

**WC25 - Reworking Body Seal (Workshop Campaign)**

Vehicle Type: **911 Carrera (991)/911 Carrera S (991)**

Model Year: **2012**

Concerns: **Body seals and individual rubber sleeves/stoppers**

Revision 1: August 2, 2012, the following revisions were made:  
 Step 9 — See addition of "Note:" regarding no installed foam pieces.  
 Steps 10 & 11 —: See clarification that "both stoppers" refers to the left and the right stoppers.

Information: This is to inform you of a voluntary Workshop Campaign on the above-mentioned vehicles. There is the possibility that certain areas of the body were not sealed correctly on the affected vehicles. As a result, water can leak into the luggage compartment or passenger compartment.

Action Required: Rework body seals using body sealant and check that individual rubber sleeves/stoppers are fitted correctly and replace them if necessary.



**Information**

If water has already leaked into the vehicle, water must be drained from the affected areas and any damaged components must be repaired.

This work must be processed using a **separate warranty claim** and **cannot** be invoiced under the workshop campaign number.

Affected Vehicles: The VIN(s) can be checked by using PIWIS Vehicle Information link to verify if the campaign affects the vehicle, a total of 1,195 vehicles in both the U.S. and Canada. This Campaign is scope specific to the VIN! Failure to verify in PIWIS may result in an improper repair.

Note: **PLEASE DO NOT PLACE A PARTS ORDER. PARTS WILL BE AUTOMATICALLY ALLOCATED TO YOUR DEALERSHIP.**

Parts Info:	999.915.337.40	⇒ Sealing foam	2 ea.
	999.703.196.40	⇒ Stopper in luggage compartment, side	2 ea.
	999.703.421.40	⇒ Stopper on longitudinal member, top	4 ea.
	999.703.195.40	⇒ Stopper in luggage compartment, bottom (for oval bore)	1 ea.
	999.703.543.40	⇒ Stopper in luggage compartment, bottom (for round bore)	1 ea.

000.043.303.38	⇒ Adhesive film for longitudinal member, top consisting of: 4 x round self-adhesive sticker (only two of the four round self-adhesive stickers will be required during the campaign)	1 ea.
...	Body sealant commercially available, e.g. - Makra Evo-Seal 801 - Sikaflex 529 - Lord Fusor 804 - 3M MSP 8374	1 ea.*

The body sealant to be used must correspond to the color of the vehicle. A bright or dark body sealant must therefore be used, depending on the color.

\* The WWS Warranty system will automatically add into the "Miscellaneous item" section (sublet) of the claim after the claim has been submitted.

**2 touch-up sticks** in vehicle color are also required. The color code can be found on the paint-data plate on the vehicle.

Color code and color designation	Part No.
Vehicles <b>with</b> solid color	
041 Black	911.095.932.20.041 ⇒ Touch-up stick Black
80K Guards Red	911.095.932.20.80K ⇒ Touch-up stick Guards Red
B9A Carrara White	911.095.932.20.B9A ⇒ Touch-up stick Carrara White
1S1 Racing Yellow	911.095.932.20.1S1 ⇒ Touch-up stick Racing Yellow
Vehicles <b>with</b> metallic color	
C9Z Basalt Black Metallic	911.095.933.20.C9Z ⇒ Touch-up stick Basalt Black Metallic
M7Z GT Silver Metallic	911.095.933.20.M7Z ⇒ Touch-up stick GT Silver Metallic
M3X Ruby Red Metallic	911.095.933.20.M3X ⇒ Touch-up stick Ruby Red Metallic
M5R Aqua Blue Metallic	911.095.933.20.M5R ⇒ Touch-up stick Aqua Blue Metallic
M5X Dark Blue Metallic	911.095.933.20.M5X ⇒ Touch-up stick Dark Blue Metallic
M7T Platinum Silver Metallic	911.095.933.20.M7T ⇒ Touch-up stick Platinum Silver Metallic
M8Z Cognac Metallic	911.095.933.20.M8Z ⇒ Touch-up stick Cognac Metallic
M8S Anthracite Brown Metallic	911.095.933.20.M8S ⇒ Touch-up stick Anthracite Brown Metallic

M7S Achat Grey Metallic	911.095.933.20.M7S ⇒ Touch-up stick Achat Grey Metallic
5P1 Lime Gold Metallic	911.095.933.20.5P1 ⇒ Touch-up stick Lime Gold Metallic

Special Tools: **WE1141 - Cartridge gun V.A.G. 1628**

Materials:

- Adhesive tape
- Masking paper
- Clean, lint-free cloth
- Cleaning solution
- Silicone spray
- Commercially available paint brush (10 mm wide)
- Commercially available body brush (15 mm wide)
- Disposable gloves
- Pan

The WWS Warranty system will automatically add into the “Miscellaneous item” section (sublet) of the claim after the claim has been submitted.

Work Procedure: See Attachment “A”.

Claim Submission: See Attachment “B”.

## Preliminary work

Attachment "A": **Work Procedure**

### Preliminary work on body front section



#### Information

The power supply in the vehicle is interrupted as soon as the battery is disconnected. The following steps must therefore be completed before disconnecting the battery:

- Open the rear lid.
  - Move the front seat to a center position to ensure easy access to the driver’s footwell and rear seat assembly.
  - Deactivate the steering wheel lock.
  - Turn ignition key to ignition lock position 0 - ignition off - and leave ignition key in the ignition lock.
- 1 Remove front luggage compartment trim panel ⇒ *Workshop Manual '700519 Removing and installing front luggage compartment trim panel - section on "Removing"*.

- 2 Remove front trim at the left and right (fender flange) ⇒ *Workshop Manual '700219 Removing and installing front trim (wing flange) - section on "Removing"*.
- 3 Remove wiper linkage ⇒ *Workshop Manual '921919 Removing and installing wiper linkage - section on "Removing"*.
- 4 Remove headlights at the left and right. ⇒ *Workshop Manual '941519 Removing and installing headlights - section on "Removing"*
- 5 Remove front apron ⇒ *Workshop Manual '631519 Removing and installing front apron - section on "Removing"*.
- 6 Remove battery ⇒ *Workshop Manual '270619 Removing and installing battery - section on "Removing"*.
- 7 Remove battery console.
  - 7.1 Loosen fastening screws ⇒ *Figure 1 -2-* and lift up battery console ⇒ *Figure 1 -1-*.
  - 7.2 Release connector on the fuel pump control unit at the underside of the battery console and remove battery console.

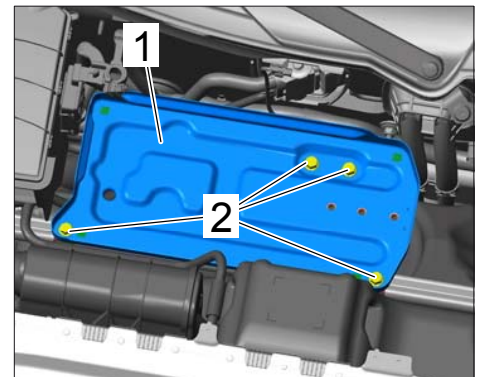


Figure 1

- 8 Expose bodyshell mounting for battery console holder.
  - 8.1 Disconnect vacuum line.
    - 8.1.1 Release vacuum line at the connection point ⇒ *Figure 2 -arrows A-* and disconnect it ⇒ *Figure 2 -arrow B-*.
    - 8.1.2 Unclip vacuum line ⇒ *Figure 2 -arrow C-*.

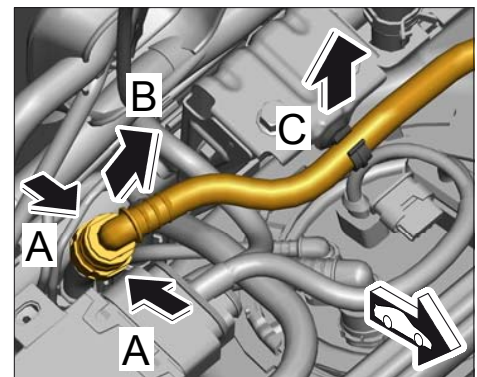


Figure 2

- 8.2 Remove battery console holder.
  - 8.2.1 Unscrew fastening screws for battery console holder.
  - 8.2.2 Unclip cable clip on the battery console holder.

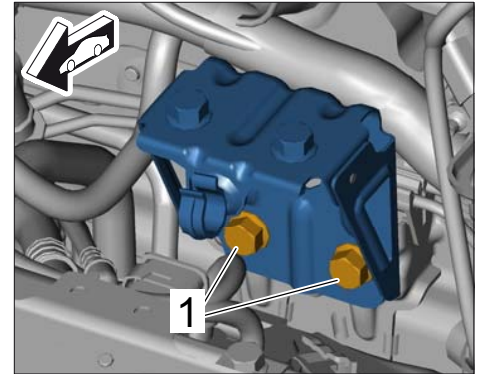


Figure 3

- 8.3 Carefully pull out foam seal ⇒ *Figure 4 -1-* between the body and fuel tank ⇒ *Figure 4 -2-* and remove any adhesive residue on the body.  
The foam seal ⇒ *Figure 4 -1-* will be re-used during installation.

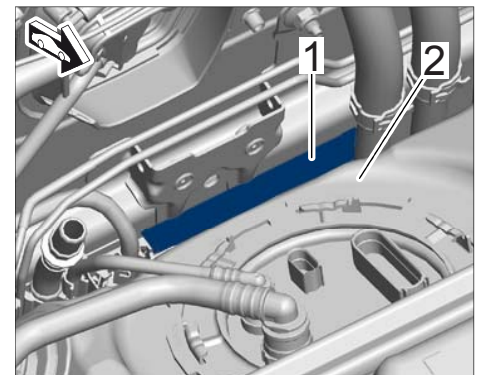


Figure 4

- 8.4 Unclip brake lines ⇒ *Figure 5 -1-* with the retaining clips ⇒ *Figure 5 -2-* at the bodyshell mounting ⇒ *Figure 5 -arrows-* and pull them forward until the inner area of the bodyshell mounting is easily accessible.

