


Front bumper/facia fit above headlamps

Topic number	LI88.20-P-071570
Version	3
Function group	88.20 - Bumpers
Date	10/7/22
Validity	BR290
Reason for change	Updated adhesive part number
Reason for block	old part number

Complaint

Bulging of front bumper above headlamps (see attachment). Function of headlights not blocked or impaired.

Attachments	
File	Description
Beanstandung.JPG 	Bulging on bumper above the headlamp

Cause

Bonding between bracket and bumper may be separating.

Remedy



Detach front bumper and check whether the brackets can be easily removed without damaging or deforming the bumper.

A) If the brackets can be easily removed without damaging or deforming the bumper --> Carry out the following rework:

1. Clean the inner side of the bumper and the new brackets and then apply primer.
2. Attach 3M tape as per Attachment 1.
3. Apply additional beads of adhesive (A 009 989 85 71 - Sikaflex ® 254 plus corresponding primer A009 989 75 71 - Sikaflex ® 209 Prime) between and next to the 3M tape, as per Attachment 2.
4. Bond the brackets to the inner side of the bumper and allow to cure sufficiently.

XENTRY TIPS

B) If the brackets cannot be removed without damaging or deforming the bumper (bond too strong) --> Perform procedure A, and replace the bumper.

Attachments	
File	Description
Halter_mit_3M.JPG 	Attachment 1
Kleberauppen.JPG 	Anhang 2

Symptoms
Body > Bumper > Poor fit

Parts						
Part number	ES1	ES2	Designation	Quantity	Note	EPC
A2908850501			Left bumper bracket	1		X
A2908850601			Right bumper bracket	1		X

Operation numbers/damage codes				
Op. no.	Operation text	Time	Damage code	Note