

## Contents

|   |           |
|---|-----------|
| <b>00 - Technical data</b> .....  | <b>1</b>  |
| <b>1 Safety briefing/employee qualification</b> .....   | <b>1</b>  |
| 1.1 Qualification .....   | 1         |
| <b>2 Safety precautions</b> .....   | <b>2</b>  |
| 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 .....  | 4         |
| 2.4 Safety precautions when working in the vicinity of high-voltage components .....                          | 5         |
| 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         |
| <b>3 Repair instructions</b> .....  | <b>7</b>  |
| 3.1 Important notes .....   | 7         |
| 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 .....  | 9         |
| 3.6 Self-locking bolts .....  | 9         |
| 3.7 Identification plates .....   | 9         |
| 3.8 Impact wrenches .....   | 10        |
| 3.9 Moulded foam inserts .....  | 10        |
| 3.10 Bonded joints .....  | 13        |
| 3.11 Galvanised body panels, high-strength and extra-high-strength steel .....                                | 14        |
| 3.12 Matching the surface contour .....   | 21        |
| 3.13 Dent removal .....   | 22        |
| 3.14 Straightening and re-alignment of body parts .....   | 23        |
| 3.15 Corrosion protection .....   | 23        |
| 3.16 Thread repair for M6 pop rivet nut .....   | 26        |
| 3.17 Renewing studs .....   | 26        |
| 3.18 Repairing thread for seat belt anchorage .....   | 27        |
| <b>4 Vehicle identification data</b> .....  | <b>29</b> |
| 4.1 Vehicle identification number .....   | 29        |
| 4.2 Type plate .....  | 30        |
| 4.3 Vehicle data sticker .....  | 30        |
| <b>5 Extraction systems for steel/aluminium body repair station ("multi-material-mix" workplace)</b><br>..... | <b>31</b> |
| <b>6 Using edge milling unit -VAS 882 005-</b> .....  | <b>33</b> |
| 6.1 General information .....   | 33        |
| 6.2 Assembling unit/changing milling tool .....   | 36        |
| 6.3 Separating flanged edges .....  | 46        |
| 6.4 Separating panels at corners and along surfaces .....   | 52        |
| 6.5 Separating outer edges .....  | 55        |
| 6.6 Roof - Renewal .....  | 58        |
| 6.7 Separating laser weld seams using round head milling unit .....   | 60        |
| 6.8 Aluminium panels .....  | 62        |
| <b>7 Processing body structure adhesive D 180 004 M2</b> .....  | <b>65</b> |
| 7.1 Preparing bonding surfaces .....  | 66        |
| <b>8 Overview of rivets and tools</b> .....   | <b>80</b> |
| 8.1 Overview of rivets used for repair measures .....   | 85        |
| <b>9 Overview of riveting attachments (pairs of tools)</b> .....  | <b>86</b> |
| <b>10 Body dimensions</b> .....   | <b>87</b> |
| 10.1 Body - front .....   | 87        |