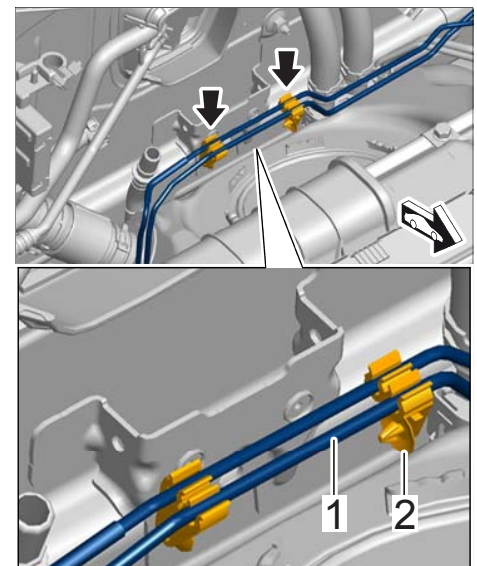


Figure 5

- 9 Carefully pull out foam seal ⇒ *Figure 6 -1-* between the right fender ⇒ *Figure 6 -2-* and longitudinal member for the wheel housing upper section ⇒ *Figure 6 -3-* and remove any adhesive residue on the longitudinal member.

The foam seal ⇒ *Figure 6 -1-* will be re-used during installation.

**Note:** If there are no foam pieces installed, disregard Step 9 and proceed to Step 10.

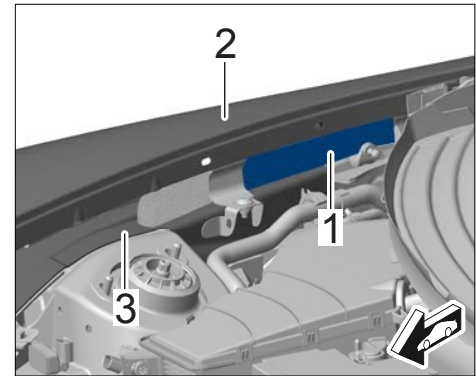


Figure 6

- 10 Remove both stoppers (left and right) on the longitudinal member for the wheel housing upper section.
- 10.1 Remove stopper from the opening in the longitudinal member for the wheel housing upper section and dispose of it ⇒ *Figure 7 -arrow-*.
- 10.2 Remove adhesive residue at the bore for the stopper and clean longitudinal member for wheel housing.

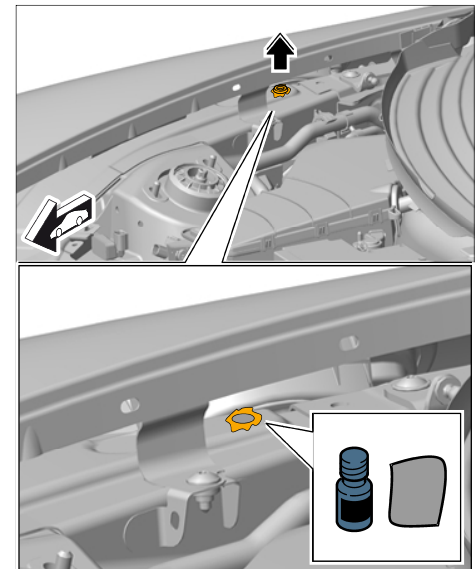


Figure 7

- 11 Remove both stoppers (left and right) on the fender joining plate.
  - 11.1 Remove stopper (painted in vehicle color) from the opening on the fender joining plate and dispose of it ⇒ *Figure 8 -arrow-*.
  - 11.2 Touch up any missing top coat paint ⇒ *Figure 8 -A-* close to the stopper with a touch-up stick in vehicle color ⇒ *Figure 8 -B-*.

**Preliminary work for rear end**

- 12 Remove engine-compartment blower ⇒ *Workshop Manual '198119 Removing and installing engine-compartment blower - section on "Removing"*.
- 13 Remove rear wheel housing liner at the left and right ⇒ *Workshop Manual '536919 Removing and installing rear wheel housing liner - section on "Removing"*.
- 14 Remove rear roof trim panel ⇒ *Workshop Manual '708519 Removing and installing rear roof trim panel - section on "Removing"*.
- 15 Unclip inner cover at the right in an upward direction and disengage emergency release cable ⇒ *Figure 9 -arrow-*.

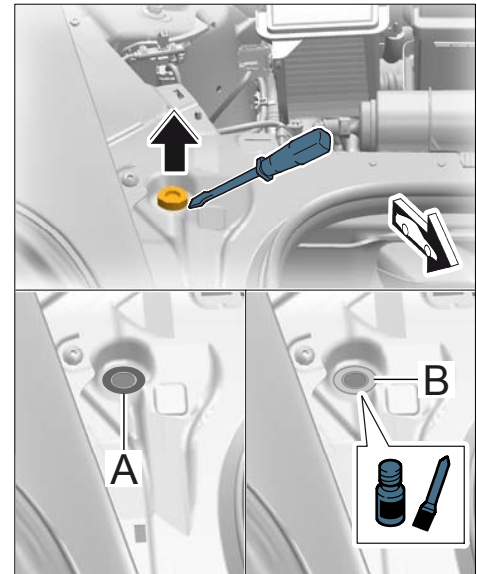


Figure 8

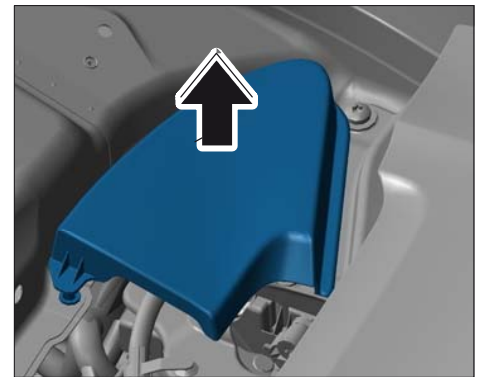


Figure 9

- 16 Remove upper part of oil filler neck.
  - 16.1 Unscrew and remove fastening screw ⇒ *Figure 10-1-* on upper part of oil filler neck ⇒ *Figure 10-2-*.
  - 16.2 Unscrew the coolant cap ⇒ *Figure 10-3-*.
  - 16.3 Screw the coolant cap in again to protect the coolant filler neck from dirt and stop parts from falling into it.
  - 16.4 Open spring band clamp ⇒ *Figure 10-4-* at the underside and pull off oil filler hose ⇒ *Figure 10-5-*.

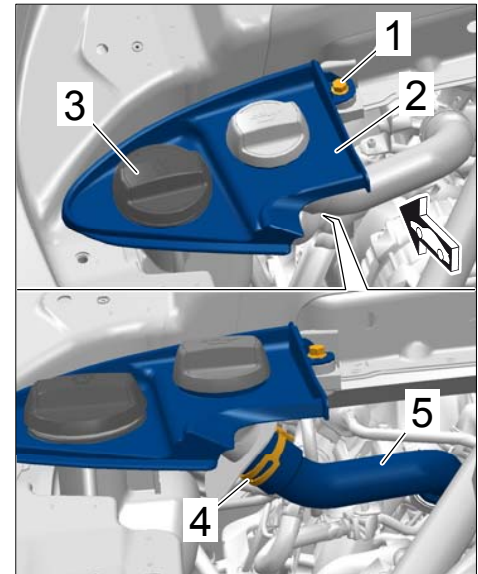


Figure 10

- 17 Pull sealing strip ⇒ *Figure 11 -1-* off the body flange.



Figure 11



Checking and reworking rubber sleeves and stoppers

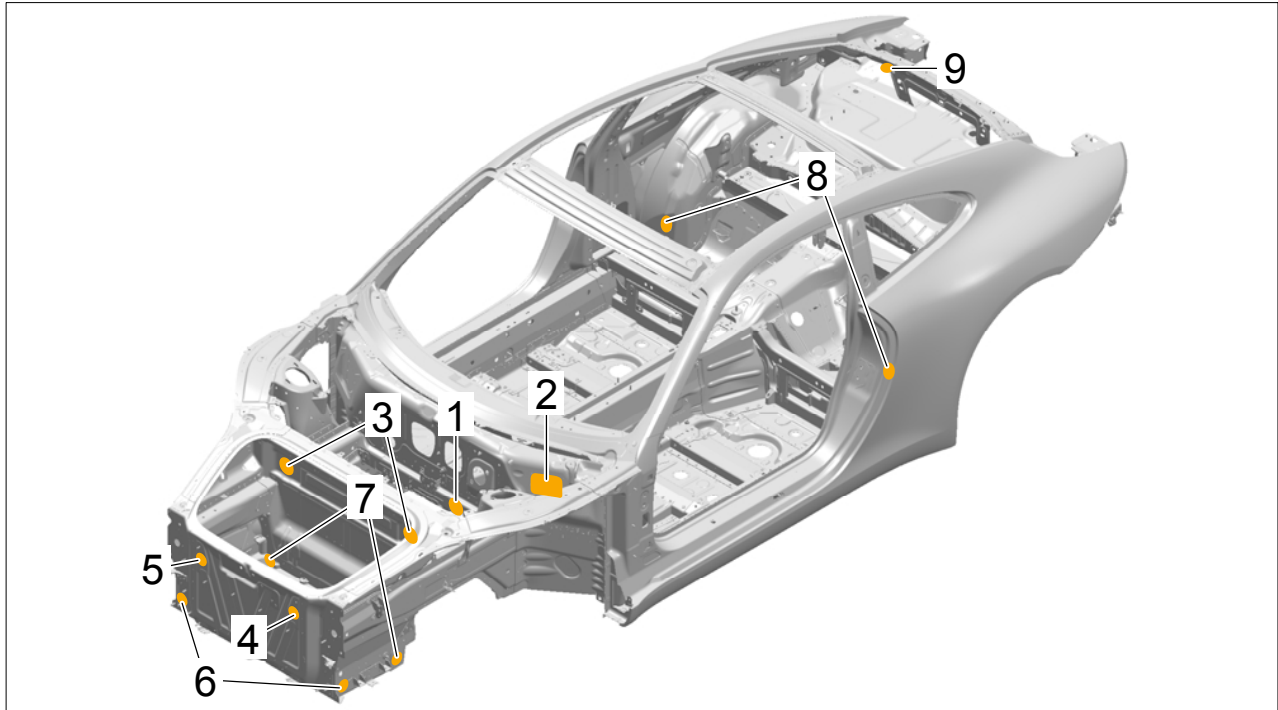


Figure 12

- 1 – Rubber sleeve on intermediate steering shaft
- 2 – Rubber sleeve on main wire harness
- 3 – Rubber sleeve on wire harness for luggage compartment
- 4 – Rubber sleeve on wire harness for front end
- 5 – Stopper on bulkhead in luggage compartment
- 6 – Stopper in luggage compartment, side
- 7 – Stopper in luggage compartment floor
- 8 – Rubber sleeve on wire harness for TPM
- 9 – Rubber sleeve on wire harness for rear lid (additional brake light)

