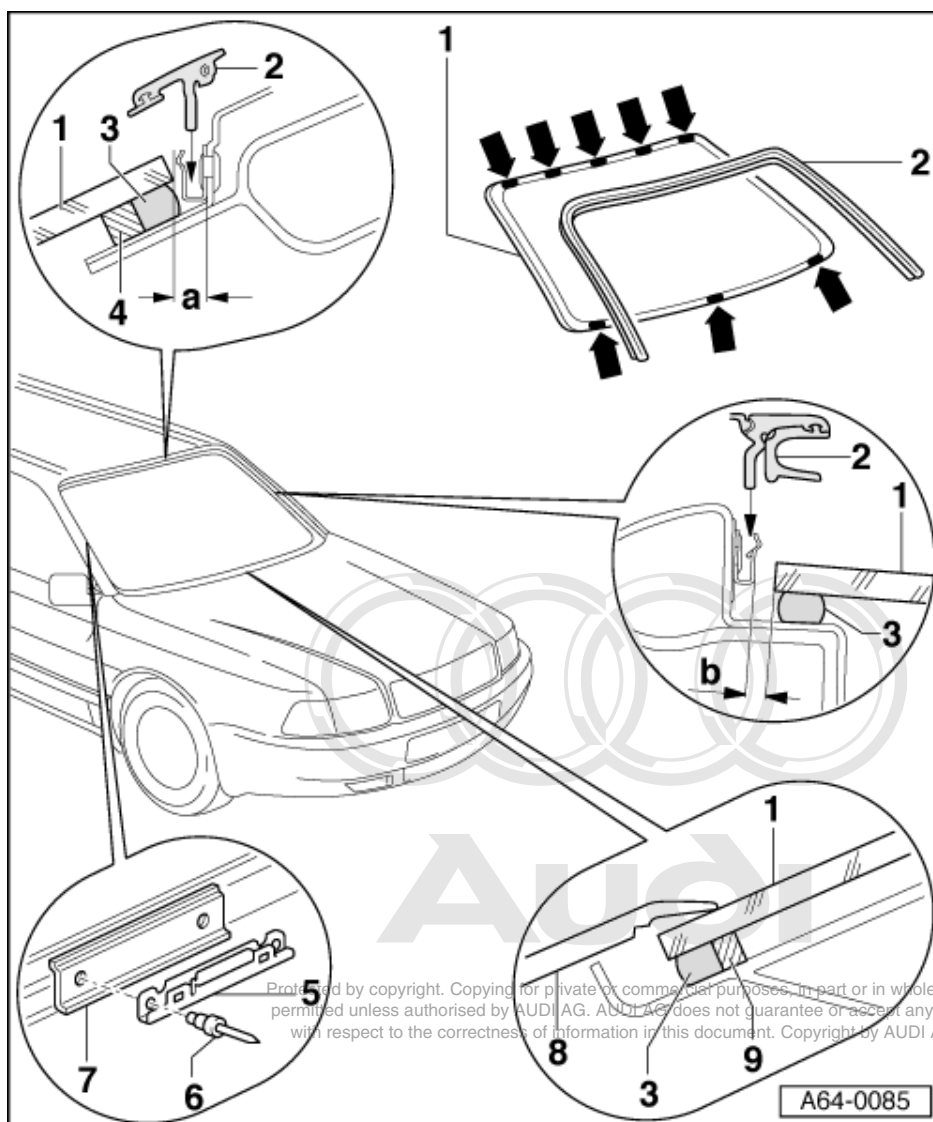
5 Bracket

- ♦ 10 off
- ♦ Trim strip -item 2 - must engage fully in fasteners when installing.
- ♦ For model year 1994 vehicles, the outer, upper retainers must be repositioned inwards where necessary =>Fig. 2 .

6 Blind rivet

- ♦ Drill off head and knock out shank
- ♦ Always use genuine rivets to avoid contact corrosion:

=> Parts List



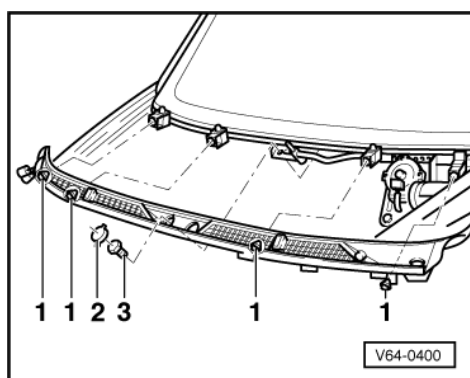
7 Shim plate

8 Scuttle trim

- ◆ Remove to remove windscreen
- ◆ Removing and installing =>Fig. 1

9 Bottom spacer

- ◆ 3 off
- ◆ Bond on in line with marks made at edge of windscreen -arrows-

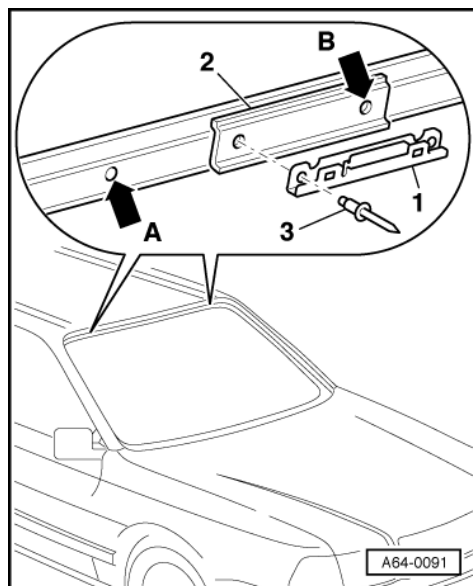


-> Fig.1 Removing and installing cowl panel trim

- Removing wiper arms.

=> Electrical System; Repair group 92; Servicing windscreen wiper system; Removing and installing windscreen wiper system Servicing windscreen wiper system Removing and installing windscreen wiper system

- Lever off trim cap -2- and unscrew bolt -3-.
- Give clips -1- at scuttle trim approx. 1/2 turn (180°) and detach trim.



-> Fig.2 Repositioning retainers

- Drill off the rivet heads at the two outer fasteners and drive out the rivet stems.
- Rivet the outer hole of the fastener -1- and the support -2- with the inner bore hole at the window flange.
- Drill the second hole, arrow -B- using a 3.2 mm bit ø in the body and rivet the fastener in place.
- The remaining bore hole, arrow -A- must be sealed using DA 009 100.

3.2 - Removing

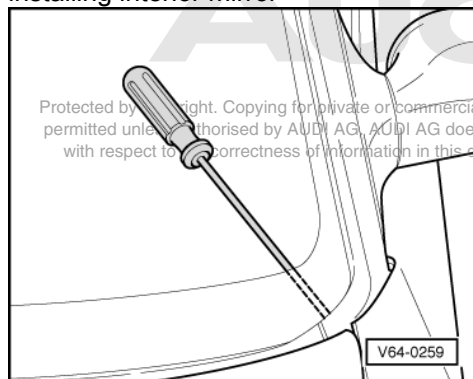
Tools and materials required => Page **163**.

Important

When removing a window, always wear protective goggles and leather gloves.

- Lever windscreen trim strip at the bottom out of fasteners, starting from A-pillar, and detach.
- Removing cowl panel trim => Fig. **170**.
- Removing interior mirror :

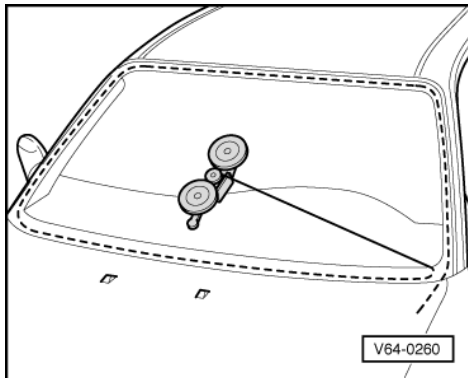
=> General Body Assembly, Interior; Repair group 68; Removing and installing interior mirror Removing and installing interior mirror



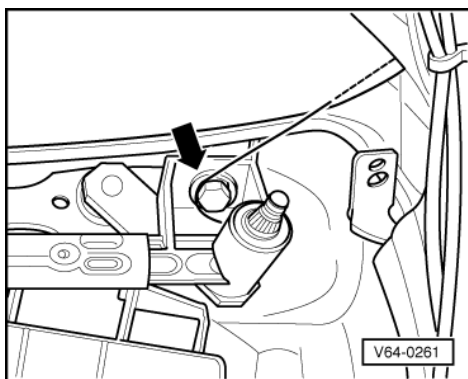
- Removing A-pillar trim :

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing upper A-pillar trim
Trim panels Removing and installing upper A-pillar trim

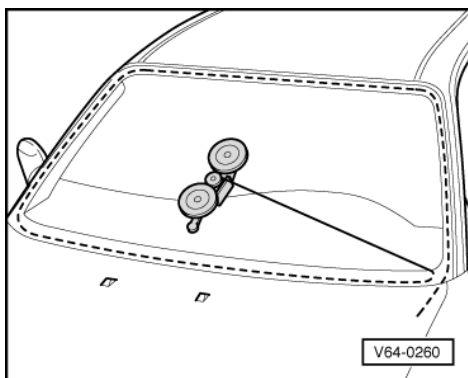
- -> Pierce adhesive bead from inside at bottom left corner of windscreen using an awl.
- Run cutting cord through end of awl and pull through into inside of vehicle.



- -> Route cutting cord along entire underside of windscreen.



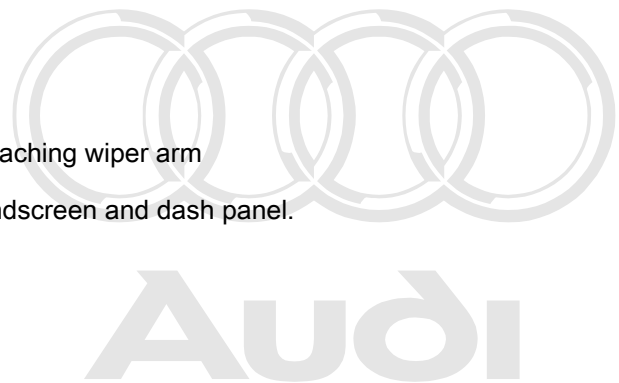
- -> Attach end of cutting cord to bolt -arrow- for attaching wiper arm
- Insert protective sheet V.A.G 1474/8 between windscreen and dash panel.



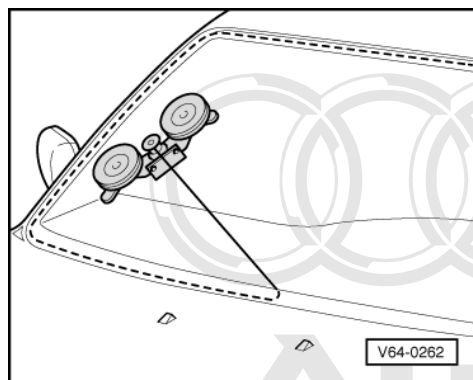
- Unscrewing left and right sun visor:

=> General Body Assembly, Interior; Repair group 70; Roof trim; Removing and installing sun visor Roof trim
Removing and installing sun visor

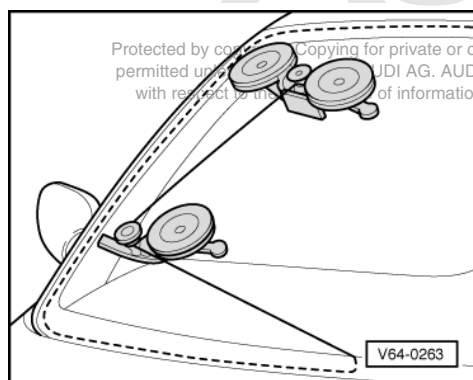
- Insert protective foil V.A.G 1474/9 between moulded headliner and windscreen.
- -> Fasten end of cutting cord in reel and cut out initial section roughly as far as centre of windscreen.



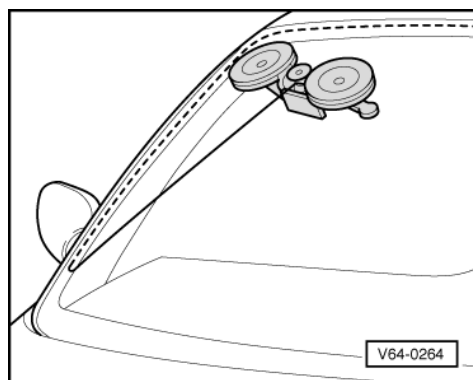
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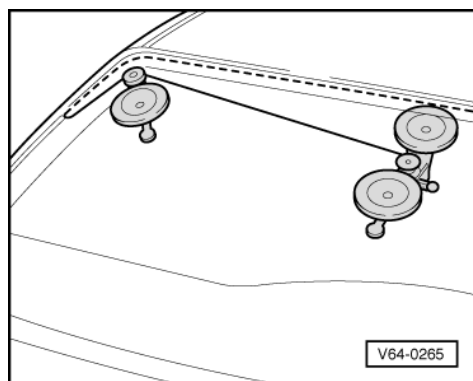
- -> Shift take-up reel as shown in illustration and continue cutting.



- -> Move reel to position shown and attach jockey pulley.
- Route cord as shown.
- Cut out glass up to the point where the cord no longer runs in the guide roller.



- -> Remove guide pulley and continue cutting out window.



- -> Move reel to position shown and attach jockey pulley in top corner of window.
- Route cord as shown.
- Cut out glass up to the point where the cord no longer runs in the guide roller.
- Remove guide roller and continue cutting out window.
- Repeat steps in upper left and lower left radii of window.
- Cut window out completely.
- Use double suction holders to remove windscreen.

3.3 - Installing

Preparation for windscreen installation

Notes:

- ◆ If an intact windscreen is to be re-used, trim residual adhesive sealant on windscreen and flange with a carpet knife; adhesive sealant must never be removed completely.
- ◆ Remaining material serves as a bonding surface for the new adhesive sealant when it is applied.
- ◆ Keep bonding surfaces clean and free from grease.
- ◆ If the cutting procedure has damaged the windscreen flange, touch up.

=> Vehicle paintwork

- ◆ Take anti-corrosion measures if necessary

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=> Binder: "Surface treatment/chemical materials"

- ◆ Do not treat areas having residual adhesive with cleaning solution and primer.

Reworked/renewed windscreen flange:

- Apply one pack primer/filler LGF 008 001 A2 to the bright metal.
- After applying primer, apply top coat with hardener to the prepared area.

Note:

The top coat must be allowed to harden before applying primer.

- After painting, clean touched-up area again and prime appropriately with glass/paint primer D 009 200 02.

Important

Glass/paint primer D 009 200 02 is electrically conductive and must never be applied to bright aluminium, as this would lead to contact corrosion.

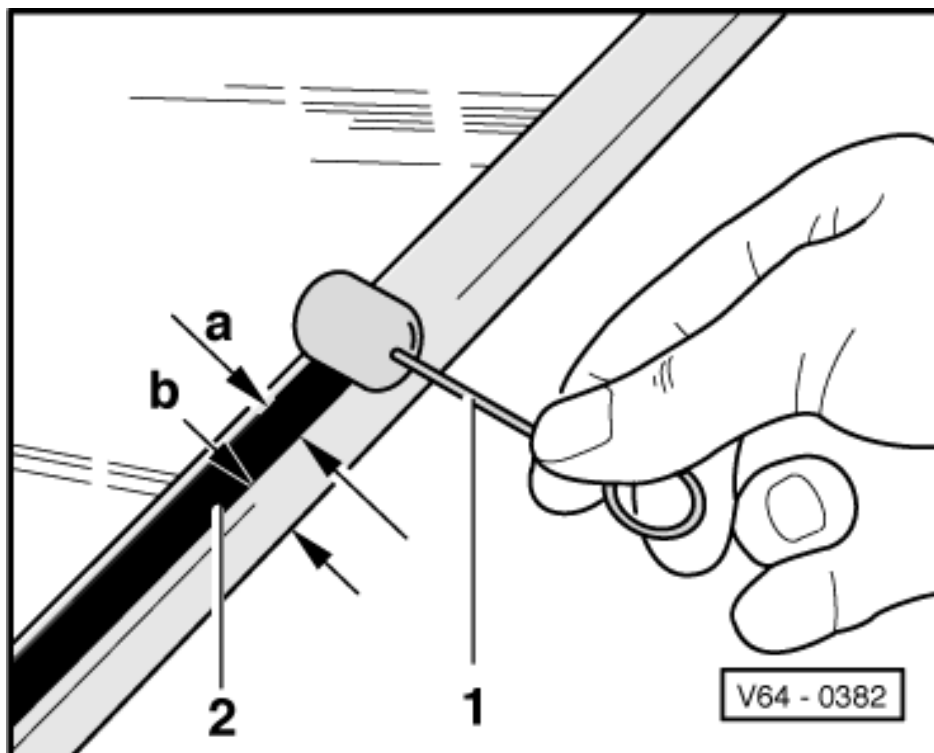
All models:

- Clean bonding area all round new windscreen with cleaning fluid.

Applying primer

Note:

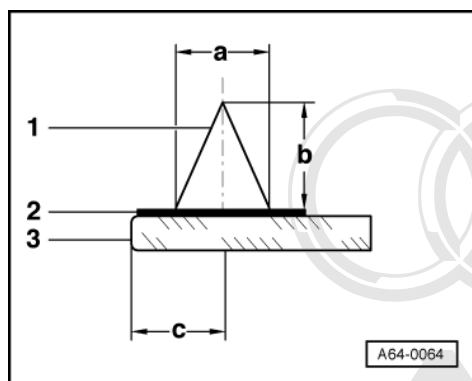
Ceramic layer on windscreens is not a primer. All new windscreens must be primed before applying adhesive sealant.



- -> Apply primer -2- evenly all round in one operation, using applicator -1-.
- Start application with fully soaked felt. Flashing-off time approx. 10 minutes.
- Primer width: Dimension a = 20 mm
- Primer must be centred with respect to adhesive bead =>Page 174 .

Note:

Allow primer to dry before touching-up primer strip.

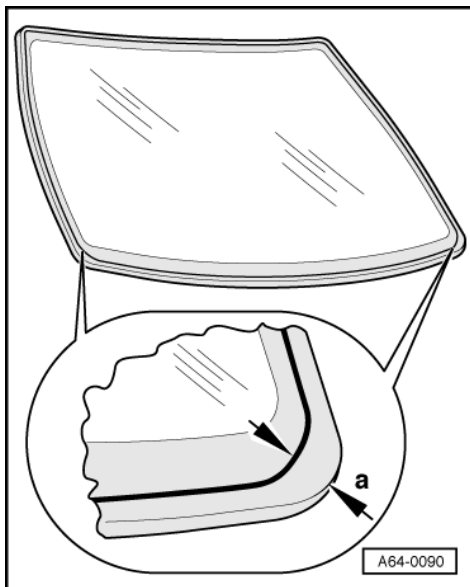


-> Application of primer and adhesive bead to straight windscreen edges

- 1 - Adhesive bead
- 2 - Primer
- 3 - Plate

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- ♦ Dimension a = 8 mm
- ♦ Dimension b = 12 mm
- ♦ Dimension c = 6 mm



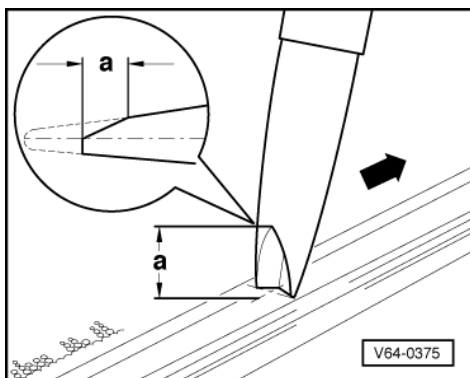
-> Application of primer and adhesive bead to corners of windscreen

- Transfer contour of adhesive bead at bottom corners of windscreen from windscreen that has been removed to the new windscreen.
- Distance between adhesive bead (centre) and bottom corners of windscreen $a = 20 \text{ mm}$

Note:

Apply adhesive bead evenly at a distance of 6 mm from side/bottom edge of window.

