

Technical Service Bulletin

57 Outer door seals loose

57 16 31 2045542/2 October 10, 2016. Supersedes Technical Service Bulletin Group 57 number 16-30 dated September 30, 2016 for reasons listed below.

Model(s)	Year	VIN Range	Vehicle-Specific Equipment
A3	2017	All	Not Applicable
A3 cabriolet	2017	All	Not Applicable

Condition

REVISION HISTORY		
Revision	Date	Purpose
2	-	Revised <i>Service</i> (Change to cleaning material) Revised <i>Required Parts and Tools</i> (Alternative material info supplied)
1	09/30/2016	Initial publication

The outer door seals have become partially detached (Figure 1).



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Figure 1. The outer door seal, partially detached.

Technical Background

Loss of adhesion between the door structure and door seal due to a flaw in the attachment process in production.

Production Solution

An optimized production process has been implemented.

Service

In cases where the outer door seal has become partially detached, it may not be necessary to replace the outer door seal. Seals can be reattached provided they are not damaged, have not been previously repaired or previously reattached, and the detachment length does not exceed 20 cm.

1. Inspect all four doors.
 - If the door seal is undamaged, has not previously been repaired or reattached, and the area that is detached is less than 20cm in length, repair the door seal using steps 2 - 10 below.
 - If the door seal is damaged, has been previously repaired or reattached, or a length greater than 20cm is detached, replace the door seal according to the repair instructions in ElsaWeb:
 - For front doors, refer to *ElsaWeb >> Body >> Body Exterior >> 57 Front Doors, Central Locking System >> Door >> Outer Door Seal Removing and Installing.*
 - For rear doors, refer to *ElsaWeb >> Body >> Body Exterior >> 58 Rear Doors >> Door >> Outer Door Seal, Removing and Installing.*

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Note:

In addition to the repair manual instructions for replacing the door seals, observe the following: Thoroughly clean the area of seal attachment with undiluted Isopropyl alcohol. Allow the area of seal attachment to dry completely (at least 5 minutes). Apply bonding agent **D 355205A2** using a **D 00950025** applicator (or a suitable, lint-free applicator brush) to the seal attachment area. Allow to dry an additional 5 minutes.

If repairing the door seals, proceed as follows:

2. Ensure that the temperature of the door and outer door seal are not cooler than 70° F (21 °C), which is vital to ensure optimum adhesion of the outer door seal.
3. Fill a general purpose spray bottle with undiluted Isopropyl alcohol. Thoroughly clean the bonding surfaces of the doors to be repaired by spraying the contact surface and wiping with a clean cloth towel. Allow the bonding surfaces to dry completely (at least 5 minutes). The bonding surfaces must be dry and free of dust, grease, silicone, or any other similar contaminant that might compromise the adhesion.



Figure 2. Filling a general purpose spray bottle with Isopropyl alcohol to aid in the contact surface preparation.

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4. Apply bonding agent **D 355205A2** using a **D 00950025** applicator (or a suitable, lint-free applicator brush) in the area to be bonded. Allow the treated surface to dry an additional 5 minutes.
5. Thinly coat the outer door seal with rubber profile adhesive **D 477KD1A2** in the area that has become detached.



Note:

Only a very thin film of the adhesive is necessary. Excessive adhesive application will result in the cured adhesive being visible, as well as excessive drying times.

6. Press the door seal lightly to the door surface to ensure complete adhesive coverage on both the seal and door surfaces and then detach it again (Figure 3). This ensures that the glue is distributed as evenly as possible on the surfaces to be bonded. Take caution to not get adhesive outside the confines of the contact surface. Any excess adhesive must be thoroughly cleaned and removed before curing or the adhesive will be visible after the repair.



Figure 3. The door seal pressed to the door (A), and detached again (B).

7. Allow the adhesive on the surfaces to dry until the adhesive is very tacky (approximately 15 - 45 minutes, depending on the humidity in the air) while it is still detached.



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8. After allowing the seal to dry until tacky, attach the seal firmly to the door surface. Roll over the area several times with special tool **3356** (or equivalent).

