

Model(s)	Year	Eng. Code	Trans. Code	VIN Range From	VIN Range To	
Phaeton	2004 –2006	All	All	All	All	

## Condition

**57 15 02** July 20, 2015 **2039003** Supersedes Technical Bulletin V571407 dated December 18, 2014 to update service number.

**Corrosion on Front Doors (Multiple Locations)** 

Outer door areas (Figure 1-4):



Figure 1 – Upper window channel strip



Figure 1.1



Figure 2 – Central protective strip



Figure 2.1

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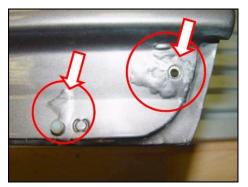


Figure 3 – Lower protective strip

Figure 3.1



Figure 4 – Surface/edge corrosion



Figure 4.1

**Inner door area** (Figure 5 and 6). Holes and edges in the flange area.



Figure 5





Figure 6 (front door, lower left)

## Note:

To determine if this procedure is covered under Warranty, always refer to the Warranty Policies and Procedures Manual.

Documentation required per Warranty Policies and Procedures Manual.

For vehicles outside of the *Limited Warranty Against Corrosion Perforation* this Technical Bulletin is for information only.

## **Technical Background**

Alignments in production can lead to hairline cracks in the top coat and paint damage (edges on holes) on the already painted door. Humidity then penetrates paint and causes blistering and/or white corrosion.

### **Production Solution**

Corrections in the production process after discovering deviations.

### Service

Procedure:

A. Repair front door <u>Only perform this operation if the total repair cost is 80% or less of the total replacement</u> <u>cost.</u>

or

B. Replace front door

Steps 1 and 2 should be completed regardless of repair or replacement of the door.

- 1. Central protective strip
- 2. Lower protective strip

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## 🕕 Note

- In most cases the protective strips are damaged when they are removed. Order, and as necessary, paint the required parts before the repair.
- Inspect the outer and inner doors in the visible area for further paint bubbles. As necessary repair according to Volkswagen guidelines.
- Inspect the fine seam sealing in the inner edge area of the doors for cracks, and as necessary, repair according to Volkswagen guidelines.

### A. Repair the front door as follows:

• Disassemble the door according to the repair manual. See Repair Group 57 in Elsa

If the affected area is only lightly corroded (no through-corrosion), proceed as follows:

- Inspect the inner edge area of the doors for cracks, particularly the fine seam sealing.
- Completely remove the corrosion in the damaged area.
- Apply a VOC compliant epoxy primer as an anti-corrosion treatment and primer to both sides of the door (locally sourced).
- Seal the edges/metal sheathings with adhesive (part number: AKD 476 KD505) before painting.
- Repaint door according to Volkswagen guidelines

#### B. Replace the front door as follows:

- Replace the door according to the repair manual. See Repair Group 57 in Elsa.
- · Paint new door according to Volkswagen guidelines.

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Steps 1 and 2 should be completed regardless of repair or replacement of the door.

### 1. Central protective strip

• Before installing the side protective strip, attach from the outside, and only on the front and rear holes/elongated hole (Figure 7 and 8, red arrows), a trim protective foil (part number: AKL 448 030 05) or similar as additional anti-chafing protection.



Figure 7

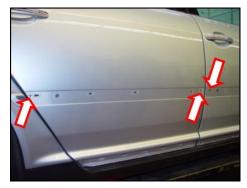


Figure 8: (example)

• Before installing the side protective strip, adhere (press) the foil around the hole lightly (e.g. with a ball pen, (Figure 9).

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## 🕕 Note

Make sure that the painted edges do not get damaged when attaching the foil.



### Figure 9 (example)

### 2. Lower protective strip

• Before installing the lower protective strip, attach on every front and rear hole (Figure 10, red arrows) from outside, a trim protective foil (part number: AKL 448 030 05) as additional anti-chafing protection.





• Before installing the protective strip, adhere (press) the foil around the hole lightly.

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 Attach new and loose plastic adjustment screws (Figure 11, red circle) with locking compound (part number: D 185 410 A2).



Figure 11: (example)

• Adjust the protective strip (according to the repair manual) within the hardening time of the locking compound (part number: D 185 410 A2).

