Das Auto.

Technical Bulletin

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

Condition

58 14 04 December 18, 2014 2039211 Corrosion on Rear Doors (Multiple Locations)

Outer door areas (Figure 1-4):



Figure 1 – Upper window channel strip Fig



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).

Holes and edges in the flange area



Figure 5



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

or

B. Replace rear door

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

1. Central protective strip

2. Lower protective strip

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 rear door as follows:

• Disassemble the door according to the repair manual. See Repair Group 58 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 rear door as follows:

- Replace the door according to the repair manual. See Repair Group 58 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 outside, and only on the front and rear holes/elongated hole (Figure 6 and 7, red arrows), a trim protective foil (part number: AKL 448 030 05) or similar as additional anti-chafing protection.



Figure 6



Figure 7: (example)

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• Before installing the side protective strip, adhere (press) the foil around the hole lightly (e.g. with a ball pen, illustration 8).

Note

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



Figure 8: (example)

2. Lower protective strip

• Before installing the lower protective strip, attach on every front and rear hole (Figure 9, red arrows) from outside, trim protective foil (part number: AKL 448 030 05) as additional anti-chafing protection.



Figure 9

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



 Attach new and loose plastic adjustment screws (Figure 10, red circle) with locking compound (part number: D 185 410 A2).



Figure 10: (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

INote:

- 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.

INote:

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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Model(s)	Yea	r(s)	Eng. Code(s)	Trans. Code(s)	VIN Range	e From	VIN Range To	
Phaeton	2004·	2006	All	All	All		All	
			SAGA	Coding				
Claim Type:	Claim Type: 160 ¹⁾							
Service Num	ber:		Damage Code	HST	(age Location s on Service No.)	
5851			0003			1	60 or 162	
Parts Man	ufacture	r	Phaeto	on (3D8)		160 or	162 ²⁾	
			Re	pair				
	Plea	se use th	ne following part r	umber in "Outside	e Materials'	,, 4)		
LACKMATF: Pain	t and Mat	erials		MU @ \$12 per unit				
Epoxy Primer (Lo	cally Sou	rced)		Claim Dollar Amount (MAX: \$40)				
	Plea	se use th	e following Labor	r Operation in "Outside Labor" ⁴⁾				
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				
			Rep	lace				
	Plea	se use th	ne following part r	umber in "Outside	e Materials'	., 4)		
LACKMATF: Paint	t and Mat	erials		MU @ \$12 per un	it			
Please use the fol	lowing		ration in "Outoid	4)				

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Select the appropriate Labor Opera - L0010000: External Painting-straig - L0020000: External Painting-meta - L0030000: External Painting-pearl	ght color Ilic/2-layer	Claim Dollar Amo	unt				
Use this for all body repair in this b - A0041000: Body Shop repair no pa		Claim Dollar Amount					
Causal Part:		L00 <mark>#</mark> 0000					
Diagnostic Time ⁴⁾							
GFF Time expenditure	01500000 = 00 TU	J max.	NO				
Road Test	01210002 = 00 TU 01210004 = 00 TU		NO				
Technical Diagnosis	01320000 = 00 TU	J	NO				
Claim Comment: Input "As per Technical Bulletin 2039211" 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 lo	cation.					
³⁾ Labor Time Units (TUs) are subject	ct to change with I	ELSA updates.					
⁴⁾ Documentation required per <i>Warr</i>	anty Policies and	Procedures Manua	al.				
⁵⁾ See attachment "srt_ref_table.pdf	" for labor time re	ference.					



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					
3D7 853 073 B GRU	Rear Left Side Protective Strip				
3D7 853 074 B GRU	Rear Right Side Protective Strip				
3D7 854 949 A V7S	Rear Left Lower Protective Strip (Cover for door)				
3D7 854 950 A V7S	Rear Right Lower Protective Strip (Cover for door)				
Replace (One of the following)					
3D7 833 051 F	Rear Left Door				
3D7 833 052 F	Rear 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.

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Paint/Corrosion Claim Form



	4000	000							VIN (17-Dig	its)	wvw:	ZZZ3DZ	ZA60000	000	
Repair			Examp	JIE		ľ	(er	Jair	Color No. (4	-digit Elsa	Web Pa	int No.)		LB5N	J
Order No.	9100		repeat repair, provide expla						Dealer Labo	-				100.00	-
									Paint mater		r unit			12.00	
			Pł				h		Dealer-own					12.00	
					E	JU							Yes	-	No
	1								Original pair	nt material	?		Yes	•	No
Service No.	Damage Code	Dmg Loc	Part manufacturer (Vendor Code)					Description of Repai	r		Paint L	abor Oper	ration(s)	Time Units	Mat Unit
5851	0003	061	061		Pai	nt One F	Rear Door (S3)			1	5851790	3	130)
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Warranty VW Representative Name (printed)

VW Representative Signature

Paint/Corrosion Claim Form



Dealer No.	400	000 🔎		-				VIN (17-Digits)	\\/\/\	ZZZ3DZA6000		as Aun
			Exampl	e .	- K	en	lace					-
Repair Order No.	910	000 📍						Color No. (4-digit I		Paint NO.)	LB5N	-
Order No.			If repeat repair, provide explana	ation in bo	ox below:	-		Dealer Labor Rate			100.00	
			nL	-	+-			Paint material pric		_	12.00	
			Ph	dt	210			Dealer-owned pair	nt shop?	Yes	•	No
								Original paint mate	erial?	Yes		No
Service No.	Damage Code	Dmg Loc	Part manufacturer (Vendor Code)				Description of Repair		Paint I	abor Operation(s) Time Units	Mat'l Units
5851	0003	061	061		Paint One	Rear Door (S3)			58516150	90	8
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					Ma	terial Unit	S		-			
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									<u> </u>			
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L'						oth doors	are affected the	prep time			4	<u> </u>
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Part Nu	umber		Part Description	Part Qty	Part Price per Unit	Total Part Price	Descriptio	on of Repair		ir/Replace Labor Operation(s)	Time Units	
		1					Remove and Install	One Rear Door		58511900	50	
				l			Replace on rear doo			58515550	330	
							Wax Body		-	51017500	30	
							Wax Body			01011000		
											-	
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		seperate							-			
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		Outsic LACK	MATF Total Paint Material	Amount	\$	96.00			Bo	dy Labor Subtota Total TU/ML	_	
				Amount	\$				Bo	Total TU/MU	660	
VW Repre	esentative		MATF Total Paint Material Total Parts	Amount	\$	96.00	Authorization Date		Во	Total TU/ML	0 \$ 2	٤ 50.00
	esentative zation No.		MATF Total Paint Material	Amount	\$	96.00	Authorization Date		Во	Total TU/MU	0 \$ 2	
			MATF Total Paint Material Total Parts	Amount	\$	96.00	Authorization Date Authorizatior		_	Total TU/ML	0 \$ 2 0 \$ 2	8250.00
			MATF Total Paint Material Total Parts	Amount	\$	96.00			_	Total TU/ML L00X000 A004100	0 \$ 2 0 \$ 2 1: \$	250.00 10.00

VW Representative Name (printed)

VW Representative Signature

SRT Reference Table for TPI# 2039211

Body Labor		
Labor Operation: Disassemble and reassemble rear door 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	58 51 37 50 = 330 TU 58 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	
Refinish Labor		
Labor Operation: Prepare painting	51 01 71 33 = 190 TU	Claim time units times labor rate in SAGA under Outside
Labor Operation: Paint one rear door (S3)	58 51 79 03 = 110 TU	Labor Operation:
Or	Or	L00 # 0000*
Labor Operation: Paint one rear door (S3/piano finish)	58 51 79 13 = 160 TU	*Please see warranty table for proper labor operation
Outside Materials		
Labor Operation: Paint one rear door or Labor Operation: Paint one rear door. (S3/piano finish)	7 MU or 10 MU	Claim material unit times \$12.00 in SAGA under Outside Materials: LACKMATF

* 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 rear door (Phaeton)		
<u>Body Labor</u>		
Labor Operation : Remove and install one rear door	58 51 19 00 = 50 TU	Claim time units times labor rate in SAGA under
Labor Operation : Replace one rear door	58 51 55 50 = 330 TU	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 rate in SAGA under
Labor Operation: Paint one rear door (S3)	58 51 61 50 = 90 TU	Outside Labor Operation:
Or	Or	L00 # 0000*
Labor Operation: Paint one rear door (S3/piano finish)	58 51 61 60 = 130 TU	Please see warranty table for proper labor operation
<u>Outside Materials</u>		
Labor Operation: Paint one rear door or Labor Operation: Paint one rear door. (S3/piano finish)	7 MU or 11 MU	Claim material unit times \$12.00 in SAGA under Outside Materials: LACKMATF