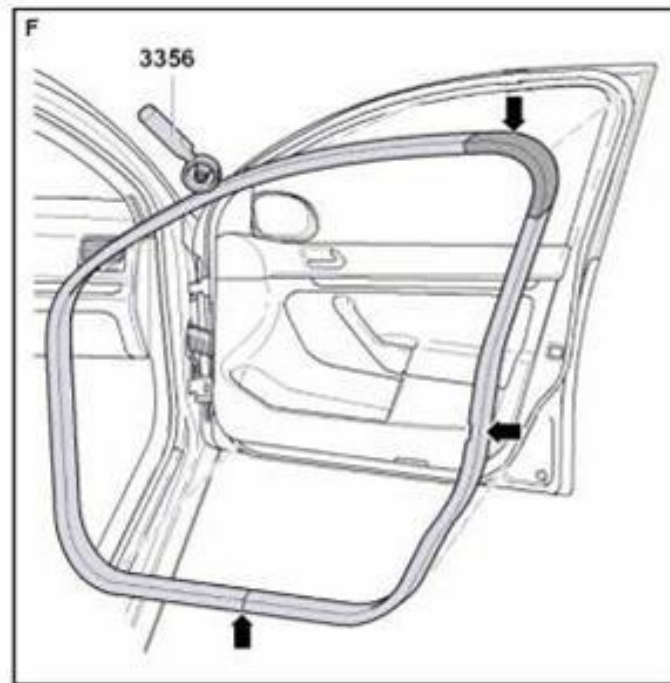


Figure 4. Use of special tool 3356.

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9. Apply force to the seal with the **3356** tool only at the base of the seal (Figure 5).



Figure 5. Apply force to the base of the seal (red arrow).

10. Use adhesive remover **D 002000A2** (or acetone) to remove any residual adhesive that may be visible.



Tip: Ideally the doors should not be closed for several hours, preferably overnight. This standing time will ensure that the doors can be closed without dislodging the seal. Instruct the customer to avoid opening and closing the doors during this curing period. The adhesive fully cures after 7 days. Also, the freshly glued and rolled seals should not be pulled on to test that they have bonded.



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Warranty

Claim Type:	<ul style="list-style-type: none"> • 110 up to 48 Months/50,000 Miles. • G10 for CPO Covered Vehicles – Verify Owner. • If vehicle is outside any warranty, this Technical Service Bulletin is informational only. 		
Service Number:	5765		
Damage Code:	0018		
	Front Door:		
	Front door trim panel remove and reinstall	7059 9999	40 TU
	Additional seal remove and reinstall and clean residual adhesive	5765 9999	70 TU
	Rear Door:		
	Rear door trim panel remove and reinstall	7073 9999	30 TU
	Rear door outer seal remove and reinstall and clean residual adhesive	5864 9999	70 TU
Diagnostic Time:	GFF	No allowance	0 TU
	Road test prior to service procedure	No allowance	0 TU
	Road test after service procedure	No allowance	0 TU
	Technical diagnosis at dealer's discretion (Refer to Section 2.2.1.2 and Audi Warranty Online for DADP allowance details)		
Claim Comment:	As per TSB #2045542/2		

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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.

Required Parts and Tools

Part Number	Part Description	Quantity Required per Door
-	Isopropyl Alcohol	0.25
D 355205A2	Bonding agent	0.25
- or -	-or-	
3M™ 111	 Adhesion Promoter	0.25
D 477KD1A2	Rubber profile adhesive	0.25
-or-	-or-	
3M™ Scotch Weld 847		0.25



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	High Performance Rubber and Gasket Adhesive	
D 002000A2	Adhesive remover	0.1
-or-	-or-	
Acetone	Acetone	0.1

Part Number	Part Description	Quantity Required per Vehicle
D 00950025	Applicator	1.0
- or-	- or-	
suitable, lint-free applicator brush	suitable, lint-free applicator brush	1.0

Tool Number	Tool Description	Note
3356	Roller	Equivalent, suitable tool may be used.

Additional Information

All parts and service references provided in this TSB (2045542) are subject to change and/or removal. Always check with your Parts Department and service manuals for the latest information.

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