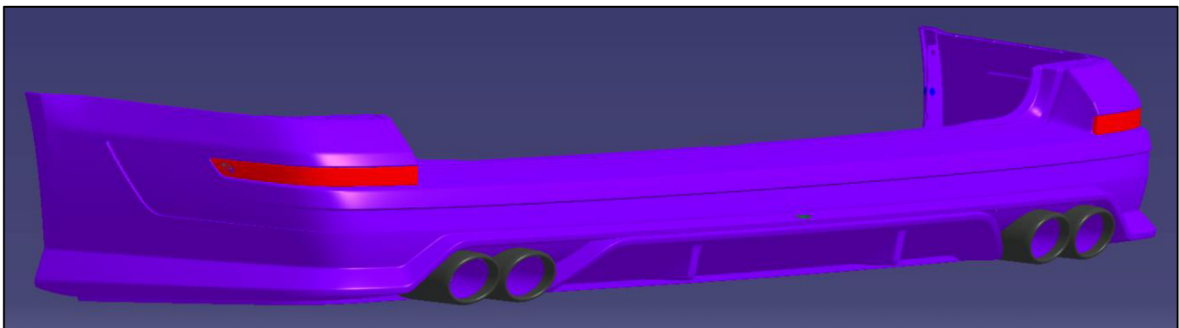


Installation instructions for ABT rear skirt attachment



ABT VW T6_7E0A (Van, MJ 2019) with installed ABT front skirt



ABT rear skirt with ABT end pipes

Scope of supply:

Amount	Description
1	ABT Rear Skirt
1	ABT end pipe, left, external, black, high gloss finish
1	ABT end pipe, left, internal, black, high gloss finish
1	ABT end pipe, right, external, black, high gloss finish
1	ABT end pipe, right, external, black, high gloss finish
2	End cap, (for capping end pipe)
2	Metal bracket, (for attachment to vehicle underside, external, left + right)
2	Metal bracket, (for attachment to vehicle underside, protruding, left + centre left)
1	Metal bracket, (for attachment to vehicle underside, centre right)
1	Metal bracket, (for attachment to vehicle underside, protruding, right)
6	Bolt, 3.9 x 12 mm, (for attaching end caps)
6	Oval head screw, M6 x 20 mm, black, (for attaching bracket)
5	Hexagonal screw, M6 x 20 mm, black, (for attaching bracket)
2	Hexagonal screw, M6 x 50 mm, black, (for attaching bracket)
2	Hexagonal screw, with collar, M10 x 50 mm, (for lowering exhaust system)
2	Hexagonal screw, with collar, M8 x 45 mm, (for lowering exhaust system)
11	Nut, M6, self-locking, (for attaching brackets)
13	Washer, M6, (for attaching brackets)
5	Washer, M6; Ø 15 mm; (for attaching brackets)
2	Spacer, Ø 20 x 30 mm, (for attaching brackets)
2	Spacer, Ø 20 x 20 mm, (for lowering exhaust system)
2	Spacer, Ø 20 x 15 mm, (for lowering exhaust system)
1	ABT emblem; self-adhesive, (Art. no. ANS000069)
1	Product information sheet
1	Installation instructions (via download)
1	General operating permit, ABE, (via download)



Important: Before commencement of the painting process, all bodywork parts must be installed carefully and without tension onto suitable painting racks. In addition, painted bodywork parts must be stored carefully and without tension until final installation.



Important: For vehicles equipped with the optional underfloor 'spare wheel', the spare wheel and mounting bracket, bolts and spacers (according to tyre size) must be removed before installation of the ABT rear skirt.
ABT Sportslin recommends the use of Tirefit (tyre sealant)



Note: Before painting, please note painting instructions under installation point 15 and discuss this with your customer.



Note: Prior to installation of components that are to be bonded, the components and the area in which you are working must be conditioned to room temperature (min. +15°C). Insufficient conditioning can lead to adhesive failure and liability problems.