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## Warranty

## **I**Note:

- Dealers may complete the repair as described without prior authorization (through a WISE Warranty Repair Acceptance request).
- Documentation required: Clear pictures, completed estimate and body shop invoice must be saved and kept on file at the Dealership for audit purposes.
- This bulletin applies for 1 door repair or replacement. If multiple doors exhibit the corrosion they should be evaluated individually and claimed on separates lines. Total Body Painting Prep Time for both doors should be claimed on the first line only.
- Labor time units (TU), Material units (MU), and Material unit rate are correct at the time of publication. The time units and/or material units may differ if the repair catalogue is updated. The information in the repair catalogue applies, except for the open time items (labor operations ending in 99) which are calculated at actual time multiplied by the body shop labor rate. The material allowance (Paint material price per unit) is subject to change. Refer to *WISE > Resource Center > Forms > Paint/Corrosion for the most current forms.*
- This section is applicable for vehicles within the terms of Volkswagen's Limited Warranty Against Corrosion Perforation. For vehicles outside the terms of the Limited Warranty Against Corrosion Perforation this section is for information only.
- This bulletin may be provided to outside shops to ensure the proper repair is completed.

### **I**Note:

### **Claim Processing Options**

**Option 1:** Utilize the attached form examples and interactive forms on WISE to assist with calculating the reimbursement amounts. **This will expedite the claim review process and reduce the time to pay the claim**.

Note that miscalculations are subject to claim adjustment.

For the complete set of pre-populated Paint/Corrosion Claim Form templates associated with this Technical Bulletin, refer to WISE > Resource Center > Forms > Paint/Corrosion.

**Option 2:** Email repair estimates to paintcamp@vw.com. The Paint and Corrosion Team will calculate the warranty allowance and complete the required form(s) on behalf of the dealer.

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Service Numbe 5729 Parts Manuf	er:	2006 160 <sup>1)</sup>	All SAGA Damage	All	All	All	
Service Numbe <mark>5729</mark> Parts Manuf	er:	160 <sup>1)</sup>		Coding			
<mark>5729</mark> Parts Manut	er:	160 <sup>1)</sup>	Damage	1			
<mark>5729</mark>			Damage				
Parts Manuf	ıfacturer		Code	HST		amage Location nds on Service No.)	
	Ifacturer		0003			060 or 062	
LACKMATF: Paint a		-	Phaeto	on (3D8)	060	or 062 <sup>2)</sup>	
LACKMATF: Paint a			Re	epair			
LACKMATF: Paint a	Plea	se use tl	he following part	number in "Outsid	e Materials" <sup>4)</sup>		
	and Mat	erials		MU @ \$12 per unit			
Epoxy Primer (Loca	ally Sou	rced)		Claim Dollar Amount (MAX: \$40)			
	Pleas	se use th	ne following Labo	r Operation in "Ou	tside Labor" <sup>4)</sup>		
Select the appropriate Labor Operation below: - L0010000: External Painting-straight color - L0020000: External Painting-metallic/2-layer - L0030000: External Painting-pearl color				Claim Dollar Amount			
Use this for all body repair in this bulletin: - A0041000: Body Shop repair no paint				Claim Dollar Amount			
			Re	place			
	Plea	se use tl	he following part	number in "Outsid	e Materials" <sup>4)</sup>		
LACKMATF: Paint a	and Mat	erials		MU @ \$12 per unit			

