



Technical Service Bulletin

94 Headlight cracked/water ingress into headlight lens

94 19 08 2034735/3 May 31, 2019. Supersedes Technical Service Bulletin Group 94 number 14-42 dated May 29, 2014 for reasons listed below.

Model(s)	Year	VIN Range	Vehicle-Specific Equipment
A6	2012-2013	All	Xenon or LED Headlights
A6	2014	000001-041047	Xenon or LED Headlights

Condition

REVISION HISTORY		
Revision	Date	Purpose
3	-	Revised <i>Warranty</i> (Updated Labor Operations and added Claim Type) Revised <i>Required Parts and Tools</i> (Updated table)
2	05/29/2014	Revised header data (Updated VIN break) Revised <i>Service</i> (Removed parts table) Revised <i>Warranty</i> (Updated Labor Operations)
1	07/24/2013	Original publication

Customer states:



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- Heavy condensation is present in the headlight (Figure 1).



Tip: Review TSB 2012749, *94 Exterior lights, moisture accumulation*. Headlights that are applicable to TSB 2012749 do not apply to this bulletin unless cracking is present.



Figure 1. Headlight with heavy condensation.



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- Lower headlight lens is cracking (Figure 2 and Figure 3).



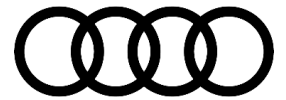
Figure 2. Lower headlight lens is cracking.



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Figure 3. Lower headlight lens is cracking.

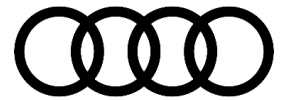


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- Upper headlight housing is cracking (at the transition from the lens to black surround) (Figure 4 and Figure 5).



Figure 4. Upper headlight housing is cracking.



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Figure 5. Upper headlight housing is cracking.

Workshop Findings:

- No visible external force marks (from accident or debris impact) are present.
- One or both sides may be affected.
- The vehicle is *not* equipped with halogen headlights.

Technical Background

The production process causes stress on the headlights from the bumper, as well as the torsional force from installation.

The moisture is an optical condition that does not affect the function or performance of the headlights, and it will not lead to corrosion or damage of the internal headlight parts.

Production Solution

Improved tempering of the headlight lens.

Service

Replace the affected headlight with the updated part number found in the ETKA parts catalog.

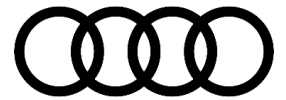


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Warranty

Claim Type:	<ul style="list-style-type: none"> • G10 for CPO Covered Vehicles – Verify Owner. • If the vehicle is outside any warranty, this Technical Service Bulletin is informational only. 		
Service Number:	9415		
Damage Code:	0015		
Labor Operations:	Remove and install the front bumper	6329 1900	See SRT
	Headlight assembly replace (Use if replacing one headlight only)	9415 5550 (Xenon) Or 9415 5551 (LED)	See SRT
	Headlight assembly replace (Use if replacing both headlights)	9415 5650 (Xenon) Or 9415 5651 (LED)	See SRT
	Remove and install one headlight (Use if replacing one headlight only)	9415 1950	See SRT
	Remove and install two headlights (Use if replacing both headlights)	9415 2050	See SRT
	Adjust headlights	9415 1650 (Non-LED) Or 9415 1651 (LED)	See SRT
Diagnostic Time:	GFF	0150 0000	Time stated on the diagnostic protocol (Max 30 TU)
	Road test prior to service procedure	No allowance	0 TU
	Road test after service procedure	No allowance	0 TU
Claim Comment:	As per TSB #2034735/3		

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.



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Required Parts and Tools

Always check with your Parts Department and/or ETKA for the latest information and parts bulletins.		
Part Number	Part Description	Quantity
See ETKA	Fasteners, Bolts, Nuts, and Screws as needed per the Repair Manual	See ETKA/ELSA
4G0941773E or 4G0941774E (if necessary)	LED Headlights	01 of each
4G0941753D or 4G0941754D (if necessary)	Xenon Headlights with AFS (PR Code 8Q5/8Q7)	01 of each
4G0941043E or 4G0941044E (if necessary)	Xenon Headlights without AFS (PR Code 8Q3)	01 of each

Additional Information

The following Technical Service Bulletin(s) will be necessary to complete this procedure:

- TSB 2012749, *94 Exterior lights, moisture accumulation.*

All parts and service references provided in this TSB (2034735) are subject to change and/or removal.

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