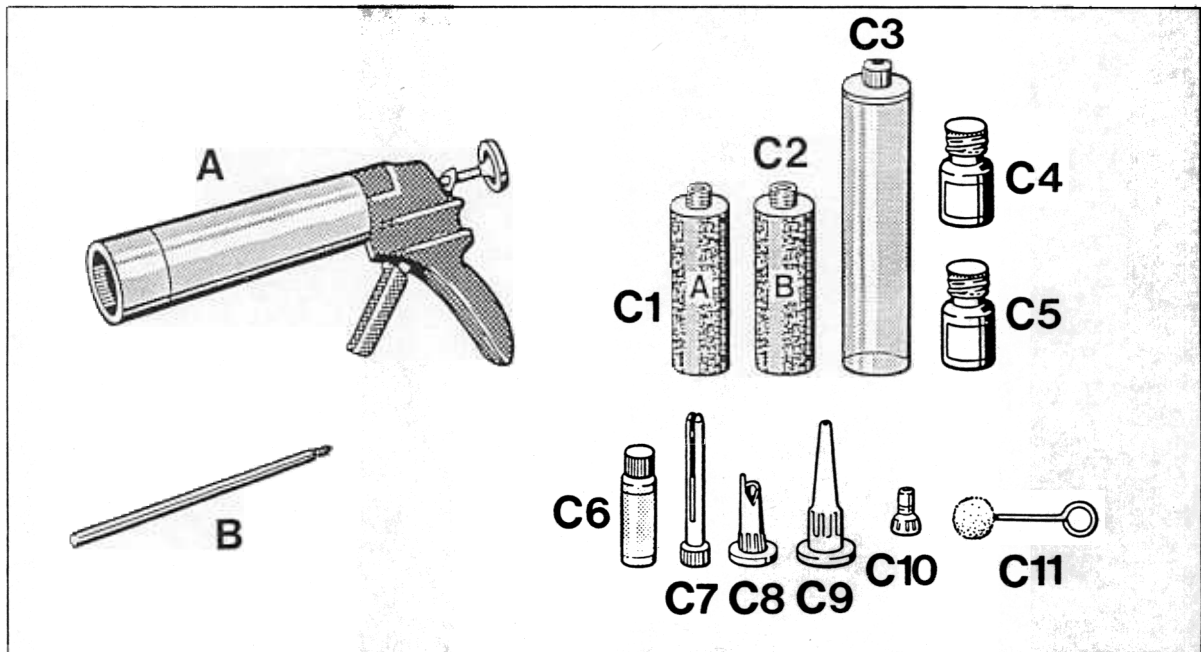


66 58 55 Replacing rear spoiler

The rear spoiler (outer rear spoiler section) must be painted prior to fitting!

When replacing the rear spoiler, paint the rear spoiler outer section in body color and bond it to the spoiler grille.

The following materials and tools are required for bonding the rear spoiler outer section to the spoiler grille:



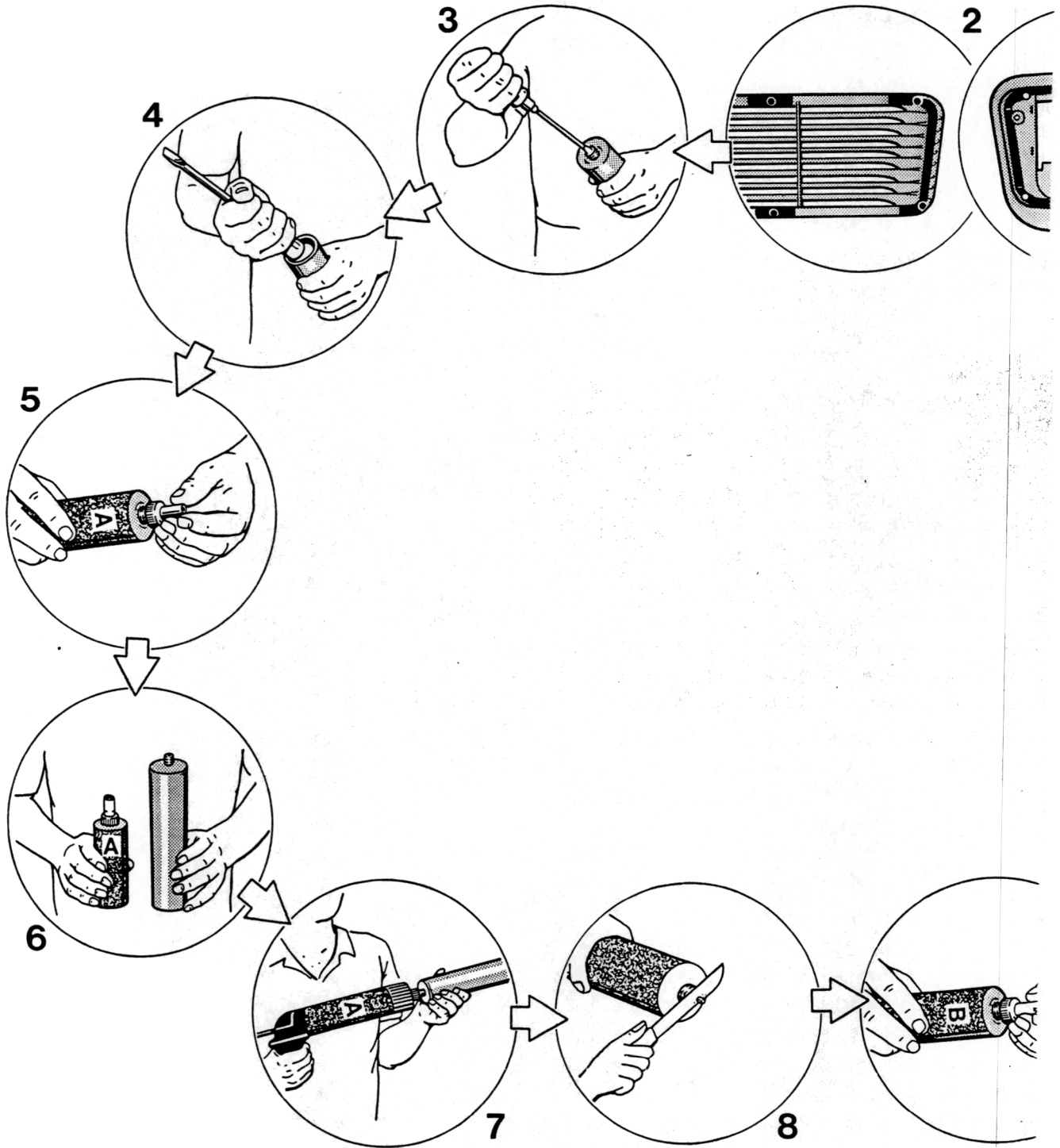
A	Bonding gun	VAG 1628	e.g. VW Werk AG KD-Gerätevertrieb
B	Mixing rod 9528	000.721.952.80	Porsche Part dept.
C	Bonding set	999.915.509.40	