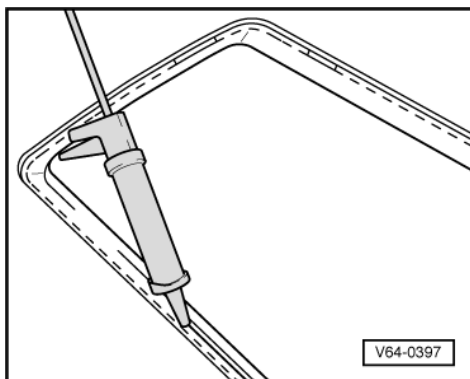
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- -> If no shaped nozzle is available, cut nozzle to size as shown in illustration.
- Dimension $a = 12 \text{ mm}$

Notes:

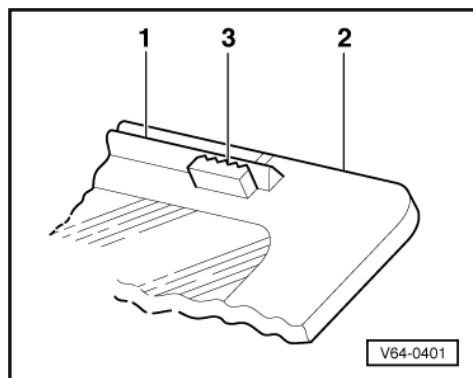
- ◆ The cross-section of the bead is determined by the opening in the tip of the nozzle and the rate of application.



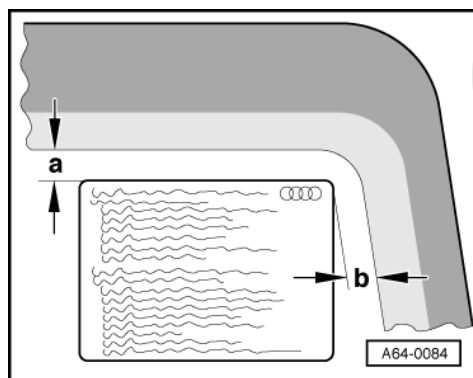
- ♦ The height of the adhesive bead is to be reduced accordingly to allow for residual material on window and window flange.

Installing windscreen

- -> Apply adhesive sealant all round as shown.
- Width of adhesive bead = 8 mm
- Distance between centre of adhesive bead and edge of windscreen is 6 mm.



- -> At top edge of windscreen, bond five spacers -3- at equal distances onto inner side of adhesive bead -1-, starting from the corners
- At bottom edge of windscreen, bond on three spacers in line with the marks made on windscreen -2-
- Insert windscreen in opening using two double suction holders.
- Laterally align window.
 - Distance between edge of windscreen and roof frame must be 7 mm.
 - Distance from fasteners must be at least 1 mm
- Press trim section into fasteners.
- Secure window glass in position in window opening with adhesive tape.

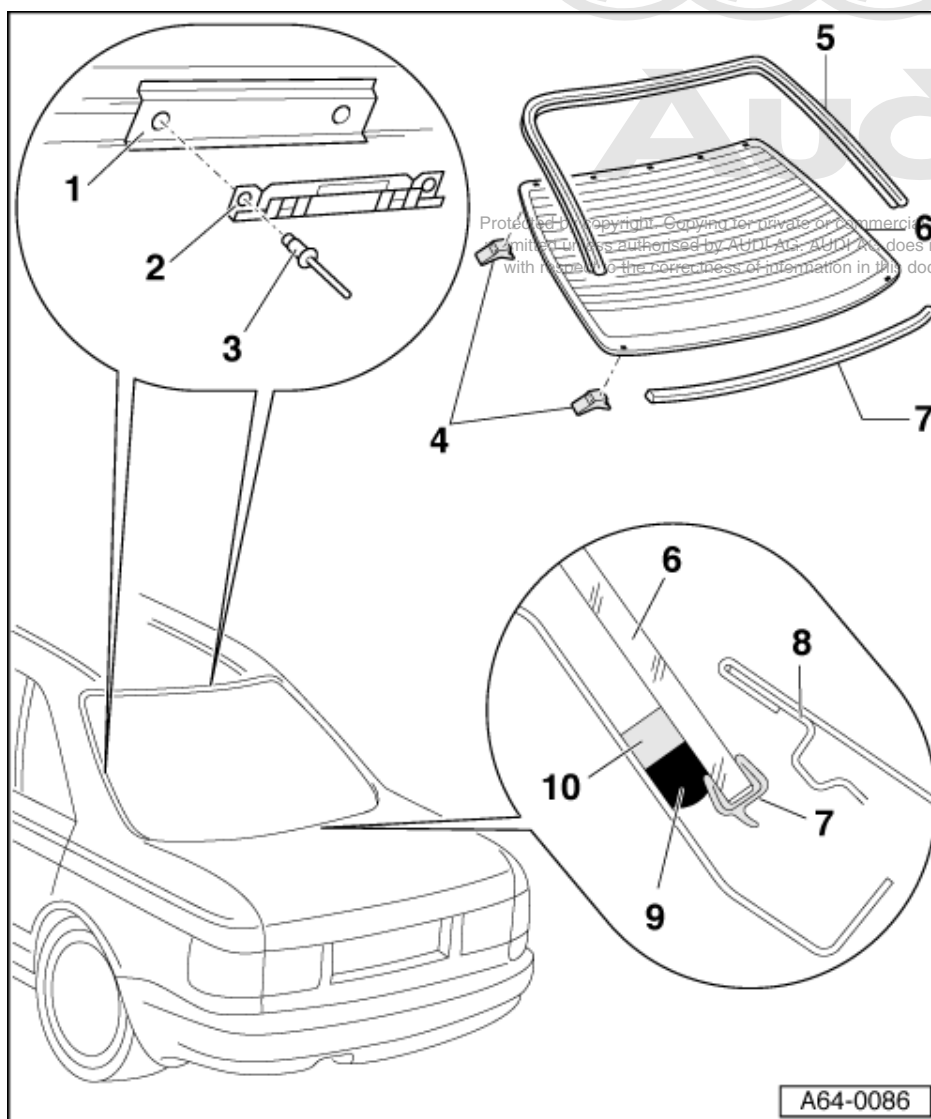


- When the minimum setting time has elapsed => Page 166
- Re-attach stickers (e.g. for airbag) in same position on new windscreen.

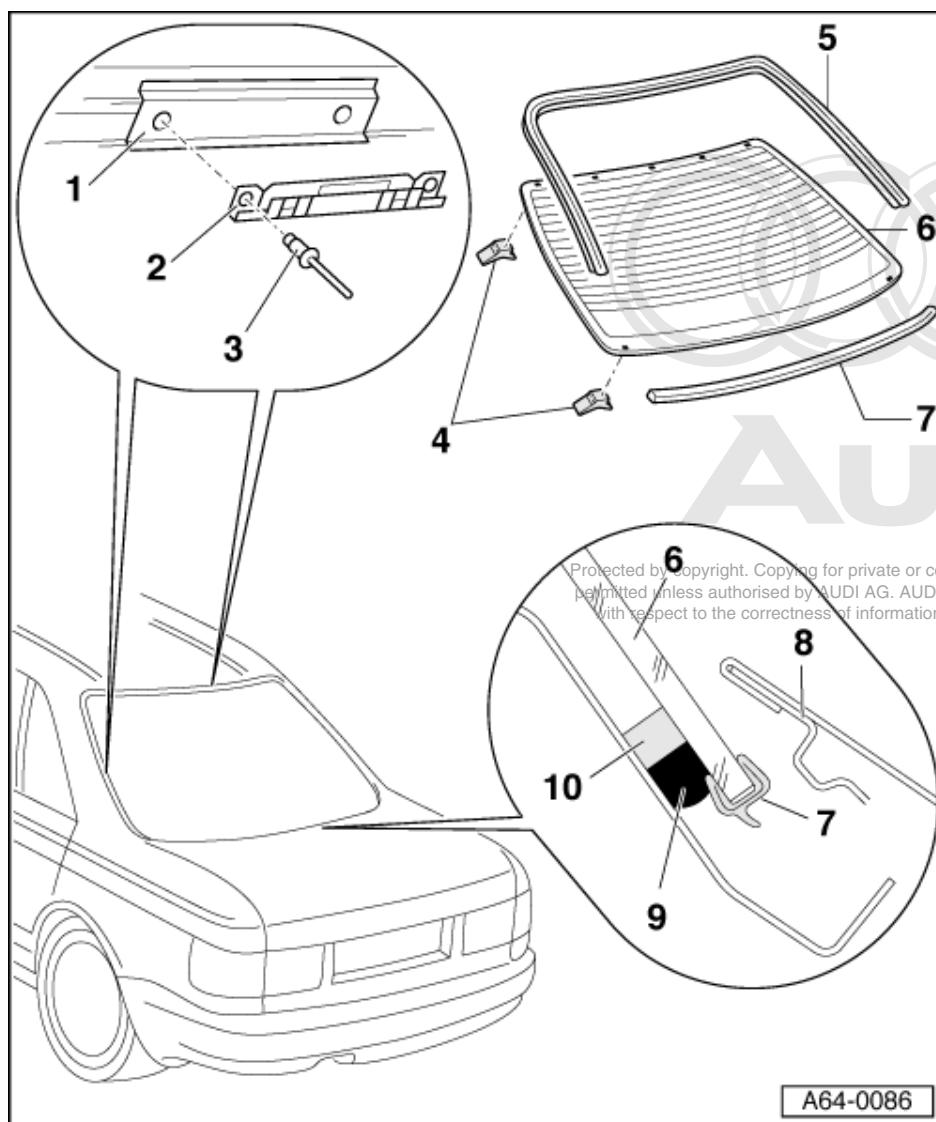
- > Sticker "Attention - Safety precautions"
- Dimension a = 16 mm
- Dimension b = 19 mm

4 - Removing and installing rear window - exploded view

4.1 - Removing and installing rear window - exploded view



- 1 Shim plate
- 2 Bracket
- 3 Blind rivet
- 4 Spacer
- 5 Trim strip
 - ♦ Pull out of fasteners
- 6 Rear window
 - ♦ Removing => Page 178
 - ♦ Installing =>Page 183
- 7 Lower surround



8 Boot lid

9 Adhesive bead

- ♦ Note different distances from edge of rear window => Page 184

10 Spacer

- ♦ Different versions for safety glass and insulating glass:

=> Parts List

4.2 - Removing

Tools and materials required => Page 163 .

Important

When removing a window, always wear protective goggles and leather gloves.

- Removing boot lid => Page 22
- Pull trim strip out of fasteners.
- Removing rear bench seat and backrest:

=> General Body Assembly, Interior; Repair group 72; Rear Seat; Removing and installing rear bench seat
Rear Seat Removing and installing rear bench seat

=> General Body Assembly, Interior; Repair group 72; Rear Seat; Removing and installing backrest Rear Seat
Removing and installing backrest

- Removing rear shelf:

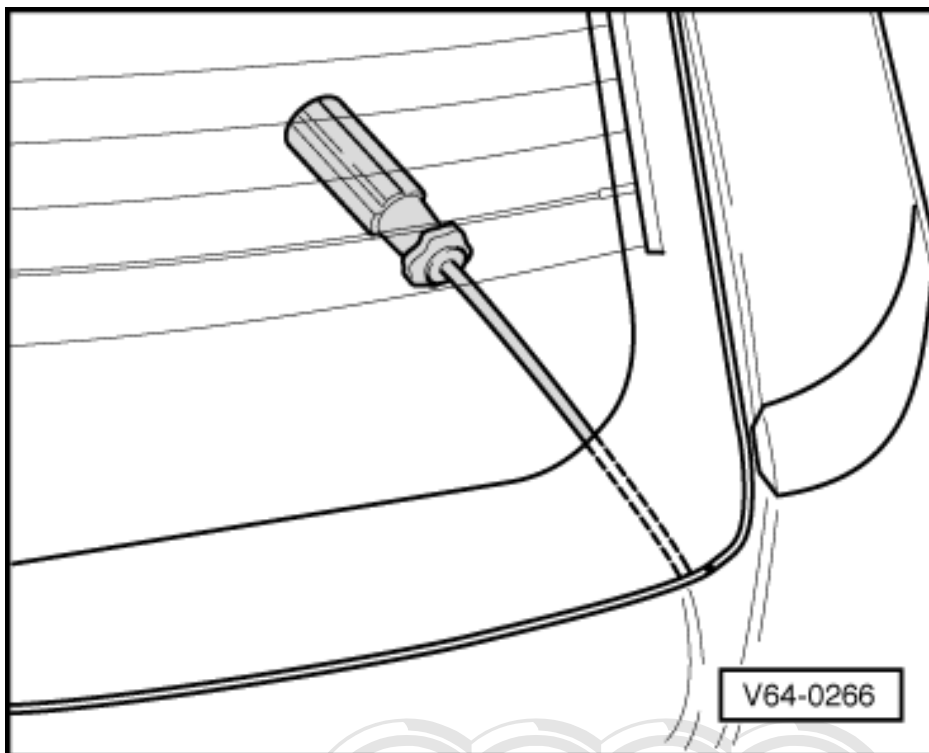
=> General Body Assembly, Interior; Repair group 70; Trims; Removing and installing rear shelf Trims Re-
moving and installing rear shelf

- Removing D-pillar trim:

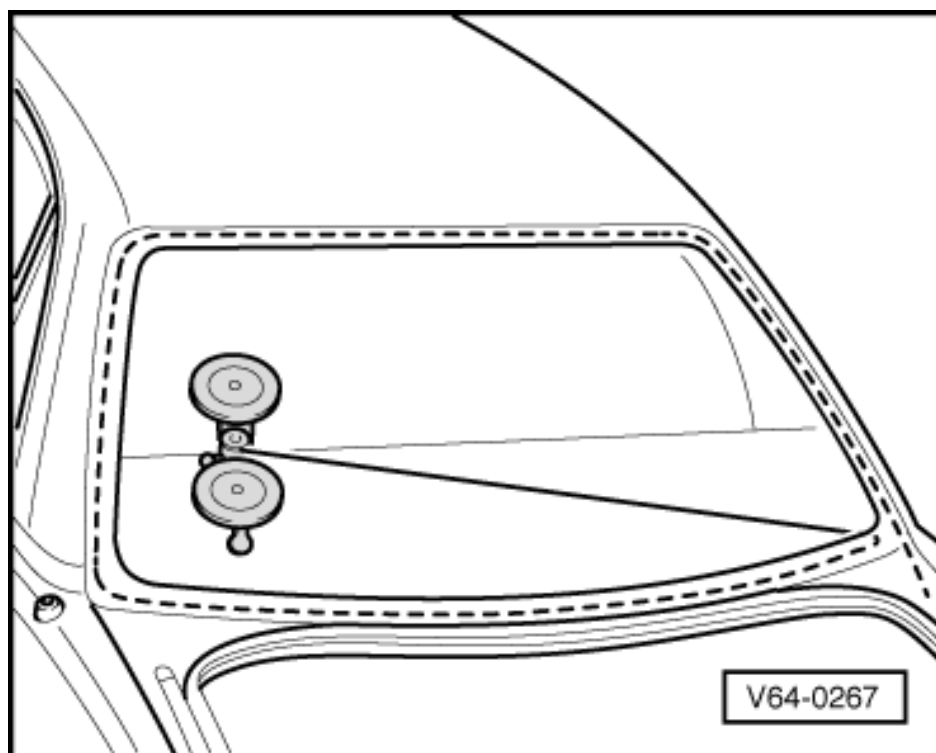
=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing D-pillar trim Trim
panels Removing and installing D-pillar trim

- Detach/unscrew connections for heated rear window and window aerial; press connections onto window
towards centre of vehicle.

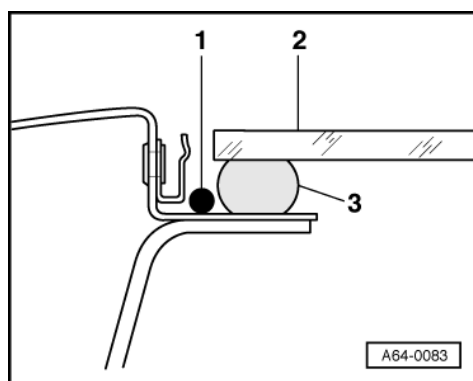
Removal of unbroken window:



- -> Using an awl, pierce adhesive sealant from inside in bottom corner of window until eye of awl is visible from outside.
- Thread in end of cord and pull into interior of vehicle.
- Feed cutting cord into reel and secure.

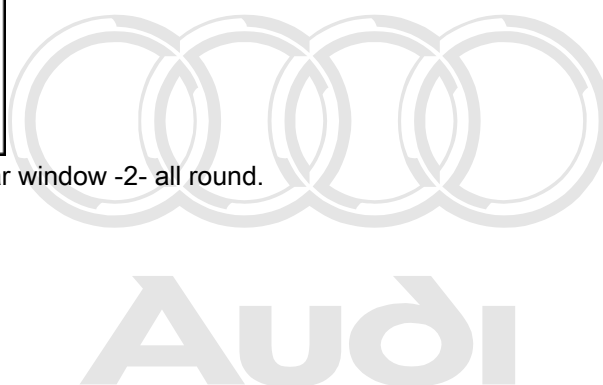


- -> Route cutting cord around rear window, as shown in the illustration.

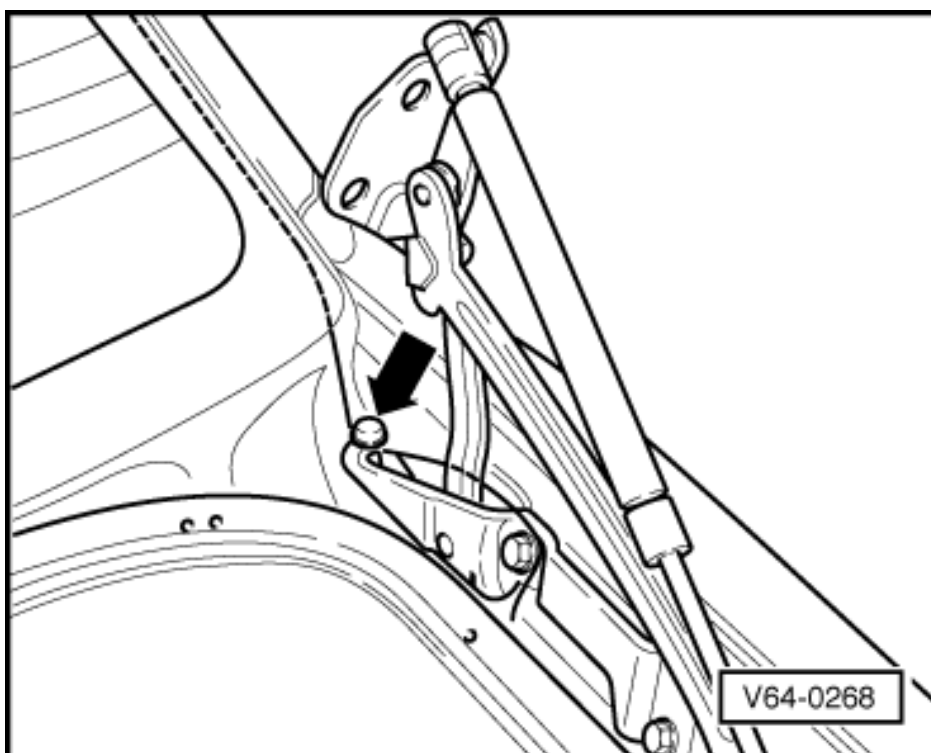


- -> Press cutting cord-1- beneath rear window -2- all round.

