

AH04 - Re-bonding Windshield (Stop Sale/Recall Campaign)

Vehicle Type: **911 (991)**

Model Year: **2017**

Subject: **Windshield**

Information: **There is a possibility that the windshield is not bonded sufficiently to the body on the affected vehicles.**

As a result, there is no guarantee that the degree of correct bonding will be sufficient to meet the necessary requirements.

Remedial Action: Re-bond windshield.

Affected Vehicles: Only the vehicles assigned to the campaign (see also PIWIS Vehicle information). This campaign affects 30 vehicles in North America.

Parts required

Important: **NOTE: PARTS WILL NOT BE AUTOMATICALLY ALLOCATED TO YOUR DEALERSHIP. ALL PARTS MUST BE ORDERED VIA A PTEC/PAV.**

Part No.:	Part No.	Designation	Qty.
	999 591 143 40	⇒ Clip	2 ea. (only if required)
	999 507 839 01	⇒ Clip	4 ea. (only if required)
	...	Adhesive set, i.e. Part No. 000 043 305 35 commercially available: - Teroson - Makra - 3M	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.

Required tools

Tools:

- **Special tools:**

Designation/Comment	Use
V.A.G 1344 - Suction Lifter	Removing windshield
VAS 6452 - Removal Kit for Flush Bonded Windows (Can be locally sourced)	
VAS 6452/2 - Wire for Removal Tool (Can be locally sourced)	
V.A.G 1561A - Special Electric Cutter (Can be locally sourced)	Preparing window aperture
VAS 5237 - Double cartridge gun VAS 5237	Applying adhesive
VAS 6430/3 - ACC reflector mirror	For calibrating front camera
VAS 6350/4 - Calibration Unit for Lane Change Assist	

- **Other tools:**

VAG 1561/20 Cutting ToolTorque wrench, 2 – 10 Nm (1.5 – 7.5 ftlb.), e.g. **V.A.G 1783 - Torque wrench, 2-10 Nm (1.5-7.5 ftlb.)**Torque wrench, 6 – 50 Nm (4.5 – 37 ftlb.), e.g. **V.A.G 1331 - Torque wrench, 6-50 Nm (4.5-37 ftlb.)****or equivalent**Pole terminal puller **VAS 6935 - Pole terminal puller or equivalent**Battery charger with a current rating of **at least 70 A**, e.g. **VAS 5908 90 amp Charger** or **INC-700 70 amp Schumacher Charger****9900 - PIWIS Tester 3**

Plastic assembly wedge (commercially available)

Re-bond windshield

Installation
position:



Installation position of windshield

- Work Procedure: 1 Remove A-pillar trim panel.
- 1.1 Remove front roof trim panel ⇒ *Workshop Manual '70831900 Removing and installing front roof trim panel (centre)'*.
 - 1.2 Remove sun visor ⇒ *Workshop Manual '682319 Removing and installing sun visor'*.
 - 1.3 Remove A-pillar trim panel ⇒ *Workshop Manual '705719 Removing and installing A-pillar trim panel (Cabriolet/Targa)'*.
- 2 Remove interior rear-view mirror ⇒ *Workshop Manual '682719 Removing and installing interior rear-view mirror'*.
- 3 Remove wire harness for rain sensor ⇒ *Workshop Manual '921219 Removing and installing rain sensor'*.
- 4 Remove cowl panel cover.
- 4.1 Remove wiper arm ⇒ *Workshop Manual '922519 Removing and installing wiper arm'*.

- 4.2 Remove cover ⇒ *Workshop Manual '852219 Removing and installing technical equipment space cover'*.
- 4.3 Remove cowl panel cover ⇒ *Workshop Manual '508719 Removing and installing cowl panel cover'*.
- 5 Remove and re-bond windshield ⇒ *Workshop Manual '641219 Removing and installing windscreen'*.
- 6 Install cowl panel cover.
 - 6.1 Install cowl panel cover ⇒ *Workshop Manual '508719 Removing and installing cowl panel cover'*.
 - 6.2 Install cover ⇒ *Workshop Manual '852219 Removing and installing technical equipment space cover'*.
 - 6.3 Install wiper arm ⇒ *Workshop Manual '922519 Removing and installing wiper arm'*.
- 7 Install wire harness for rain sensor ⇒ *Workshop Manual '921219 Removing and installing rain sensor'*.
- 8 Install interior rear-view mirror ⇒ *Workshop Manual '682719 Removing and installing interior rear-view mirror'*.
- 9 Install A-pillar trim panel.
 - 9.1 Install A-pillar trim panel ⇒ *Workshop Manual '705719 Removing and installing A-pillar trim panel (Cabriolet/Targa)'*.
 - 9.2 Install sun visor ⇒ *Workshop Manual '682319 Removing and installing sun visor'*.
 - 9.3 Install front roof trim panel ⇒ *Workshop Manual '70831900 Removing and installing front roof trim panel (centre)'*.
 - 9.4 On vehicles with front camera, calibrate the front camera. For instructions, see: ⇒ *Workshop Manual '963855 Replacing front camera'*.
- 10 Enter the campaign in the Warranty and Maintenance booklet.