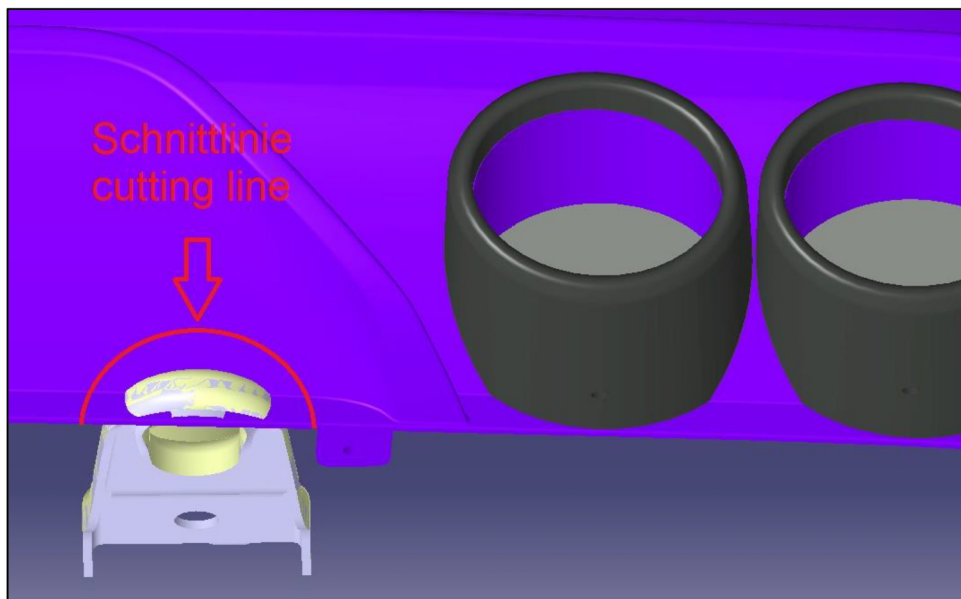
Important: It is not possible to remove the optionally available standard loading edge from the standard rear skirt without damaging it. Please order the appropriate loading edge protector (see PR number) from your spare parts dealer and attach it to the ABT rear skirt in accordance with the manufacturer's instructions.



Attention: In order to be able to continue using the standard rear towing eye after attaching the ABT rear skirt, either the ABT rear skirt must be processed with suitable workshop equipment in the affected area (see following picture) **before painting** or the towing eye must be removed.



Attention: Always observe the national regulations before disassembling the towing eye!



Area to be cut out of the ABT rear skirt



Important: The adhesive necessary for installation of the glued components is not supplied. Only adhesives listed in the parts certificate/ABE reports may be used. Failure to do so will lead to loss of the general operating permit for the vehicle and in the event of damage, can lead to criminal consequences. The authorized adhesives are available as a comprehensive adhesive kit from Volkswagen/Audi under part number 000.071.785 D.

One adhesive kit is required for the installation of the supplied parts. The primer from the adhesive kit is required for installation. These installation instructions refer to the contents of the above-stated adhesive kit.

Installation Instructions

Installation time: approx. 2.5 hours (without painting and adhesive curing)



Important: Read these installation instructions fully and carefully before installation. They contain important notes and information that must be observed before and during the installation process in order to help avoid misunderstandings. ABT Sportsline recommends all installation work to be carried out by a specialist workshop. In the event of any doubt, please contact our technical customer service department on the following number: +49 (0) 831 57140-905.

1. Check the goods **before** assembly and painting for integrity and completeness against the parts list.
2. Remove the standard rear skirt from the vehicle. Follow instructions in the current VW repair manual.



3. **Attention:** Only for vehicles without factory towbar:
4. Cut the impact beam as shown in fig. 1. Deburr the cut edges carefully and protect the machined areas carefully with suitable, high quality agents against corrosion.