Procedure:



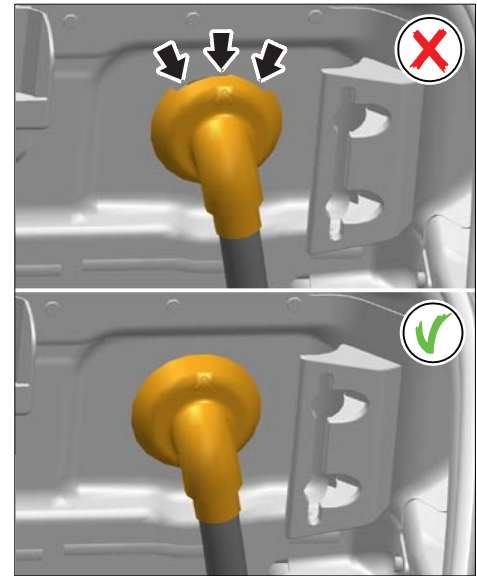
**Information**

Some of the repair illustrations show only one side of the vehicle. Naturally, some steps also have to be performed on the opposite side of the vehicle as well. These must be carried out as a mirror image of the steps shown.

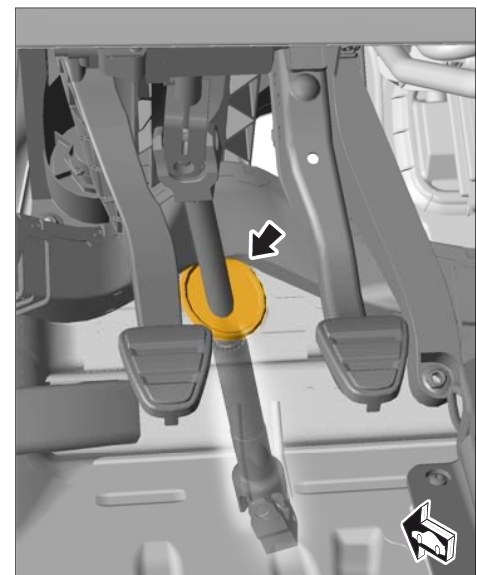
**Information**

In the following steps, make sure that the rubber sleeves and stoppers are fitted correctly. Make sure, in particular, that the sealing lips are not trapped ⇒ *Figure 13* -**arrows**- and make good contact all the way around.

The contact surface of the rubber sleeves and stoppers must be free of dirt and adhesive residue.

*Figure 13*

- 1 Check that rubber sleeve on intermediate steering shaft is fitted correctly all the way around ⇒ *Figure 14* -**arrow**- and adjust it if necessary.

*Figure 14*

- 2 Check that rubber sleeve on main wire harness ⇒ *Figure 15 -2-* is fitted correctly all the way around and adjust it if necessary.

Also check the tightening torque of the fastening screws ⇒ *Figure 15 -1-*. **Tightening torque 9.7 Nm (7.5 ftlb.)**

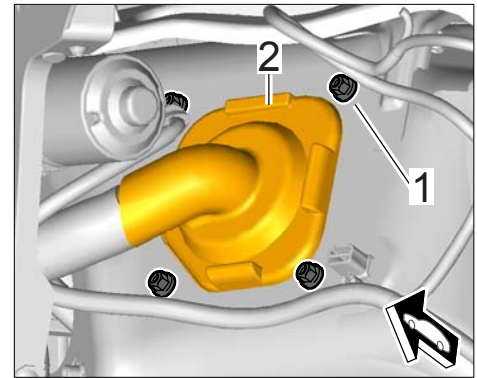


Figure 15

- 3 Check that rubber sleeves on wire harness for luggage compartment are fitted correctly all the way around ⇒ *Figure 16 -arrows-* and adjust them if necessary.

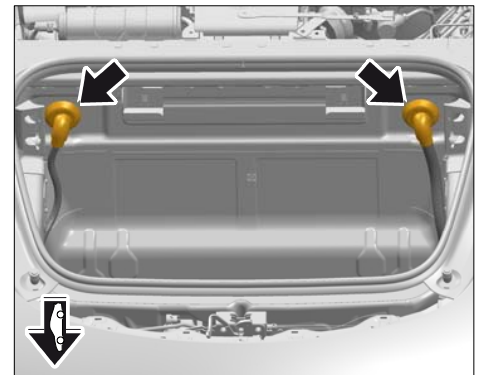


Figure 16

- 4 Check that rubber sleeve on wire harness for front end at the bulkhead in the front luggage compartment is fitted correctly all the way around and adjust it if necessary.

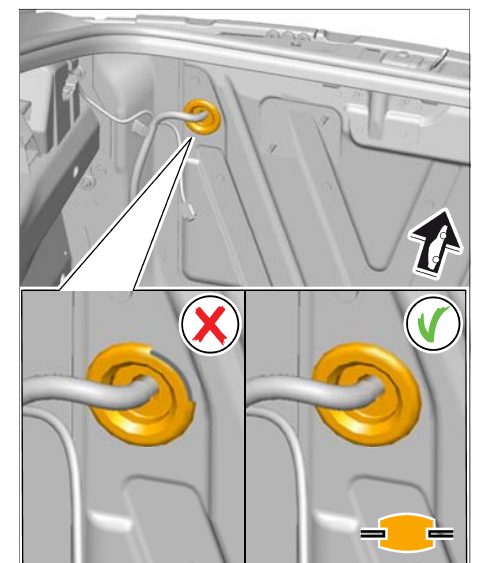


Figure 17

- 5 Check that stopper on bulkhead in front luggage compartment is fitted correctly all the way around and adjust it if necessary.

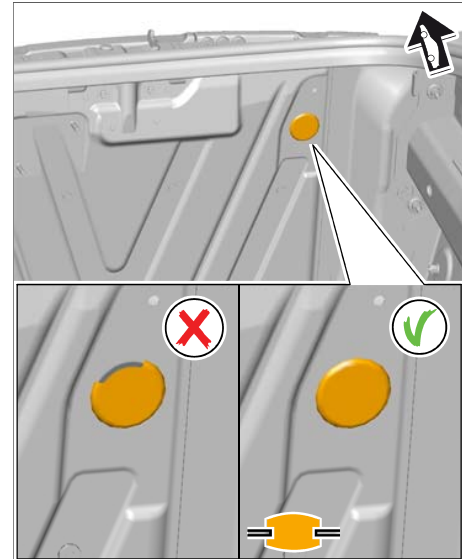


Figure 18

- 6 Replace both stoppers at the sides of the luggage compartment.
  - 6.1 Press locking lug on the stoppers from the inside of the luggage compartment to the outside using a suitable tool ⇒ *Figure 19 -arrows-*.
  - 6.2 Pull out stoppers completely from the outside.
  - 6.3 Carefully remove adhesive residue on the outside of the luggage compartment using a metal spatula or scraper.
  - 6.4 Treat any visible paint damage using a corrosion protection touch-up stick.

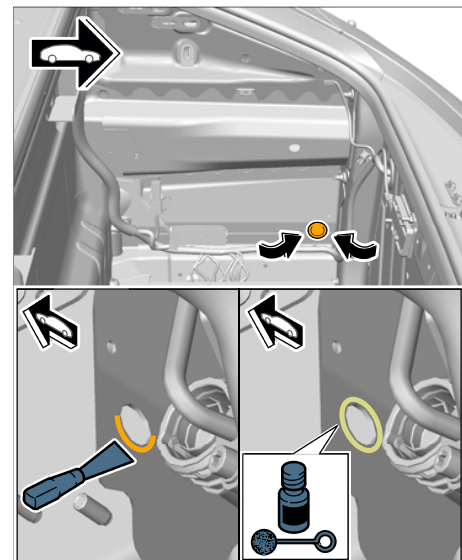


Figure 19

- 6.5 Fit new stoppers, Part No. **999.703.196.40**, at the sides of the luggage compartment from the inside.

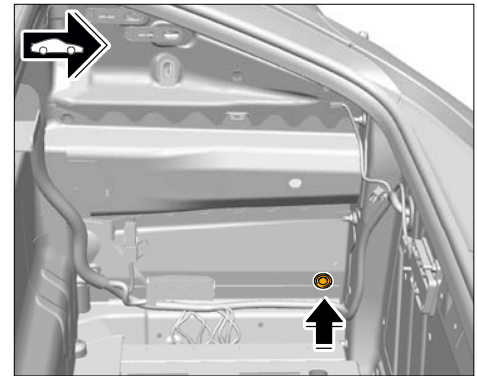


Figure 20

- 7 Replace stoppers at the front of the luggage compartment floor (vehicle underside).
  - 7.1 Press out both stoppers at the underside of the vehicle using a screwdriver.