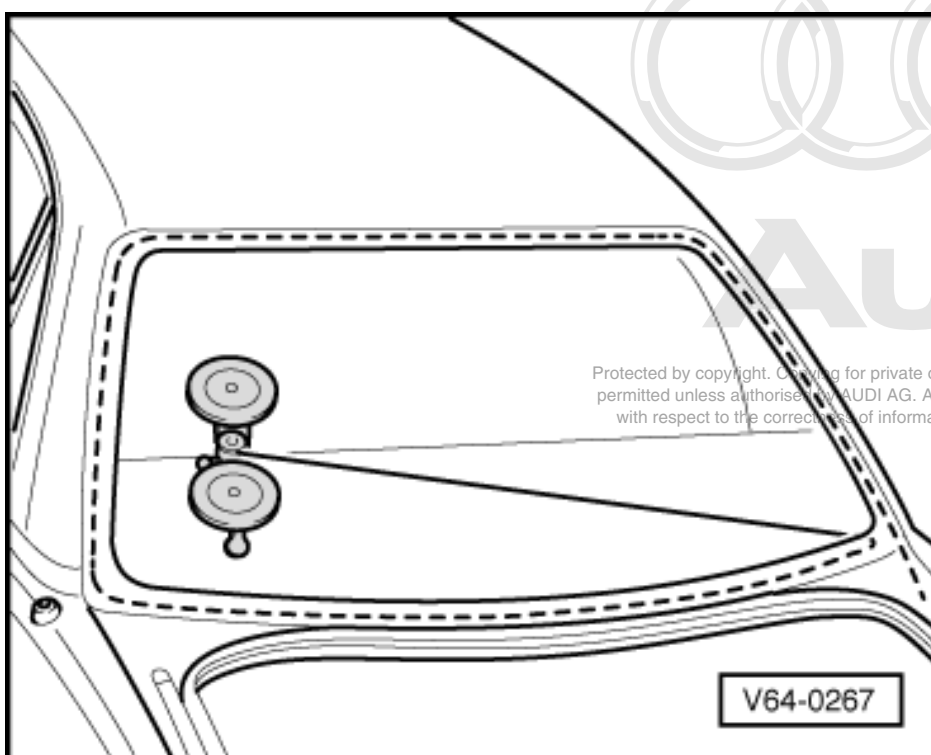
3 - Adhesive sealant



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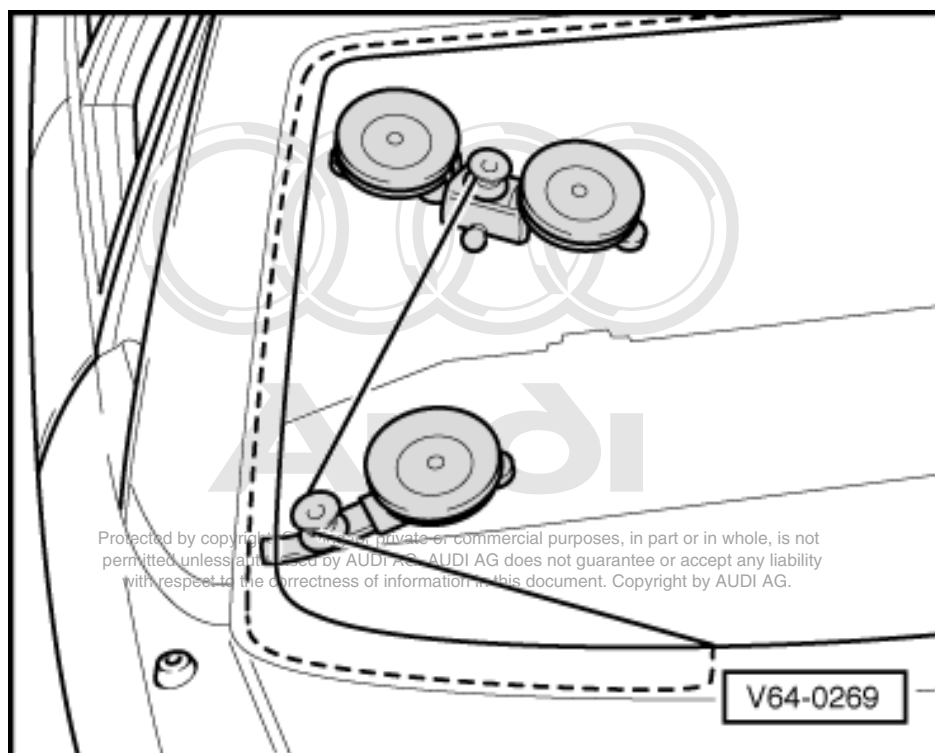


- -> Place end of cutting cord around buffer stop -arrow- and secure with bolt for boot-lid hinge.
- Insert protective sheet V.A.G 1474/10 between moulded headliner and rear window.

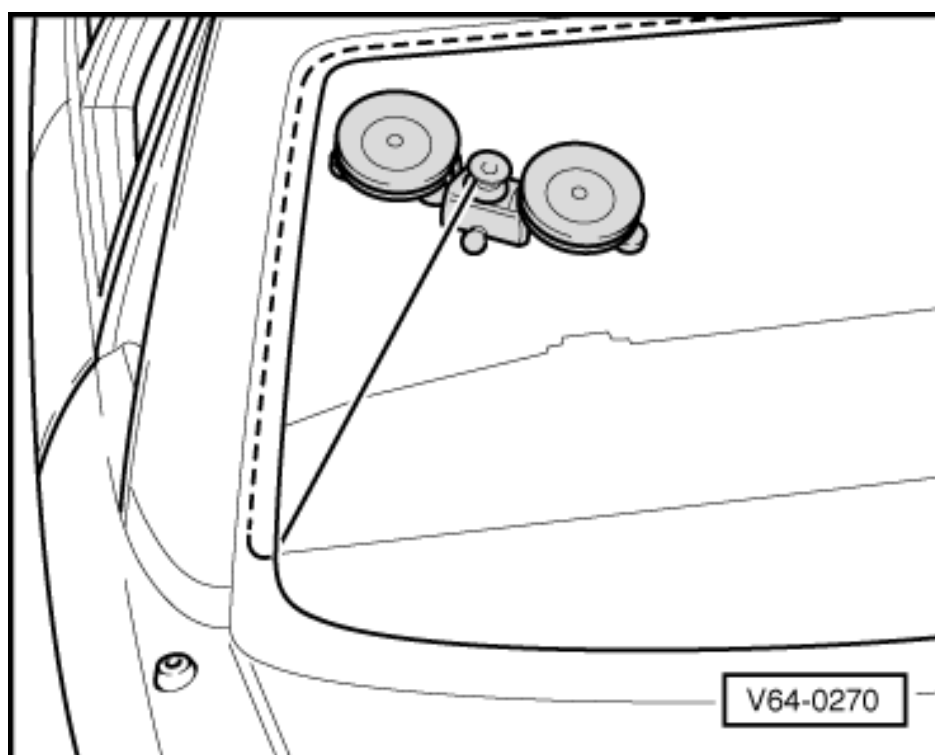


- -> Cut free first section.

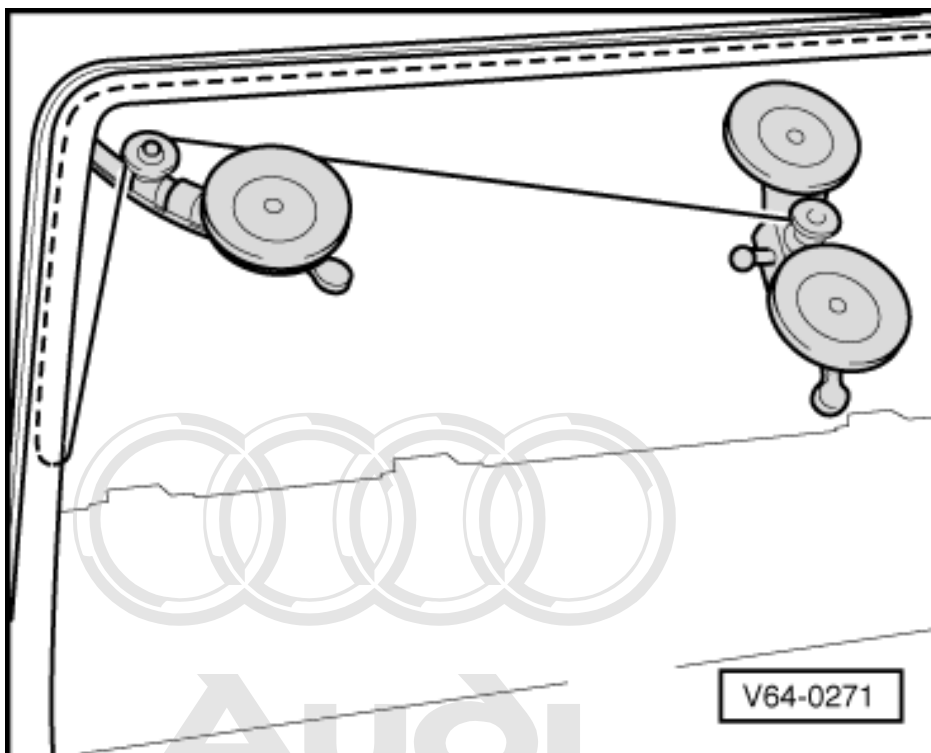
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- -> Move reel to position shown and attach jockey pulley in bottom corner of window.
- Route cord as shown.
- Cut out glass up to the point where the cord no longer runs in the guide roller.



- -> Remove guide pulley and continue cutting out window.



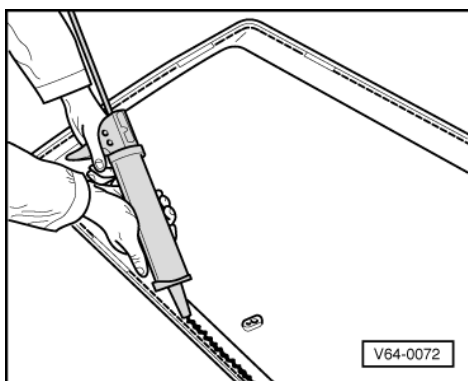
- -> Move reel to position shown and attach jockey pulley in top corner of window.
- Route cord as shown.
- Cut out glass up to the point where the cord no longer runs in the guide roller.
- Insert protective foil between moulded headliner and rear window.
- Remove guide roller and continue cutting out window.
- Repeat these work stages for the top and bottom right corners of the window.
- Cut window out completely.
- Use double suction holders to remove window.

Removal of broken window:

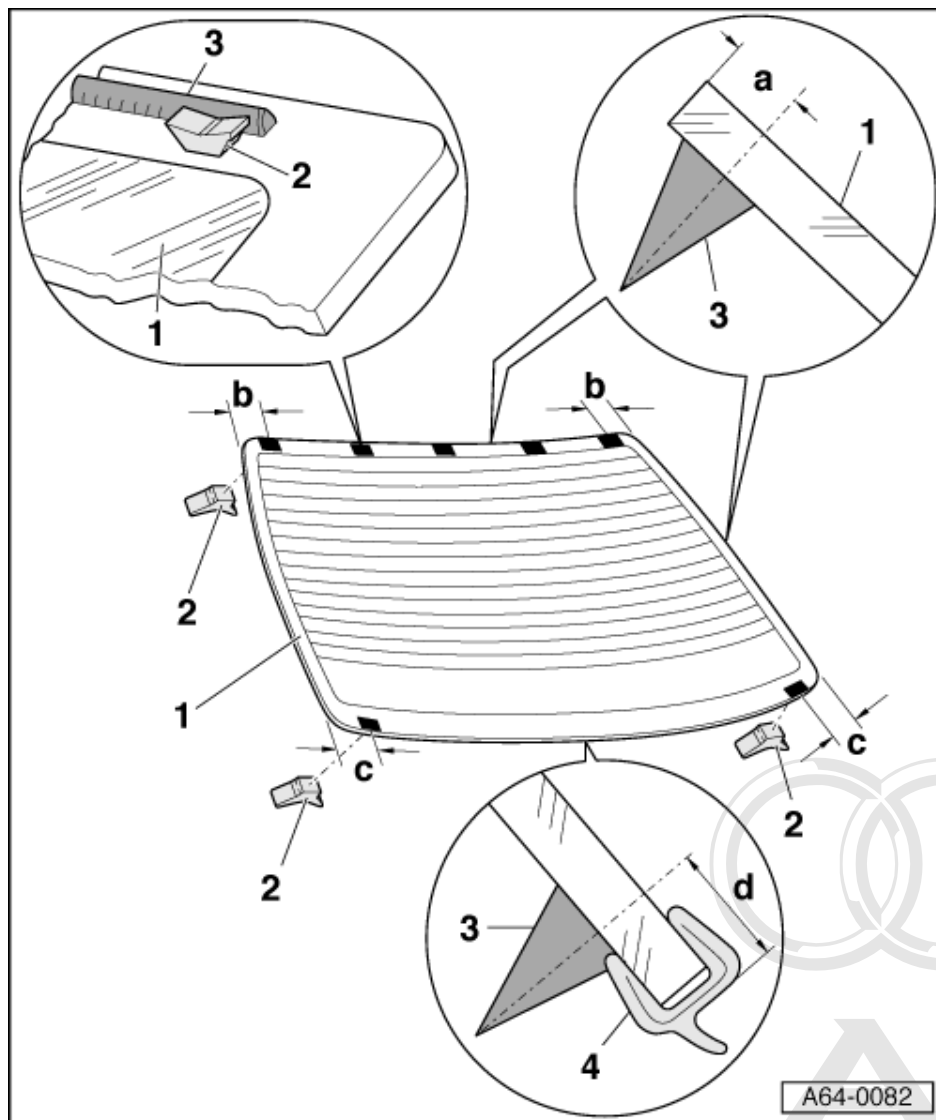
- Remove pieces of glass up to adhesive sealant.
- Separate glass residues and adhesive sealant with carpet knife or electric cutter.

4.3 - Installing

- Preparations for installing window => Page 173 .



- -> Apply adhesive sealant all round as shown.
- Note different distances from edge of window =>Page 184 .
- Insert window in opening using two double suction holders.
- Laterally align window.
- Press trim strip into fasteners.
- Secure window glass in position in window opening with fabric reinforced adhesive tape.



Dimensions for adhesive bead application

1 Rear window

2 Spacer

- ♦ 7 off
- ♦ Different versions for safety glass and insulating glass:

=> Parts List

- ♦ At top, press five spacers at equal intervals into side of adhesive bead.
Dimension b = 75 mm
- ♦ At bottom, press two spacers into side of adhesive bead.
Dimension c = 80 mm

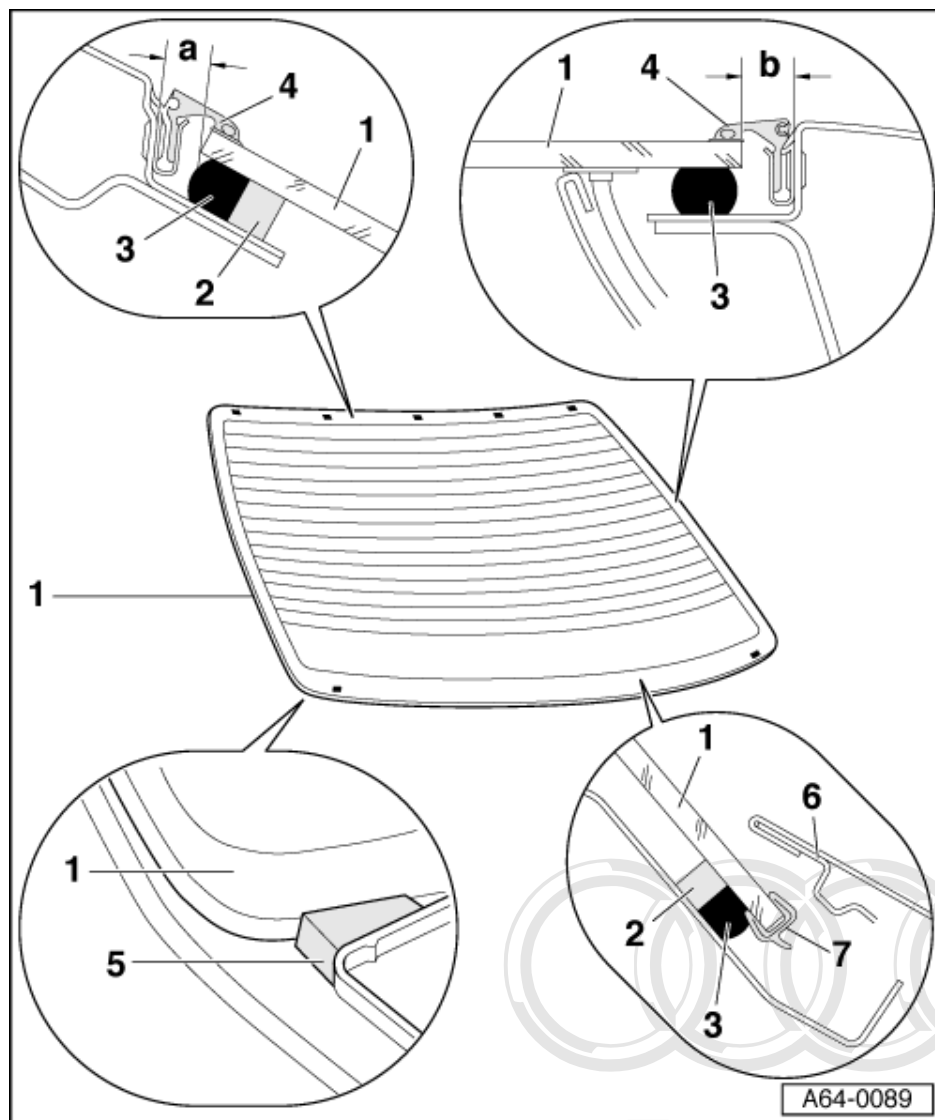
3 Adhesive bead

- ♦ Note different distances from edge of window:
Dimension a = 6 mm

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Dimension d = 10 mm

4 Lower surround



Distances between rear window and window flange

1 Rear window

- ♦ Distance at top
Dimension a = 8 mm
- ♦ Distance on side
Dimension b = 75 mm

2 Spacer

3 Adhesive bead

4 Trim strip

5 Adjuster

6 Boot lid

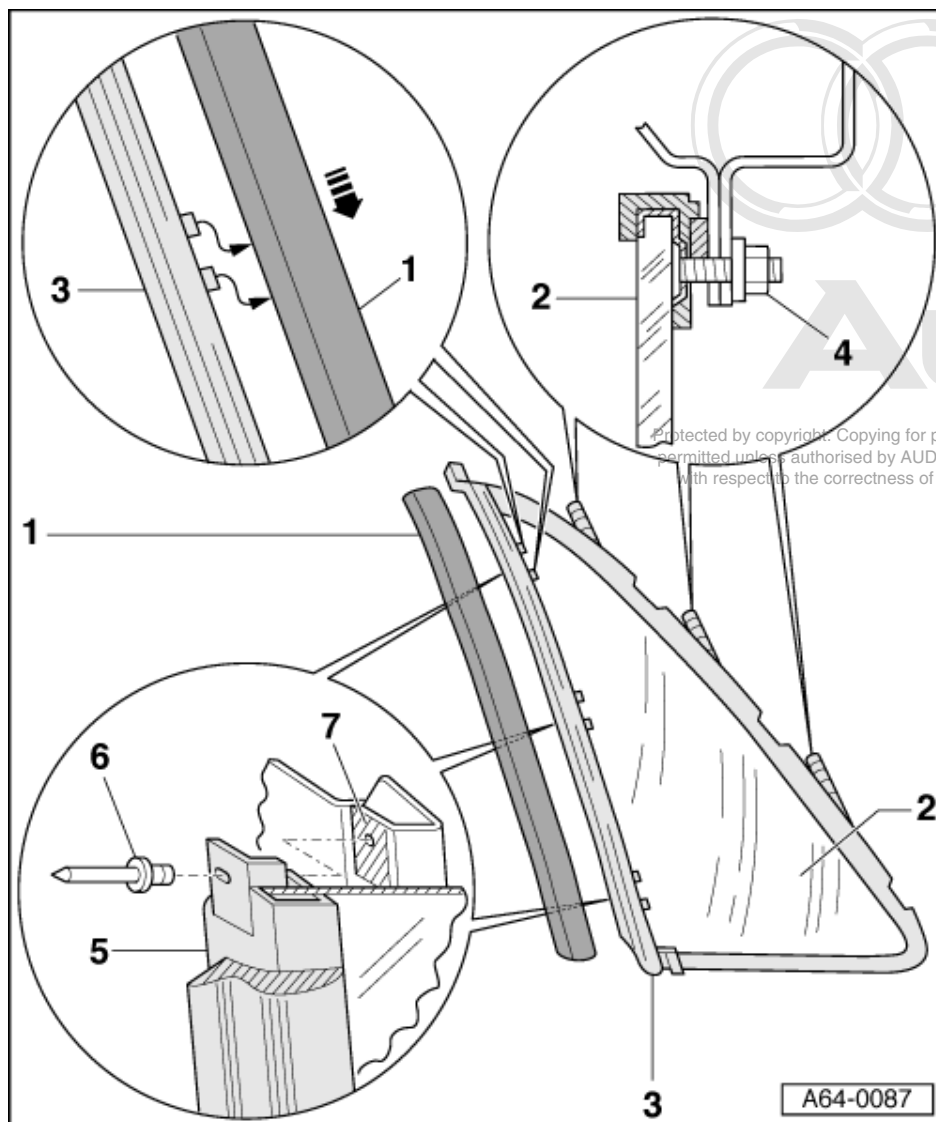
7 Lower surround

- ♦ Adhesive bead must slightly overlap onto surround

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5 - Removing and installing side window

