

**WLA4 - Retrofitting Heat Shield (Workshop Campaign)**

Revision: This bulletin replaces bulletin Group 1 19/20 WLA4, dated April 30, 2020.

Model Year: **As of 2014 up to 2019**

Vehicle Type: **911 Turbo (991)**

Subject: **Heat shield on rear cross member**

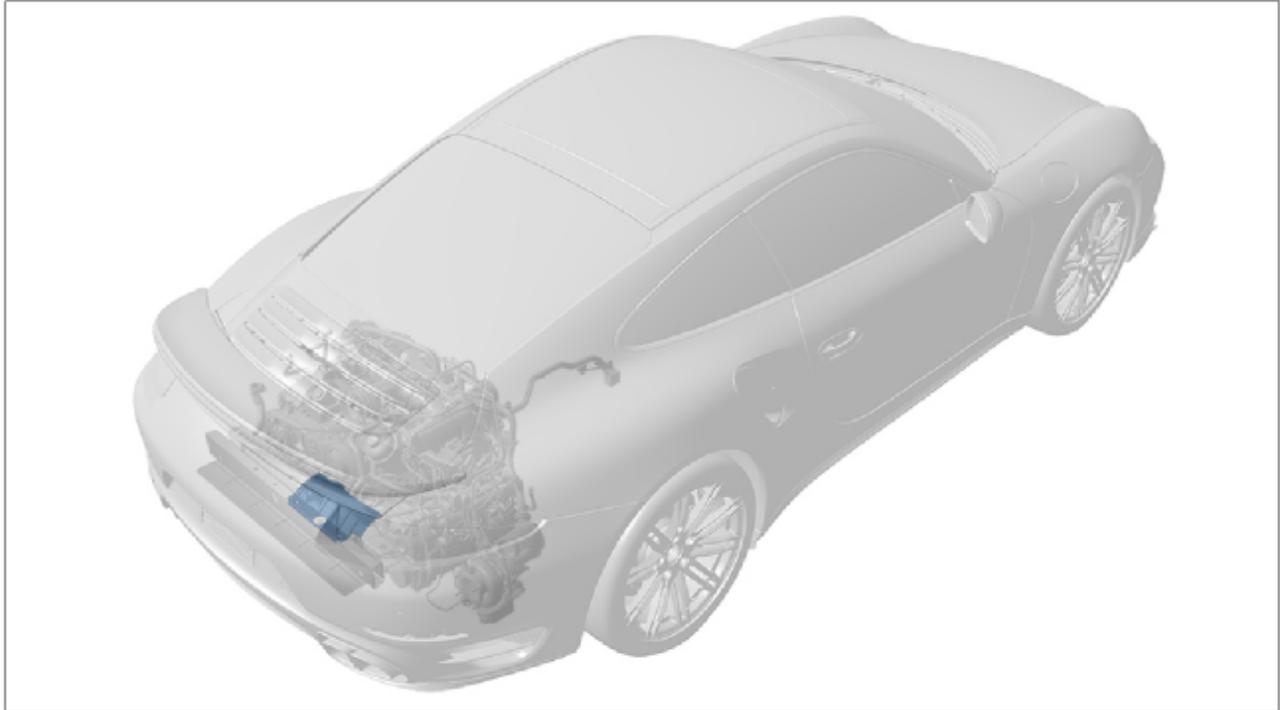
Information: **Foreign bodies, or material that is not part of the engine design or manufacture (e.g. cleaning cloths), in the engine compartment may touch hot exhaust system components, causing a potential fire hazard.**

Analysis of this damage has identified foreign objects or materials (e.g. cleaning cloths) found in the engine compartment as the cause of these incidents. Foreign objects or materials of this kind can touch hot exhaust system components while driving, causing them to ignite.

Remedial Action: Retrofit heat shield on rear cross member in the engine compartment. This shield may help to prevent any foreign objects or materials from touching exhaust-carrying or hot components in the engine compartment.

Affected Vehicles: Only the vehicles assigned to the campaign (see also PCSS Vehicle Information). This campaign affects 41,925 vehicles in North America.