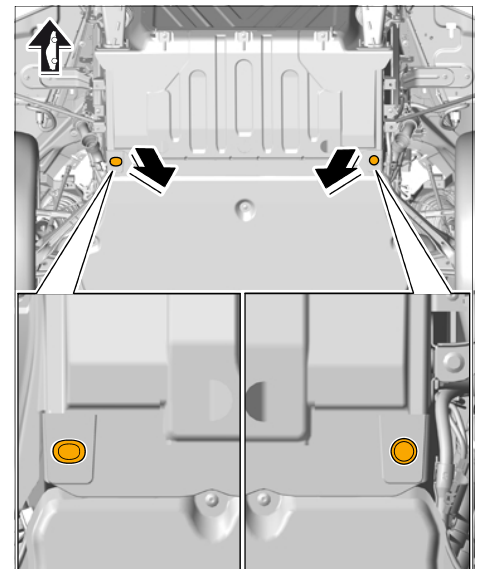
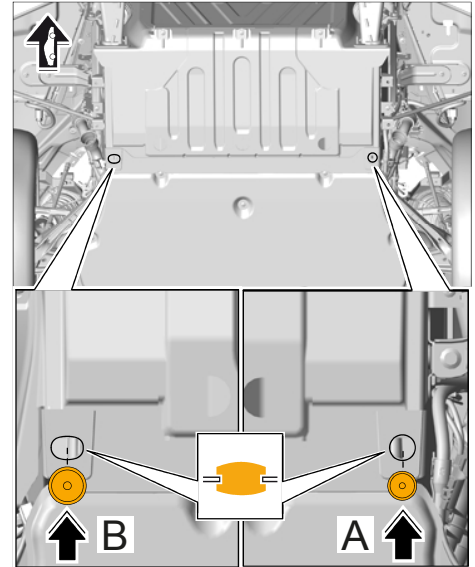


Figure 21

**Information**

It can sometimes be difficult to fit the stoppers at this position. If necessary, use a suitable tool to press carefully into the stoppers and make sure that the rubber lip on the stoppers is pressed in over the sheetmetal flange all the way around.

- 7.2 Press new stopper, Part No. **999.703.543.40**, into the **round** bore on the luggage compartment floor ⇒ *Figure 22* -**arrow A**-.
- 7.3 Press new stopper, Part No. **999.703.195.40**, into the **oval** bore on the luggage compartment floor ⇒ *Figure 22* -**arrow B**-.

*Figure 22*

- 8 Check that both rubber sleeves on wire harness for TPM in the rear wheel housings are fitted correctly all the way around ⇒ *Figure 23* -**arrow**- and adjust them if necessary.

*Figure 23*

- 9 Check that rubber sleeve on wire harness for rear lid (additional brake light) is fitted correctly all the way around ⇒ *Figure 24 -arrows-* and adjust it if necessary.

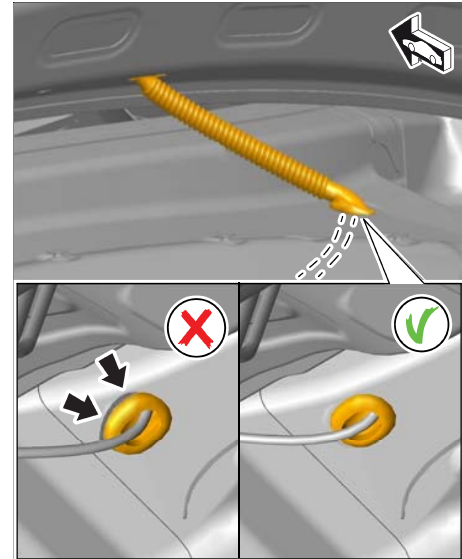


Figure 24

**Checking front side members at the left and right for water leaks**



**Information**

The following water test involves spraying water on the area of the body on which there may be a leak. At the same time, a second person checks the inner area of the luggage compartment for water leaks. It can take up to 2 minutes to detect a possible leak as a result of water leaking in, depending on the vehicle.

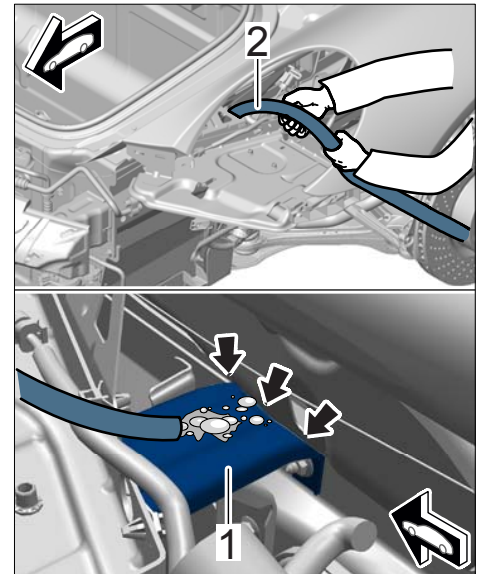
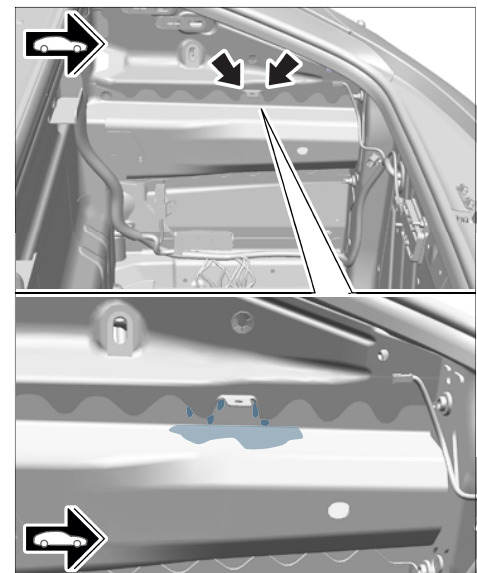
⇒ Do not use a high-pressure cleaner. Use a normal water hose with spray nozzle or shower attachment.

- 1 Place a pan underneath the vehicle to collect water.

- Spray the front side member close to the wing holder ⇒ *Figure 25-1-* with water for approx. 2 minutes using a water hose ⇒ *Figure 25-2-* (⇒ *Figure 25-arrows-*).

**Information**

A leak is indicated by water leaking in at the upper sheetmetal flange (corrugated) of the front side member in the luggage compartment ⇒ *Figure 26-arrows-*.

*Figure 25**Figure 26*



If water is leaking into the luggage compartment, the area at the fender holder ⇒ *Figure 27-1*- must be sealed with body sealant ⇒ *Figure 27-2*-.

To do this, remove the fender holder ( ⇒ *Workshop Manual '505519 Removing and installing wing'*) and rework the incomplete seam seal with body sealant. Remove residual moisture well before applying and spreading out the new seam seal.

The additional application of the seam seal in the fender holder area must be processed using a **separate warranty claim** and **cannot** be invoiced under the workshop campaign number.

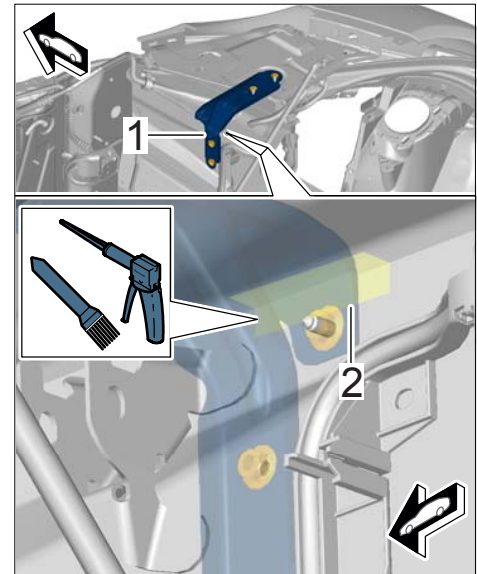


Figure 27

## Reworking seam seals

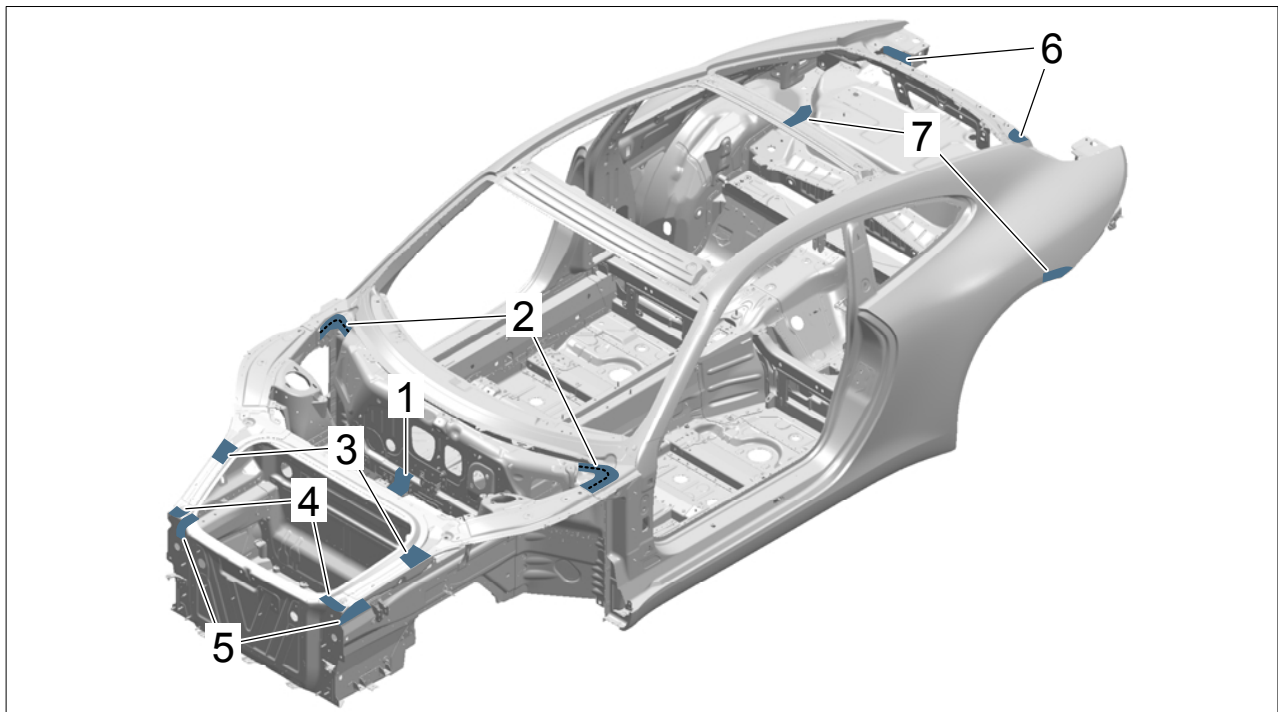


Figure 28

- 1 – Bodysell mounting for battery console holder and firewall

- 2 – Longitudinal member for wheel housing to cowl panel frame/A-pillar
- 3 – Rectangular cut-out on fender joining plate
- 4 – Luggage compartment bracket to fender joining plate
- 5 – Luggage compartment bracket to front side member
- 6 – Outer rear side section to inner rear side section/cross member
- 7 – Outer rear side section to outer rear wheel housing

Procedure:



### Information

Mask or cover all adjacent components before starting sealing work.