5.1 - Removing and installing side window



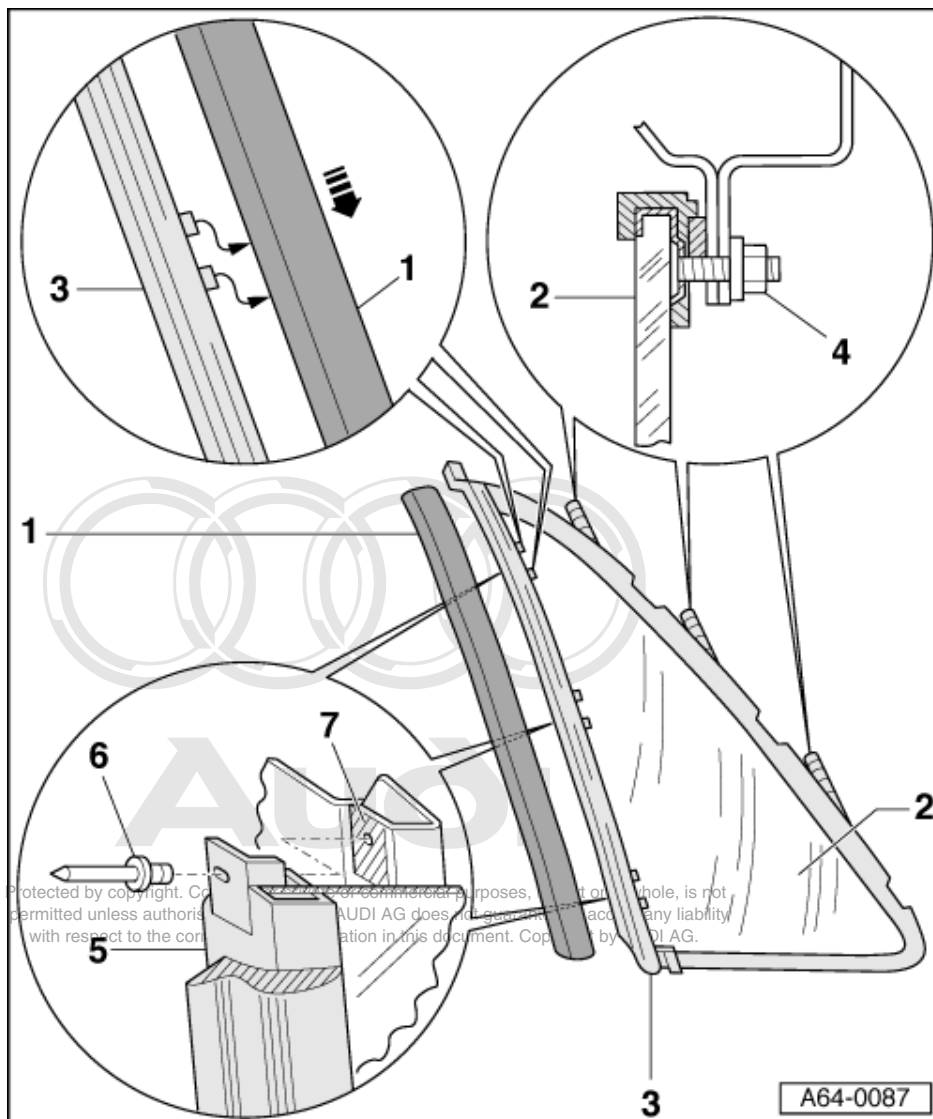
Important
 When removing shattered window always wear protective goggles and leather gloves.

1 Trim strip

- Detaching rear roof trim strip to remove => Page 194 .
- ◆ Press trim strip firmly downwards -arrow- and disengage from fastener

2 Side window

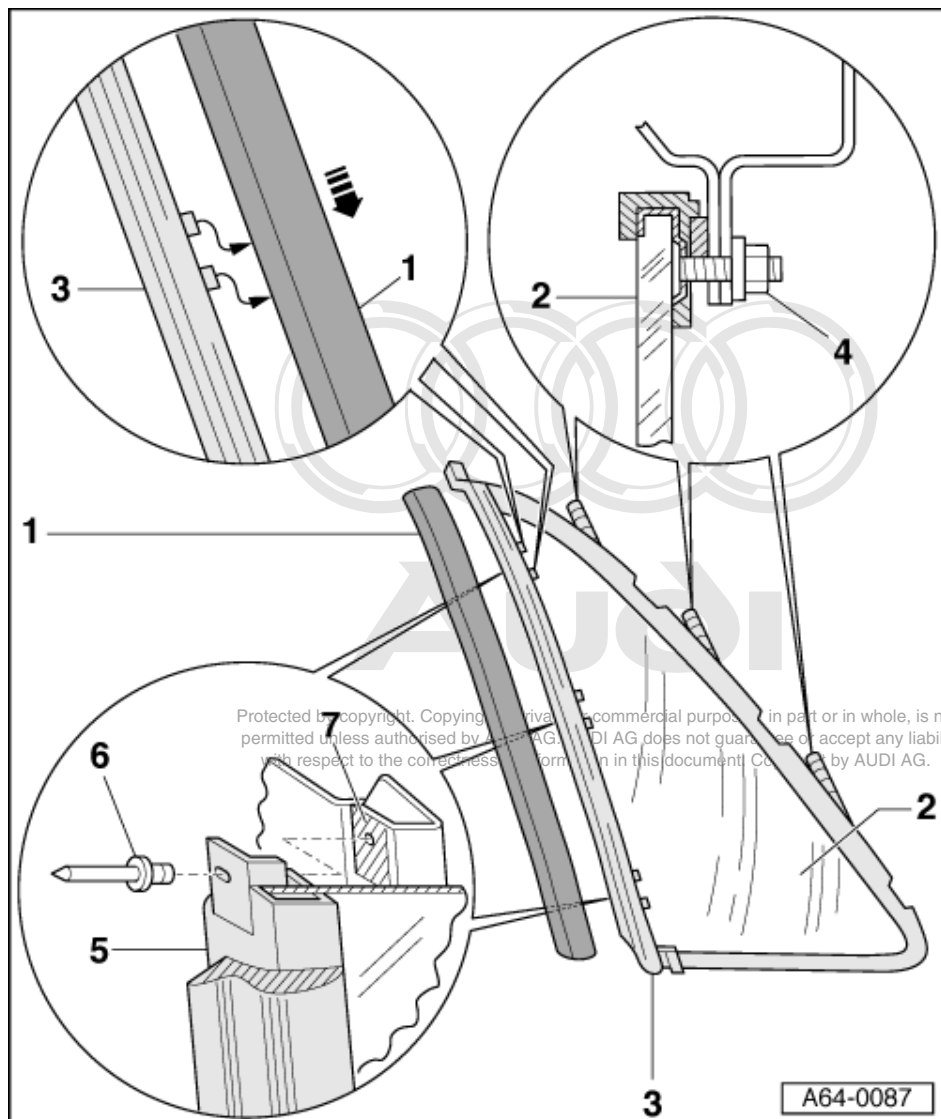
- ◆ Removing:
- Removing rear roof trim strip => Page 194 .



- Remove trim strip -item **1** -.
- Unclip top part of C-pillar trim
- Pull door seal off C-pillar in area of window.
- Press cover strip -item **5** - aside
- Drill off heads of rivets -item **6** - beneath strip and knock out shanks inwards.
- Unscrew nuts -item **4** - at window flange in area of D-pillar.
- Press the bottom and then the top of the side window out of opening and remove.

3 Side window frame

- ♦ Cannot be renewed separately



4 Nut - 1 Nm

5 Cover

- ♦ Cannot be renewed separately

6 Tubular rivet

- ♦ Always use genuine rivets to avoid contact corrosion:

=> Parts List

7 Shim plate

- ♦ Serves as seal

66 - Exterior equipment

1 - Contact corrosion

1.1 - Contact corrosion

Contact corrosion can occur if non approved fasteners are used on the vehicle (bolts, nuts, washers etc.).

For this reason, all the fasteners used in production are specially treated. These components can be identified by their greenish surface finish.

In addition to this, all rubber and plastic parts and all adhesives are made of non-electrically conductive materials.

If you are not sure whether used parts can be refitted, always fit new parts.

Important

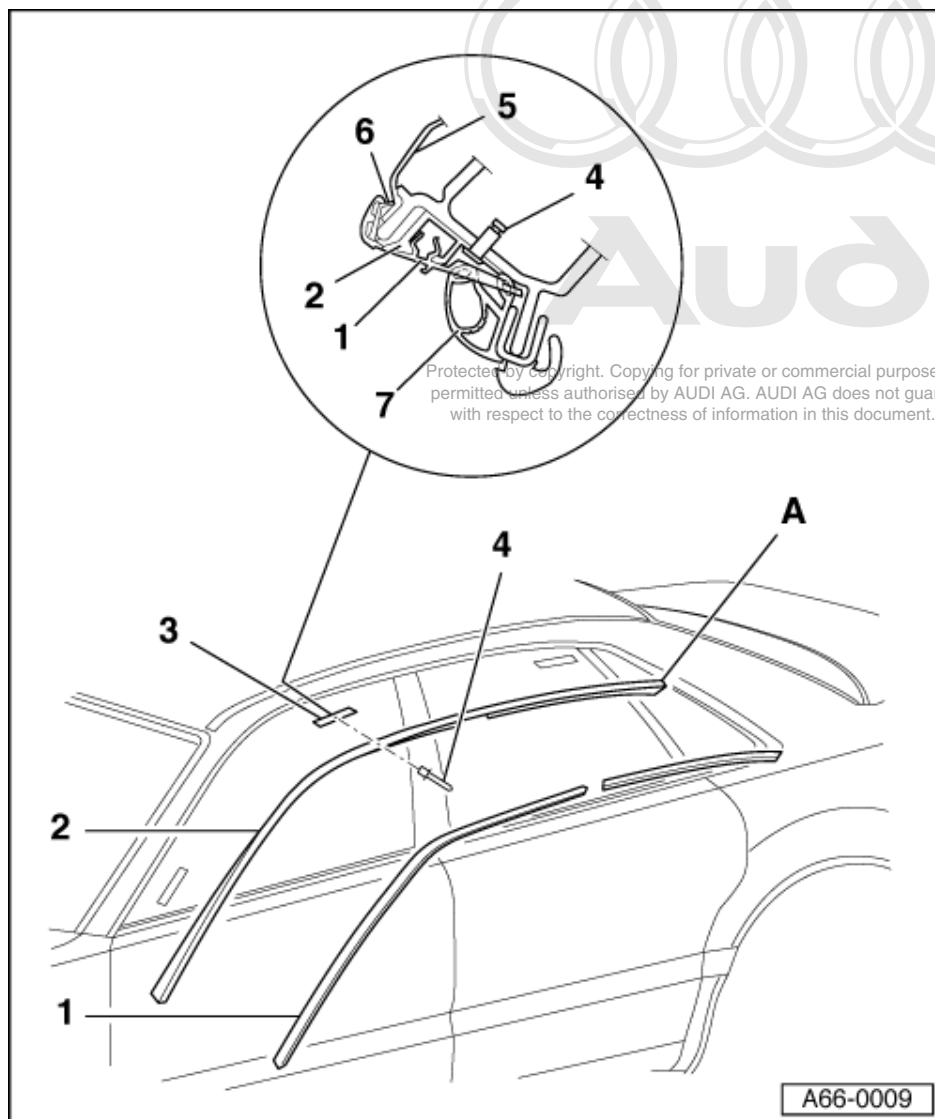
- ◆ **Use only genuine Audi A8 Parts.**
- ◆ **Accessories must be approved by AUDI AG.**
- ◆ **Damage resulting from contact corrosion is not covered by the warranty.**



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2 - Roof trim strip

2.1 - Roof trim strip

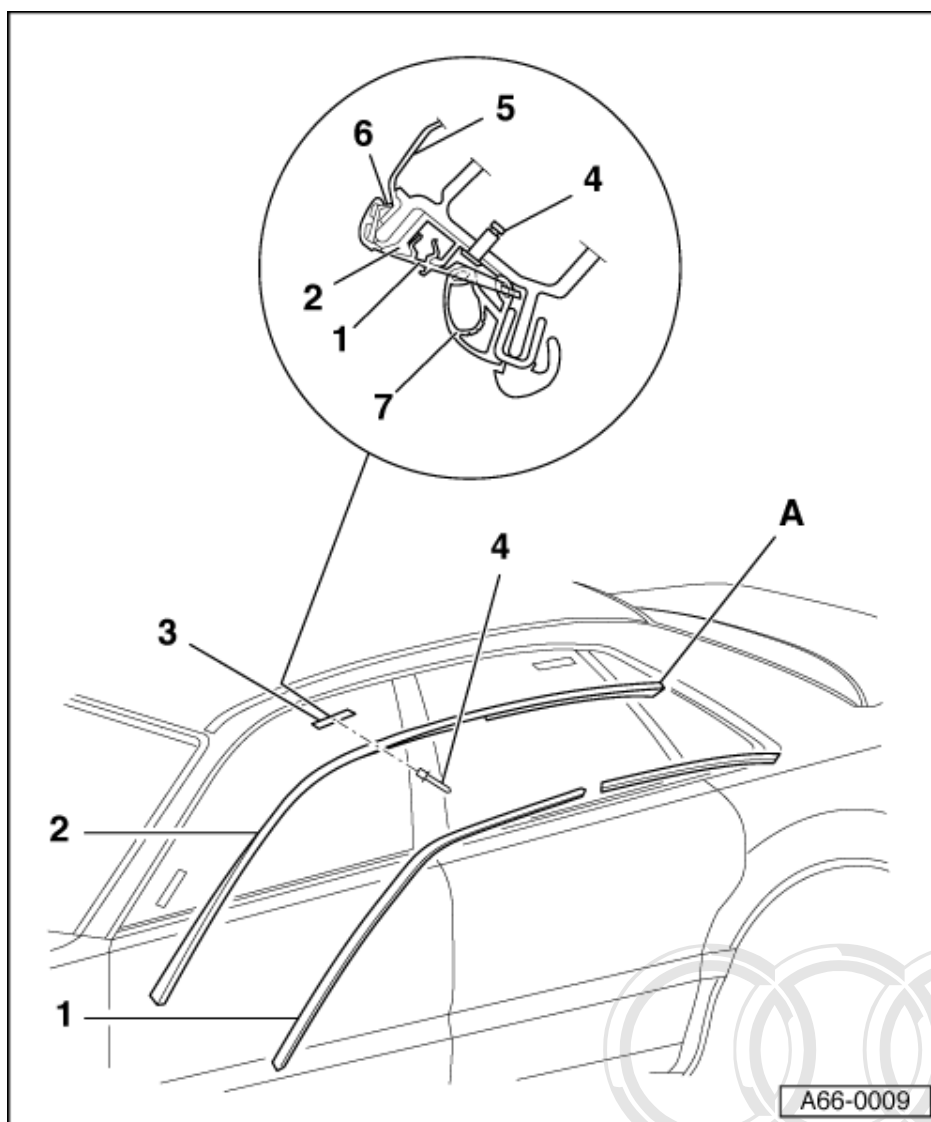


2.2 - Removing and installing front roof trim strip

Important
Never twist or bend the roof trim strip, as this causes permanent visible damage.

1 Cover strip

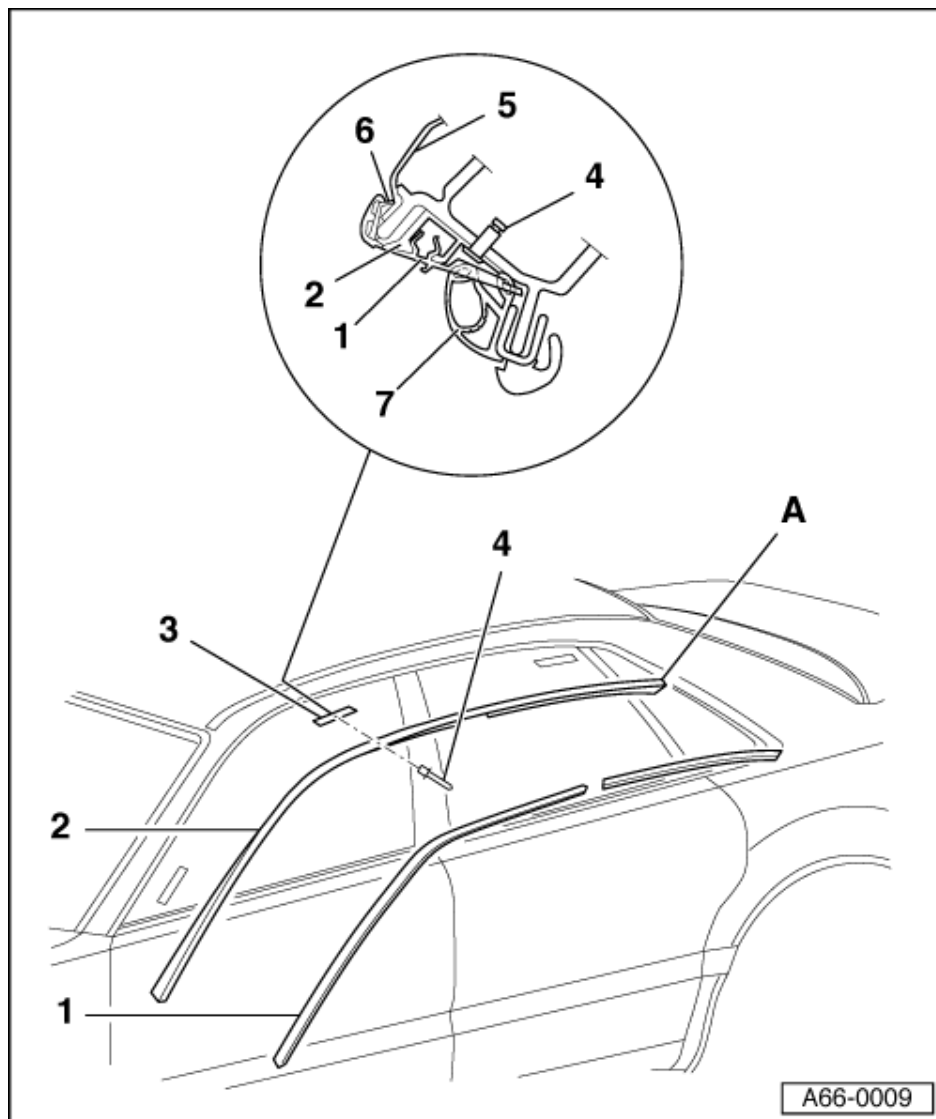
- ◆ 2 off
- ◆ Removing:
 - Lever cover strip out of roof trim strip -item 2 -
- ◆ Installing:
 - Press cover strip into roof trim strip -item 2 -
 - Guide lugs of roof trim strip must engage in cover strip.



