

**Complaint - "Corrosion on Underbody Panelling Screws": Reworking screws (57/17)**

Model Line: **918 Spyder**

Model Year: **2015**

Subject: **Corrosion on underbody panelling screws**

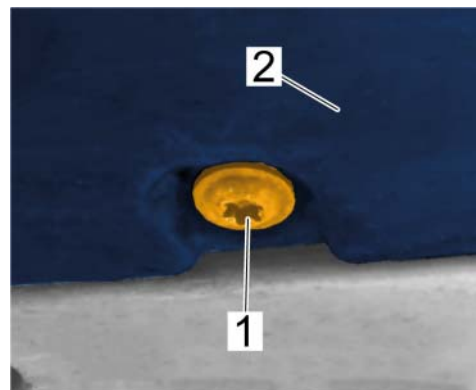
Information: **Traces of corrosion may be visible close to the fastening screws due to the material pairing.**

Remedial Action: Rework screws on underbody panelling.

- Tools:
- Brake cleaner
  - Polishing pad (commercially available, e.g. "NEVR-DULL")
  - Clean cloth

**Reworking screws on underbody panelling**

- 1 Unscrew the relevant fastening screw (⇒ *Fastening screw-1-*) and remove underbody panelling (⇒ *Fastening screw-2-*).



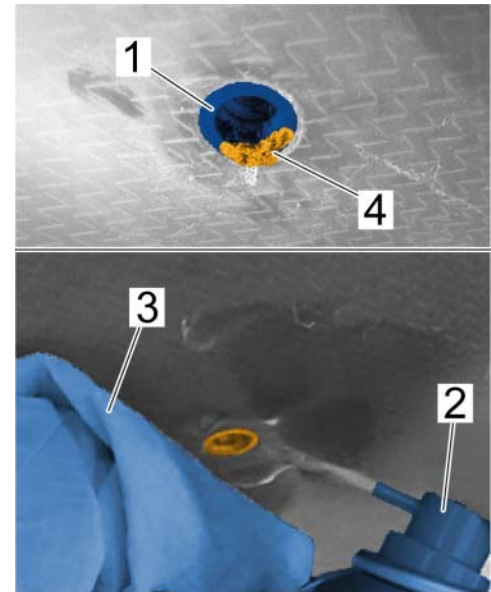
*Fastening screw*



**Brake cleaner**

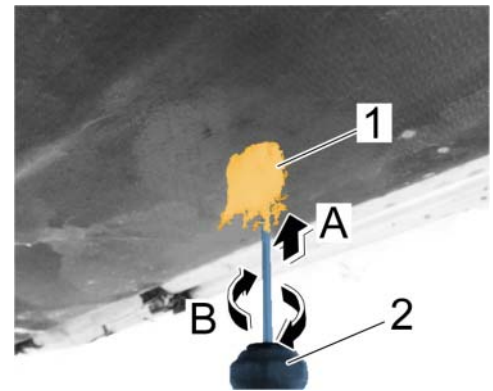
- ⇒ Wear personal protective gear.
- ⇒ Ensure that there is good ventilation.
- ⇒ Avoid contact with brake cleaner.

- 2 Clean threaded insert ( $\Rightarrow$  *Outside of threaded insert -1-*) from the outside using brake cleaner.
  - 2.1 Spray brake cleaner ( $\Rightarrow$  *Outside of threaded insert -2-*) onto the threaded insert ( $\Rightarrow$  *Outside of threaded insert -1-*) from the outside.
  - 2.2 Remove remaining corrosion ( $\Rightarrow$  *Outside of threaded insert -4-*) using a cloth ( $\Rightarrow$  *Outside of threaded insert -3-*).



*Outside of threaded insert*

- 3 Clean threaded insert from the inside.
  - 3.1 **Insert polishing pad** ( $\Rightarrow$  *Inside of threaded insert -1-*) using a suitable tool ( $\Rightarrow$  *Inside of threaded insert -2-*) into the threaded insert ( $\Rightarrow$  *Inside of threaded insert -arrow A-*).
  - 3.2 Clean threaded insert from the inside by rotating the pad ( $\Rightarrow$  *Inside of threaded insert -arrows B-*).
  - 3.3 **Pull the polishing pad** ( $\Rightarrow$  *Inside of threaded insert -1-*) out of the threaded insert.



Inside of threaded insert

**WARNING**

**Brake cleaner**

- ⇒ Wear personal protective gear.
- ⇒ Ensure that there is good ventilation.
- ⇒ Avoid contact with brake cleaner.

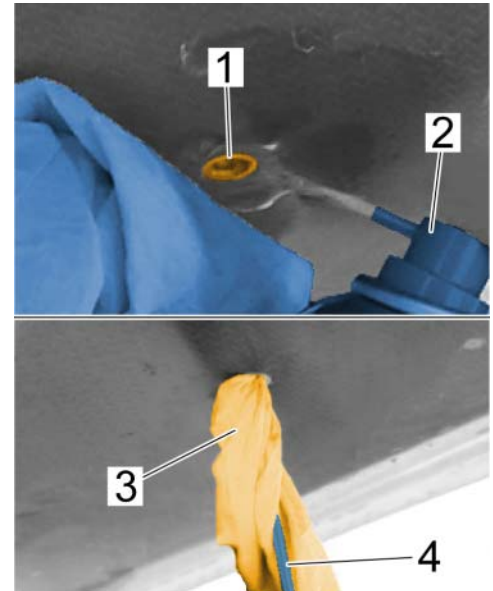
- 4 Clean threaded insert (⇒ *Cloth -1-*) from the inside using brake cleaner (⇒ *Cloth -2-*).
  - 4.1 Spray brake cleaner (⇒ *Cloth -2-*) into the threaded insert.
  - 4.2 Insert cloth (⇒ *Cloth -3-*) using a suitable tool (⇒ *Cloth -4-*) into the threaded insert (⇒ *Cloth -1-*).
  - 4.3 Clean threaded insert (⇒ *Cloth -1-*) from the inside.



**Information**

Make sure not to leave any residues in the threaded insert.

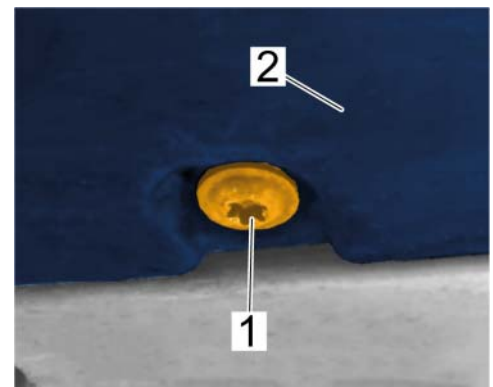
- 4.4 Pull the cloth (⇒ *Cloth -3-*) out of the threaded insert (⇒ *Cloth -1-*).



*Cloth*

- 5 Fit underbody panelling, screw in **new** fastening screws and tighten to ⇒ Tightening torque 10 Nm (7.5 ftlb.) .

Location	Explanation	Type	Basic value	Tolerance 1	Tolerance 2
Underbody panelling to underbody	Item 1	Tightening torque	10 Nm (7.5 ftlb.)		



*Fastening screws*

Invoicing:

APOS	Labor operation	I No.
51904950	Reworking underbody panelling	

For invoicing and documentation using PQIS, enter the following coding:

Location (FES5)	51930	Center cover
Damage type (SA4)	3311	Surface corrosion

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