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Select the appropriate Labor Operation below: - L0010000: External Painting-straight color - L0020000: External Painting-metallic/2-layer - L0030000: External Painting-pearl color Use this for all body repair in this bulletin: - A0041000: Body Shop repair no paint Claim Dollar Amount Claim Dollar Amount Claim Dollar Amount Causal Part: L00#0000 GFF Time expenditure 0150000 = 00 TU max. NO Road Test 01210002 = 00 TU max. NO 01210004 = 00 TU Technical Diagnosis 0132000 = 00 TU Section Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim. <sup>1</sup> For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only <sup>2</sup> Corrosion claim vendor code will be the damage location. <sup>3</sup> Labor Time Units (TUs) are subject to change with ELSA updates. <sup>4</sup> Documentation required per <i>Warranty Policies and Procedures Manual.</i>					
- A0041000: Body Shop repair no paint       Claim Dollar Amount         Causal Part:       L00#0000         Diagnostic Time 4)       Diagnostic Time 4)         GFF Time expenditure       01500000 = 00 TU max.       NO         Road Test       01210002 = 00 TU olimitation on the section of Warranty Claim.       NO         Technical Diagnosis       01320000 = 00 TU       NO         Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim.       NO         ') For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only 2' Corrosion claim vendor code will be the damage location.       3' Labor Time Units (TUs) are subject to change with ELSA updates.	- L0010000: External Painting-straig	ght color Illic/2-layer	Claim Dollar Amount		
Diagnostic Time 4)         GFF Time expenditure       01500000 = 00 TU max.       NO         Road Test       01210002 = 00 TU       NO         01210004 = 00 TU       NO         Technical Diagnosis       01320000 = 00 TU       NO         Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim.         1) For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only         2) Corrosion claim vendor code will be the damage location.       3) Labor Time Units (TUs) are subject to change with ELSA updates.			Claim Dollar Amount		
GFF Time expenditure       01500000 = 00 TU max.       NO         Road Test       01210002 = 00 TU       NO         01210004 = 00 TU       01210004 = 00 TU       NO         Technical Diagnosis       01320000 = 00 TU       NO         Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim.       1) For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only         2) Corrosion claim vendor code will be the damage location.       3) Labor Time Units (TUs) are subject to change with ELSA updates.	Causal Part:		L00#0000		
Road Test       01210002 = 00 TU 01210004 = 00 TU       NO         Technical Diagnosis       01320000 = 00 TU       NO         Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim.       NO <sup>1</sup> ) For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only       si formation only <sup>2)</sup> Corrosion claim vendor code will be the damage location.       si Labor Time Units (TUs) are subject to change with ELSA updates.		Diagnos	stic Time <sup>4)</sup>		
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Claim Comment: Input "As per Technical Bulletin 2039003" in comment section of Warranty Claim. <sup>1)</sup> For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only <sup>2)</sup> Corrosion claim vendor code will be the damage location. <sup>3)</sup> Labor Time Units (TUs) are subject to change with ELSA updates.	Road Test				
<ul> <li><sup>1)</sup> For Vehicles outside the Limited Warranty Against Corrosion Perforation this bulletin is information only</li> <li><sup>2)</sup> Corrosion claim vendor code will be the damage location.</li> <li><sup>3)</sup> Labor Time Units (TUs) are subject to change with ELSA updates.</li> </ul>	Technical Diagnosis	01320000 = 00 TU	U NO		
<ul> <li><sup>2)</sup> Corrosion claim vendor code will be the damage location.</li> <li><sup>3)</sup> Labor Time Units (TUs) are subject to change with ELSA updates.</li> </ul>	Claim Comment: Input "As per Tec	hnical Bulletin 20	39003" in commen	t section of Warranty Claim.	
<sup>3)</sup> Labor Time Units (TUs) are subject to change with ELSA updates.				tion this bulletin is information only	
		-			
<sup>9</sup> Documentation required per warranty Policies and Procedures Manual.		•	-		
<sup>5)</sup> See attachment "srt_ref_table.pdf" for labor time reference.		-		ai.	



## **Required Parts and Tools**

Repair and Replace					
Part number	Designation				
AKD 476 KD505	Polyurethane adhesive sealant – Quantity: 0.25				
AKL 448 030 05	Protective Foil				
D 185 410 A2	Liquid locking fluid (Compound) – Quantity: 0.25				
One of the following					
3D0 853 299 A GRU	Front Left Side Protective Strip				
3D0 853 300 A GRU	Front Right Side Protective Strip				
3D0 854 939 C V7S	Front Left Lower Protective Strip (Cover for door)				
3D0 854 940 C V7S	Front Right Lower Protective Strip (Cover for door)				
Replace (One of the following)					
3D4 831 055 S	Front Left Door				
3D4 831 056 S	Front Right Door				

For Special Tools see Repair Manual.

## **Additional Information**

All part and service references provided in this Technical Bulletin are subject to change and/or removal. Always check with your Parts Dept. and Repair Manuals for the latest information.

