



94-23-01 - Headlamp: Rubber lip-seal (between headlight and fender) loose

Release date: 10/17/2023

## Condition

Applicable Vehicles					
Model(s)	Year	Eng. Code	Trans. Code	VIN Range From	VIN Range To
Golf R, GTI	2022 - 2024	All	All	All	All

Revision Table			
Instance Number	Published Date	Version Number	Reason For Update
2069487/4	10/17/2023	94-23-01	Update to model year applicability.
2069487/2	4/6/2023	94-23-01	Update to part quantity.
2069487/1	2/15/2023	94-23-01	Original publication.

## Technical Background

Incorrect assembly of the rubber lip/seal in the assembly process. This can result in damage to the locking lug. As a result of the damage to the locking lug, the rubber lip/seal comes loose or protrudes.

This procedure will help and eliminate the need for headlamp replacement.



**Note:**

Headlamp assembly replacements with this concern could be subjected to debiting upon review.

## Production Solution

Not applicable.

## Service

### Glue the rubber lip/seal

The rubber lip/seal (see Figure 1, red arrow) between the headlamp and the fender (left/right) is loose/detaching/is off.

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Figure 1.

**Procedure for gluing the rubber lip/seal:****Prepare rubber lip/seal:**

Remove headlamp assembly. See repair manual Group 94 in Elsa.

Thoroughly clean the adhesive surface of the rubber lip/seal with isopropanol/water (mixing ratio: 50/50). Air the adhesive surface well. PN# D--009-40-104.

**Note:**

Use only 91%+ Isopropyl alcohol as a cleaner (9% water). Always allow cleaner to fully evaporate prior to starting the installation. Do not use Isopropyl with any additional surfactants (cleaners) or additives (scents). All installation areas must be completely free of any detergent, wax or detailing residue for proper adhesion.

Shake adhesion promoter/plastic primer (D 181220A1) well before use. Apply thinly and evenly with a sponge brush (see figure 2, part number: D 009 500 25) to the adhesive surface of the seal. Flash-off time 3min.

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Figure 2.

- Remove approximately 20 cm of adhesive tape (see figure 3, part number: D 438P11M3). Apply the adhesive tape to the primed surface of the rubber lip/seal and press firmly.



Figure 3.

**Tip:**

**One roll of double sided tape will do approximately 30 vehicles.**

**Prepare headlamps:**

- Thoroughly clean the adhesive surface on the headlamp with isopropanol/water (mixing ratio: 50/50). Allow the adhesive surface to dry well.
- Remove the liner/protective film from the adhesive tape on the rubber lip/seal (see figure 4, red).
- Apply the rubber lip/seal with adhesive tape to the headlamp and press firmly (see figure 5).

**Note:**

After 30 minutes, the final bonding strength of the adhesive tape is about 80%.



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Figure 4.



Figure 5

- Reinstall headlamp assembly. See repair manual Group 94 in Elsa.



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## Warranty

<b>To determine if this procedure is covered under Warranty, always refer to the Warranty Policies and Procedures Manual <sup>1)</sup></b>					
Model(s)	Year(s)	Eng. Code(s)	Trans. Code(s)	VIN Range From	VIN Range To
Golf R, GTI	2022 - 2024	All	All	All	All
<b>SAGA Coding</b>					
<b>Claim Type:</b>			<b>Use applicable Claim Type <sup>1)</sup></b>		
Service Number:	Damage Code	HST		Damage Location (Depends on Service No.)	
9415	0018	--		001 = Left 002 = Right	
Parts Manufacturer	Golf R, GTI		WG8		
If one headlamp is affected:					
<b>Labor Operation <sup>3)</sup></b> : Headlight assembly remove+Install			94151950 = 20 TU		
<b>Labor Operation <sup>3)</sup></b> : Radiator grill remove+install			66051900 = 20 TU		
<b>Labor Operation <sup>3)</sup></b> : Front bumper cover remove+install			63295040 = 40 TU		
<b>Labor Operation <sup>3)</sup></b> : Repair headlight			94154199 = 20 TU		
<b>Labor Operation <sup>3)</sup></b> : Headlight assembly adjusted			94151650 = 20 TU		
If both headlamps are affected:					
<b>Labor Operation <sup>3)</sup></b> : Headlight assemblies remove+Install			94152050 = 40 TU		
<b>Labor Operation <sup>3)</sup></b> : Radiator grill remove+install			66051900 = 20 TU		



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<b>Labor Operation</b> <sup>3)</sup> : Front bumper cover remove+install		63295040 = 40 TU
<b>Labor Operation</b> <sup>3)</sup> : Repair both headlights		94154299 = 30 TU
<b>Labor Operation</b> <sup>3)</sup> : Headlight assembly adjusted		94151650 = 20 TU
<b>Causal Part: Select labor operation</b>		9415****
<b>Diagnostic Time</b> <sup>4)</sup>		
<b>GFF Time expenditure</b>	01500000 = Actual GFF print out	Yes
<b>Road Test</b>	01210002 = 00 TU 01210004 = 00 TU	NO
<b>Technical Diagnosis</b>	01320000 = 00 TU max.	NO
<b>Claim Comment:</b> Input "As per Technical Bulletin 2069487" in comment section of Warranty Claim.		
<p><sup>1)</sup> Vehicle may be outside any Warranty in which case this Technical Bulletin is informational only.</p> <p><sup>2)</sup> Code per warranty vendor code policy.</p> <p><sup>3)</sup> Labor Time Units (TUs) are subject to change with ELSA updates.</p> <p><sup>4)</sup> Documentation required per Warranty Policies and Procedures Manual.</p>		

### Required Parts and Tools

Part No:	Part Description	Quantity
D 438P11M3	Adhesive tape	.033
D 009 500 25	Sponge brush	1
D 181220A1	Adhesion promoter/Plastic primer	.033
D--009-40-104	91%+ Isopropyl alcohol	.033
<b>Part numbers are accurate at time of publication. Always refer to ETKA for the latest part information.</b>		



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## Additional Information

All part and service references provided in this Technical Bulletin are subject to change and/or removal. Always check with your Parts Dept. and Repair Manuals for the latest information.