|                           |  |            |
|---------------------------|--|------------|
| 10.2                      | Body - centre  | 89         |
| 10.3                      | Floor group  | 95         |
| 10.4                      | Body - rear  | 97         |
| 10.5                      | Body - rear (Avant)  | 99         |
| <b>11</b>                 | <b>Tools</b>   | <b>102</b> |
| <b>12</b>                 | <b>Straightening jig</b>   | <b>107</b> |
| 12.1                      | Procedure for repairing structural body damage on Audi vehicles          | 107        |
| <b>50 - Body - front</b>  |  | <b>109</b> |
| <b>1</b>                  | <b>Safety precautions</b>  | <b>109</b> |
| <b>2</b>                  | <b>Intermediate piece - Renewal</b>                                      | <b>110</b> |
| 2.1                       | Tools  | 110        |
| 2.2                       | Procedure  | 111        |
| <b>3</b>                  | <b>Front bumper bracket - Renewal</b>                                    | <b>116</b> |
| 3.1                       | Tools  | 116        |
| 3.2                       | Procedure  | 117        |
| <b>4</b>                  | <b>Wing mounting flange - Renewal</b>                                    | <b>119</b> |
| 4.1                       | Tools  | 120        |
| 4.2                       | Procedure  | 120        |
| <b>5</b>                  | <b>Suspension turret - Renewal</b>                                       | <b>129</b> |
| 5.1                       | Tools  | 129        |
| 5.2                       | Procedure  | 130        |
| <b>6</b>                  | <b>Front longitudinal member - Renewal</b>                               | <b>141</b> |
| 6.1                       | Tools  | 142        |
| 6.2                       | Procedure  | 143        |
| <b>7</b>                  | <b>Front longitudinal member - Partial renewal (part sections 1 + 2)</b> | <b>157</b> |
| 7.1                       | Tools  | 157        |
| 7.2                       | Procedure  | 158        |
| <b>8</b>                  | <b>Repairing threads for attachment of subframe</b>                      | <b>169</b> |
| 8.1                       | Tools  | 169        |
| <b>51 - Body - centre</b> |  | <b>177</b> |
| <b>1</b>                  | <b>Safety precautions</b>  | <b>177</b> |
| <b>2</b>                  | <b>Permitted separating cuts on complete side panel</b>                  | <b>178</b> |
| <b>3</b>                  | <b>Roof - Renewal (Saloon)</b>   | <b>180</b> |
| 3.1                       | Tools  | 180        |
| 3.2                       | Procedure  | 186        |
| <b>4</b>                  | <b>Roof - Renewal (Saloon with tilting sunroof)</b>                      | <b>200</b> |
| 4.1                       | Tools  | 200        |
| 4.2                       | Procedure  | 202        |
| <b>5</b>                  | <b>Roof - Renewal (Saloon with large sunroof, long version)</b>          | <b>215</b> |
| 5.1                       | Tools  | 215        |
| 5.2                       | Procedure  | 216        |
| <b>6</b>                  | <b>Roof - Renewal (Avant)</b>  | <b>227</b> |
| 6.1                       | Tools  | 227        |
| 6.2                       | Procedure  | 233        |
| <b>7</b>                  | <b>Roof - Renewal (Avant with large sunroof)</b>                         | <b>248</b> |
| 7.1                       | Tools  | 248        |
| 7.2                       | Procedure  | 249        |
| <b>8</b>                  | <b>Roof side member - Renewal (Saloon)</b>                               | <b>261</b> |
| 8.1                       | Tools  | 261        |
| 8.2                       | Procedure  | 262        |
| <b>9</b>                  | <b>Roof side member - Renewal (Avant)</b>                                | <b>268</b> |

|                               |  |            |
|-------------------------------|--|------------|
| 9.1                           | Tools .....  | 268        |
| 9.2                           | Procedure .....  | 269        |
| <b>10</b>                     | <b>Roof cross member (front) - Renewal .....</b>       | <b>275</b> |
| 10.1                          | Tools .....  | 275        |
| 10.2                          | Procedure .....  | 276        |
| <b>11</b>                     | <b>Roof cross member (rear) - Renewal .....</b>        | <b>279</b> |
| 11.1                          | Tools .....  | 279        |
| 11.2                          | Procedure .....  | 280        |
| <b>12</b>                     | <b>Rear roof cross member - Renewal (Avant) .....</b>  | <b>283</b> |
| 12.1                          | Tools .....  | 283        |
| 12.2                          | Procedure .....  | 284        |
| <b>13</b>                     | <b>Inner rear roof frame - Renewal (Avant) .....</b>   | <b>287</b> |
| 13.1                          | Tools .....  | 287        |
| 13.2                          | Procedure .....  | 288        |
| <b>14</b>                     | <b>Hinge mounting - Renewal .....</b>                  | <b>293</b> |
| 14.1                          | Tools .....  | 293        |
| 14.2                          | Procedure .....  | 294        |
| <b>15</b>                     | <b>Outer A-pillar - Renewal .....</b>                  | <b>298</b> |
| 15.1                          | Tools .....  | 298        |
| 15.2                          | Procedure .....  | 299        |
| <b>16</b>                     | <b>Upper inner A-pillar - Partial renewal .....</b>    | <b>305</b> |
| 16.1                          | Tools .....  | 305        |
| 16.2                          | Procedure .....  | 306        |
| <b>17</b>                     | <b>Lower inner A-pillar - Partial renewal .....</b>    | <b>317</b> |
| 17.1                          | Tools .....  | 317        |
| 17.2                          | Procedure .....  | 318        |
| <b>18</b>                     | <b>Outer B-pillar - Renewal .....</b>                  | <b>322</b> |
| 18.1                          | Tools .....  | 322        |
| 18.2                          | Procedure .....  | 323        |
| <b>19</b>                     | <b>Inner B-pillar - Renewal .....</b>                  | <b>328</b> |
| 19.1                          | Tools .....  | 329        |
| 19.2                          | Procedure .....  | 329        |
| <b>20</b>                     | <b>Outer side member - Renewal .....</b>               | <b>339</b> |
| 20.1                          | Tools .....  | 339        |
| 20.2                          | Procedure .....  | 340        |
| <b>21</b>                     | <b>Inner side member - Renewal .....</b>               | <b>345</b> |
| 21.1                          | Tools .....  | 345        |
| 21.2                          | Procedure .....  | 345        |
| <b>22</b>                     | <b>Inner side member - Renewal (Avant) .....</b>       | <b>351</b> |
| 22.1                          | Tools .....  | 351        |
| 22.2                          | Procedure .....  | 351        |
| <b>23</b>                     | <b>Inner side member reinforcement - Renewal .....</b> | <b>357</b> |
| 23.1                          | Tools .....  | 357        |
| 23.2                          | Procedure .....  | 358        |
| <b>24</b>                     | <b>Centre seat cross member - Renewal .....</b>        | <b>363</b> |
| 24.1                          | Tools .....  | 363        |
| 24.2                          | Procedure .....  | 364        |
| <b>25</b>                     | <b>Seat cross member - Renewal .....</b>               | <b>370</b> |
| 25.1                          | Tools .....  | 370        |
| 25.2                          | Procedure .....  | 371        |
| <b>53 - Body - rear .....</b> |  | <b>375</b> |
| 1                             | Safety precautions .....                               | 375        |