2 Roof trim strip

- ◆ Removing:
 - Removing outer B-pillar trim => Page 205 .
 - Removing A-pillar trim
=>Page 205 .
 - Remove cover strips -item 1 -.
 - Drill off rivets -item 4 - if fitted.
 - Detach roof trim strip at front from roof and pull forwards out of guide pin -A-.
- ◆ Second mechanic required for installation
- ◆ Spacers -3- must be fitted

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Notes:

- ♦ If drilling off the rivets has damaged the paintwork, touch up.

=> Vehicle paintwork

- ♦ Take anti-corrosion measures if necessary

=> Binder: "Surface treatment/chemical materials"

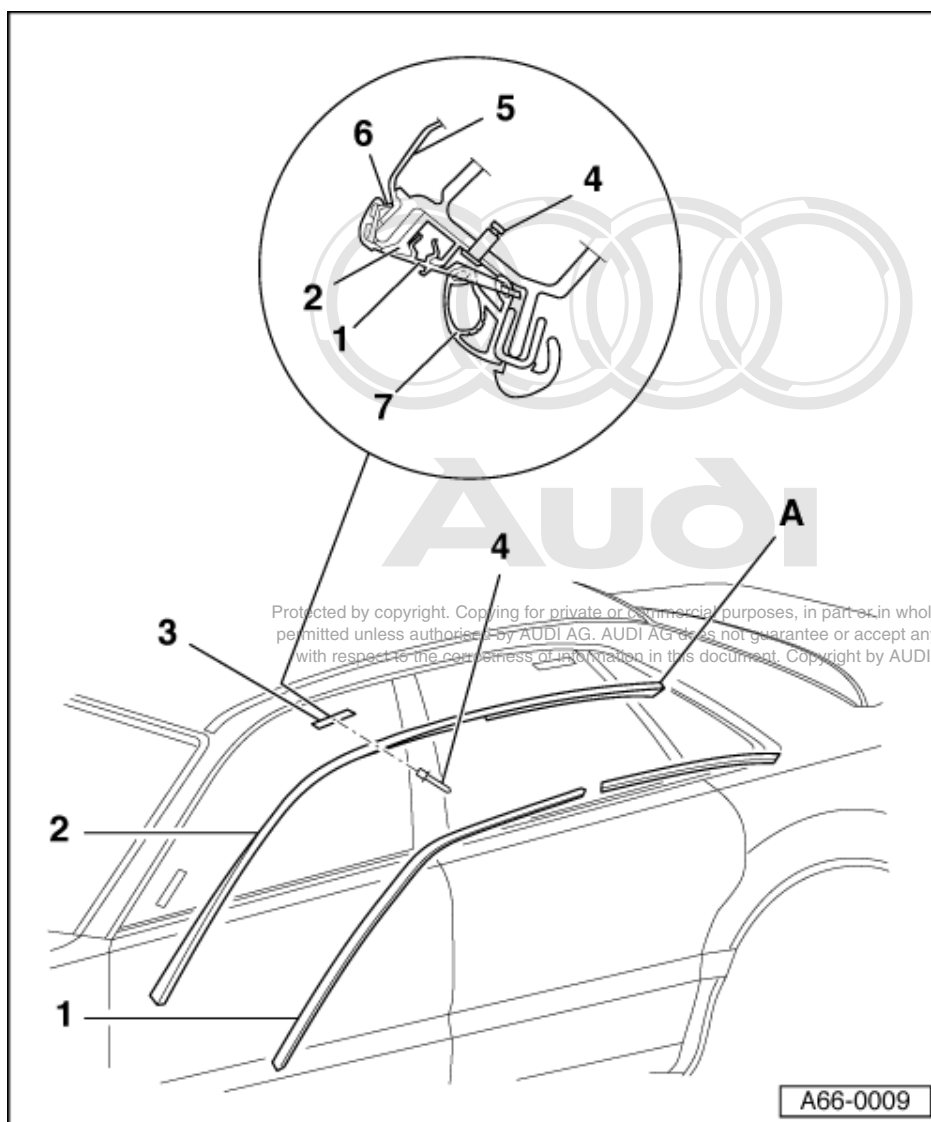
3 Shim plate

- ♦ 3 off
- ♦ No replacement part
- ♦ Seal with sealing compound AKD 512 0000 05

4 Blind rivet

- ♦ 9 off
- ♦ Up to ident. no. 4DT 009 015
- ♦ Drill off rivet heads to remove

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- ♦ Always use genuine rivets to avoid contact corrosion:

=> Parts List

- ♦ Seal with sealing compound AKD 512 0000 05

4 - Oval-head screw - 1 Nm

- ♦ 9 off
- ♦ From ident. no. 4DT 009 016
- ♦ Seal with sealing compound AKD 512 0000 05

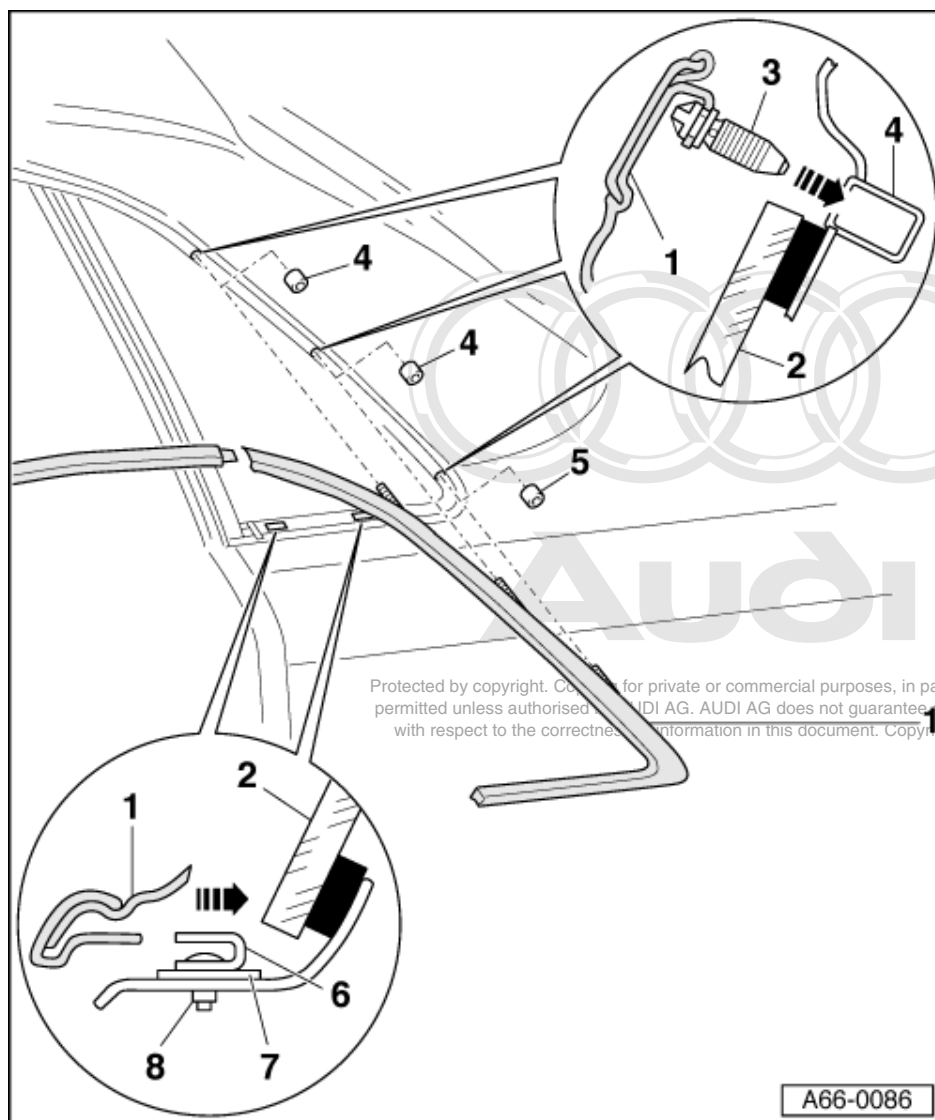
5 Roof

6 Roof seal

- ♦ Cannot be renewed separately

7 Door inner seal

2.3 - Removing and installing rear roof trim strip



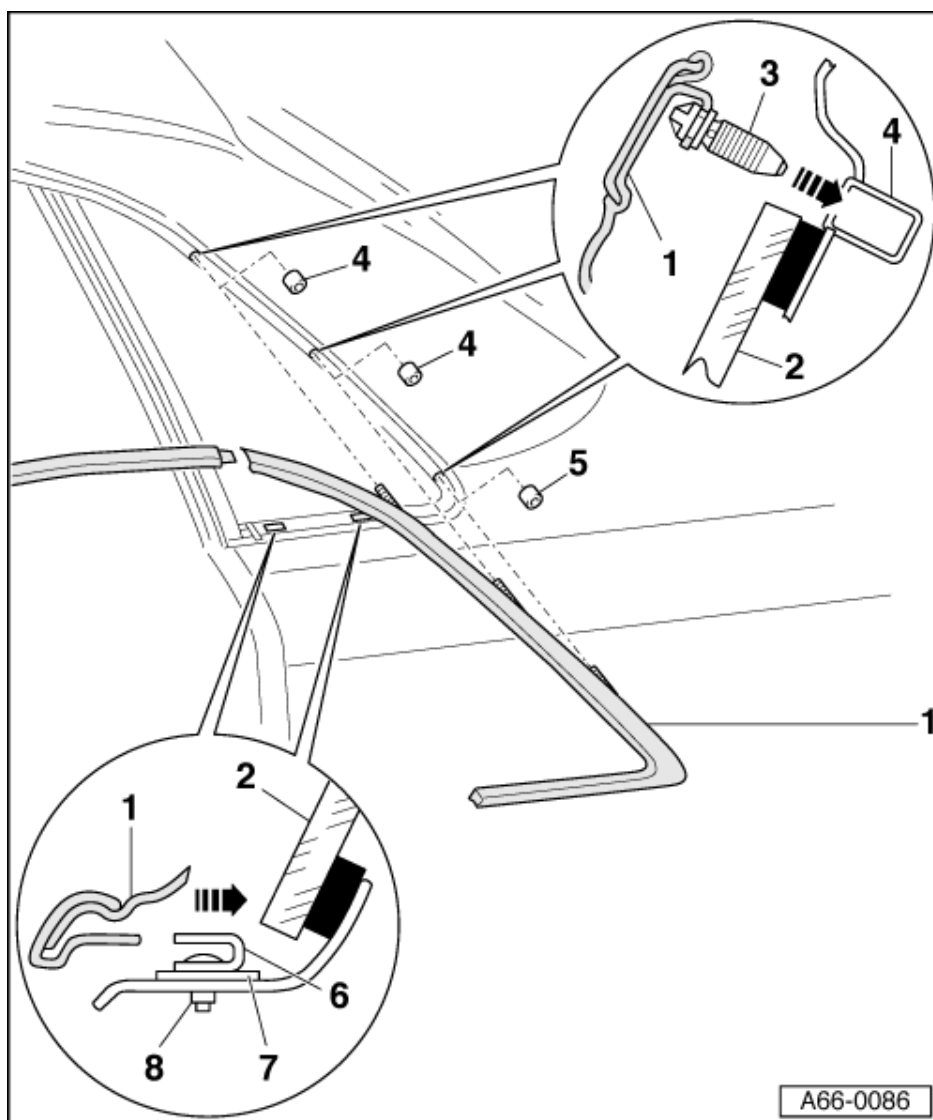
Important
 Never twist or bend the roof trim strip, as this causes permanent visible damage.

1 Rear roof trim strip

- ♦ Removing:
- Removing D-pillar trim:

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing D-pillar trim Trim panels Removing and installing D-pillar trim

- Unclip roof trim strip at bottom from fasteners -item 6 -.

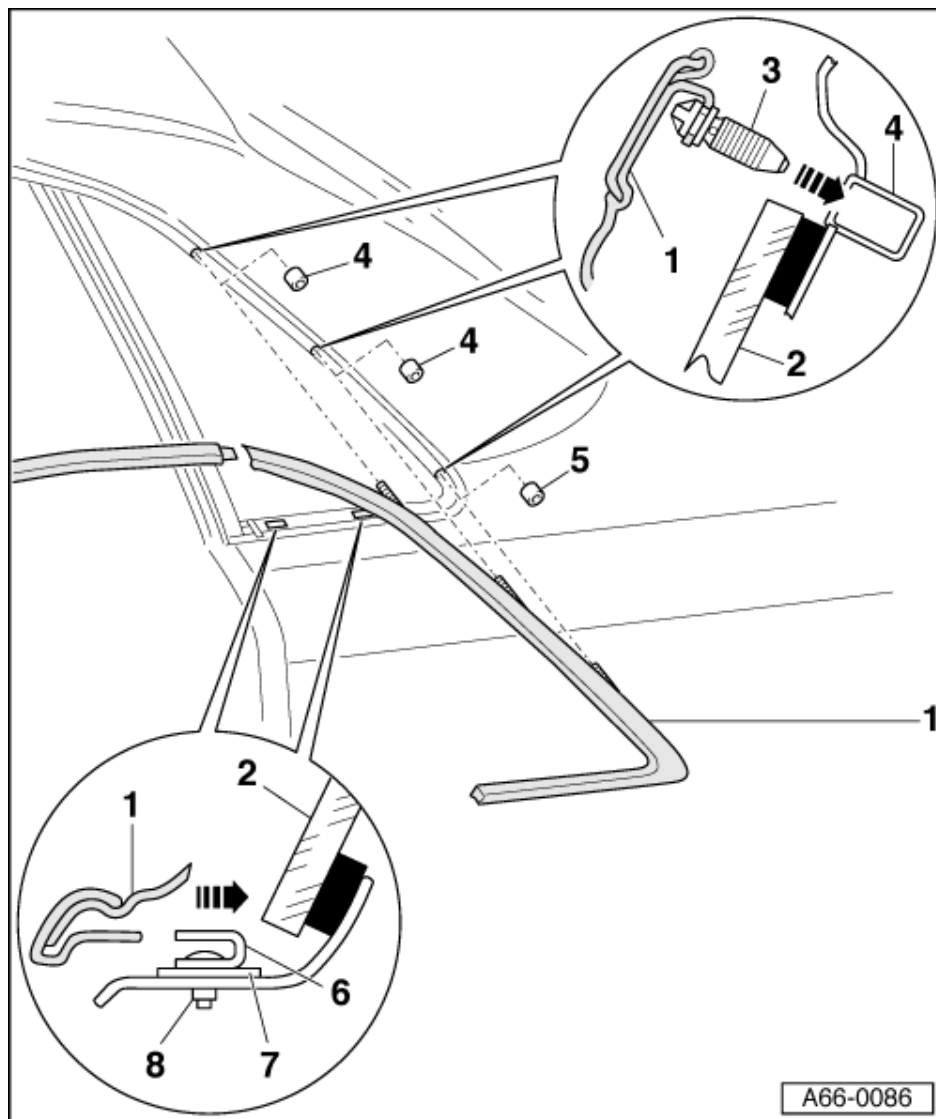


- Press out retaining clip **4** -, centre guide pin and finally upper guide pin -item **3** - from inside vehicle
- Pull roof trim strip off guide pin of roof trim strip at front and detach.
- ♦ When installing, re-seal holes for -items **4** and **5** - from inside.

- 2** Side window
- 3** Guide pin
- 4** Retaining clip
 - ♦ 2 off
- 5** Retaining clip



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- 6 Clamp
- ♦ 2 off
- 7 Shim plate
- ♦ 2 off
- 8 Blind rivet
- ♦ 2 off
 - ♦ Always use genuine rivets to avoid contact corrosion:

=> Parts List



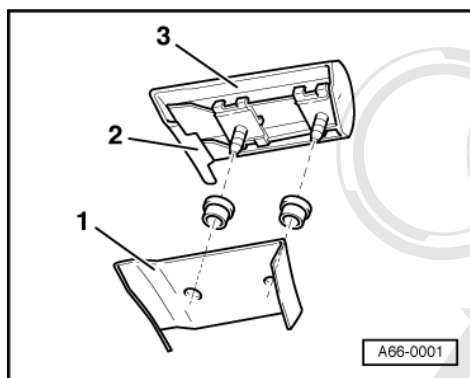
Audi

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3 - Protective strips

3.1 - Protective strips

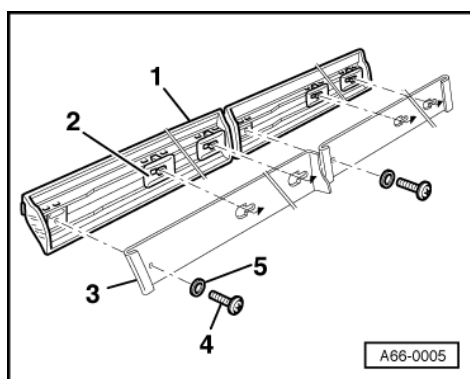
3.2 - Removing and installing protective rubber strip for wing



- -> Unclip protective rubber strip -3- from bracket -2- at wing -1-.
- Detach protective rubber strip to front.

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3.3 - Removing and installing protective rubber strip for front and rear door



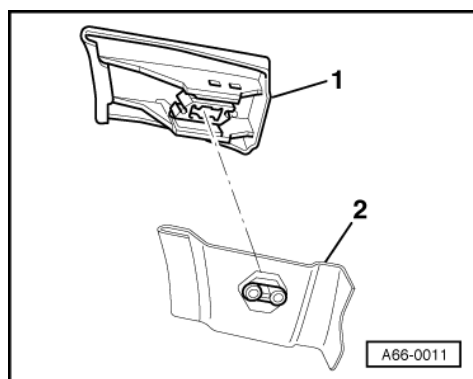
- -> Unscrew bolt -4- at rear of door.

Note:

Bolt is concealed by door seal on rear door.