The surfaces to be sealed must be free of grease and dirt before applying body sealant. For this purpose, clean all affected areas with cleaning solution and a lint-free cloth.

- 1 Rework bodyshell mounting for battery console holder and firewall.
  - 1.1 Apply body sealant to the area marked in yellow ⇒ *Figure 29* inside and outside ⇒ *Figure 29 -arrows A-* the bodyshell mounting and spread it out evenly with a brush.
  - 1.2 Apply body sealant to the area marked in yellow ⇒ *Figure 29* over the welded seams and spread it out evenly with a brush.

Make sure not to block the water drain bore ⇒ *Figure 29 -arrow B-* with body sealant.

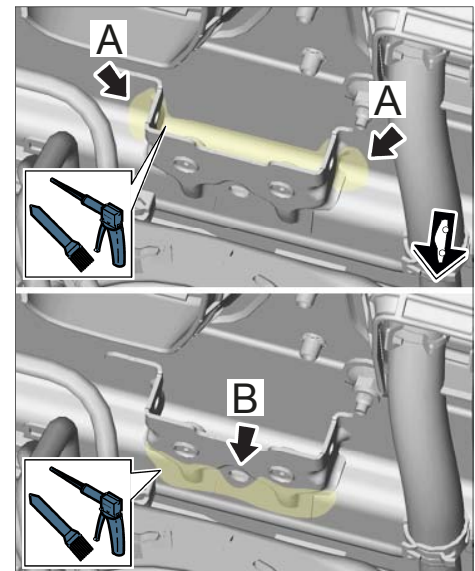


Figure 29

- 1.3 Apply body sealant to the area marked in yellow on the welded seams joining the firewall upper section to the firewall lower section and spread it out evenly with a brush.

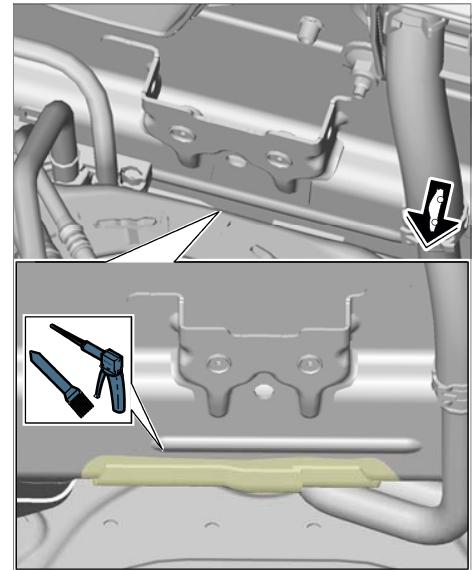


Figure 30

- 2 Rework joint between longitudinal member for wheel housing upper section and cowl panel frame/A-pillar at both sides.

- 2.1 Apply body sealant to the area marked in yellow above the cowl panel frame ⇒ Figure 31 -arrow A- and spread it out evenly with a brush.
- 2.2 Apply body sealant to the area marked in yellow below the cowl panel frame ⇒ Figure 31 -arrow B- and spread it out evenly with a brush.

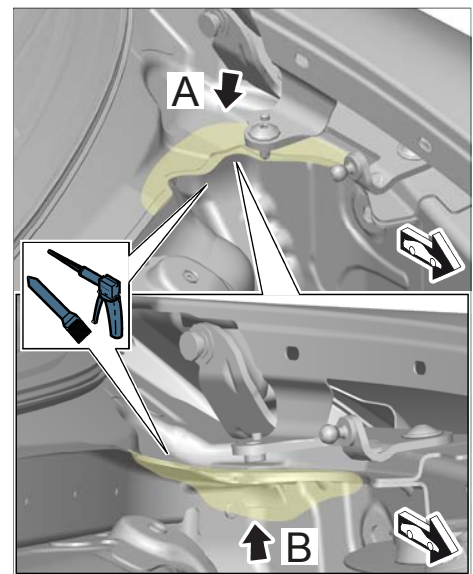


Figure 31

- 3 Rework rectangular cut-out on wing joining plate at both sides.
  - 3.1 Mask rectangular cut-out using a round self-adhesive sticker from the adhesive film, Part No. **000.043.303.38** (⇒ *Figure 32 -1-*).
  - 3.2 Apply body sealant over the masked cut-out in the area marked in yellow ⇒ *Figure 32 -2-* and spread it out evenly with a brush.

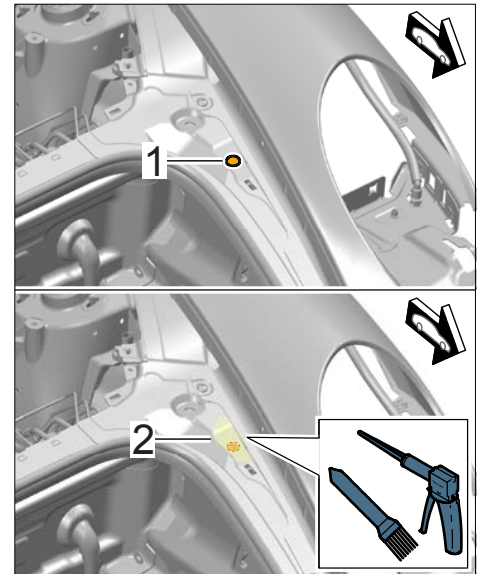


Figure 32

- 4 Rework joint between luggage compartment bracket and wing joining plate at both sides.

To do this, apply body sealant to the area marked in yellow ⇒ *Figure 33* and spread it out evenly with a brush.

Make sure to spread the body sealant down over the outer edge ⇒ *Figure 33 -arrow-*.

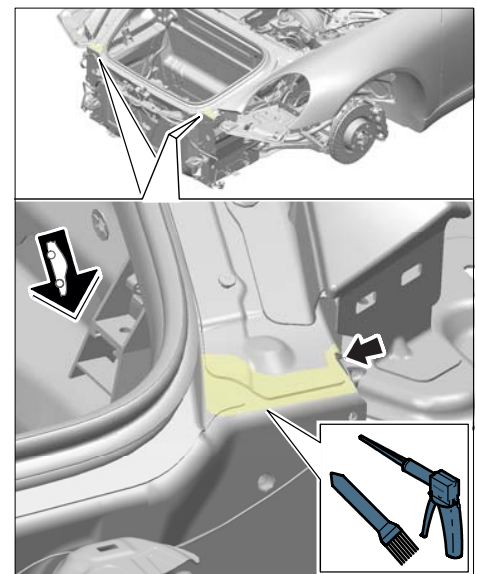


Figure 33

- 5 Rework joint between luggage compartment bracket and front side member at both sides.

To do this, apply body sealant to the area marked in yellow ⇒ *Figure 34* and spread it out evenly with a brush.

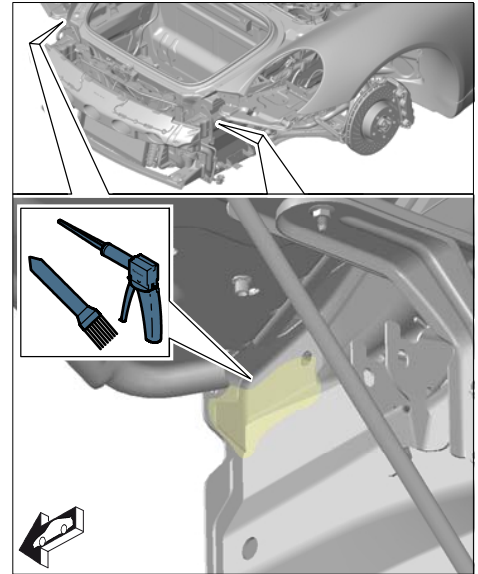


Figure 34

- 6 Rework joint between outer rear side section and inner rear side section/cross member at both sides.

To do this, apply body sealant to the area marked in yellow ⇒ *Figure 35* and spread it out evenly with a brush.

Make sure to spread the body sealant up to approx. 10 mm below the sheetmetal flange.

