Connection offline

Technical product information

Topic	Rear Quarter Panel LH/RH - Body Adjustment Process | Continental GT | 18-24MY
Market area	Bentley: worldwide (2WBE),China 796 VW Import Comp. Ltd (Vico), Beijing (6796)
Brand	Bentley
Transaction No.	2080998/2
Level	EH
Status	
Release date	

New customer code

Object of complaint	Complaint type	Position
body -> exterior parts -> wing	dimensional accuracy -> flushness: protrusion	rear left
body -> exterior parts	dimensional accuracy	
body -> exterior parts -> wing	dimensional accuracy -> flushness: recess	rear right
body -> exterior parts -> wing	dimensional accuracy -> flushness: protrusion	rear right
body -> exterior parts -> wing	dimensional accuracy -> shut line too large	rear right
body -> exterior parts -> wing	dimensional accuracy -> flushness: recess	rear left
body -> exterior parts -> wing	dimensional accuracy -> shut line too large	

Vehicle data

Continental GT

Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
3S3*	2018	E		*	*	*
3S3*	2019	E		*	*	*
3S3*	2020	E		*	*	*
3S3*	2021	E		*	*	*
3S3*	2022	E		*	*	*
3S3*	2023	E		*	*	*
3S3*	2024	E		*	*	*

Documents

Document name
master.xml

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Technical product information

Transaction No.: **2080998 /2**

Rear Quarter Panel LH/RH - Body Adjustment Process | Continental GT | 18-24MY

Customer statement / workshop findings

Following body repair involving the rear side panel area, improper alignment may be observed between the side panel, rear lamp, and boot lid. Inspection confirms that dimensional integrity in the Y direction does not meet manufacture specifications.

Revision History – 2080998/2 – TPI now external facing, 99 code removed from warranty instructions.

Technical background

If dimensional alignment cannot be achieved using standard adjustment methods, carry out the alignment and modification procedure described in this bulletin to restore correct panel positioning and visual quality.

Refer to the *'Measure'* section and perform all steps to completion.

NOTICE

This information is strictly internal only. These steps describe the metal adjustment process required when fitting affected panels and will only be supplied upon approval of the Body & Trim TM.

Production change

Revised panels implemented in series production. Vehicles produced 25 model year and onwards are not affected.

Measure

DANGER

Aluminium and steel grinding dust can create a serious explosive fire hazard when mixed. When carrying out body repair work on multi-material vehicles (Steel/Aluminium) the following Exhaust extraction system -VAS 6572/2- MUST always be used. Refer to "Extraction systems for multi-material body repairs" ElsaPro → Rep. Gr. 99

CAUTION

Follow all ElsaPro structural repair safety procedures. Including but not limited to: Isolate 12V battery before cutting, grinding or welding, Use approved PPE including eye, respiratory and heat protection. Shield wiring, lamps, trim and flammables.

The following procedure is based on a left-hand outer side panel rear. The right-hand side is similar except for the fuel flap (dependent on market region).

1. Refer to *ElsaPro Body Repairs → Rep. Gr. 53 – Side Panel Rear: Replacement*

Follow all specified instructions for general task preparation, removing and preparing the new rear side (quarter) panel for installation.

NOTICE

The instructions below are supplementary to the *'Preparing Body for Installation'* section and apply ONLY when misalignment is observed between the side panel, rear lamp, and boot lid.

2. Position the replacement side panel assembly on the vehicle, leaving the relevant joining area unfastened to allow adjustment.

