

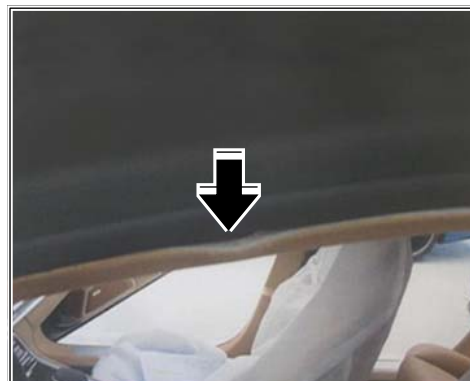
Complaint - Headliner is Sticking Out in the Door Seal Area: Re-Aligning Headliner (98/20)

Model Line: **Panamera (971)**

Model Year: **As of 2017**

Subject: **Headliner**

Information: The headliner in the door area can stick out over the inner door seal due to manufacturing tolerances ⇒ *Headliner*.



Headliner

- Remedial Action:
- Detach and check headliner.
 - Replace door seals in accordance with instructions.
 - Rework and align headliner.

Parts required

Parts Info:	Part No.	Designation - Use	Qty.
	971831721A	⇒ Front door seal - inner left	1 ea.
	971831722A	⇒ Front door seal - inner right	1 ea.
	971833721Y	⇒ Rear door seal - inner left (I-no. OE1 and K8D)	1 ea.
	971833722Y	⇒ Rear door seal - inner right (I-no. OE1 and K8D)	1 ea.
		or	

971833721C	⇒ Rear door seal – inner left (I-no. OE2)	1 ea.
971833722C	⇒ Rear door seal – inner right (I-no. OE2)	1 ea.
N 10596302	⇒ Internal hexagon round/oval-head screw – Sun visor	2 ea.
9A700794200	⇒ Bearing pin – D-pillar trim panel	2 ea.
9A700791500	⇒ Hexagon-head bolt – Belt installing on front seat	2 ea.

If the headliner is defective, also use:

Part No.	Designation – Use	Qty.
00004330535	⇒ 2-component window bonding agent, set – Windshield	1 ea.
971845522 ¹⁾	⇒ Windshield frame – Windshield	1 ea.
974867501 x	⇒ Headliner (I-no. K8D - Sport Turismo) or	1 ea.
971867505 x	⇒ Headliner (I-no. OE2 - long wheelbase) or	1 ea.
971867501 x	⇒ Headliner (I-no. OE1 - short wheelbase)	1 ea.

¹⁾ Replace only if damaged.

Preparatory work

Work Procedure: 1 Detach the headliner, see ⇒ *Workshop Manual '708419 Removing and installing headliner'*.



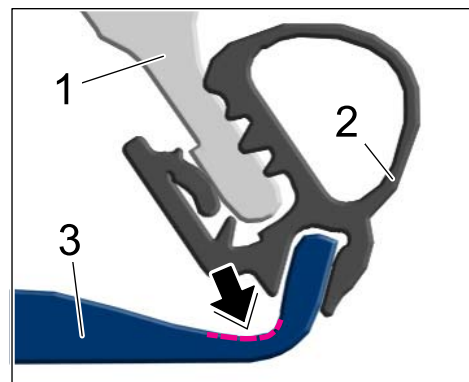
Information

Check whether the headliner ⇒ *Checking for kinks -3-* is kinked in the critical area ⇒ *Checking for kinks -Arrow-* and replace it if it is damaged.

- 1 – Bodyshell
- 2 – Door seal
- 3 – Headliner

2 Remove front door seals, see ⇒ *Workshop Manual '576319 Removing and installing front door seal'*.

3 Remove rear door seals, see ⇒ *Workshop Manual '586319 Removing and installing rear door seal'*.



Checking for kinks

Installing door seals and reworking and installing headliner

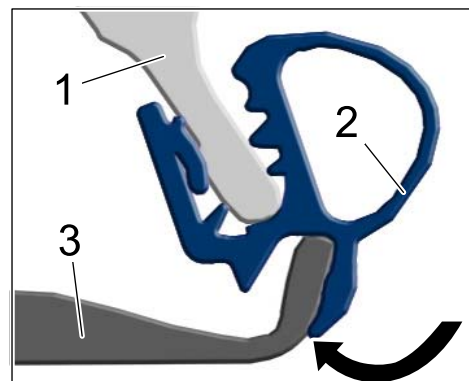
Work Procedure: 1 Install front and rear door seals, see ⇒ *Workshop Manual '576319 Removing and installing front door seal'* and ⇒ *Workshop Manual '586319 Removing and installing rear door seal'*.