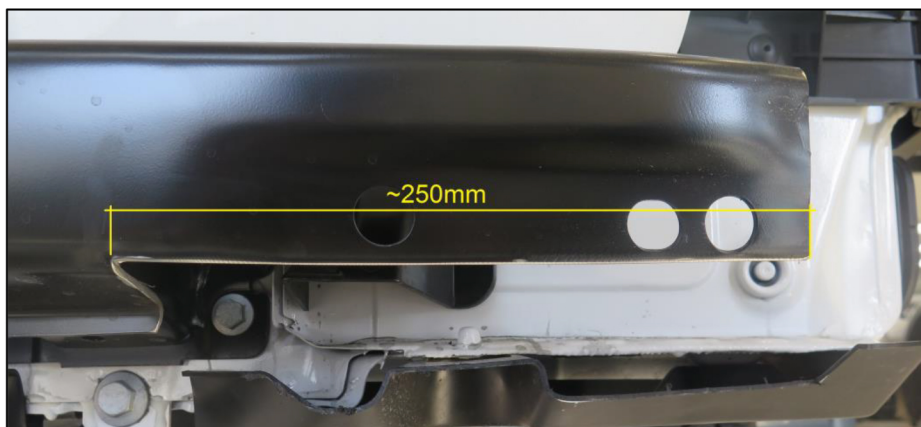


Fig. 1: Completely processed impact beam (right side shown, left side mirror image)

5. Remove the rear towing device from the vehicle (fig. 2). This cannot be used after the rear skirt has been installed.

Attention: Observe the country-specific legal requirements and the information on page 17!

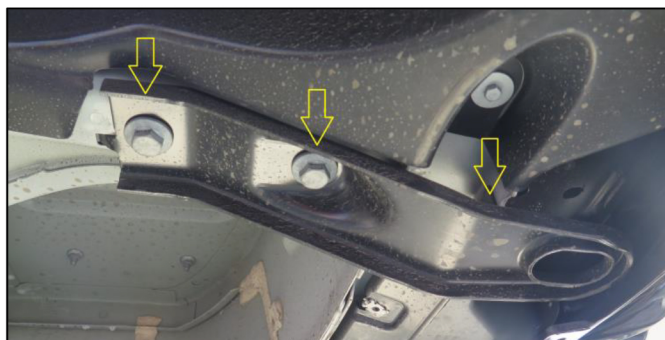


Fig. 2: Disassemble the towing device

6. **All vehicles:** Provisionally install the **unpainted** ABT rear skirt in reverse order on the vehicle and check for accuracy of fit onto the vehicle. Make necessary adjustments with suitable tools. If in doubt, please contact our technical customer service department on +49 (0)831 / 57140 - 905.



Tip: To check for accuracy of fit, fix the ABT rear skirt to the vehicle, e.g. with tape.



7. Check the ABT end pipes for accuracy of fit in the ABT rear skirt.
Note: The respective position on the ABT rear skirt is stamped on the inside of the end pipes (e.g. 'LA' for 'left external', etc. See figure 12, page 24).

8. Remove the ABT end pipes and ABT rear skirt from the vehicle.



9. **Important: Only for vehicles with park-assist/park steer-assist:**

10. Drill the necessary holes for the ultrasonic sensors (Ø18 mm). Lightly deburr the holes and remove residue.



Note: Positions for the ultrasonic sensors are marked on the inside of the ABT rear skirt (yellow = park-assist, green = park steer-assist, figure 3).



Important: Depending on VW standard specification, two different positions are available for the external parking sensors. Use the respective position for the standard skirt.

11. Carefully remove the standard sensor brackets from the standard rear skirt.

12. Carefully remove any double-sided tape residue from the bonding areas of the sensor brackets and roughen the bonding areas with P80 sandpaper.

13. Roughen the respective bonding areas for the sensor brackets on the ABT rear skirt with P80 sandpaper.



Attention: After sanding the bonding areas, check whether the sensors are flush on the visible side of the ABT rear skirt. Possibly rework.