#### **Paint/Corrosion Claim Form**



Dealer No.	4000	000	Examp					air	VIN (17-Digits)	WV	WZZZ3DZ	A60000		Jas Auto
Repair			Examp	16		• 6	(er	Jair	Color No. (4-di	git ElsaWeb	Paint No.)		LB5N	-
Order No.	9100	000 If	repeat repair, provide explan	ation ir	h box b	elow:			Dealer Labor F	-	,		100.00	
I			_				_		Paint material	price per unit	t		12.00	
			Ph	2	ρ	n	n		Dealer-owned	paint shop?	•	Yes	•	No
									Original paint r	naterial?	•	Yes		No
Service No.	Damage Code	Dmg Loc	Part manufacturer (Vendor Code)					Description of Repair		Pain	t Labor Oper	ration(s)	Time Units	Mat'l Units
5729	0003	061	061		• Pai	nt One F	ront Door (	S3)			57517903	3	130	
				1				. ,						
						Veri	fy ALL La	bor Operation Ti	mes and					
						Mat	erial Unit	:S	-					
								cc						1
								are affected the						1
								imed on the first	-					
						and	only the	first Paint/Corro	sion form					1
Note: Author	orization and		oursement are contingent on			original		Body Paint	ing Prep Time		51017173	3	160	
		μa	arts for the repair							_	Deint C			
The vehicle			or any previous damage. Digital p							e is a	Paint S	Subtotal	290	3
	SUDIE	t invoice for pa	inting, the invoice amount must b	be split t	etween	outside (s	sublet) labor	and outside (sublet) mai	eriai.					
Part Nu	mbor		Part Description	Part 0	Pa	rt Price	Total Part	Descripti	on of Repair	Re	pair/Replace	Labor	Time	
Fatting	umber		Part Description	Fart	<sup>rty</sup> p	er Unit	Price	Descripti			Operation(	s)	Units	
		Epoxy Prime	er		1 \$	40.00		Disassemble and re	assemble		5751375	0	370	
			/	1				front door						
				1				Remove corrosion f	rom front		5751630	0	70	
		<b>E</b> uropean la	Quantity and Dairy Qu					door/modify front	door					
		Example	Quantity and Price On	iiy -								0	30	
			parts should be claim	- be				Wax Body		i i	5101750			1
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	followin	ng location	d forms can be found i	in the				Wax Body					Units	
	followin WISE >	ng location Resource	d forms can be found i 1: Center > Forms > Paint	in the	E			Wax Body					Units	
	followin WISE > Corrosio	ng location Resource on > TB# -	d forms can be found i	in the	E			Wax Body					Units	
	followin WISE >	ng location Resource on > TB# -	d forms can be found i 1: Center > Forms > Paint	in the	E			Wax Body					Units	
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	followin WISE > Corrosio	ng location Resource on > TB# - repair.	d forms can be found i n: Center > Forms > Paint Form specific to the ve	in the				Wax Body			Example	e Time		
	followin WISE > Corrosio	ng location Resource on > TB# - repair.	d forms can be found i n: Center > Forms > Paint Form specific to the ve Material Part Amount	in the	tal \$		40.00	Wax Body			Example Body Labor S	e Time	470	
	followin WISE > Corrosio	ng location Resource on > TB# - repair.	d forms can be found in: Center > Forms > Paint Form specific to the ver Material Part Amount	in the t/ ehicle	tal \$		96.00	Wax Body			Example Body Labor S	e Time		
	followin WISE > Corrosid and the	ng location Resource on > TB# - repair.	d forms can be found i n: Center > Forms > Paint Form specific to the ve Material Part Amount	in the t/ ehicle	tal \$						Example Body Labor S Total	E Time	470	
VW Repre	followin WISE > Corrosid and the	ng location Resource on > TB# - repair.	d forms can be found in: Center > Forms > Paint Form specific to the ver Material Part Amount ITF Total Paint Materia Total Parts	in the t/ ehicle	tal \$		96.00	Wax Body			Example Body Labor \$ Total	E Time Subtotal TU/MU	470 760	290.00
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Warranty

VW Representative Name (printed)