Installation  
Position:



*Installation position of heat shield*

### Required parts and materials

Parts Info:	Part No.	Designation	Qty.
	00004330476	⇒ Heat shield	1 ea.
	00004330477	⇒ Blind rivet	2 ea.

Materials: **Required materials** (usually already available at the Porsche dealer):

- Corrosion protection paint (commercially available)\*

\* For warranty processing, the Part No. **WLA40000001** with the "expendable items" designation can be invoiced as an **additional part** in the warranty claim. Maximum cost: \$0.12.

### Required tools

- Tools:
- **PNA 713 001 5 - Rivet Tool** or commercially available riveting tool for blind rivets with a diameter of at least 4.2 mm (rivet pin)

- Commercially available HSS twist drill with a diameter of 6.5 mm
- 90° countersink tool or triangular scraper
- Battery-operated or hand drill
- Water-resistant pen
- Commercially available body brush
- Center punch

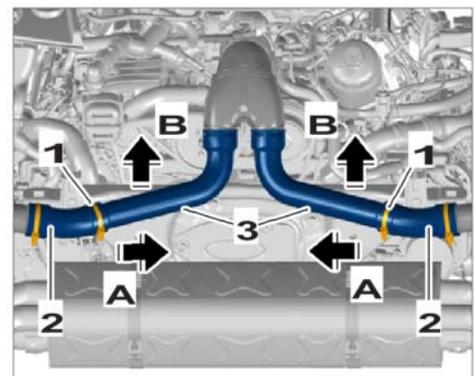
## Preparatory work

Work Procedure: 1 Remove air cleaner housing ⇒ *Workshop Manual '242519 Removing and installing air cleaner housing'*.

2 Loosen lower pressure pipe.

2.1 Loosen inner screw-type clamps ⇒ *Loosening lower pressure pipe -1-* and pull pressure pipes ⇒ *Loosening lower pressure pipe -3-* out of the pressure hoses ⇒ *Loosening lower pressure pipe -2-* (⇒ *Loosening lower pressure pipe -arrows A-*).

2.2 Pull pressure pipe at both sides up out of the rubber mounting in the cross member ⇒ *Loosening lower pressure pipe -arrows B-*.



*Loosening lower pressure pipe*

## Installing heat shield on rear cross member



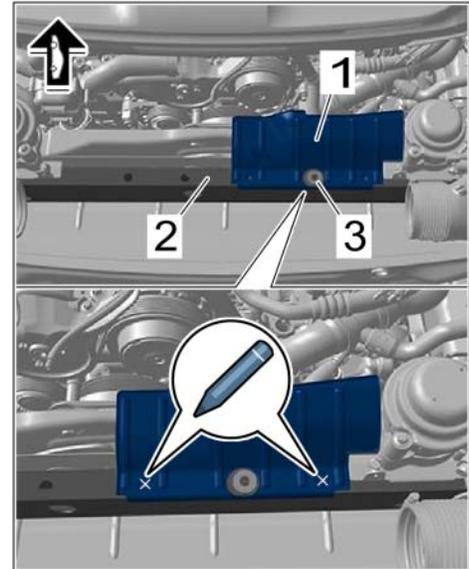
**Airborne metal debris and dust particles produced during grinding, drilling and milling**

- Risk of eye injuries
- Irritation to respiratory system

⇒ Wear personal protective equipment consisting of protective goggles, breathing mask and protective gloves.

Work Procedure: 1 Prepare for installing the heat shield on the rear cross member.

- 1.1 Position heat shield ⇒ *Marking installation position of heat shield -1-* on the cross member ⇒ *Marking installation position of heat shield -3-* as shown and align it using the rubber sleeve ⇒ *Marking installation position of heat shield -2-*.



*Marking installation position of heat shield*

Part No.	Designation	Qty.
00004330476	Heat shield	1 ea.

