

Contents

00 - Technical data	1
1 Safety briefing/employee qualification	1
1.1 Qualification	1
2 Safety precautions	2
2.1 Safety precautions	2
2.2 Work that requires high-voltage system to be de-energised	4
2.3 Safety precautions when working on the high-voltage system	5
2.4 Safety precautions when working in the vicinity of high-voltage components	6
2.5 Safety precautions when working on the cooling system	6
2.6 Safety precautions when using testers and measuring instruments during a road test	6
3 Repair instructions	8
3.1 Important notes	8
3.2 Information on handling fine dust, aluminium dust and steel dust	8
3.3 Routing and attachment of pipes, hoses and wiring	9
3.4 Contact corrosion	9
3.5 Bonding surfaces for adhesive strips	10
3.6 Self-locking bolts	10
3.7 Identification plates	10
3.8 Impact wrenches	10
3.9 Moulded foam inserts	11
3.10 Bonded joints	13
3.11 Galvanised body panels, high-strength and extra-high-strength steel	14
3.12 Matching the surface contour	18
3.13 Laser welding	19
3.14 Renewing studs	19
4 Vehicle identification data	22
4.1 Type plate and vehicle identification number	22
4.2 Vehicle data sticker	22
5 Extraction systems for steel/aluminium body repair station ("multi-material-mix" workplace)	23
6 Overview of riveting attachments (pairs of tools)	25
7 Overview of rivets and tools	26
7.1 Overview of rivets used for repair measures	30
8 Body dimensions	33
8.1 Body - front	33
9 Processing body structure adhesive D 180 004 M2	39
9.1 Preparing bonding surfaces	40
10 Tools	54
11 Straightening jig	58
11.1 Procedure for repairing structural body damage on Audi vehicles	58
50 - Body - front	59
1 Safety precautions	59
2 Impact damper mounting - Renewal	60
2.1 Tools	60
2.2 Procedure	61
3 Upper wheel housing longitudinal member - Partial renewal	64
3.1 Tools	64
3.2 Procedure	65
4 Upper wheel housing longitudinal member - Renewal	72
4.1 Tools	72



4.2	Procedure	73
5	Front longitudinal member - Partial renewal	82
5.1	Tools	82
5.2	Procedure	83
6	Front longitudinal member with suspension turret - Renewal	88
6.1	Tools	88
6.2	Procedure	89
7	Front longitudinal member - Renewal	98
7.1	Tools	98
7.2	Procedure	99
8	Upper footwell cross member - Renewal	107
8.1	Tools	107
8.2	Procedure	108
9	Repairing threads for attachment of subframe	112
9.1	Tools	112
51 - Body - centre		119
1	Safety precautions	119
2	Permitted separating cuts on complete side panel	120
3	Roof - Renewal	122
3.1	Tools	122
3.2	Procedure	123
3.3	Roof - Renewal (vehicles with panoramic tilting sunroof)	141
4	Carbon roof - Renewal (RS 5)	162
4.1	Tools	162
4.2	Procedure	163
4.3	Preparing body flange for installation	167
4.4	Installing roof	167
5	Roof side member - Renewal (Sportback)	171
5.1	Tools	171
5.2	Procedure	172
6	Roof side member - Renewal (Coupé)	178
7	Tools	179
8	Procedure	180
9	Roof cross member (front) - Renewal	186
9.1	Tools	186
9.2	Procedure	187
10	Rear roof cross member - Renewal (Sportback)	190
10.1	Tools	190
10.2	Procedure	191
11	Outer A-pillar - Renewal	196
11.1	Tools	196
11.2	Procedure	197
12	Inner A-pillar - Renewal	202
12.1	Tools	202
12.2	Procedure	203
13	Upper inner A-pillar - Partial renewal	208
13.1	Tools	208
13.2	Procedure	209
14	Outer B-pillar - Renewal (Sportback)	218
14.1	Tools	218
14.2	Procedure	219

15	Inner B-pillar - Partial renewal (Coupé)	224
15.1	Tools	224
15.2	Procedure	225
16	Inner B-pillar - Partial renewal (Sportback)	237
16.1	Tools	237
16.2	Procedure	238
17	Outer side member - Renewal (Coupé)	253
17.1	Tools	253
17.2	Procedure	254
18	Outer side member - Renewal (Sportback)	258
18.1	Tools	258
18.2	Procedure	259
19	Inner side member - Renewal (Coupé)	263
19.1	Tools	263
19.2	Procedure	264
20	Inner side member - Renewal (Sportback)	272
20.1	Tools	272
20.2	Procedure	273
21	Front seat cross member - Renewal	281
21.1	Tools	281
21.2	Procedure	282
22	Rear seat cross member - Renewal	286
22.1	Tools	286
22.2	Procedure	287
23	Centre tunnel - Renewal	292
23.1	Tools	292
23.2	Procedure	293
53 - Body - rear		299
1	Safety precautions	299
2	Permitted separating cuts on complete side panel	300
3	Cross panel - Renewal	302
3.1	Tools	303
3.2	Procedure	304
4	Lock carrier - Renewal	308
4.1	Tools	309
4.2	Procedure	309
5	Lock carrier - Renewal (Sportback)	314
5.1	Tools	315
5.2	Procedure	315
6	Tail light mounting - Renewal	320
6.1	Tools	321
6.2	Procedure	321
7	Rear longitudinal member - Renewal	326
7.1	Tools	327
7.2	Procedure	327
8	Side panel - Renewal (Coupé)	336
8.1	Tools	337
8.2	Procedure	338
9	Side panel - Renewal (Sportback)	345
9.1	Tools	346
9.2	Procedure	346



10	C-pillar reinforcement - Renewal (Coupé)	354
10.1	Tools	354
10.2	Procedure	355
11	C-pillar reinforcement - Renewal (Sportback)	359
11.1	Tools	359
11.2	Procedure	360
12	Rear wheel housing - Renewal	365
12.1	Tools	366
12.2	Procedure	366
13	Inner rear wheel housing - Renewal	372
13.1	Tools	373
13.2	Procedure	373
14	Spare wheel well - Renewal	380
14.1	Tools	381
14.2	Procedure	381
15	Luggage compartment floor - Renewal (only for vehicles with natural gas technology) ..	387
15.1	Tools	388
15.2	Procedure	388
16	Cross member for spare wheel well - Renewal	393
16.1	Tools	393
16.2	Procedure	394