VW Representative Signature

### **Paint/Corrosion Claim Form**



Dealer No.	400	000 🔎						VIN (17-Digits)	WVW	ZZZ3DZA600		Jas Auro
			Example If repeat repair, provide explana	<b>e</b> •	- K	eD	lace	Color No. (4-digit I			LB5N	
Repair Order No.	910	000 -	If report repair, provide evelop	ation in he				Dealer Labor Rate		raint No.)	100.00	-
								Paint material pric			12.00	-
			Ph	26	htr	n		Dealer-owned pair		-	12.00	
				ac				Original paint mate		Yes		No No
	_	_						Oliginal paint mate		Yes		
Service No.	Damage Code	Dmg Loc	Part manufacturer (Vendor Code)			I	Description of Repair		Paint I	Labor Operation(	5) Time Units	Mat'l Units
5729	0003	061	061		Paint One	e Front Door (	S3)			57516150	110	) 11
							oor Operation Ti	mes and				
					IVI	aterial Unit	S					
		<u> </u>			If I	Both doors	are affected the	prep time				
							imed on the first					
							first Paint/Corro	-				
Note: Authoria	orization an	d claim re	eimbursement are contingent on parts for the repair	the usage	e of origina	al .	Body Painti	ng Prep Time		51017153	160	
<b>T</b> I			line been been been been been been been b			1. I. I. M. H				Paint Subtota	d 270	) 11
The vehicle			d for any previous damage. Digital ph r painting, the invoice amount must be									
Part Nu	umber		Part Description	Part Qty	Part Pric per Unit		Descriptio	on of Repair		air/Replace Labor Operation(s)	Time Units	
							Remove and Install	One Front Door		57511900	50	)
							Replace one front d	oor		57515550	370	)
							Wax Body			51017500	30	)
	Full pre	-popula	ated forms can be found i	n the								
	followi											
			ce Center > Forms > Paint,									
			# - Form specific to the ve	hicle								
	and the	repair	•									
		<b> </b>										
									4			
		·	ide Material Part Amount			-			Bo	dy Labor Subtot	-	
		LAC	KMATF Total Paint Material			132.00			<u> </u>	Total TU/M	J 720	) 11
			Total Parts	Amount	\$	132.00					-	
VW Repre		r	TD 000000			_	Authorization Date			L00X000		270.00
Authori	zation No.		TB 2039003							A004100		450.00
							Authorization		Total	Outside Materia		132.00
							valid until		_	Tota	d: \$ 8	852.00
			Warranty									

VW Representative Name (printed)

VW Representative Signature

### SRT Reference Table for TPI# 2039003

Repair front door (Phaeton)		
Body Labor		
Labor Operation: Disassemble and reassemble front door	57 51 37 50 = 370 TU	
Labor Operation: Remove corrosion in damaged area. Modify affected areas as needed: 1. Upper window channel strip 2. Central side protective strip 3. Lower protective strip 4. Surface/edge corrosion	57 51 63 00 = * TU	Claim time units times labor rate in SAGA under Outside Labor Operation: A0041000
Labor Operation : Wax Body	51 01 75 00 = 30 TU	
<u>Refinish Labor</u>		
Labor Operation: Prepare painting	51 01 71 33 = 190 TU	Claim time units times labor
Labor Operation: Paint one front door (S3)	57 51 79 03 = 130 TU	rate in SAGA under Outside Labor Operation:
or Labor Operation: Paint one front door (S3/piano finish)	or 57 51 79 13 = 190 TU	L00 #0000* *Please see warranty table for proper labor operation
<u>Outside Materials</u>		
Labor Operation: Paint one front door or Labor Operation: Paint one front door. (S3/piano finish)	8 MU or 10 MU	Claim material unit times \$12.00 in SAGA under Outside Materials:
		ΙΑΛΚΜΑΤΕ

\* Front door replacement should be considered if the total repair cost will exceed 80% of the total replacement cost. Refer to the Reimbursement Policy section of the *Warranty Policies and Procedure Manual*. This section provides important guidelines when considering component repair vs. replacement options (the "80% rule").

Replace front door (Phaeton)		
<u>Body Labor</u>		
Labor Operation : Remove and install one front door	57 51 19 00 = 50 TU	Claim time units times labor rate in SAGA under
Labor Operation : Replace one front door	Outside Labor Operation:	
Labor Operation : Wax Body	51 01 75 00 = 30 TU	A0041000
<u>Refinish Labor</u>		
Labor Operation: Prepare painting	51 01 71 53 = 160 TU	Claim time units times
Labor Operation: Paint one front door (S3)	57 51 61 50= 110 TU	labor rate in SAGA under Outside Labor Operation:
or Labor Operation: Paint one front door (S3/piano finish)	or 57 51 61 60 = 160 TU	L00 <del>#</del> 0000*
(55/pidno linish)		Please see warranty table for proper labor operation
Outside Materials		
Labor Operation: Paint one front door	11 MU	Claim material unit times
or	or	\$12.00 in SAGA under
Labor Operation: Paint one front door. (S3/piano finish)	15 MU	Outside Materials: