

# Technical Service Bulletin



## 60 Sunroof frame modification

60 23 65 2065731/3 April 7, 2023. Supersedes Technical Service Bulletin Group 60 number 22-59 dated May 6, 2022, for reasons listed below.

Model(s)	Year	VIN Range	Vehicle-Specific Equipment
Q3, Q7, and Q8	2019 – 2022	All	Not Applicable
e-tron quattro	2019 2021 – 2022		
e-tron Sportback quattro	2020 – 2022		
SQ7, SQ8, and RS Q8	2020 – 2022		
e-tron S quattro	2022		
e-tron quattro, e-tron Sportback quattro, and e-tron S quattro	2023	000001 – 013040	
Q3	2023	000001 – 057223	
Q7, SQ7, Q8, SQ8, and RS Q8	2023	000001 - 008589	

## Condition

REVISION HISTORY		
Revision	Date	Purpose
3	-	Revised Header (Specify VIN breaks for production solution) Revised <i>Production Solution</i> (Solution implementation defined)
2	05/06/2022	Revised header (Add MY 2023)
1	01/09/2022	Initial publication

### Customer states:

Various complaints where the technical solution is to replace the front sunroof glass panel or sunroof frame.

### Workshop findings:

If it is necessary to replace the front sunroof glass panel or sunroof frame for any reason, it may be necessary to modify the sunroof frame.



## Technical Background

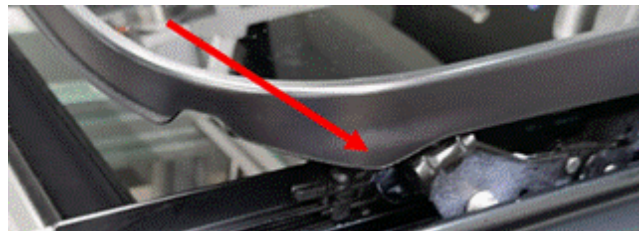
The development progression of the sunroof assembly has changed such that the replacement components, specifically the sunroof frame and front sunroof glass panel, may require a modification to complete the assembly compatibility.

## Production Solution

The interference between the sunroof frame and the front sunroof glass panel has been corrected in production. Only vehicles for which this TSB appears are affected and may require modification should replacement of the sunroof frame and/or front sunroof glass panel be necessary.

## Service

1. If the sunroof frame and/or front sunroof glass panel require replacement the water guidance washer on the sunroof mechanism pivot protrudes to the extent that the rubber “skirt” on the front glass panel also protrudes creating interference between the glass panel and the sunroof opening. This interference can prevent the front glass panel closing sequence from completing.
2. Figure 2 shows the location of the “skirt” protrusion from the water guidance washer.



**Figure 1.** The front sunroof glass panel side skirt is deformed due to a protruding water guidance washer.



**Figure 2.** Front sunroof glass panel side skirt protrusion from an unmodified water guidance washer.

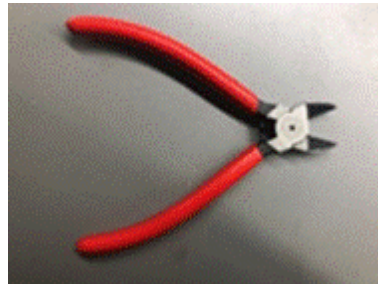


3. Figure 3 shows the water guidance washer with the front sunroof glass panel removed.



**Figure 3.** Water guidance washer on the front frame mechanism pivot.

4. Remove the front sunroof glass panel. Using a small pair of diagonal cutters (side cutters) trim away the water guidance washer. The washer must be cut back such that it protrudes no greater than the pivot pin. Perform this operation to both sides.





**Figure 4.** Diagonal cutters (side cutters).

5. Figure 5 shows the removed water guidance washer trimmed below the pivot pin. Since this pivot pin is concealed by the front sunroof glass panel “skirt” it is not necessary to smooth the edges of the cut surfaces.



**Figure 5.** Water guidance washer on the front frame mechanism pivot.



6.  **Note:**  
 During the modification procedure exercise extreme caution not to scratch or otherwise damage the surrounding metal components of the sunroof frame and lifting mechanism. Surround the area being modified with masking tape if necessary.
  
7.  **Note:**  
 Ensure that all plastic fragments from the water guidance washer created during the modification are removed completely. Use a vacuum cleaner if necessary. Stray plastic fragments from this modification that remain will cause permanent damage to the sunroof frame mechanism.
  
8. Reinstall the front sunroof glass panel and adjust it according to the specifications in ElsaPro. Remember to set the sunroof panel and rollershade end stop adaptation after reassembly using the sunroof panel and rollershade switches. Refer to TSB 2054505: *60 Sunroof glass panel or sunroof rollershade do not operate* for instructions.

## Warranty

<b>Claim Type:</b>	<ul style="list-style-type: none"> <li>• 110 up to 48 Months/50,000 Miles.</li> <li>• G10 for CPO Covered Vehicles – Verify Owner.</li> <li>• If the vehicle is outside of any warranty, this Technical Service Bulletin is informational only.</li> </ul>		
<b>Service Number:</b>	6028		
<b>Damage Code:</b>	0010		
<b>Labor Operations:</b>	Glass tilting roof panel (front) remove and reinstall.	60 39 19 00	See SRT with associated operations
	Perform modification to water guidance washer – Both sides	60 28 50 99	10 TU
<b>Diagnostic Time:</b>	GFF – Perform sunroof end stop adaptation	0150 0000	10 TU
	Road test prior to the service procedure	No allowance	0 TU
	Road test after the service procedure	No allowance	0 TU
<b>Claim Comment:</b>	As per TSB 2065731/3		

All warranty claims submitted for payment must be in accordance with the *Audi Warranty Policies and Procedures Manual*. Claims are subject to review or audit by Audi Warranty.

## Additional Information



The following Technical Service Bulletin(s) will be necessary to complete this procedure:

- TSB 2054505: *60 Sunroof glass panel or sunroof rollershade do not operate.*

All part and service references provided in this TSB (**2065731**) are subject to change and/or removal. Always check with your Parts Department and/or ETKA for the latest information and parts bulletins. Please check the Repair Manual for fasteners, bolts, nuts, and screws that require replacement during the repair.

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