Spare Parts Requirements - Tank Module / Charging Module: Reworking Rear Side Section (39 / 18)

Vehicle Type: **Panamera (971)**

Model Year: **As of 2017 up to 2018**

Subject: **Rear side section**

Information: **Side sections can crack when replacing the tank module or charging module.**

⇒ Example: Crack in rear side section

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Remedial Action: Rework rear side section.

Tools:
- Welder
- Welding cover
- Drill bit (2 mm)
- Milling tool
- File
- Sandpaper

Work Procedure: 1 **Preliminary work:**

1.1 **PHEV only:**

Isolate the high-voltage system from the power supply.

⇒ Workshop Manual '2X00IN Isolating high-voltage system from power supply/Starting high-voltage system'

⇒ Workshop Manual '2X00IN General warning notes for working on the high-voltage vehicle electrical system'

1.2 Remove rear wheel at the left or right.

⇒ *Workshop Manual '440519 Removing and installing wheel'*

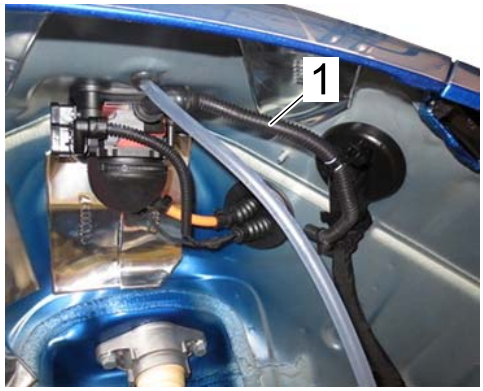
1.3 Remove rear wheel housing liner at the left or right.

⇒ *Workshop Manual '536919 Removing and installing rear wheel housing liner '*

1.4 Disconnect drain hose ⇒ *Drain hose on tank module/charging module* **-1-** on the tank module or charging module in the wheel arch.

Information

The tank module or charging module will be damaged during removal and must be replaced during installation.



Drain hose on tank module/charging module

1.5 Remove tank module or charging module including drain hose.

⇒ *Workshop Manual '553755 Replacing filler flap (module)'*

⇒ *Workshop Manual '554055 Replacing side section flap (module)'*

1.6 Remove insulating mat from the relevant rear side section ⇒ *Insulating mat on side panel* **-1-**.

1.7 **Only if the crack extends into the side section:**

Remove dent in the side section.

⇒ *Workshop Manual '0730IN Dent repairs'*

Insulating mat on side panel

CAUTION

Non-observance of safety instructions for body repairs

- **Risk of damage to the vehicle**
- **Danger of injury**

⇒ **Read the relevant safety instructions as well as general information and quality instructions ⇒ *Workshop Manual '5X00IN01 Safety instructions'*.**

2 **Rework rear side section:**

Information

Spot-drilling the crack prevents it from spreading.

2.1 Sand the crack area until bare and spot-drill the end of the crack using a 2-mm drill bit.

⇒ *Crack sanded down and spot-drilled*

2.2 Place a welding cover in the opening on the tank tray or charging tray - **when working on the tank tray, always fit the fuel tank cap beforehand**.

Crack sanded down and spot-drilled

⇒ *Welding cover (shown in charging tray)*

Welding cover (shown in charging tray)

CAUTION

Non-observance of safety instructions for body repairs

- **Risk of damage to the vehicle**
- **Danger of injury**

⇒ **Read the relevant safety instructions as well as general information and quality instructions ⇒ *Workshop Manual '5X00IN01 Safety instructions'*.**

CAUTION

Danger of explosion and fire from flying sparks during grinding and welding work!

- **Danger of injury and danger of damage to vehicle parts and other vehicles due to flying sparks**

⇒ **Cover vehicle parts such as battery, fuel system, paintwork, glass and passenger compartment parts with fire-proof covers and, if necessary, remove batteries and fuel-carrying components.**

⇒ **No other vehicles may be left unprotected in areas used for body repair!**

2.3 Weld the rear side section. ⇒*Workshop Manual '5X00IN10 Welding aluminium'*

⇒*Crack welded*

2.4 Sand down the welded seam using a milling tool, file and sandpaper.

Crack welded

⇒*Welded seam sanded down*

Welded seam sanded down

3 **Paint affected surface:**

⇒*Workshop Manual '0750IN Paint repairs'*

3.1 Sand the surface to be painted, apply primer and filler and then leave to dry for 30 minutes.

⇒ *Surface primed and filled*

3.2 Sand the filler, clean and mask the area to be painted and cover adjacent areas.

Surface primed and filled

3.3 Paint the affected surface: ⇒ *Surface painted*

3.3.1 Apply prime-coat paint.

3.3.2 Leave to dry for 10 minutes.

3.3.3 Apply clear lacquer.

3.3.4 Leave to dry for 30–45 minutes

3.4 Polish the affected side section.

Surface painted

⇒ *Side section polished*

Side section polished

4 **Subsequent work:**

4.1 Fit all removed components in reverse order again.

4.2 **PHEV only:**

Start the high-voltage system.

⇒ *Workshop Manual '2X00IN Isolating high-voltage system from power supply/Starting high-voltage system'*

4.3 Erase fault memory.

⇒ *Workshop Manual '033500 Fault memory for on-board diagnosis'*

End of action required.

Invoicing: The work involved is invoiced under the labor operation:

APOS	Labor operation	I No.
27080367	Testing high-voltage batteries	
55375500	Replacing filler flaps	
53554981	Reworking rear side sections	
51017113	Preparing body paintwork	
51017980	Painting the body	
53557903	Painting rear side sections	

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

Location (FES5)	53550	Rear side section
Damage type (SA4)	1521	Crack/tear

References:

⇒ *Workshop Manual '2X00IN Isolating high-voltage system from power supply/Starting high-voltage system'*

⇒ *Workshop Manual '2X00IN General warning notes for working on the high-voltage vehicle electrical system'*

⇒ *Workshop Manual '440519 Removing and installing wheel'*

⇒ *Workshop Manual '536919 Removing and installing rear wheel housing liner '*

⇒ *Workshop Manual '553755 Replacing filler flap (module)'*

⇒ *Workshop Manual '554055 Replacing side section flap (module)'*

⇒ *Workshop Manual '0730IN Dent repairs'*

⇒ *Workshop Manual '5X00IN10 Welding aluminium'*

⇒ *Workshop Manual '0750IN Paint repairs'*

⇒ *Workshop Manual '033500 Fault memory for on-board diagnosis'*