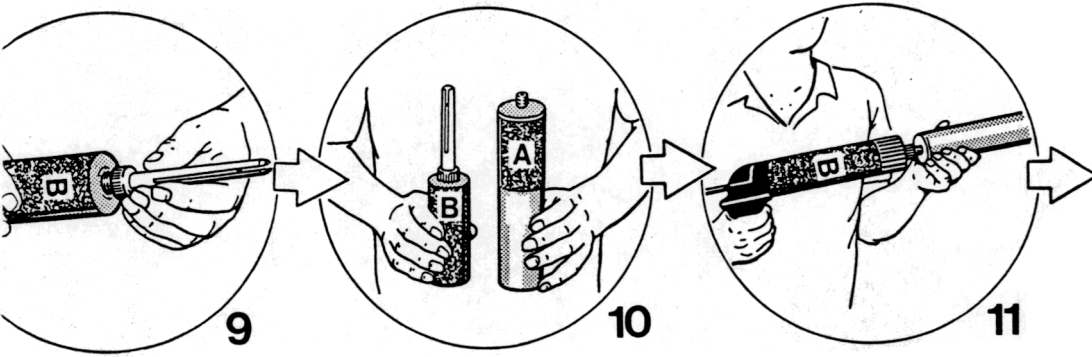
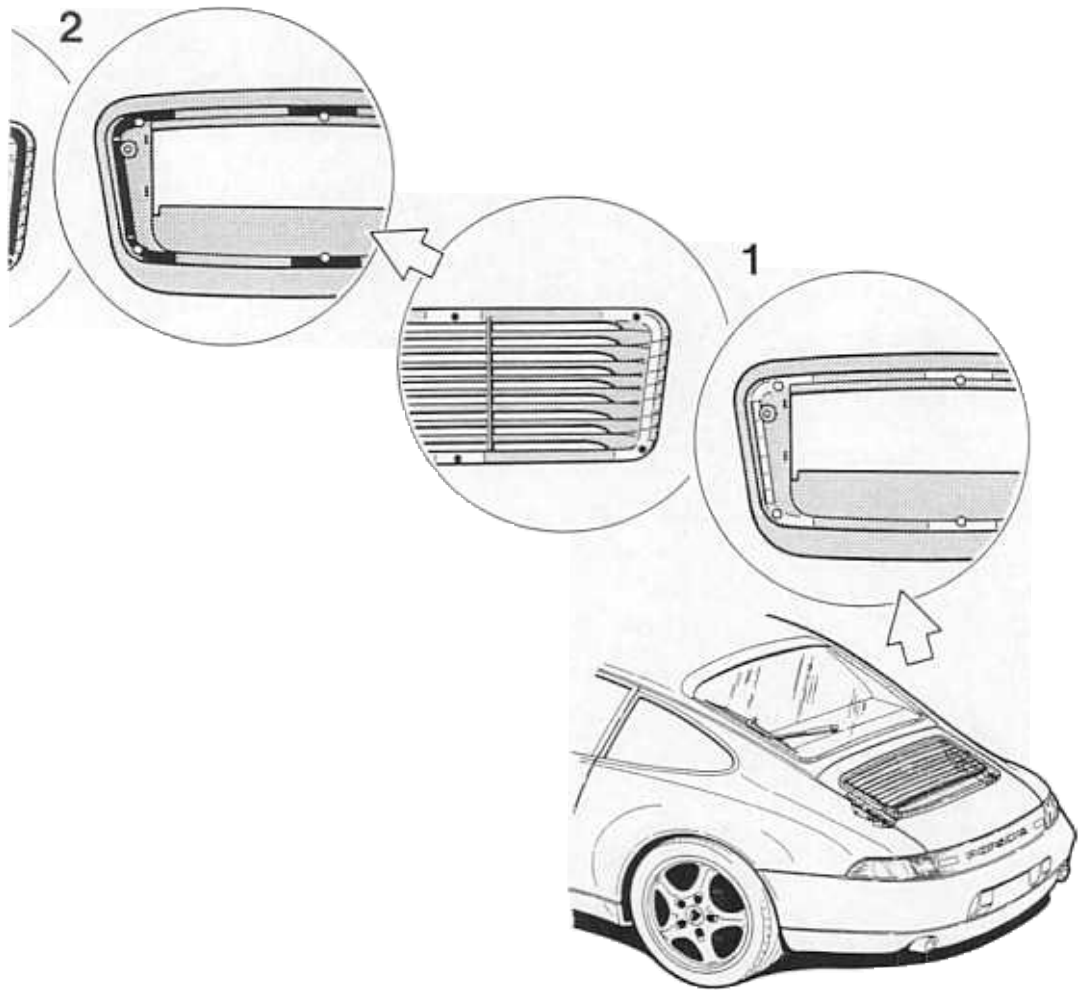
Bonding set contents:

C 1 = Cartridge component A
 C 2 = Cartridge component B
 C 3 = Mixing cartridge
 C 4 = Primer
 C 5 = Activator
 C 6 = Cleaning solution

C 7 = Injector nozzle
 C 8 = Application nozzle
 C 9 = Application nozzle
 C 10 = Filling nozzle
 C 11 = Touch-in tool