Warranty processing



Information

The specified working times were determined specifically for carrying out this campaign and include all required preliminary and subsequent work.

The working times may differ from the working times published in the Labor Operation List in PIWIS.



Information

The preliminary and subsequent work must always be carried out by a Porsche dealer.

Note: Porsche dealers that carry out **this campaign fully** must submit an invoice for one of the Scopes 1 or 5.
 Porsche dealers that hand the vehicle over to an **external service provider** in order to carry out the **work required for removing and installing the windshield** must submit an invoice for Scopes 3 or 7.
 Please document a copy of the invoice for this in PQIS.

Scope 1: Scope 1 must be invoiced for vehicles **without front camera (I-no. +631/+632/+852)**.

Working time:

Re-bonding windshield

Labor time: **355 TU**

- Includes:
- Removing and installing A-pillar trim panel
 - Removing and installing interior rear-view mirror
 - Removing and installing wire harness for rain sensor
 - Removing and installing front roof trim panel (center)
 - Removing and installing sun visor
 - Removing and installing wiper arm
 - Removing and installing technical equipment space cover
 - Removing and installing cowl panel cover

Parts required:

999 591 143 40	Clip	2 ea. (only if required)
999 507 839 01	Clip	4 ea. (only if required)
AH040000001*	Cutting wire	1 ea. (for warranty invoicing only)*
000 043 305 35	Adhesive set	1 ea.
or		
AH040000002**	Adhesive set	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.

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⇒ **Damage Code AH04 099 000 1**

Scope 5:

Scope 5 must be invoiced for vehicles **with front camera (I-no. +631/+632/+852)**.

Working time:

Re-bonding windshield

Labor time: **422 TU**

Includes:

- Removing and installing A-pillar trim panel
- Removing and installing interior rear-view mirror
- Removing and installing wire harness for rain sensor
- Removing and installing front roof trim panel (center)
- Removing and installing sun visor
- Removing and installing wiper arm
- Removing and installing technical equipment space cover
- Removing and installing cowl panel cover
- Re-calibrating front camera

Parts required:

999 591 143 40	Clip	2 ea. (only if required)
999 507 839 01	Clip	4 ea. (only if required)
AH040000001*	Cutting wire	1 ea. (for warranty invoicing only)*
000 043 305 35	Adhesive set	1 ea.
or		
AH040000002**	Adhesive set	1 ea. (for warranty invoicing only)**

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⇒ **Damage Code AH04 099 000 1**

Scope 3: Scope 3 must be invoiced for vehicles **without front camera** (I-no. -631/-632/-852) if the work required for removing and installing the windshield is carried out by an **external service provider**.

Working time:

Re-bonding windshield

Labor time: **149 TU**

- Includes:
- Removing and installing A-pillar trim panel
 - Removing and installing interior rear-view mirror
 - Removing and installing wire harness for rain sensor
 - Removing and installing front roof trim panel (center)
 - Removing and installing sun visor
 - Removing and installing wiper arm
 - Removing and installing technical equipment space cover
 - Removing and installing cowl panel cover

The work involved in removing and installing the windshield is carried out by an external service provider and must therefore be invoiced as sublet labor time.

Parts required:

999 591 143 40	Clip	2 ea. (only if required)
999 507 839 01	Clip	4 ea. (only if required)
AH040000001*	Cutting wire	1 ea. (for warranty invoicing only)*
000 043 305 35	Adhesive set	1 ea.
or		
AH040000002**	Adhesive set	1 ea. (for warranty invoicing only)**

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Sublet labor:

Removing and installing windshield

Sublet labor time: **max. 206 TU**

⇒ Damage Code AH04 099 000 1

Scope 7:

Scope 7 must be invoiced for vehicles **with front camera** (I-no. -631/-632/-852) if the work required for removing and installing the windshield is carried out by an **external service provider**.

Working time:

Re-bonding windshield

Labor time: **215 TU**

Includes:

- Removing and installing A-pillar trim panel
- Removing and installing interior rear-view mirror
- Removing and installing wire harness for rain sensor
- Removing and installing front roof trim panel (center)
- Removing and installing sun visor
- Removing and installing wiper arm
- Removing and installing technical equipment space cover
- Removing and installing cowl panel cover

Re-calibrating front camera

The work involved in removing and installing the windshield is carried out by an external service provider and must therefore be invoiced as sublet labor time.

Parts required:

999 591 143 40	Clip	2 ea. (only if required)
999 507 839 01	Clip	4 ea. (only if required)
AH040000001*	Cutting wire	1 ea. (for warranty invoicing only)*
000 043 305 35	Adhesive set	1 ea.
or		
AH040000002**	Adhesive set	1 ea. (for warranty invoicing only)**

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Sublet labor:

Removing and installing windshield

Sublet labor time: **max.**
207 TU

⇒ **Damage Code AH04 099 000 1**

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