14. Clean all bonding surfaces thoroughly with a suitable cleaning agent (e.g. silicone remover).

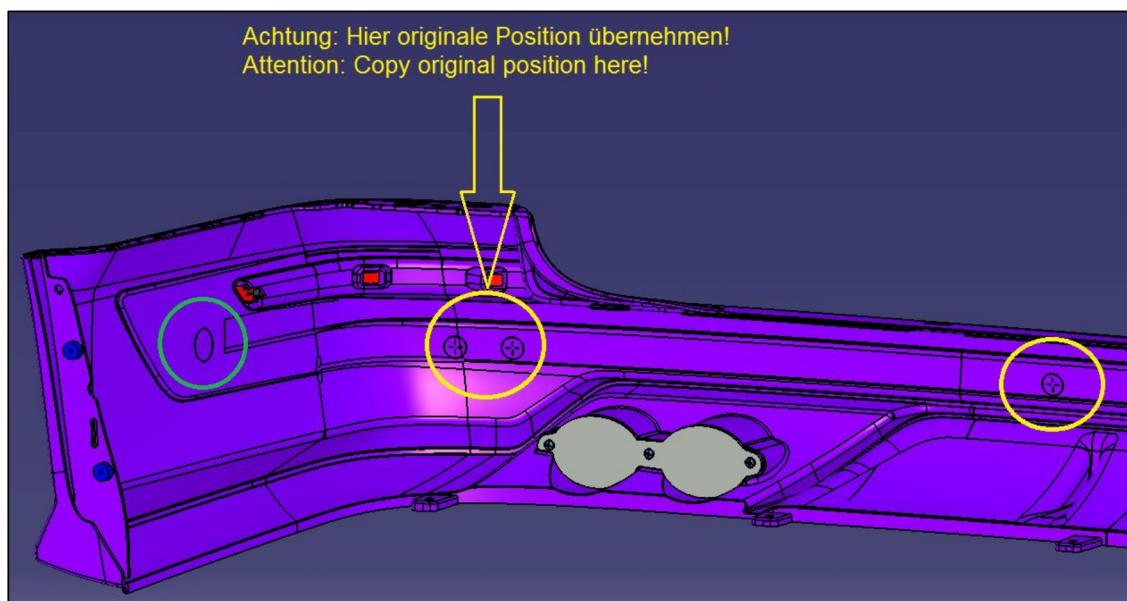


Fig 3: Markings for ultrasonic sensors (yellow = park-assist, green = park steer-assist)

15. Glue the brackets to the respective positions on the ABT rear skirt with a fast-curing 2K adhesive (e.g. Würth replast fast).



Important: When gluing the brackets, take care to maintain the orientation of the electrical connections.



16. **Important: Only for vehicles with towbars:**

17. Carefully cut the hole marked on the inside of the ABT rear skirt for the tow bar (Fig. 4). Lightly deburr the cut edges and remove residue.



Note: For vehicles with towbar, the opening is not intended to be sealed with a cover when the towbar is not in use.