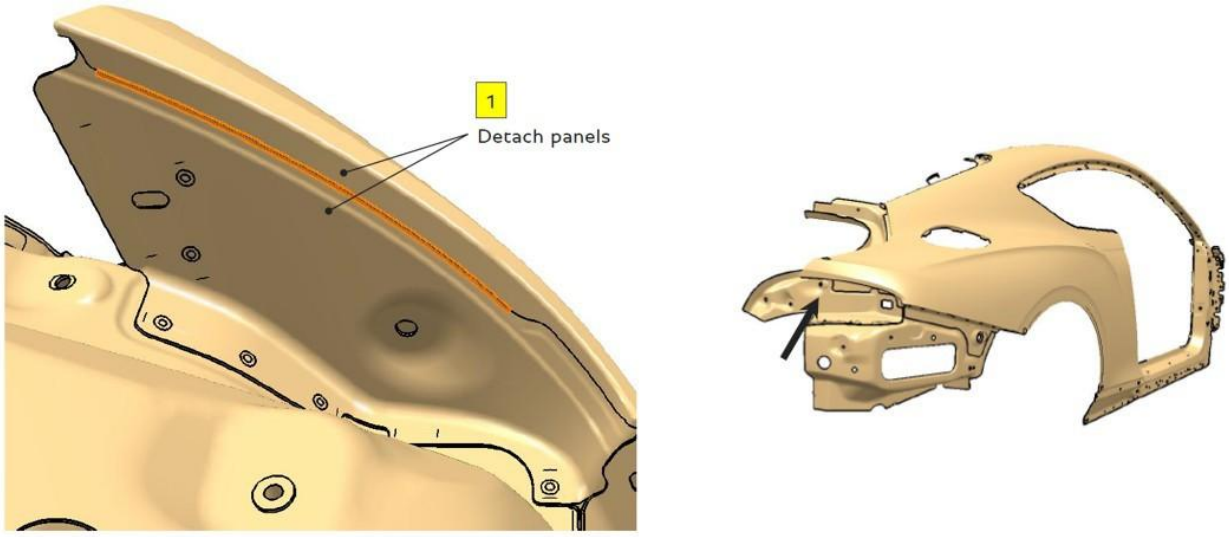


Figure 1

3. Temporarily install the boot lid and rear lamp assembly and align the panel using a best fit method.

4. Using a body saw cut through the specified weld -1- shown in figure 1 as required.

5. Remove the rear lamp and weld the components in position in accordance with approved body repair procedures.

6. Dress the weld flush with the surrounding panel surface.

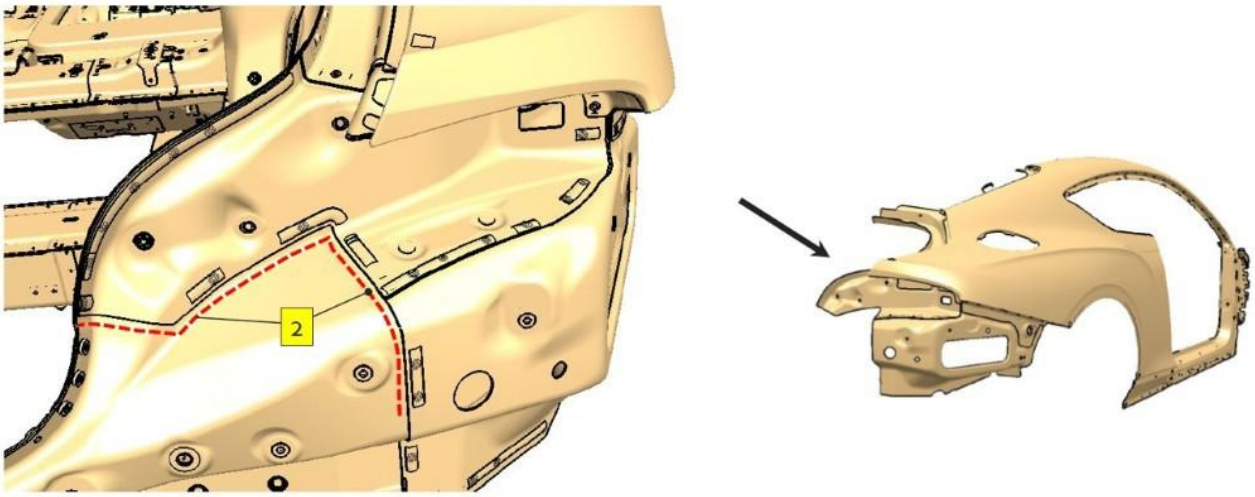


Figure 2

7. Before Joining this area 2- as shown in figure 2.

8. Use the boot lid and rear lamp as reference components to align the side panel assembly in the Y direction to achieve the best possible fit of the new assembly with the surrounding body panels.