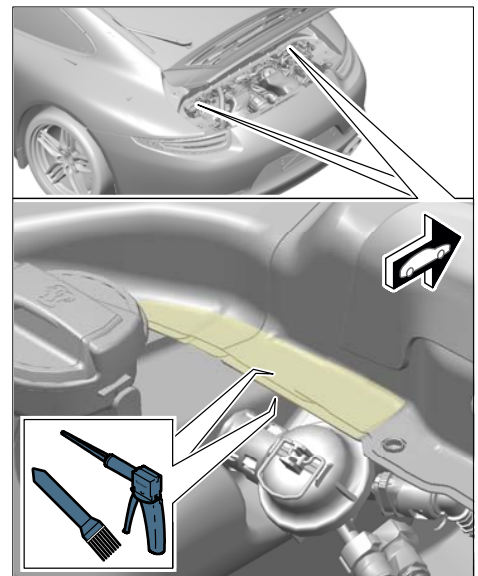


Figure 35

- 7 Rework joint between outer rear side section and outer rear wheel housing at both sides.
  - 7.1 Pull speed nut off the body flange.
  - 7.2 Apply body sealant to the area marked in yellow ⇒ *Figure 36* and spread it out evenly with a brush.
  - 7.3 Re-fit speed nut immediately after spreading out the body sealant.



#### Information

The seam seal can be painted when it has reached approx. 70% hardness. This generally requires a hardening time of approx. 4 - 5 hours at 73° F (23° C), 50% relative humidity. Higher air humidity or dampening with water accelerates the hardening process.

The hardening can be checked with a nail test. Press a finger nail gently into the hardened body sealant. If this causes no damage to the surface, the seam seal can be painted.

- 8 Once the hardening process is complete, **paint** all areas on which you have applied body sealant with top-coat paint (touch-up stick in vehicle color) until adequate coverage is achieved.

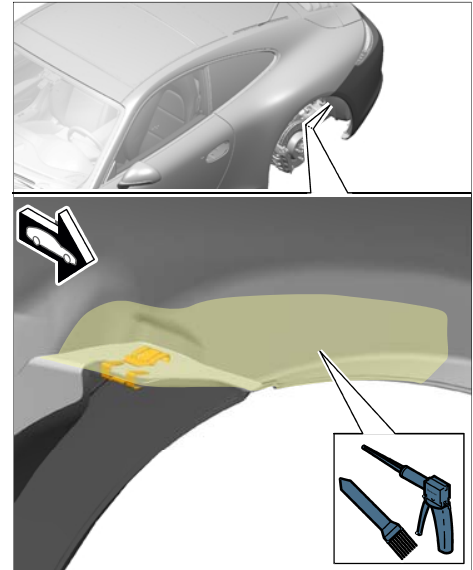


Figure 36

**Sealing cavities in longitudinal member for wheel housing upper section**

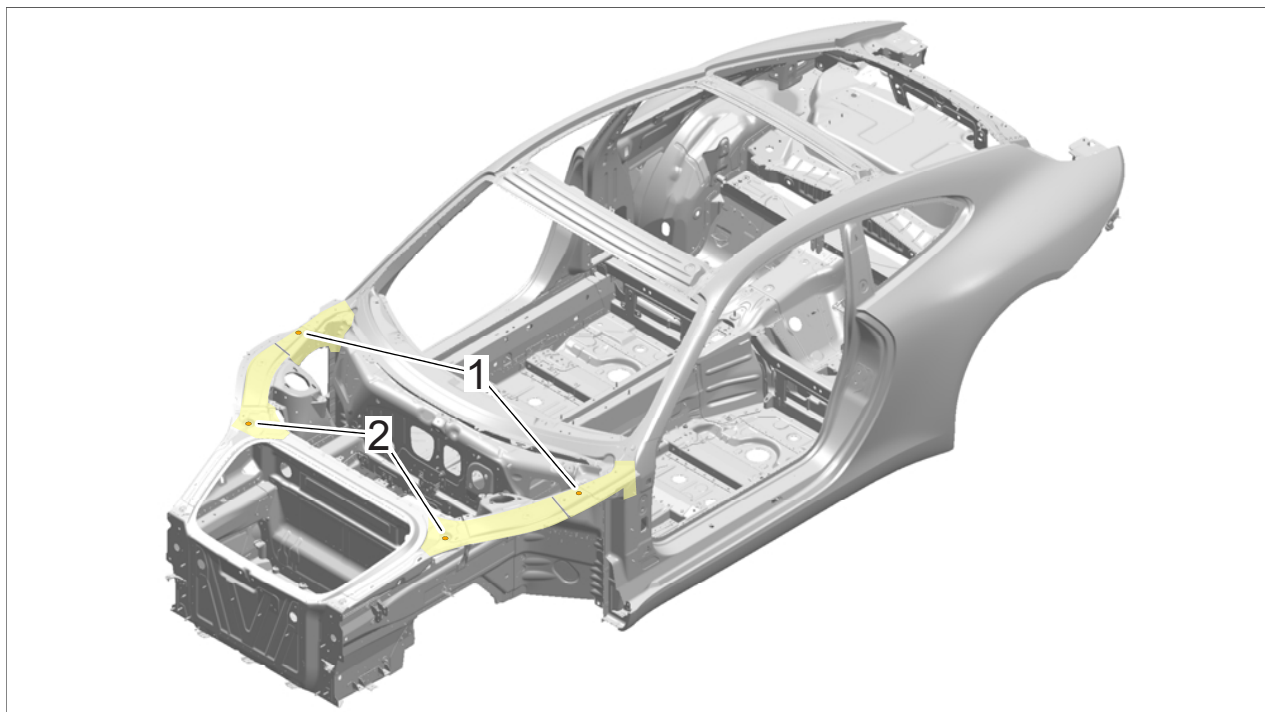


Figure 37

**Foam point 1** – Opening on longitudinal member for wheel housing upper section

**Foam point 2** – Opening on wing joining plate

- Procedure:
- 9 Mask the marked area at the two upper corners of the luggage compartment with adhesive tape ⇒ *Figure 38-1* to prevent sealing foam from getting into the luggage compartment.



### Information

Always observe the current work safety regulations when working with sealing foam ⇒ *Workshop Manual '5X00IN22 Working with body foam filler'*.

One can of sealing foam must be used for each side of the vehicle. When applying sealing foam, approx. 50% of the can must be used for foam point 1 and 50% for foam point 2.

- 10 Activate the foam can, Part No. **999.915.337.40**, in accordance with the manufacturer's instructions on the can.
- 11 Fill longitudinal member for wheel housing upper section with foam (**foam point 1**).
  - 11.1 Guide spray pipe of foam can through the opening on the longitudinal member for the wheel housing upper section ⇒ *Figure 39 -arrow-* as far as possible towards the A-pillar.
  - 11.2 Fill longitudinal member for wheel housing upper section with foam for approx. 15 seconds. During the last 5 seconds, pull the spray pipe out slowly and evenly.

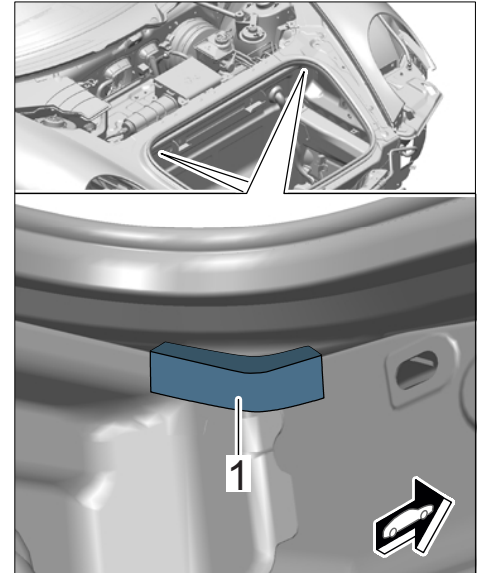


Figure 38

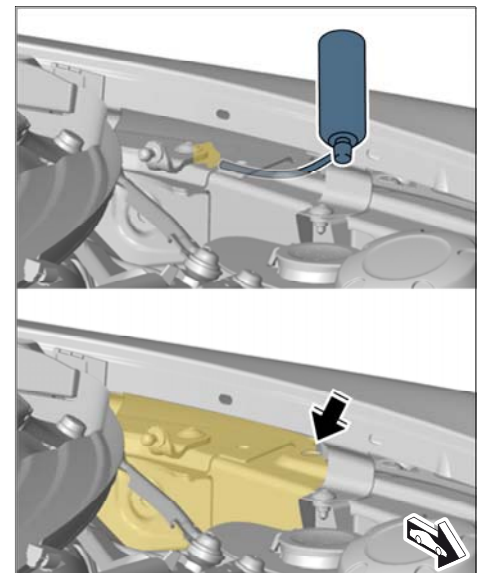


Figure 39





**Information**

To make it easier to press in the stopper, coat the stopper with commercially available silicone spray beforehand.

- 11.3 Close off the opening on the longitudinal member for the wheel housing upper section using a stopper, Part No. **999.703.421.40** , immediately after pulling out the spray pipe ⇒ *Figure 40 -arrow-*.
- 11.4 Remove any sealing foam that has oozed out immediately, ensuring that there are no traces of sealing foam remaining, and clean using cleaning solution.

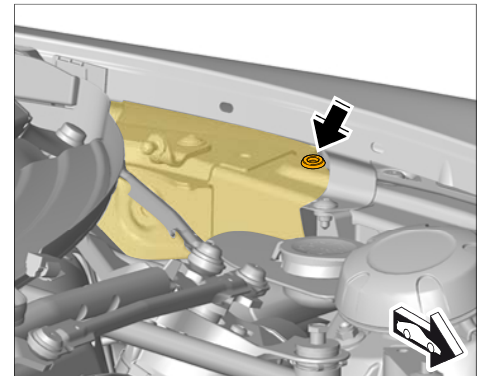


Figure 40

- 12 Fill longitudinal member for wheel housing upper section close to the wing joining plate with foam (**foam point 2**).
- 12.1 Guide spray pipe of foam can through the opening on the wing joining plate as far as possible towards the A-pillar ⇒ *Figure 41 -arrow A-*.
- 12.2 Fill longitudinal member for wheel housing upper section towards the A-pillar with foam for approx. 10 seconds. When the foam filling process is almost complete, pull the foam pipe out slightly until it can be turned in the opening of the wing joining plate. Guide in the spray pipe in the opposite direction of the front end ⇒ *Figure 41 -arrow B-* and fill that area with foam for a further 5 seconds.