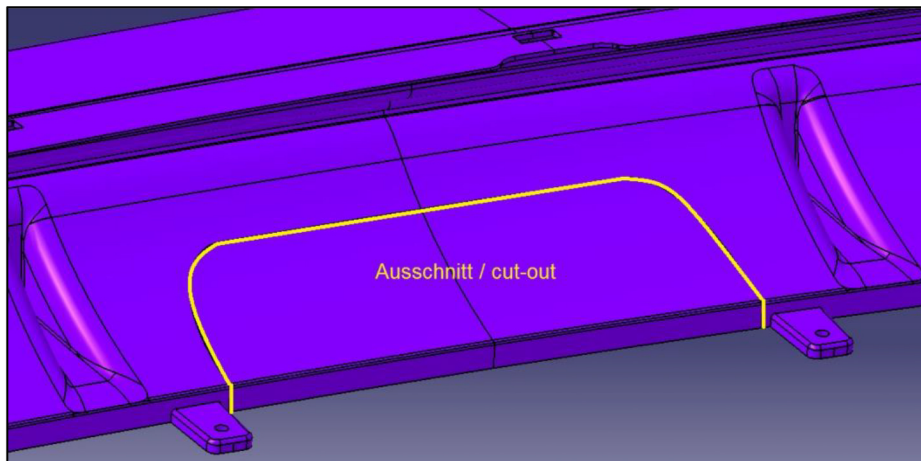


Fig 4: Marking for towbar cut-out



18. **All vehicles:** Paint the ABT rear skirt and the supplied sealing caps in accordance with the paint cycle for PUR components on page 27.

Note: Painting of the finished surface of the ABT end pipes is not intended by ABT Sportsline.



Tip: For aesthetic reasons, ABT Sportsline recommends that the end caps in the ABT rear skirt implied end pipes and surrounding areas are sprayed matt black.

19. Carefully remove the standard reflectors from the standard rear skirt. Follow instructions in the current VW repair manual.

20. Carefully install the standard reflectors in reverse order of removal into the ABT rear skirt (Fig. 5).

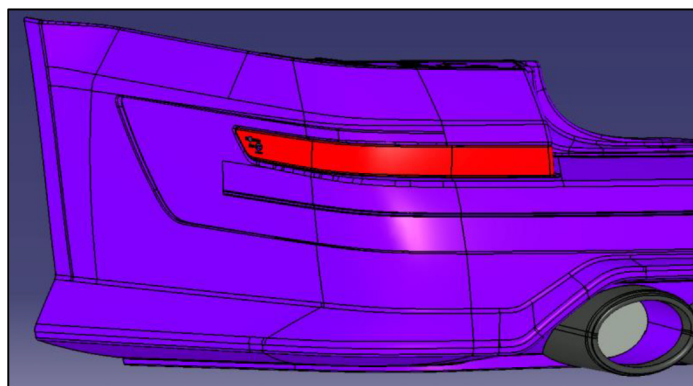


Fig 5: Reflector in ABT rear skirt

21. Install the supplied implied end pipe end caps into the ABT rear skirt with the supplied 3.9x12mm screws (Fig. 6, torque 2Nm).



Important: Mounting holes must be drilled beforehand (Ø2mm).

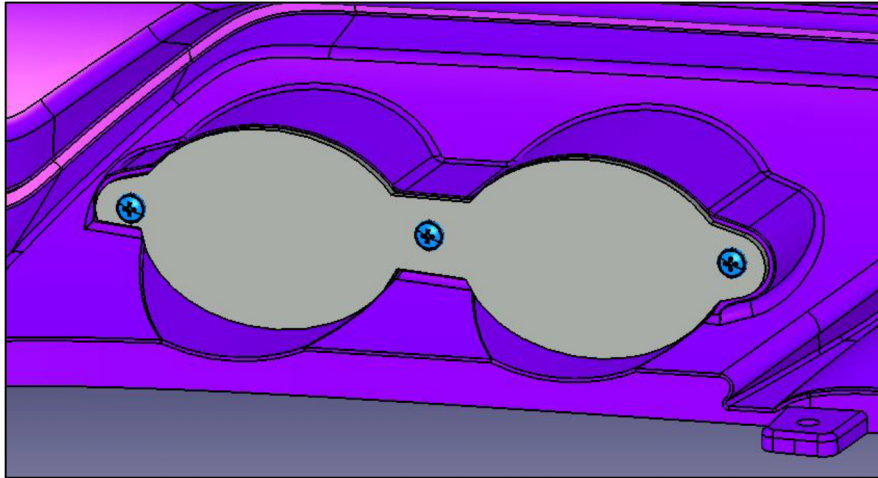


Fig. 6: installed end caps (right side pictured, left side mirror image)

22. Install the completed ABT rear skirt onto the vehicle. Proceed in reverse order of removal.
23. Cut the standard underbody fairing as shown in figures 7 + 8 (page 21+22). Lightly deburr the cut edges and remove residue and swarf.