Dimensional deviations in this axis (Y) may be present. Check against the opposite side of the car for reference.

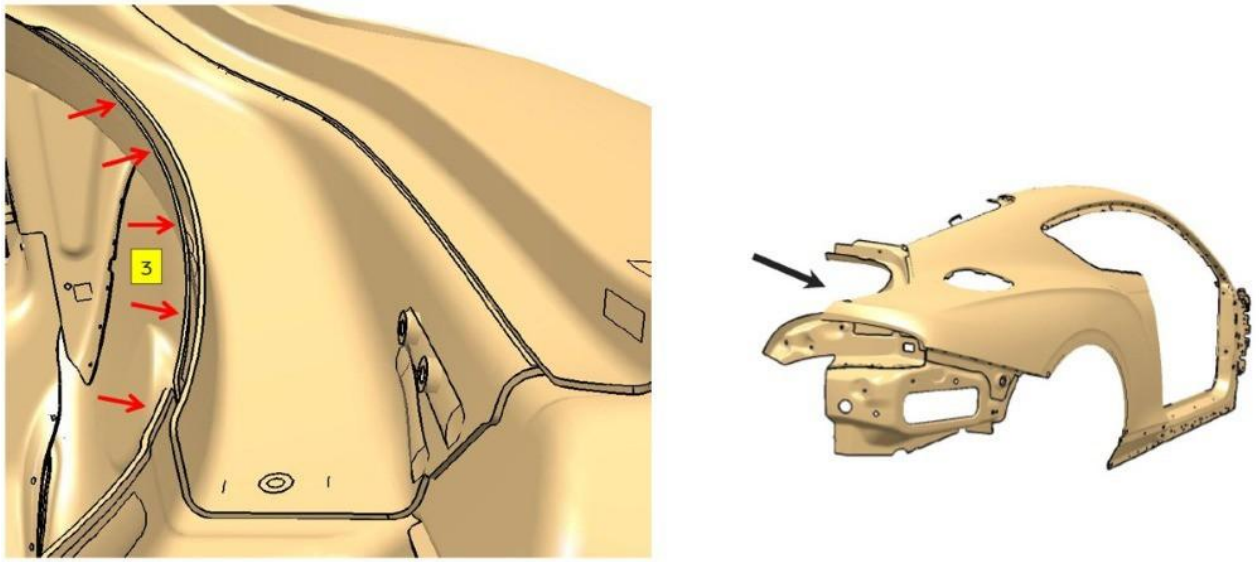


Figure 3

9. Inspect the drain channel alignment -3- and plannish the inboard flange as required to ensure proper mating with the assembly.

10. With the rear side panel clamped into position, refit the boot lid and door (if required) and check that the gapping profiles are consistent.

If so, continue with onward instructions in ElsaPro.

Refer to ElsaPro Body Repairs → Rep. Gr. 53 – Side Panel Rear – Installing side panel rear

NOTICE

IMPORTANT: Please ensure that all reworked areas are repaired using only Bentleyapproved aftermarket paint repair procedures. This is essential to restore corrosion protection and to prevent the risk of future corrosion. All paint repairs must be carried out in accordance with the applicable Bentley paint repair guidelines.

Warranty accounting instructions

If the Body Adjustment Process is required, refer to the instructions below and claim the applicable additional labour time. This is to be claimed in addition to the standard warranty accounting instructions in ELSA Pro for rear side panel replacement.

Warranty Type: 110 or 910

Damage Service Number: 53 55

Damage Code: 00 55

Labour

Time to Perform Body Adjustment Process

Labour Operation Code: 53 55 15 98

Time: 300 TU

Parts information

Refer to ETKA parts catalogue