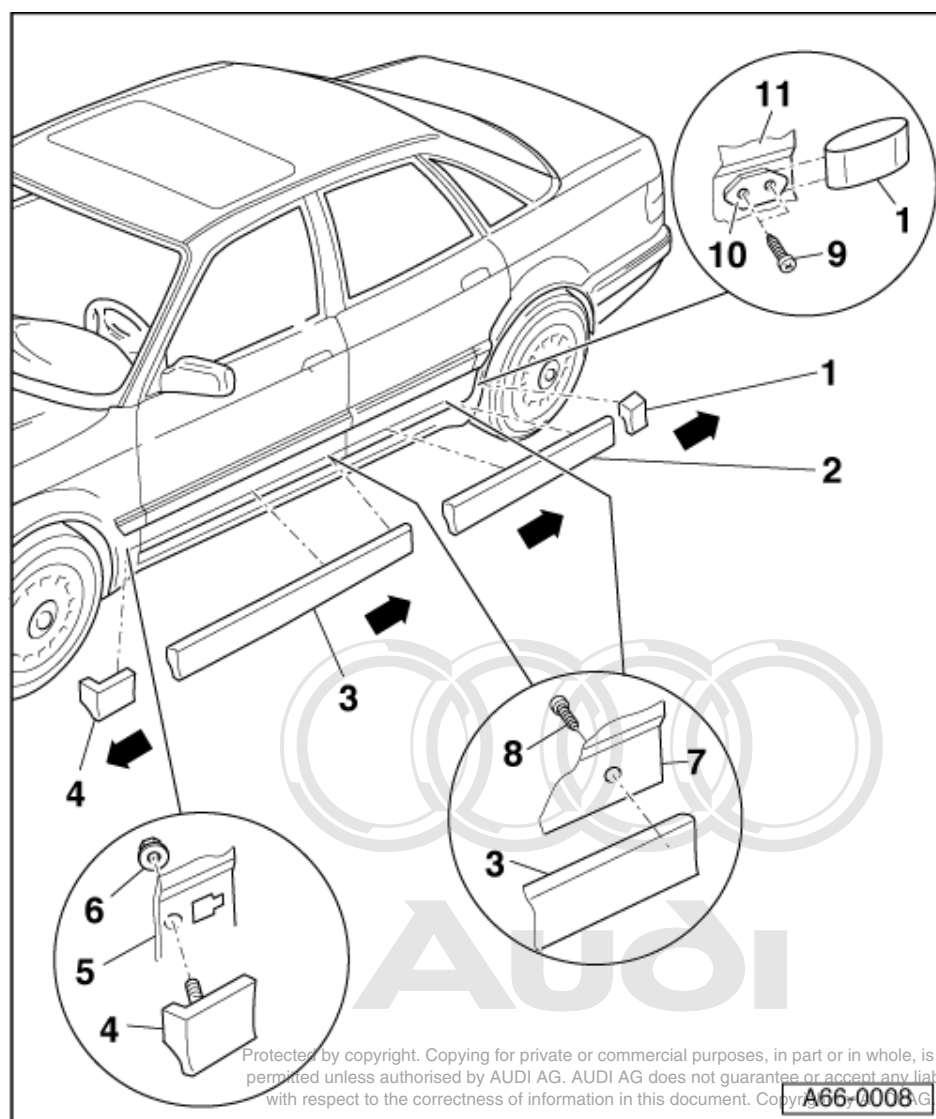
- Pull protective rubber strips -1- together with fasteners -2- to rear to remove from door shell -3-
- 5 - Plate

3.4 - Removing and installing protective rubber strip for rear side panel



- -> Unclip protective rubber strip -1- from bracket at side panel -2- and detach to front.

3.5 - Removing and installing trim cover for side member

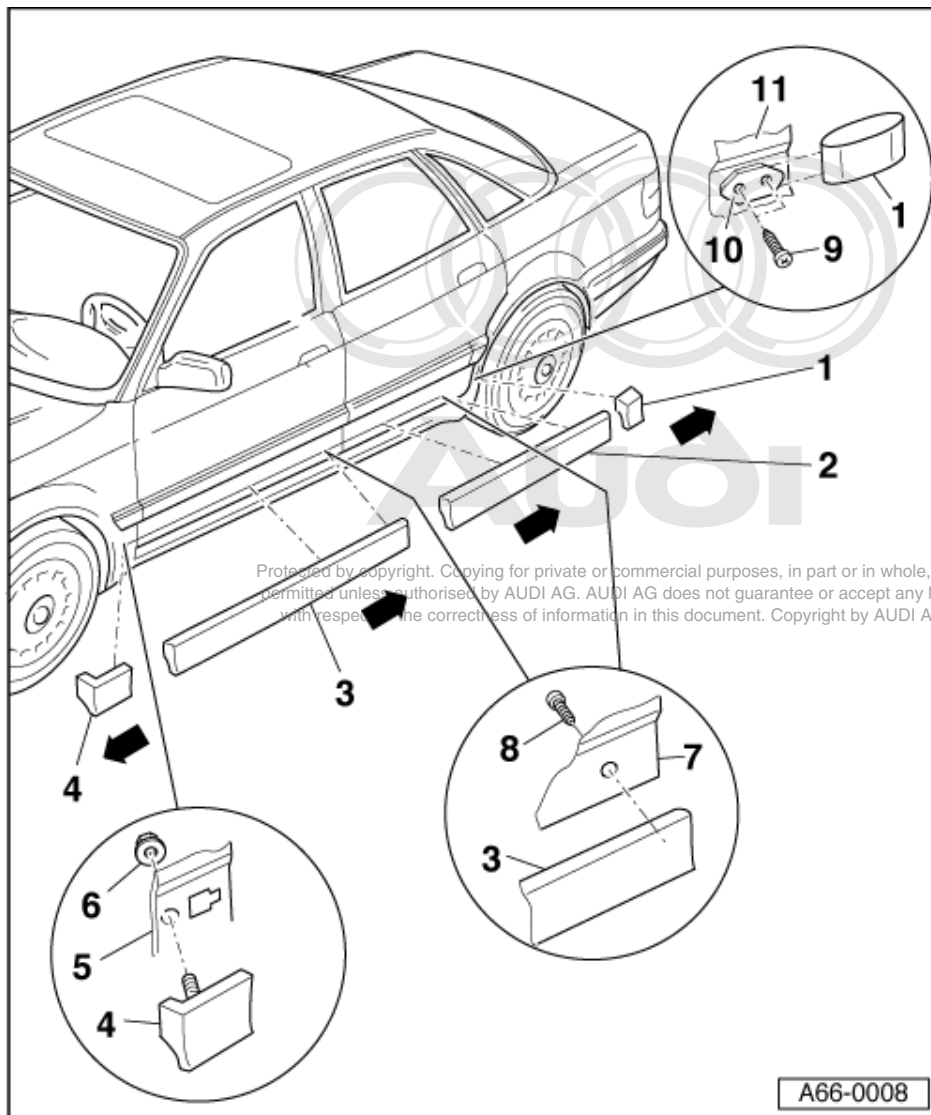


1 Cover

- ◆ For side panel
- ◆ Pull off firmly in direction of arrow

2 Cover

- ◆ For rear door
- ◆ Removing:
 - Unscrew bolt - **8** -.
 - Lift (disengage) rear edge of cover, detach from door shell -item **7** - in direction of arrow and detach.



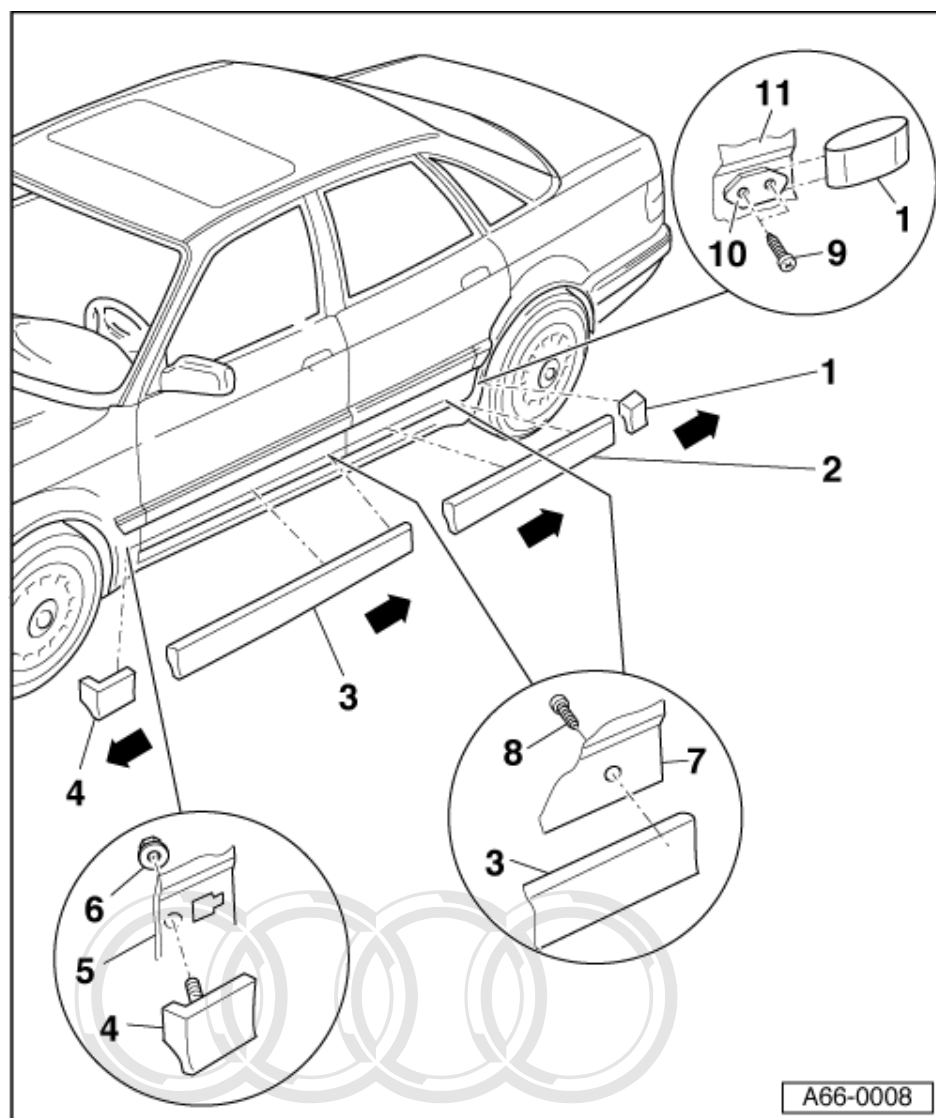
3 Cover

- ◆ For front door
- ◆ Removing:
 - Unscrew bolt - **8** -.
 - Lift (disengage) rear edge of cover, detach from door shell -item **7** - in direction of arrow and detach.

4 Cover

- ◆ For wing
- ◆ Removing:
 - Move back wheel-housing liner in area of cover -item **1** - until nut is accessible.
 - Unscrew nut - **6** -.
 - Slide cover in direction of arrow out of wing -item **5** -and detach.

5 Wings



A66-0008

6 Nut

7 Door shell

8 Bolt

9 Bolt

10 Bracket

◆ 2 off

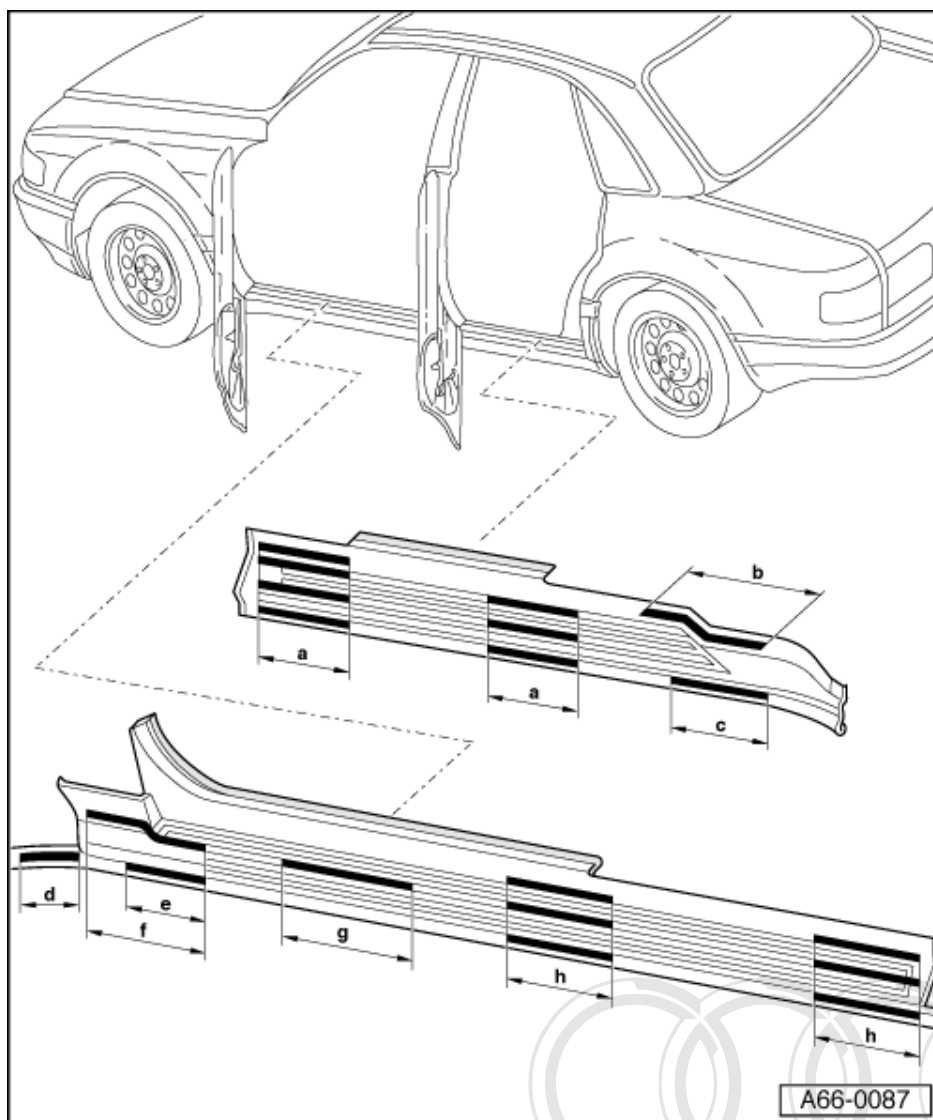
◆ For cover

◆ Removing:

- Remove cover for side panel, item **1** -.
- Remove bolts - **9** -.

11 Side panel

3.6 - Removing and installing outer sill panel trim



- Inner sill panel trim removed:

=> General Body Assembly, Interior; Repair group 70; Trim panels; Removing and installing inner sill panel Trim panels Removing and installing inner sill panel

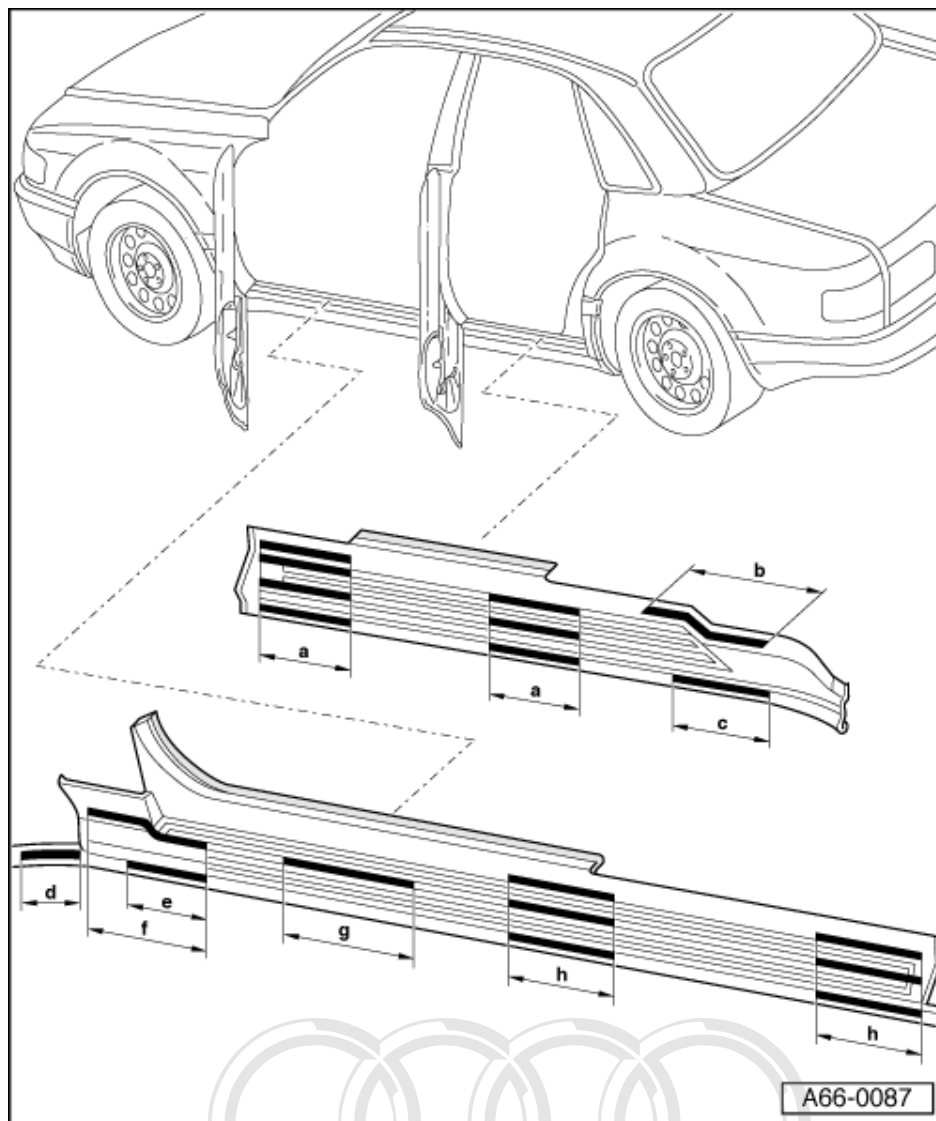
- Lower B-pillar trim removed:

=> General Body Assembly, Interior; Repair group 70; Trims; Removing and installing B-pillar trim Trims Removing and installing B-pillar trim

Removing

- Detach inner door seal in area of sill panel trim.
- Before removing, warm sill panel trim with hot-air blower and pull from sill.