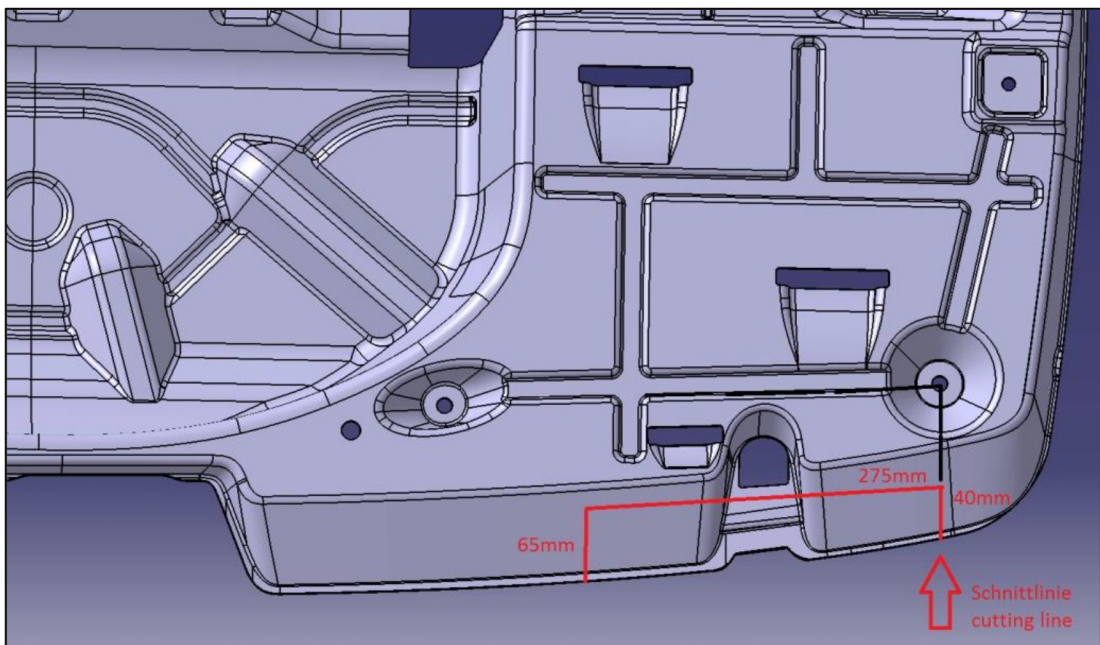


Fig 7: Cut to left underbody fairing (view rotated by 180°)