Information

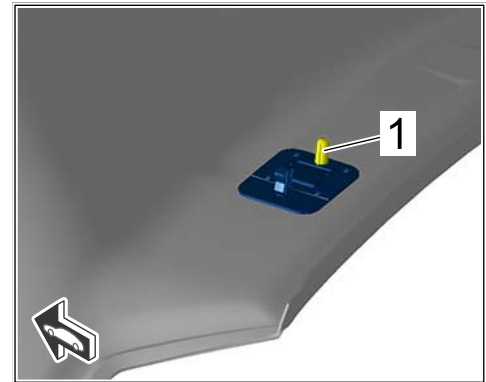
During installation, make sure that the door seals ⇒ *Installing door seals -2-* are installed facing inwards ⇒ *Installing door seals -Arrow-*.

- 1 – Bodyshell
- 2 – Door seal
- 3 – Headliner



Installing door seals

- 2 Remove centring mandrel on the rear left headliner ⇒
Rear left centring mandrel-1 - using a suitable tool.



Rear left centring mandrel

- 3 Remove centring mandrel on the front headliner ⇒
Front centring mandrel-1 - using a suitable tool.
- 4 Center the headliner over the screw-on points at the front. The distances with respect to the door seals must be the same.



Information

You will need a second mechanic to help you with this step.

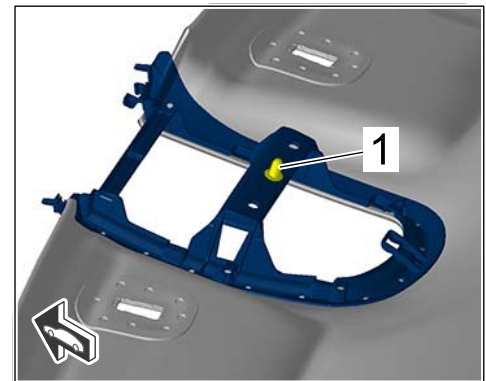
- 5 Carefully insert the headliner into the door seals.



Information

- Make sure not to kink the headliner when installing it.
- The headliner must **not** be bonded in the door seal area.

- 6 Pull door seals over the headliner from the outside in.



Front centring mandrel

Concluding work

Work Procedure: 1 Secure the headliner, see ⇒ *Workshop Manual '708419 Removing and installing headliner - section on "Installing"*.

Invoicing

Invoicing: For documentation and warranty invoicing, enter the labour operations, PQIS coding and part numbers specified below in the warranty claim:

APOS	Labour operation	I No.
70841900	Replacing headliner (I-no. 3FA)	
70841905	Replacing headliner (I-no. 3FE)	
70841910	Replacing headliner (I-no. 3FU)	
70844900	Reworking headliner (I-no. 3FA)	
70844905	Reworking headliner (I-no. 3FE)	
70844910	Reworking headliner (I-no. 3FU)	

PQIS coding:

Location (FES5)	70840	Headliner
Damage type (SA4)	1025	loosely installed

Parts Info:

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971831722A	Front door seal – inner right	1 ea.
971833721Y	Rear door seal – inner left (I-no. OE1 and K8D)	1 ea.
971833722Y	Rear door seal – inner right (I-no. OE1 and K8D)	1 ea.
	or	
971833721C	Rear door seal – inner left (I-no. OE2)	1 ea.
971833722C	Rear door seal – inner right (I-no. OE2)	1 ea.
00004330535 ¹⁾	2-component window bonding agent, set – Windshield	1 ea.
971845522 ²⁾	Windshield frame – Windshield	1 ea.
N 10596302	Internal hexagon round/oval-head screw – Sun visor	2 ea.

9A700794200	Bearing pin – D-pillar trim panel	2 ea.
9A700791500	Hexagon-head bolt – Belt installing on front seat	2 ea.

1) Only for new headliner.

2) Replace only if damaged.

References: ⇒ *Workshop Manual '708419 Removing and installing roof trim panel'*
⇒ *Workshop Manual '576319 Removing and installing front door seal'*
⇒ *Workshop Manual '586319 Removing and installing rear door seal'*

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