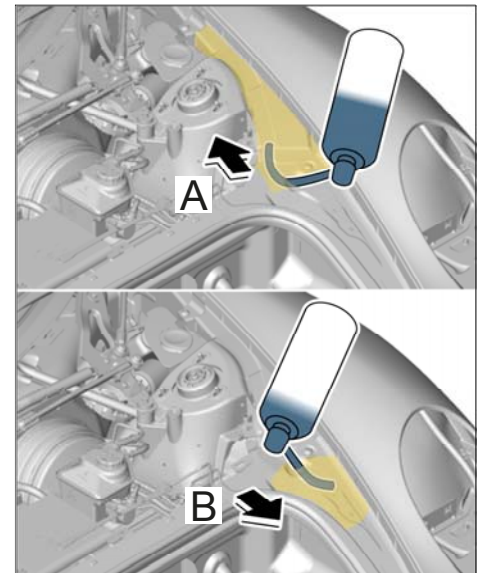
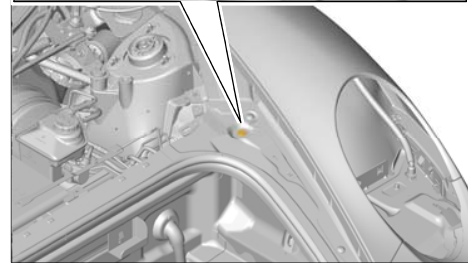
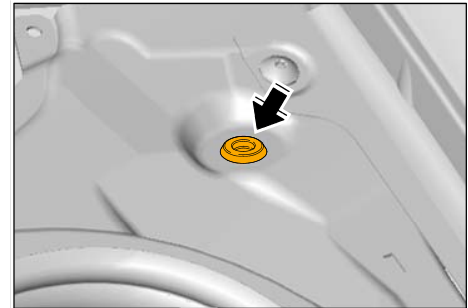
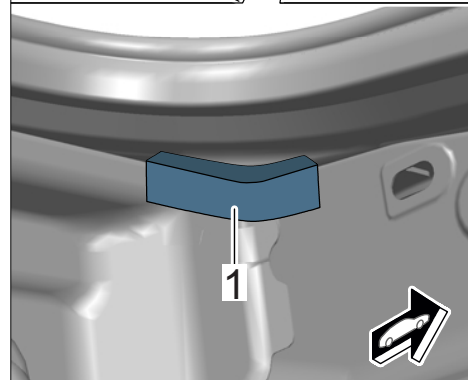
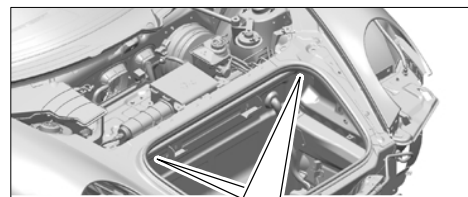


Figure 41

**Information**

To make it easier to press in the stopper, coat the stopper with commercially available silicone spray beforehand.

- 12.3 Close off the opening on the wing joining plate using a stopper, Part No. **999.703.421.40**, immediately after pulling out the spray pipe ⇒ *Figure 42 -arrow-*.
- 12.4 Remove any sealing foam that has oozed out immediately, ensuring that there are no traces of sealing foam remaining, and clean using cleaning solution.
- 13 Perform steps 5 to 7 on the opposite side of the vehicle.
- 14 When the chemical reaction of the sealing foam is complete, remove strips of adhesive tape ⇒ *Figure 43 -1-* from the luggage compartment.

*Figure 42**Figure 43*

**Subsequent work**

Procedure: **Subsequent work for rear end**

- 1 Engage emergency release cable and clip in the inner cover at the right ⇒ *Figure 44 -arrow-*.

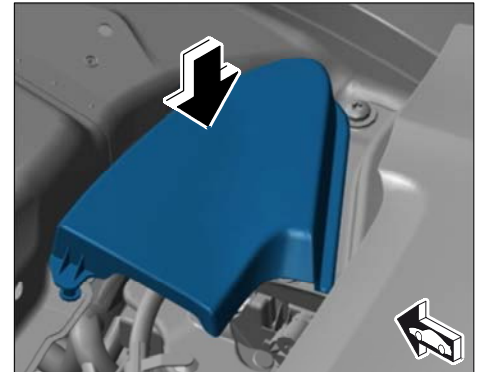


Figure 44

- 2 Slide on sealing strip ⇒ *Figure 45 -1-* over the body flange.



Figure 45

- 3 Install upper part of oil filler neck.
  - 3.1 Unscrew the coolant cap ⇒ *Figure 46 -3-*.
  - 3.2 Fit upper part of oil filler neck ⇒ *Figure 46 -2-* to the oil filler hose ⇒ *Figure 46 -5-* and secure with the spring band clamp ⇒ *Figure 46 -4-*.
  - 3.3 Position upper part of oil filler neck ⇒ *Figure 46 -2-* and secure with the fastening screw ⇒ *Figure 46 -1-*.
  - 3.4 Screw in the coolant cap ⇒ *Figure 46 -3-*.
- 4 Install engine-compartment blower ⇒ *Workshop Manual '198119 Removing and installing engine-compartment blower - section on "Installing"*.
- 5 Install rear wheel housing liner at the left and right ⇒ *Workshop Manual '536919 Removing and installing rear wheel housing liner - section on "Installing"*.
- 6 Install rear roof trim panel ⇒ *Workshop Manual '708519 Removing and installing rear roof trim panel - section on "Installing"*.

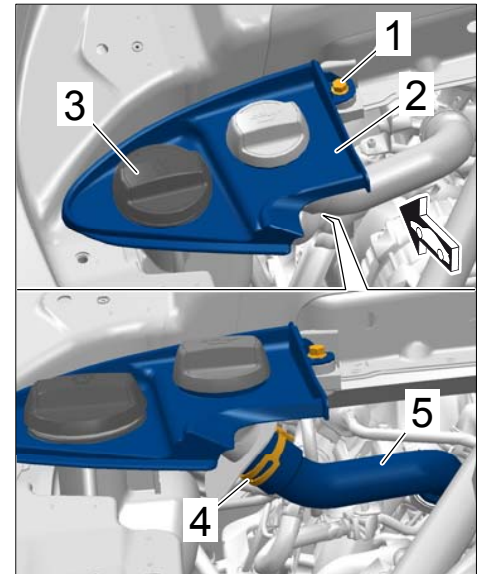


Figure 46

#### Subsequent work for body front section

- 7 Re-fit foam seal ⇒ *Figure 47 -1-* between the right wing ⇒ *Figure 47 -2-* and longitudinal member for the wheel housing upper section ⇒ *Figure 47 -3-*.  
Stick on the foam seal ⇒ *Figure 47 -1-* using double-sided adhesive tape if necessary.
- 8 Install battery console holder.

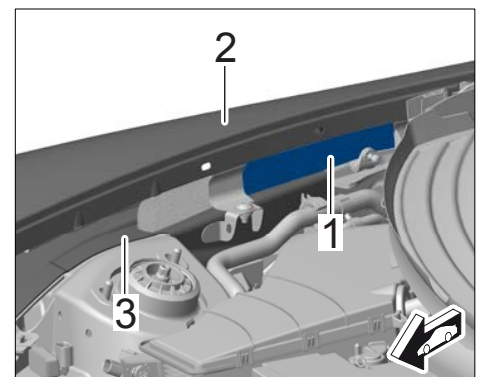


Figure 47

- 8.1 Re-fit foam seal ⇒ *Figure 48-1-* between the body and fuel tank ⇒ *Figure 48-2-* and stick it on using double-sided adhesive tape if necessary.

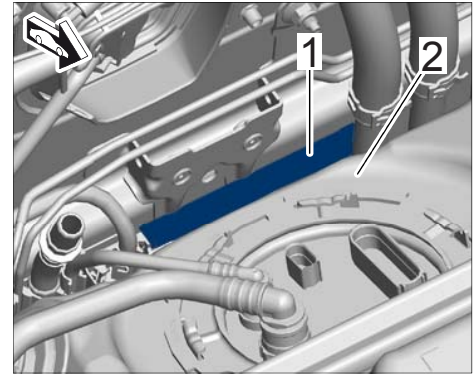


Figure 48

- 8.2 Clip in brake lines ⇒ *Figure 49-1-* using the retaining clips ⇒ *Figure 49-2-* at the bodyshell mounting ⇒ *Figure 49-arrows-*.
- 8.3 Clip in cable clip on the battery console holder.

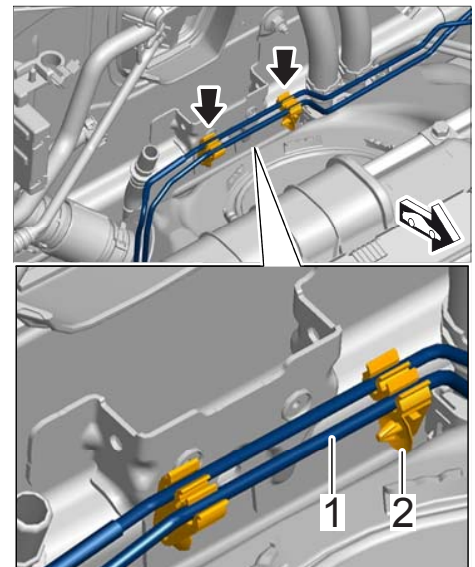


Figure 49

- 8.4 Position battery console holder at the bodyshell mounting and secure with the fastening screws ⇒ *Figure 50-1-*. **Tightening torque 23 Nm (17 ftlb.)**

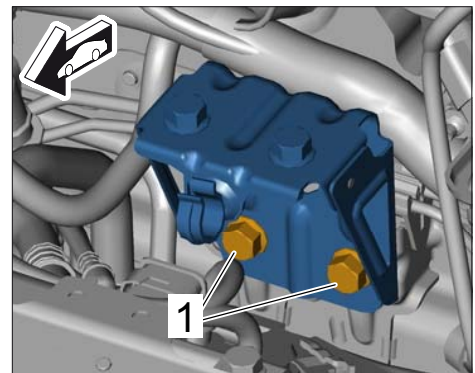


Figure 50

- 8.5 Secure the vacuum line.
- 8.5.1 Plug in vacuum line ⇒ *Figure 51* -**arrow A**- until it engages securely.
- 8.5.2 Clip in vacuum line at the battery console holder ⇒ *Figure 51* -**arrow B**-.

