

Contents

00 - Materials	1
1 Qualification	1
2 Safety information	2
2.1 Safety information	2
2.2 Safety precautions when working on the cooling system	4
2.3 Safety precautions when using testers and measuring instruments during a road test	4
3 Repair instructions	5
3.1 Important notes	5
3.2 General notes	5
3.3 Information on handling fine dust, aluminium dust and steel dust	6
3.4 Routing and attachment of pipes, hoses and wiring	6
3.5 Contact corrosion	7
3.6 Bonding surfaces for self-adhesive components	7
3.7 Secure threaded connections	7
3.8 Identification plates	7
3.9 Impact wrenches	7
3.10 Matching the surface contour	8
4 Using edge milling unit -VAS 882 005-	10
4.1 General information	10
4.2 Assembling unit/changing milling tool	13
4.3 Separating flanged edges	23
4.4 Separating panels at corners and along surfaces	29
4.5 Separating outer edges	32
4.6 Renewing roof	35
4.7 Separating laser weld seams using round head milling unit	37
4.8 Aluminium panels	39
5 Processing body structure adhesive D 180 004 M2	42
5.1 Preparing bonding surfaces	43
6 Tools	57
50 - Body - front	62
1 Safety information	62
2 Renewing support	63
2.1 Procedure	63
3 Renewing intermediate piece - part section	65
3.1 Procedure	65
4 Renewing front longitudinal member	68
4.1 Procedure	68
5 Renewing front longitudinal member - part section	71
5.1 Procedure	71
6 Renewing front longitudinal member (A6 V8)	73
6.1 Procedure	73
7 Renewing front longitudinal member - part section (A6 V8)	76
7.1 Procedure	76
51 - Body - centre	78
1 Safety information	78
2 Renewing roof	79
2.1 Procedure	79
3 Renewing roof - Avant	83
3.1 Procedure	83



4	Renewing roof side member	88
4.1	Procedure	88
5	Renewing roof side member - Avant	92
5.1	Procedure	92
6	Renewing rear roof frame - Avant	96
6.1	Procedure	96
7	Renewing roof side member reinforcement	98
7.1	Procedure	98
8	Renewing front roof cross member	100
8.1	Procedure	100
9	Renewing rear roof cross member	102
9.1	Procedure	102
10	Renewing A-pillar	104
10.1	Procedure	104
11	Renewing B-pillar	107
11.1	Procedure	107
12	Renewing inner B-pillar	109
12.1	Procedure	109
13	Renewing inner B-pillar	111
13.1	Procedure	111
14	Renewing outer side member	113
14.1	Procedure	113
15	Renewing inner side member	117
15.1	Procedure	117
16	Renewing plenum chamber	120
16.1	Procedure	120
17	Renewing floor panel - part section	122
17.1	Cutting locations	122
53 - Body - rear		125
1	Safety information	125
2	Renewing rear upper cross panel	126
2.1	Procedure	126
3	Renewing rear upper cross panel - Avant	128
3.1	Procedure	128
4	Renewing inner cross panel	130
4.1	Procedure	130
5	Renewing inner cross panel - Avant	132
5.1	Procedure	132
6	Renewing lower cross panel	134
6.1	Procedure	134
7	Renewing tail light mounting	136
7.1	Procedure	136
8	Renewing rear mounting panel - partial renewal (Avant models)	139
8.1	Cutting locations	139
9	Renewing luggage compartment floor - part section	142
9.1	Procedure	142
10	Renewing rear longitudinal member	144
10.1	Procedure	144
11	Renewing rear longitudinal member - part section	147
11.1	Procedure	147

12	Renewing side panel	150
12.1	Procedure	150
13	Renewing side panel - Avant	154
13.1	Procedure	154
14	Renewing rear wheel housing	158
14.1	Procedure	158
15	Renewing rear wheel housing liner	160
15.1	Procedure	160
16	Renewing rear wheel housing liner - part section	162
16.1	Procedure	162