|           |  |            |
|-----------|--|------------|
| <b>2</b>  | <b>Permitted separating cuts on complete side panel</b>                    | <b>376</b> |
| <b>3</b>  | <b>Rear upper cross panel - Renewal</b>                                    | <b>378</b> |
| 3.1       | Tools  | 378        |
| 3.2       | Procedure  | 379        |
| <b>4</b>  | <b>Rear cross panel - Renewal</b>  | <b>382</b> |
| 4.1       | Tools  | 382        |
| 4.2       | Procedure  | 383        |
| <b>5</b>  | <b>Rear cross panel - Renewal (Avant)</b>                                  | <b>386</b> |
| 5.1       | Tools  | 386        |
| 5.2       | Procedure  | 387        |
| <b>6</b>  | <b>Cross panel - Renewal (Avant)</b>                                       | <b>390</b> |
| 6.1       | Tools  | 390        |
| 6.2       | Procedure  | 390        |
| <b>7</b>  | <b>Rear longitudinal member - Partial renewal (Avant)</b>                  | <b>394</b> |
| 7.1       | Tools  | 394        |
| 7.2       | Procedure  | 395        |
| <b>8</b>  | <b>Rear longitudinal member - Partial renewal</b>                          | <b>401</b> |
| 8.1       | Tools  | 401        |
| 8.2       | Procedure  | 402        |
| <b>9</b>  | <b>Side panel - Renewal</b>  | <b>408</b> |
| 9.1       | Tools  | 408        |
| 9.2       | Procedure  | 409        |
| <b>10</b> | <b>Side panel - Renewal (Avant)</b>  | <b>416</b> |
| 10.1      | Tools  | 416        |
| 10.2      | Procedure  | 417        |
| <b>11</b> | <b>C-pillar reinforcement - Renewal (Saloon and Avant identical)</b>       | <b>424</b> |
| 11.1      | Tools  | 425        |
| 11.2      | Procedure  | 426        |
| <b>12</b> | <b>Rear wheel housing - Partial renewal</b>                                | <b>432</b> |
| 12.1      | Tools  | 432        |
| 12.2      | Procedure  | 433        |
| <b>13</b> | <b>Rear wheel housing - Partial renewal (Avant)</b>                        | <b>437</b> |
| 13.1      | Tools  | 437        |
| 13.2      | Procedure  | 438        |
| <b>14</b> | <b>Luggage compartment floor - Renewal</b>                                 | <b>442</b> |
| 14.1      | Tools  | 442        |
| 14.2      | Procedure  | 443        |
| <b>15</b> | <b>Luggage compartment floor - Renewal (only for PHEV vehicles, China)</b> | <b>447</b> |
| 15.1      | Tools  | 447        |
| 15.2      | Procedure  | 448        |