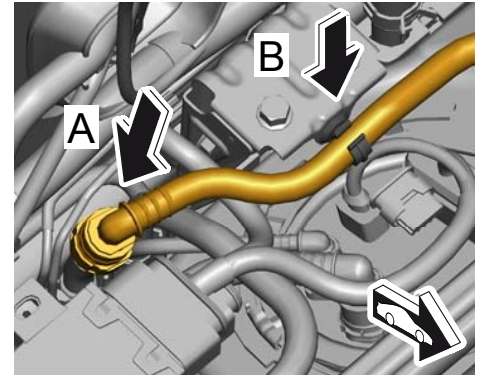


Figure 51

- 9 Install battery console.
- 9.1 Plug in connector for the fuel pump control unit at the underside of the battery console ⇒ *Figure 52* -**1**- until it engages securely.
- 9.2 Tighten fastening screws ⇒ *Figure 52* -**2**- for the battery console to the specified tightening torque. **Tightening torque 23 Nm (17 ftlb.)**

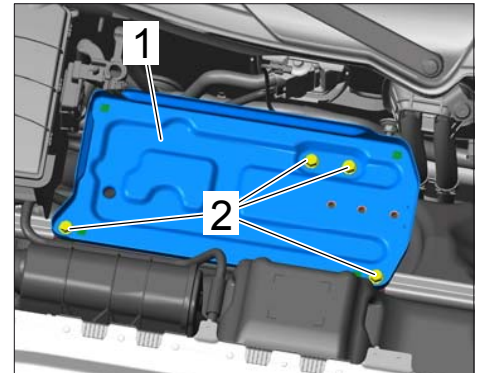


Figure 52

- 10 Install wiper linkage ⇒ *Workshop Manual '921919 Removing and installing wiper linkage* - section on "Installing".
- 11 Install front apron ⇒ *Workshop Manual '631519 Removing and installing front apron* - section on "Installing".
- 12 Install headlights at the left and right ⇒ *Workshop Manual '941519 Removing and installing headlights* - section on "Installing".
- 13 Install battery ⇒ *Workshop Manual '270619 Removing and installing battery* - section on "Installing".
- 14 Install front luggage compartment trim panel ⇒ *Workshop Manual '700519 Removing and installing front luggage compartment trim panel* - section on "Installing".
- 15 Install front trim at the left and right (wing flange) ⇒ *Workshop Manual '700219 Removing and installing front trim (wing flange)* - section on "Installing".
- 16 Enter the workshop campaign in the Warranty and Maintenance booklet.

**Attachment "B"**

**Claim Submission** - Workshop Campaign WC25

Warranty claims should be submitted via WWS/PQIS.

Open campaigns may be checked by using either the PIWIS Vehicle Information system or through PQIS Job Creation.

Labor, parts, and sublet will be automatically inserted when Technician is selected in WWS/PQIS.

**Applies to Scope 1 Only**

— Labor will be inserted automatically when the technician is selected in WWS. If necessary, the required part numbers will need to be manually entered into WWS by the dealer administrator.

— The sublet (miscellaneous Item) will be inserted automatically when the technician is selected in WWS.

Scope 1:

<b>Working time:</b>		
Reworking body seal		Labor time: <b>555 TU</b>
Includes:	<ul style="list-style-type: none"> <li>Removing and installing cover</li> <li>Removing and installing battery</li> <li>Work instructions after disconnecting the battery</li> <li>Removing and installing front luggage compartment trim panel</li> <li>Removing and installing front trim (wing flange)</li> <li>Removing and installing wiper arm</li> <li>Removing and installing cowl panel cover</li> <li>Removing and installing wiper linkage</li> <li>Removing and installing front wheel housing liner (front part)</li> <li>Removing and installing headlights</li> <li>Removing and installing battery console</li> <li>Removing and installing engine-compartment blower</li> <li>Removing and installing rear wheels</li> <li>Removing and installing rear wheel housing liner</li> <li>Removing and installing rear roof trim panel</li> <li>Checking and reworking rubber sleeves and stoppers</li> <li>Reworking seam seal</li> <li>Sealing body cavities</li> </ul>	
<b>Parts required:</b>		
999.915.337.40	Sealing foam	2 ea.
999.703.196.40	Stopper in luggage compartment, side	2 ea.
999.703.421.40	Stopper on longitudinal member, top	4 ea.
000.043.303.38	Adhesive film for longitudinal member, top	1 ea.
999.703.195.40	Stopper in luggage compartment, bottom (oval)	1 ea.

999.703.543.40	Stopper in luggage compartment, bottom (round)	1 ea.
911.095.932.20.xxx <b>or</b> 911.095.933.20.xxx	Touch-up stick for solid colors <b>or</b> Touch-up stick for metallic colors	2 ea.
WC250000001*	Body sealant commercially available, e.g. - Makra Evo-Seal 801 - Sikaflex 529 - Lord Fusor 804 - 3M MSP 8374	1 ea.* (For warranty invoicing only)
WC250000002*	Expendable items (adhesive tape, paper)	1 ea.* (For warranty invoicing only)
* The WWS Warranty system will automatically add into the "Miscellaneous item" section (sublet) of the claim after the claim has been submitted.		
⇒ <b>Damage code WC25 066 000 1</b>		

Scope 2: Scope 2 must be invoiced if the work is outsourced.

<b>Working time:</b>		
Reworking body seal		Labor time: <b>0 TU</b>
The work involved will be outsourced and will therefore be invoiced according to third-party (sublet) labor time.		
<b>Parts required:</b>		
999.915.337.40	Sealing foam	2 ea.
999.703.196.40	Stopper in luggage compartment, side	2 ea.
999.703.421.40	Stopper on longitudinal member, top	4 ea.
000.043.303.38	Adhesive film for longitudinal member, top	1 ea.
999.703.195.40	Stopper in luggage compartment, bottom (oval)	1 ea.



999.703.543.40	Stopper in luggage compartment, bottom (round)	1 ea.
911.095.932.20.xxx <b>or</b>	Touch-up stick for solid colors <b>or</b>	2 ea.
911.095.933.20.xxx	Touch-up stick for metallic colors	
WC250000001*	Body sealant commercially available, e.g. - Makra Evo-Seal 801 - Sikaflex 529 - Lord Fusor 804 - 3M MSP 8374	1 ea.* (For warranty invoicing only)
WC250000002*	Expendable items (adhesive tape, paper)	1 ea.* (For warranty invoicing only)
<p>* The WWS Warranty system will automatically add into the “Miscellaneous item” section (sublet) of the claim after the claim has been submitted.</p>		
<p><b>Third-party labor:</b></p>		
Removing and installing cover		Third-party labor time: <b>555 TU</b>
Removing and installing battery		
Work instructions after disconnecting the battery		
Removing and installing front luggage compartment trim panel		
Removing and installing front trim (fender flange)		
Removing and installing wiper arm		
Removing and installing cowl panel cover		
Removing and installing wiper linkage		
Removing and installing front wheel housing liner (front part)		
Removing and installing headlights		
Removing and installing battery console		
Removing and installing engine-compartment blower		
Removing and installing rear wheels		
Removing and installing rear wheel housing liner		
Removing and installing rear roof trim panel		
Checking and reworking rubber sleeves and stoppers		
Reworking seam seal		
Sealing body cavities		

⇒ **Damage code WC25 066 000 1**

- References:
- ⇒ Workshop Manual '852219 Removing and installing cover'
  - ⇒ Workshop Manual '270619 Removing and installing battery'
  - ⇒ Workshop Manual '700519 Removing and installing front luggage compartment trim panel'
  - ⇒ Workshop Manual '700219 Removing and installing front trim (wing flange)'
  - ⇒ Workshop Manual '922519 Removing and installing wiper arm'
  - ⇒ Workshop Manual '508719 Removing and installing cowl panel cover'
  - ⇒ Workshop Manual '921919 Removing and installing wiper linkage'
  - ⇒ Workshop Manual '505619 Removing and installing front wheel housing liner'
  - ⇒ Workshop Manual '941519 Removing and installing headlights'
  - ⇒ Workshop Manual '198119 Removing and installing engine-compartment blower'
  - ⇒ Workshop Manual '440519 Removing and installing wheel'
  - ⇒ Workshop Manual '536919 Removing and installing rear wheel housing liner'
  - ⇒ Workshop Manual '708519 Removing and installing rear roof trim panel'
  - ⇒ Workshop Manual '2X00IN Work instructions after disconnecting the battery'

**Important Notice:** Porsche Cars N.A Technical Bulletins are intended for use by professional technicians, not a "Do-it-yourselfer." They are written to inform these technicians of conditions that may occur on some vehicles, or to provide information that could assist in the proper service of a vehicle. Special tools may be required to perform certain operations identified in these bulletins. Use of tools and procedures other than those recommended in these bulletins may be detrimental to the safe operation of your vehicle. Properly trained technicians have the equipment, tools, safety instructions and know-how to do a job properly and safely. If a condition is described, do not assume that the bulletin applies to your vehicle, or that your vehicle will have that condition. See your Porsche Dealer for information on whether your vehicle may benefit from the information. Part numbers listed in these bulletins are for reference only. Always check with your authorized Porsche dealer to verify correct part numbers.

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