

Spare Parts Requirements for High-Voltage Battery – Observe Additional Measure Required (34/21)

Revision: This bulletin replaces bulletin Group 2 34/21, dated April 5, 2021.

Model Year: **As of 2020 up to 2021**

Model Line: **Taycan (Y1A)**

Concerns: **Damping elements for high-voltage battery**

Information: After replacing the high-voltage battery or individual modules, noises can be heard while driving due to missing damping elements.

Action required: Before working on the high-voltage battery, check whether damping elements are installed on the old high-voltage battery. If the high-voltage battery or individual modules need to be replaced, new damping elements must be affixed to the high-voltage battery in this case.

Required tools and parts (if necessary)

- Tools:
- Universal cutter
 - Marking pen
 - Rule

Parts Info:	Part No.	Designation	Qty.
	9J1915448	⇒ Damping element, 240 x 60 x 3 mm / 9.45 x 2.36 x 0.12 in	18 ea.

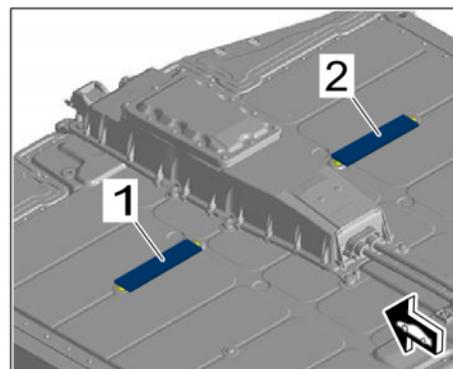
Preparatory work

Work Procedure: 1 Check whether damping elements are installed on the high-voltage battery at the front left ⇒ *Front damping elements -1-* and right ⇒ *Front damping elements -2-*.



Information

New damping elements must **not** be affixed if damping elements were not previously affixed. Otherwise, the high-voltage battery or underbody could be damaged.



Front damping elements

Affixing new damping elements (if required)

Work Procedure: 1 Shorten nine damping elements (240 x 60 x 3 mm/ 9.45 x 2.36 x 0.12 in) to a length of 177 mm/ 6.97 in.

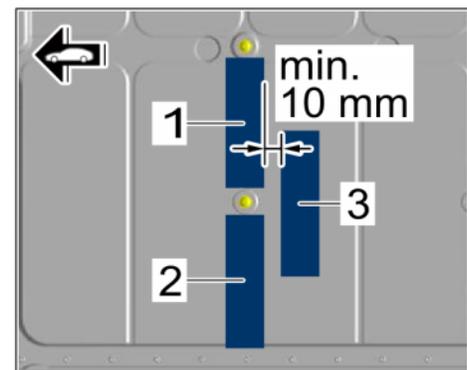
2 Stick three damping elements (177 x 60 x 3 mm/ 6.97 x 2.36 x 0.12 in) flush with each other. Three damping elements (element = stack of 3 pads) must then be installed on each side of the high-voltage battery even if only one damping element was affixed on each side of the old high-voltage battery.

- All sections of pads will be in stacks of 3 (will be 9mm/ 0.36 in thick when stacked together)
- This means 9 pads are used on each side; 18 per battery.

3 Position the first damping element ⇒ *Front left damping elements -1-* in the middle between the screws and stick it on.

**Information**

- Never affix damping elements over the screws as they must remain accessible.
- The damping elements must be pressed into existing depressions and pressed on all the way around.
- The individual damping elements must be **at least 10 mm/ 0.39 in** apart.



Front left damping elements

4 Position the second damping element ⇒ *Front left damping elements -2-* at the left next to the screw and stick it on.

5 Position the third damping element ⇒ *Front left damping elements -3-* in the middle under the screw and stick it on.

6 Repeat these steps for the right side.

Invoicing

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

APOS	Labor operation	I No.
27084990	Reworking high-voltage batteries	

PQIS coding:

Location (FES5)	2708T	High-voltage battery cover
Damage type (SA4)	3014	Scratches

Parts Info:

Part No.	Designation	Qty.
9J1915448	Damping element, 240 x 60 x 3 mm/ 9.45 x 2.36 x 0.12 in	18 ea.

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