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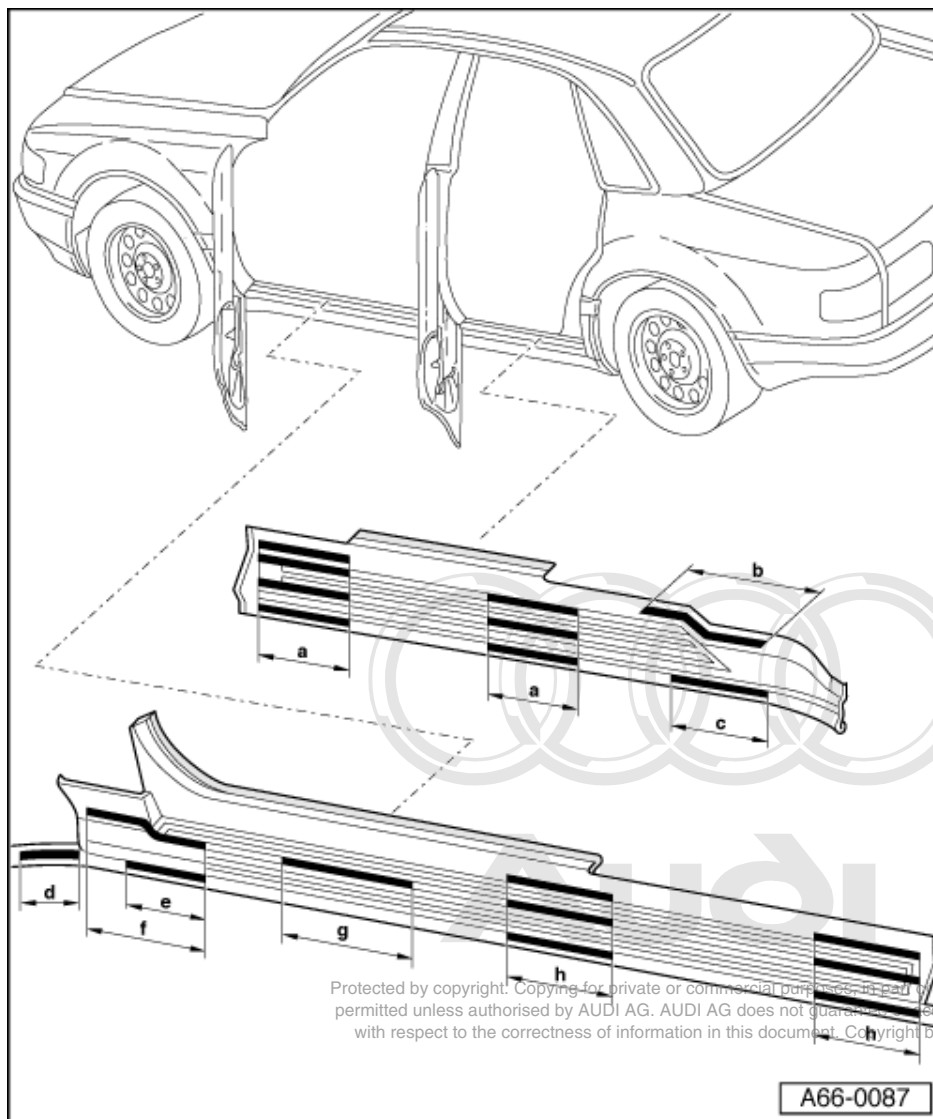


Installing

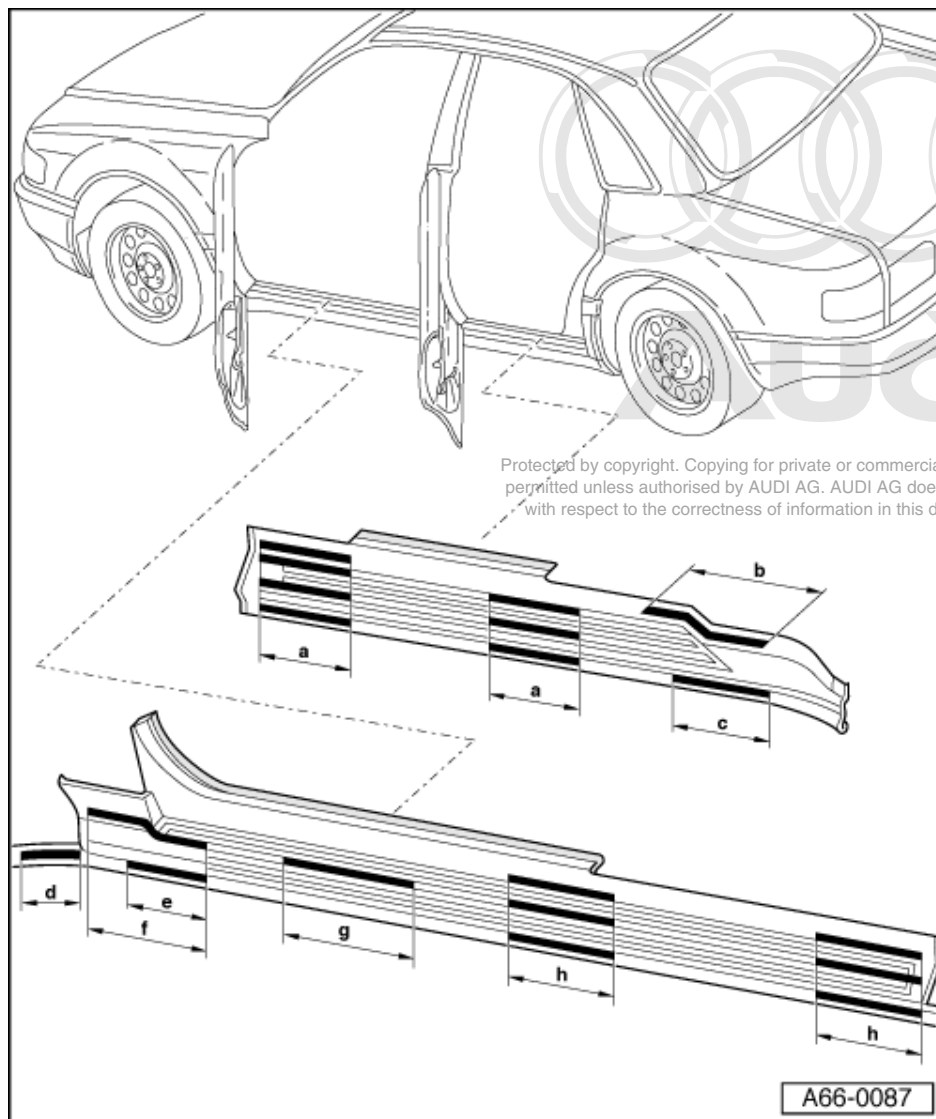
- Trim residual adhesive material at sill to a height of approx. 1 mm; never remove completely.

Notes:

- ♦ Remaining material serves as a bonding surface for the new adhesive sealant when it is applied.
- ♦ Do not treat areas having residual adhesive with cleaning solution and primer.
- Clean bonding surfaces on sill panel trim with a lint-free cloth and cleaning fluid D 009 401 04.
- Prime the surfaces marked black on the sill panel trim with plastic primer D 009 600. Flashing-off time approx. 15 minutes.



- Apply a - \varnothing 4 mm bead of adhesive material DA 009 100 to the surfaces marked in black as follows:
 - Dimension a = 100 mm
 - Dimension b = 180 mm
 - Dimension c = 120 mm
 - Dimension d = 40 mm
 - Dimension e = 70 mm
 - Dimension f = 160 mm
 - Dimension g = 260 mm
 - Dimension h = 140 mm



- Do not remove backing from double-sided adhesive tape (shaded area in Fig.) until shortly before fitting.
- Fit sill panel trim at the latest 10 minutes after applying adhesive material and press on firmly using hard rubber roller (commercially available).

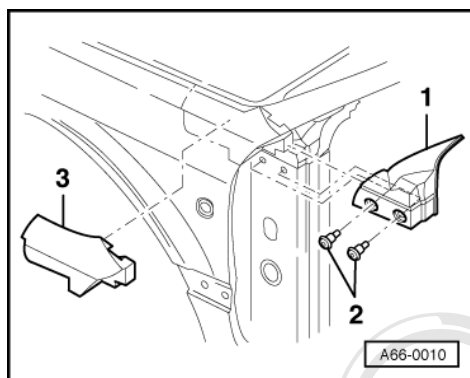
Waiting time

4 hours between pressing on sill panel trim with hard rubber roller and vehicle ready for use.

During waiting time, vehicle must be left standing at room temperature ($> 15^{\circ}\text{C}$).

4 - Removing and installing outer trim

4.1 - Removing and installing outer trim

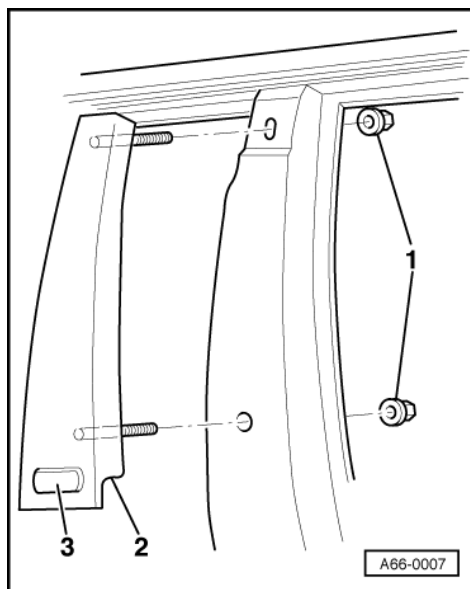


4.2 - Removing and installing A-pillar trim

- -> Press pin of expanding clip -2- approx. 3... 4 mm into last notch.
- Detach expanding clips -2-.
- Detach trim -1- from A-pillar.

3 - Filler piece (two-piece)

4.3 - Removing and installing B-pillar trim



- Removing B-pillar trim:

=> General Body Assembly, Interior; Repair group 70; Trims; Removing and installing B-pillar trim Trims Removing and installing B-pillar trim

- -> Unscrew nuts -1-.
- Detach trim -2-.



Note:

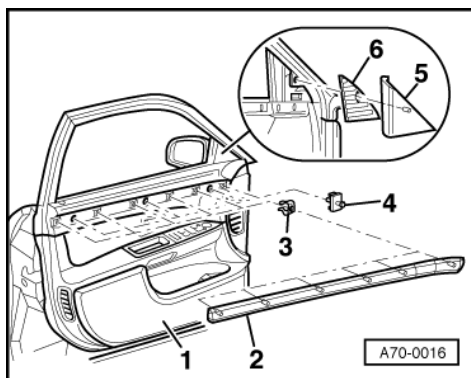
Connector must be detached on vehicles fitted with the optional infrared remote control -3-.

5 - Exterior mirror

5.1 - Exterior mirror

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5.2 - Removing and installing exterior mirror

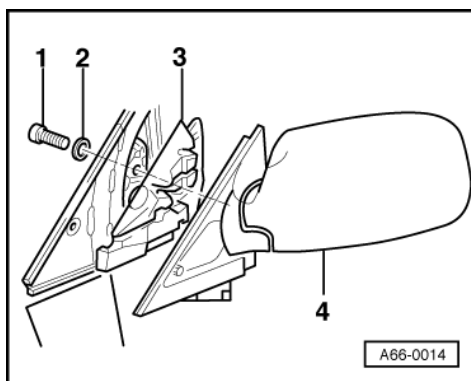


- -> Unclip trim -5- from door subframe.
- Detach seal -6-.
- Wind door window fully down.

Note:

On vehicles with mirror memory, front door trim must be removed before detaching connector.

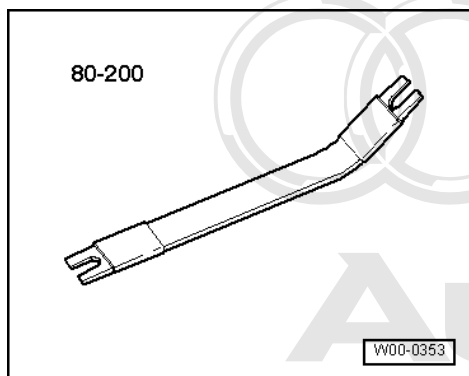
=> General Body Assembly, Interior; Repair group 70; Front door trim; Removing and installing front door trim
Front door trim Removing and installing front door trim



- -> Unscrew bolt -1- together with washer -2- (8 Nm).
- Lift out exterior mirror -4- behind window slot seal and window guide.
- Also lift off seal -3-
- Detach connector.
- When installing, align exterior mirror to window channel.

5.3 - Removing and installing exterior mirror glass

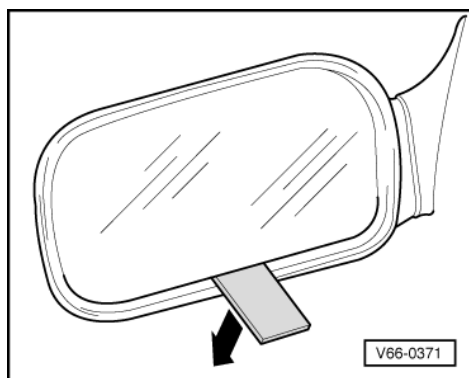
Special tools, testers and auxiliary items required



- ♦ **Special tool 80-200** copyright. Copying for private or commercial purposes, in part or in whole, is not permitted unless authorised by AUDI AG. AUDI AG does not guarantee or accept any liability with respect to the correctness of information in this document. Copyright by AUDI AG.

Removing

- Mask mirror housing.

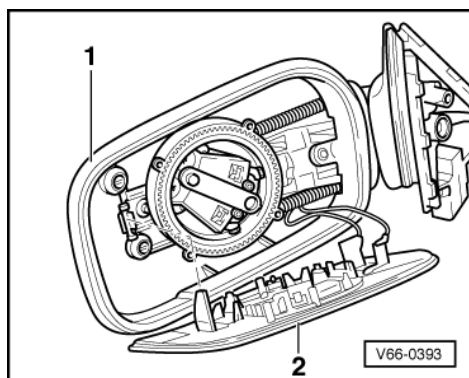


- -> Use special tool 80-200 or thin plastic wedge to carefully lever off mirror glass first at the bottom and then at the top.
- Unplug connectors.

Installing

Important
Always wear protective gloves when installing mirror glass.

- Attach connectors.

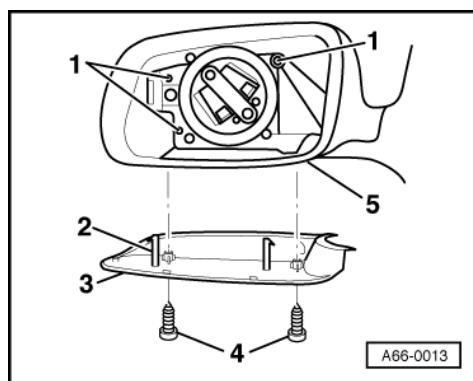


- -> The friction lug on the mirror glass -2- must be inserted into the friction spring in the housing -1- when inserting the mirror glass.
- Press mirror glass into place.

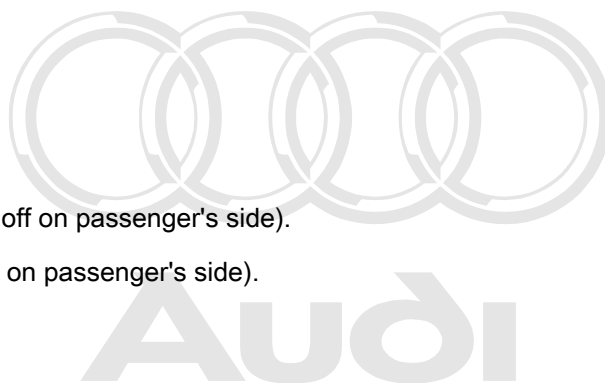
Note:

Only exert pressure in centre of glass.

5.4 - Removing and installing housing for exterior mirror

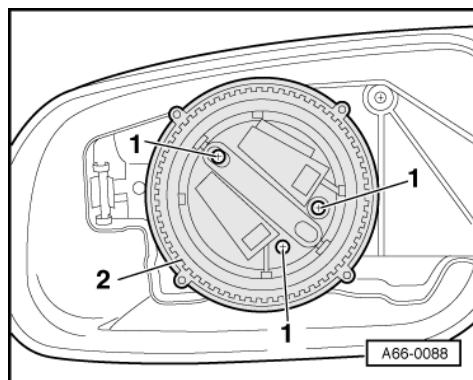


- Removing mirror glass => Page 207 .
- -> Unscrew screws -4- (2 off on driver's side, 1 off on passenger's side).
- Push back lugs -2- and remove cover -3-.
- Unscrew screws -1- (3 off on driver's side, 2 off on passenger's side).
- Lift off housing -5-.



5.5 - Renewing electric adjuster

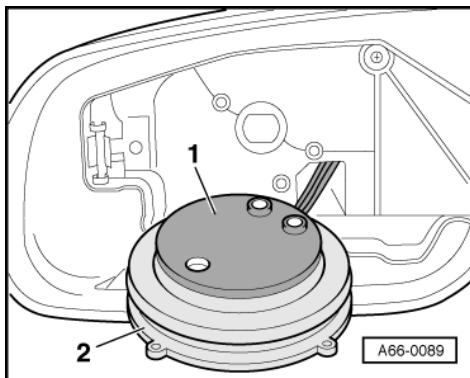
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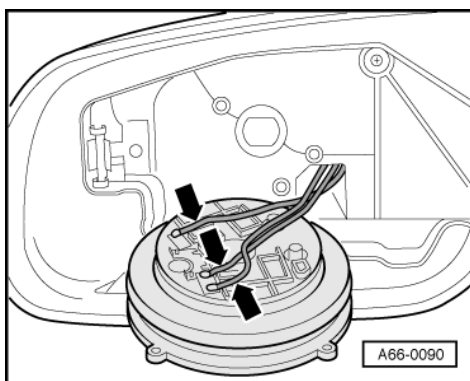
Note:

On vehicles with mirror memory, electric adjuster cannot be renewed separately.

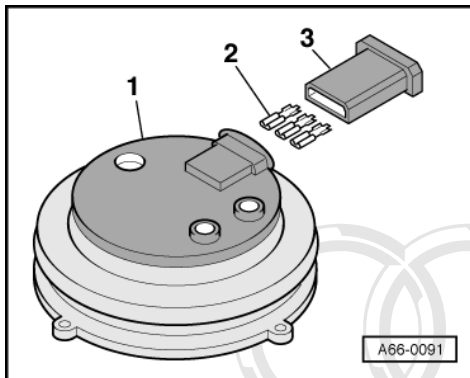
- Switch off ignition.
- Removing mirror glass => Page 207 .
- -> Unscrew 3 bolts -1- (1 Nm).
- Detach electric adjuster -2-.



- -> Detach cover -1- from electric adjuster -2-.



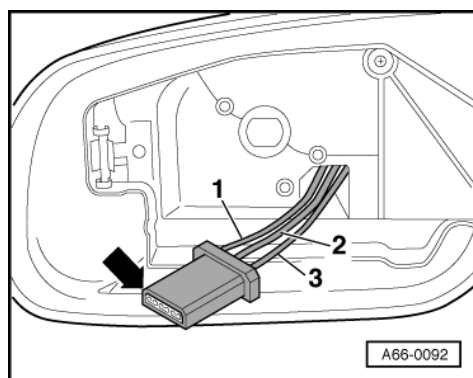
- -> Cut through wires right next to soldered joints -arrows-.



-> Scope of adjuster replacement parts

- 1 - Adjuster
- 2 - Cable connector
- 3 - Connector housing

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- -> Install wires in the connector housing that is enclosed with replacement part.
- Contact 1 - Red wire
- Contact 2 - Brown/white wire
- Contact 3 - White wire

Note:

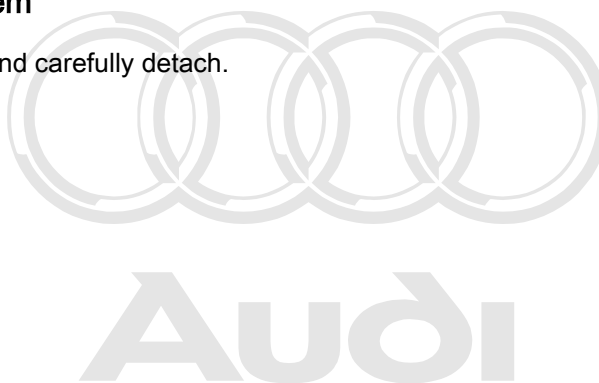
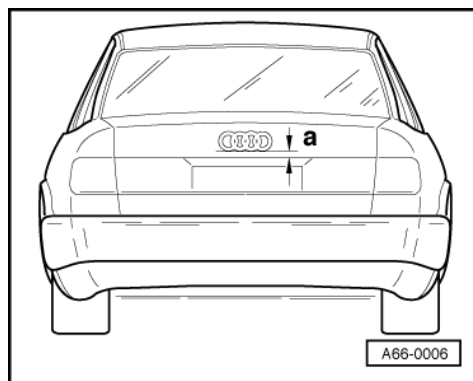
Arrow points towards chamfer on connector housing.

6 - Emblem

6.1 - Emblem

6.2 - Removing and installing Audi emblem

- Heat old emblem slightly with hot-air blower and carefully detach.



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- -> Clean bonding surface on body using a lint-free cloth and white spirit.
- Before gluing, mark dimension a and centre of boot lid.
 - Dimension a = 35 mm
- Heat Audi emblem to approx. 40 °C.
- Pull backing off adhesive surface of Audi emblem.
- Glue the emblem to the centre of boot lid at a distance -a- from edge of boot lid.

7 - Protective foil

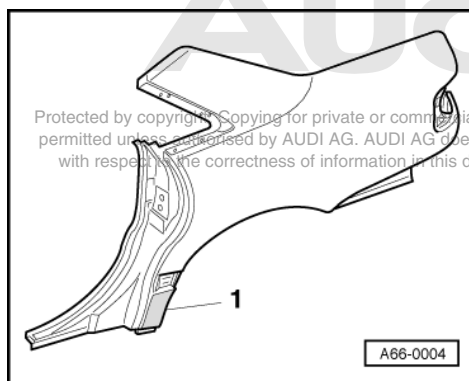
7.1 - Protective foil

7.2 - Bonding protective foil onto side panel

- Pull old protective foil off side panel.