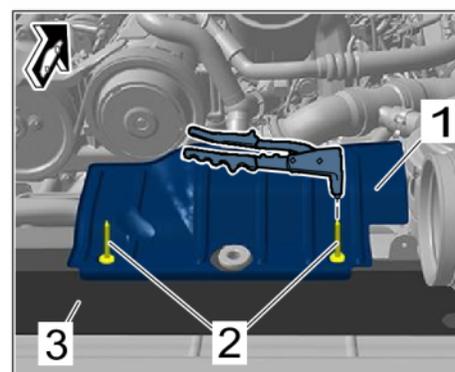
- 1.2 Mark the positions of the holes for the blind rivets that will be used later to secure the heat shield to the cross member.  
To do this, mark the position for the holes using a water-resistant pen as shown ⇒ *Marking installation position of heat shield.*

- 1.3 Punch the markings you made on the cross member using a center punch to make it easier for the drill to get a grip during subsequent drilling.
- 1.4 Carefully drill the cross member at the previously marked and punched positions using the hand drill and a **twist drill bit with a diameter of 6.5 mm**.  
Be particularly careful not to damage adjacent components while drilling and make sure to remove any drill chips immediately using a vacuum cleaner. Use a suitable base, if necessary, to protect components.
- 1.5 De-burr holes using a triangular scraper or a 90° tapered countersink.
- 1.6 Apply primer to the surface at the hole that is exposed as a result of drilling.



Drilling cross member

- 2 Secure heat shield on the cross member.
  - 2.1 Position heat shield ⇒ *Securing heat shield -1-* over the holes you made earlier on the cross member ⇒ *Securing heat shield-3-*.
  - 2.2 Insert blind rivet ⇒ *Securing heat shield -2-* into the mouthpiece of the blind riveting tool and install it fully into the first hole using the blind riveting tool.



Securing heat shield

Part No.	Designation	Qty.
00004330477	Blind rivet	2 ea.

- 2.3 Hold the blind riveting tool at a right angle to the cross member and press down firmly.
- 2.4 Actuate the blind riveting tool to fix the rivet.
- 2.5 After fixing the rivet, eject the spent rivet mandrel from the blind riveting tool. Gather up spent mandrels and dispose of them.
- 2.6 Repeat the riveting process on the second hole.

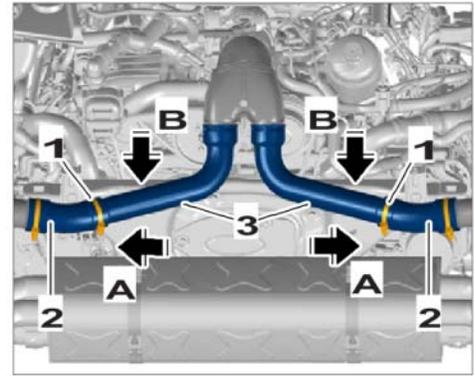
**Concluding work**

Work Procedure: 1 Secure lower pressure pipe.

- 1.1 Insert pressure pipes at the sides into the pressure hoses.
- 1.2 Press pressure pipes into the rubber mountings on the cross member
- 1.3 Position and tighten outer screw-type clamps.

**Tightening torque 5.5 Nm (4 ftlb.)**

- 2 Install air cleaner housing ⇒ *Workshop Manual '242519 Removing and installing air cleaner housing'*.
- 3 Enter the campaign in the Warranty and Maintenance booklet.



*Securing lower pressure pipe*

**Warranty processing**

Scope 1: **Only relevant for 911 Carrera (991)** – see Technical Information for these vehicle types

Scope 2: **Only relevant for 911 Turbo (991)**

**Working time:**

Retrofitting heat shield

Labor time: **176 TU**

Includes: Removing and installing rear spoiler  
Removing and installing air cleaner housing

**Parts required:**

00004330476	Heat shield	1 ea.
00004330477	Blind rivet	2 ea.

**Required materials:**

WLA40000001*	Expendable items *	1 ea. *
		(for warranty invoicing only)

\* For warranty processing, enter the Part No. **WLA40000001** with the "expendable items" designation as an **additional part** costing \$0.12 in the warranty claim.

⇒ **Damage Code WLA4 066 000 1**

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