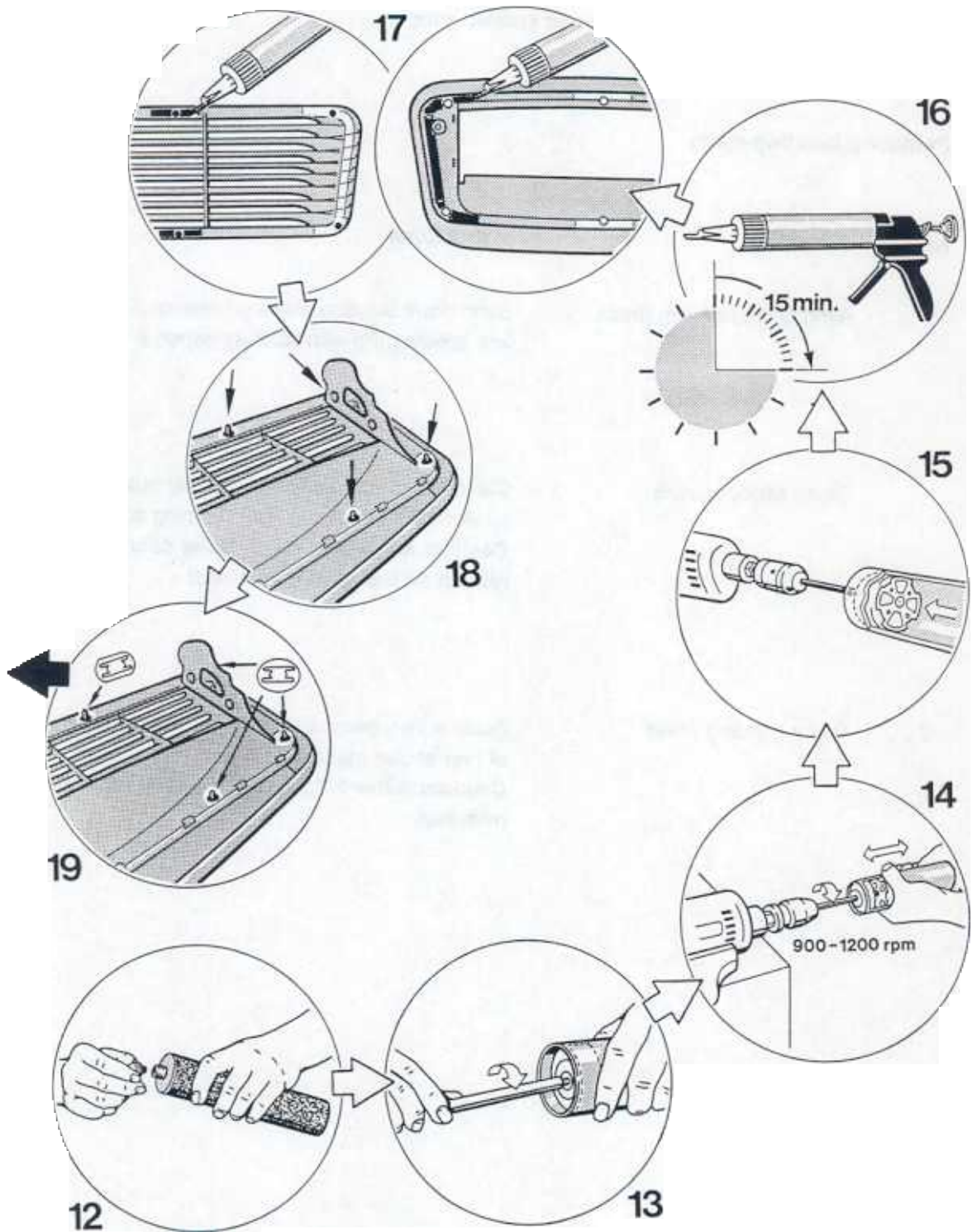
66 58 55 Replacing rear spoiler





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66 58 55 Replacing rear spoiler



66 58 55 Replacing rear spoiler

The rear spoiler (outer rear spoiler section) must be painted prior to fitting!