Note:

Before bonding, the temperature of side panel and foil in the area to be glued must be between +20 °C and +60 °C.



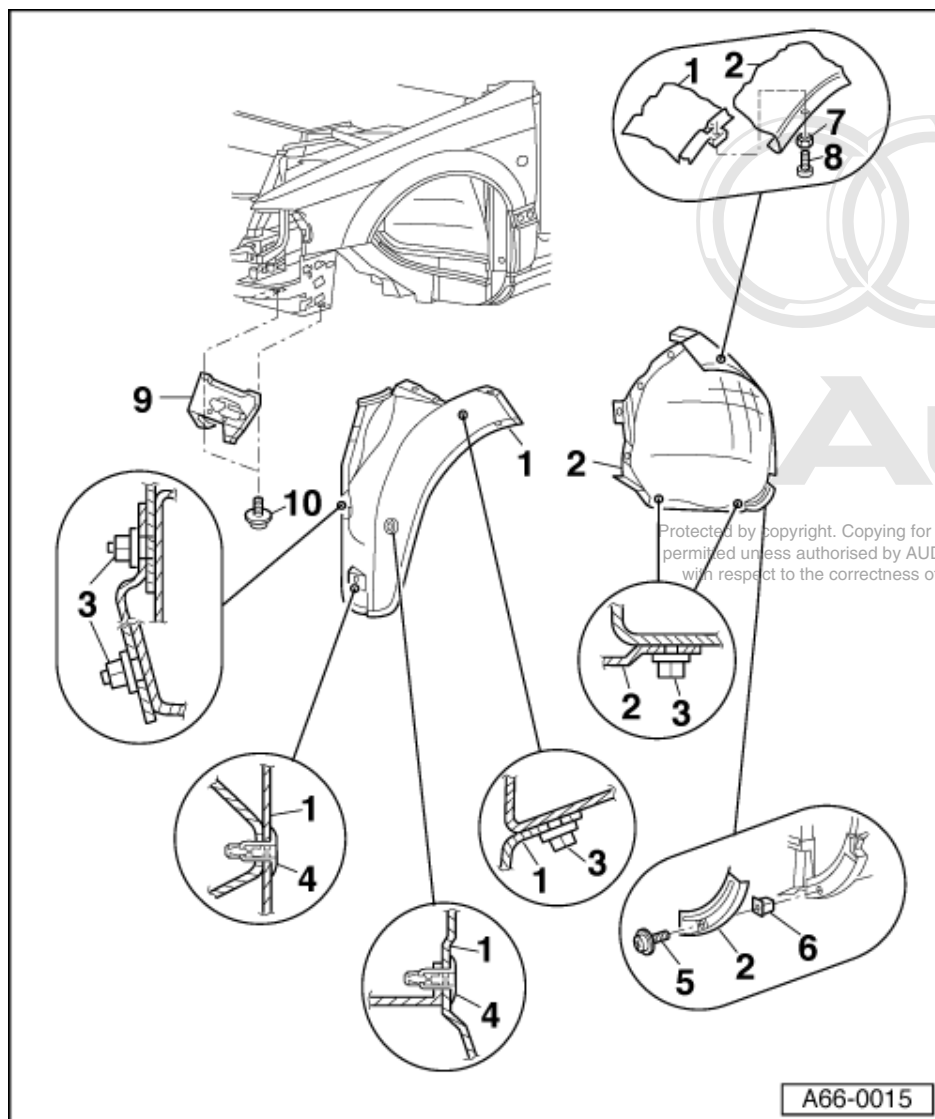
- -> Clean bonding surface on body using a lint-free cloth and white spirit.
- Lubricate bonding surface with a mixture of alcohol and low surface-tension water (1:3).
- Pull off backing paper from adhesive surface of foil.
- Press on the foil starting from the centre towards the edges so that the water film is pressed out from below the foil.
- Make sure that no air bubbles are trapped when pressing on the foil.

Note:

Carefully pierce any air bubbles with a needle and press foil on again.

8 - Wheel housing liners

8.1 - Wheel housing liners



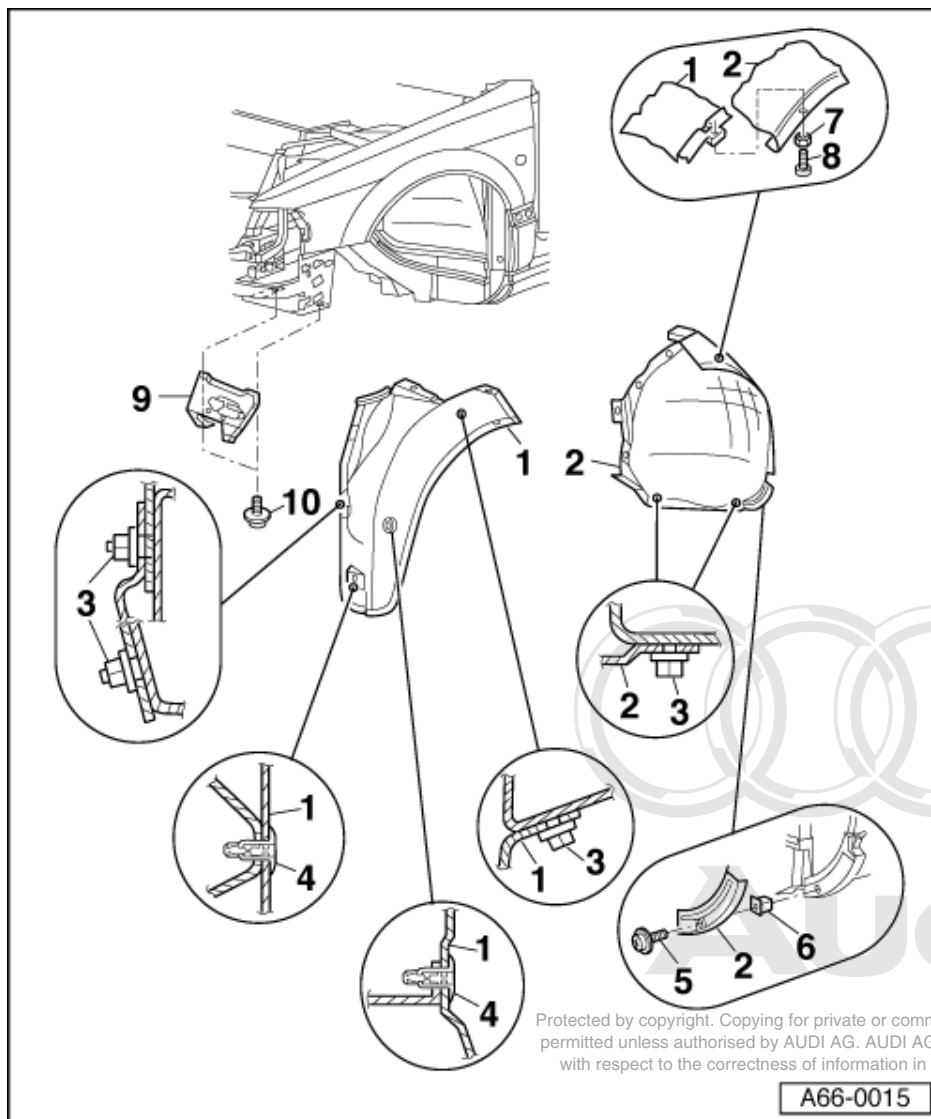
8.2 - Removing and installing front wheel housing liner

1 Front section of wheel-housing liner

- ◆ Removing:
 - Detach front section first to remove entire wheel-housing liner.
 - Unscrew cap nuts -item 3 -, press out pin of split rivet -item 4 -, pull out split rivet and detach front section.

2 Rear section of wheel-housing liner

- ◆ Removing:
 - Remove front section.
 - Unscrew cap nuts -item 3 -, unscrew combi bolts -item 5 - and -item 8 - and detach rear section.

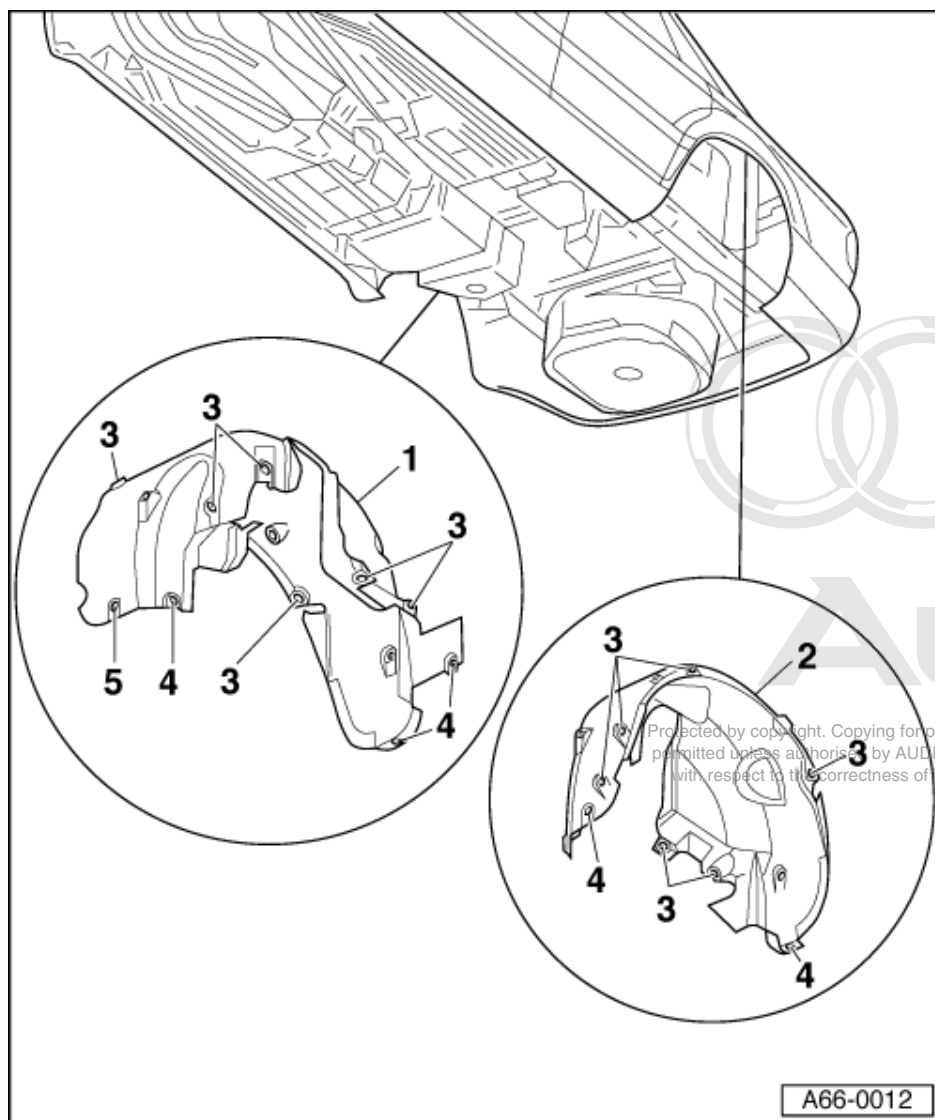


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A66-0015

- 3 Cap nut - 1 Nm
- 4 Split rivet
 - ◆ Press out pin and pull out split rivet
- 5 Combi bolt
- 6 Expanding nut
- 7 Washer
- 8 Bolt
- 9 Mount
 - ◆ For wheel-housing liner
 - ◆ Unscrew combi bolt -item 10 -.
- 10 Combi bolt

8.3 - Removing and installing rear wheel housing liner



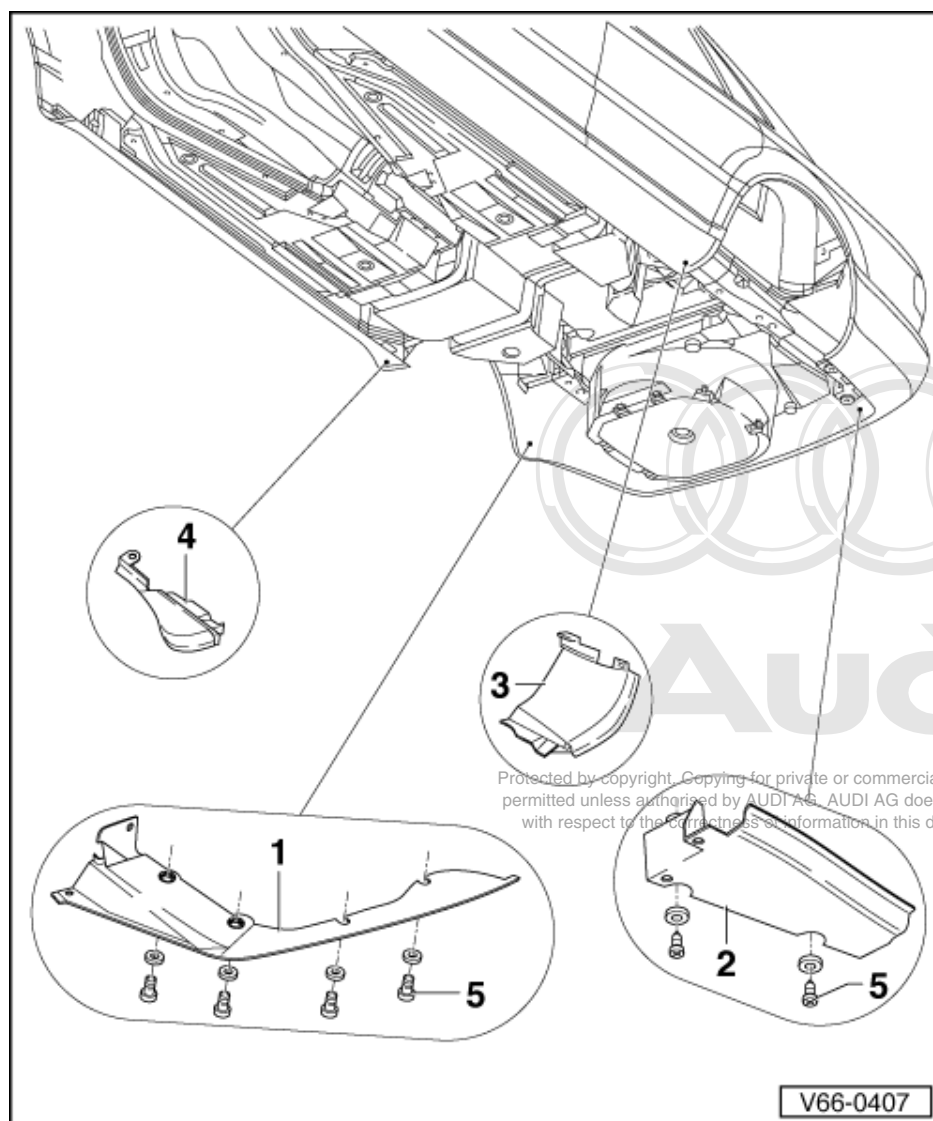
Note:

The fastening elements differ depending on date of manufacture.

- 1 Rear right wheel-housing liner**
 - ♦ To remove, unscrew bolts, unfasten quick-release fastener and unscrew cap nuts.
- 2 Rear left wheel-housing liner**
 - ♦ To remove, unfasten quick-release fastener and unscrew cap nuts.
- 3 Cap nut - 1 Nm**
- 4 Bolt**
- 5 Bolt**

9 - Underbody cover panels

9.1 - Underbody cover panels



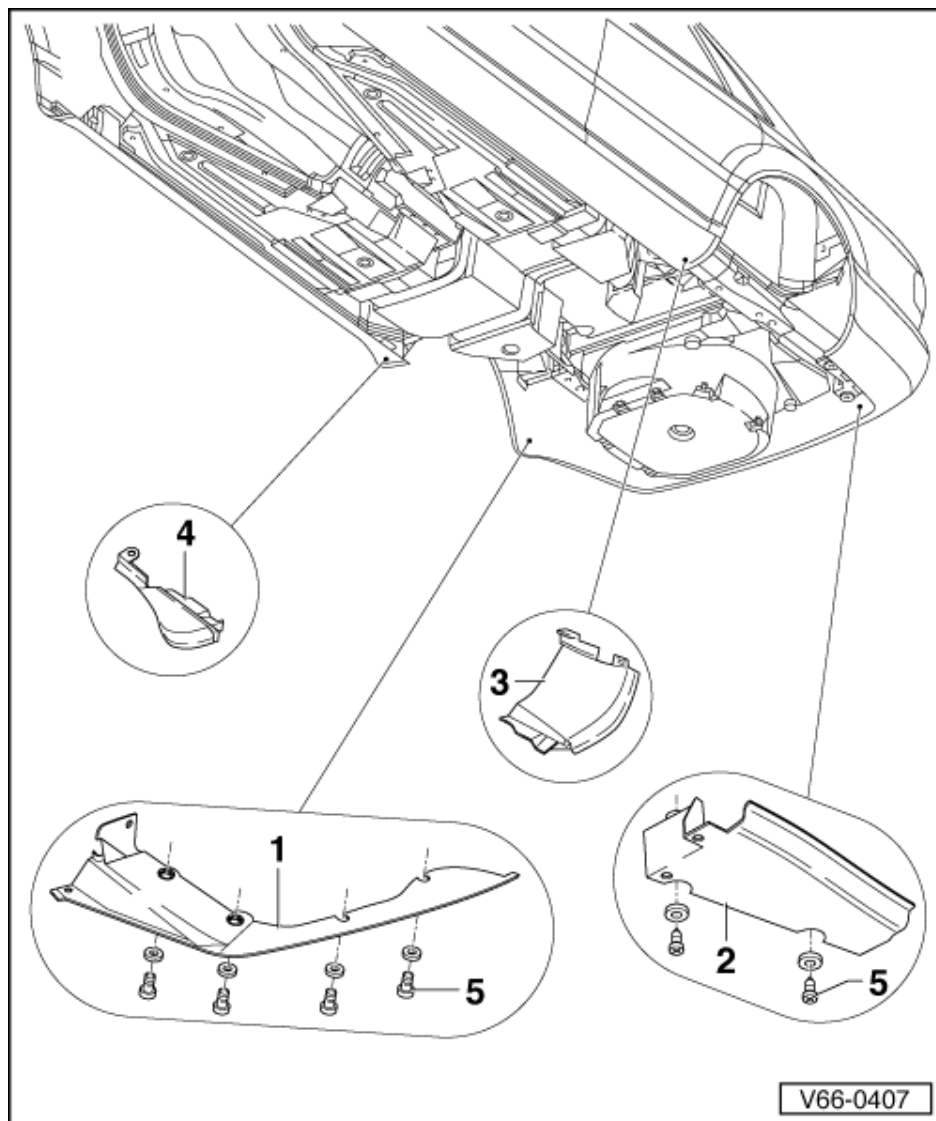
9.2 - Removing and installing cover panel

1 Right cover panel

- ◆ Remove to remove bumper
- ◆ Unscrew bolts -item 5-, remove split rivet and unfasten quick-release fastener at wheel-housing liner

2 Left cover panel

- ◆ Unfasten heat shield at left cover panel and bend aside slightly
- ◆ Unscrew bolts -item 5- and remove split rivet.



3 Left side-member trim

- ♦ Removing:
 - Remove sill panel trim
=>Page 201
 - Remove split rivet and unscrew bolts.

4 Right side-member trim

- ♦ Removing:
 - Remove sill panel trim
=>Page 201
 - Remove split rivet and unscrew bolts.

5 Hexagon bolt - 2 Nm



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