Bonding rear spoiler outer section and spoiler grille

Preparing bonding areas

No.	Operation	Instructions
1	Sand down bonding areas	Sand down bonding areas on rear spoiler outer section and spoiler grille with sanding paper, P 80 grit .
	Clean sanded areas	Clean sanded areas on rear spoiler outer section and spoiler grille thoroughly with cleaning solution (C6). Caution: Make sure no cleaning solution residues remain on the spoiler sections!
2	Prime bonding areas	Apply a thin, even coat of primer (C4) to bonding areas of rear spoiler outer section and spoiler grille. Caution: Allow a flash-off time of at least 10 minutes!

Preparing the bonding cartridge for application of adhesive

No.	Operation	Instructions
3	Open nozzle fitting on cartridge containing component A	Use a screwdriver to pierce the diaphragm of the nozzle connection of cartridge containing component A (C1).
4	Open flanged cover of cartridge containing component A	Use the screwdriver handle to pierce the flanged cover at the end of the cartridge containing component A (C1).
5	Screw filling nozzle onto cartridge containing component A	Screw filling nozzle (C10) onto cartridge containing component A (C1).
6	Place cartridge containing component A into the bonding gun	Place cartridge containing component A (C1) into bonding gun (A). Remove screw-on cap of mixing cartridge (C3).
7	Press component A into mixing cartridge	Place filling nozzle (C10) of cartridge containing component A (C1) into mixing cartridge (C3). Use bonding gun (A) to press component A into mixing cartridge (C3).
8	Open nozzle fitting of cartridge containing component B	Use a knife to cut off the tip of the nozzle fitting of the cartridge containing component B (C2).
9	Screw injector nozzle onto cartridge containing component B	Screw injector nozzle (C7) onto cartridge containing component B (C2).
10	Place cartridge containing component B into bonding gun	Place cartridge containing component B (C2) into bonding gun (A).

No.	Operation	Instructions
11	Press component B into mixing cartridge with component A	Insert injector nozzle (C7) of cartridge containing component B (C2) into mixing cartridge (C3). Use bonding gun (A) to press component B (C2) into mixing cartridge (C3) with component A.
12	Close mixing cartridge	Pull injector nozzle (C7) out of mixing cartridge (C3) and close mixing cartridge with screw-on cap.
13	Screw mixing rod into mixing cartridge	Screw mixing rod (B) manually into internal thread of mixing disc of mixing cartridge (C3). Clamp other end of mixing rod in a drill chuck. Fit the power drill in a suitable clamping device.
14	Mix component A und component B	Switch on drill (speed 900 to 1200 rpm) and rotate mixing cartridge 25 times from stop to stop. Perform all 25 double strokes fairly rapidly!
15	Engage mixing disc into piston	Pull back mixing cartridge until a rattling sensation is felt. Switch off drill and screw mixing rod out of mixing cartridge. This will cause the mixing disc to engage into the piston of the mixing cartridge.
16	Place mixing cartridge into bonding gun	Insert mixing cartridge with mixed 2-pack adhesive into bonding gun. Screw application nozzle (C8) onto mixing cartridge.

Caution: Observe open time of 15 minutes!

Open time is the time available for application of the adhesive and for assembling the spoiler components.

Assembling the spoiler parts

No.	Operation	Instructions
17	Apply adhesive	<p>Apply 2-pack adhesive with the bonding gun to the rear spoiler outer section – in the right and left-hand areas – to a minimum thickness of 3 mm.</p> <p>Apply 2-pack adhesive with the bonding gun to the spoiler grille – in the areas on the right and left of the locating pins (length approx. 40 mm) – to a minimum thickness of 3 mm.</p>
18	Assemble spoiler parts	<p>Place spoiler grille into rear spoiler outer section and adjust with locating pins.</p> <p>Gap adjustment and height offset on the outside between the rear spoiler outer section and spoiler grille must be identical along the entire circumference.</p>
19	Locate spoiler grille	<p>Locate spoiler grille to the rear spoiler outer section at the locating pins by pressing the spring nuts into place.</p>
	Clean areas of vision	<p>Any adhesive that has squeezed out must be removed immediately and the affected areas of vision must be cleaned with cleaning solution (C5).</p>
	Shorten lower locating pins	<p>Shorten lower locating pins (5 ea.) after the curing time (1 hour) has elapsed so that they are flush with the spring nuts.</p>