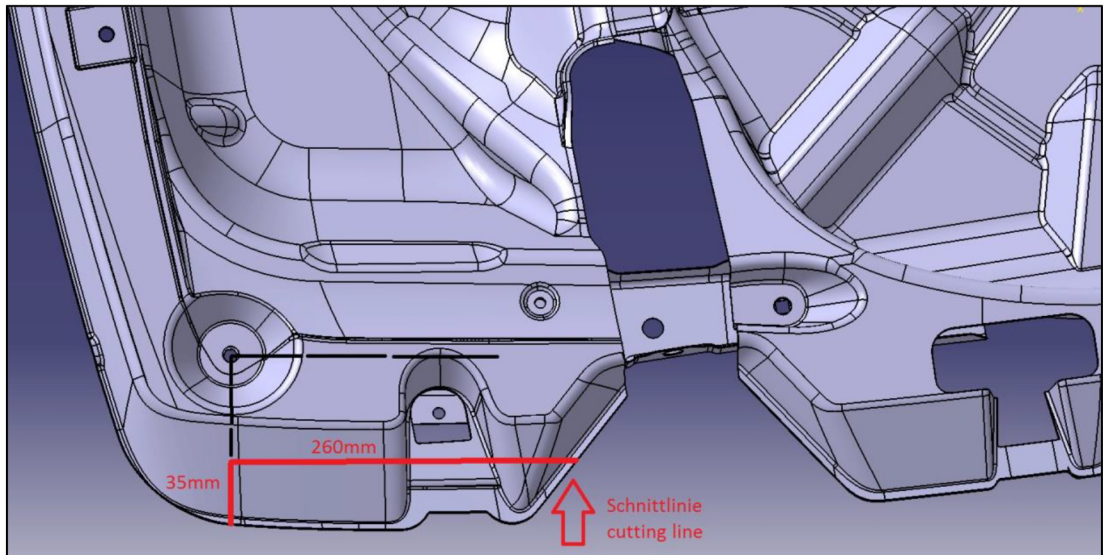


Fig 8: Cut to right underbody fairing (view rotated by 180°)

24. Install the cut underside fairing with the supplied fixing materials.
25. Attach the ABT rear skirt to the vehicle underside with the supplied fixing materials. Assignment of fixing materials is shown in figures 9 + 10 (page 22+23).



Fig 9: Assignment of fixing materials (left-hand side of vehicle)

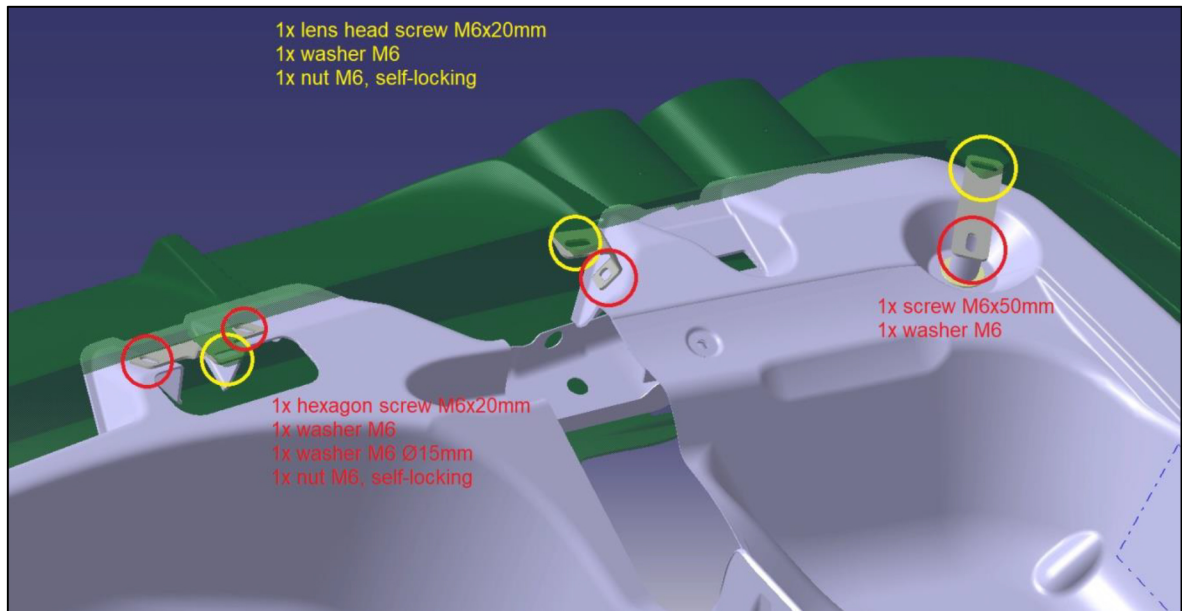


Fig 10: Assignment of fixing materials (right-hand side of vehicle)

26. Lightly roughen the bonding areas (Fig. 11) of the ABT end pipes (in the ABT end pipes and on the ABT rear skirt). Remove any grinding dust and clean the bonding areas thoroughly.

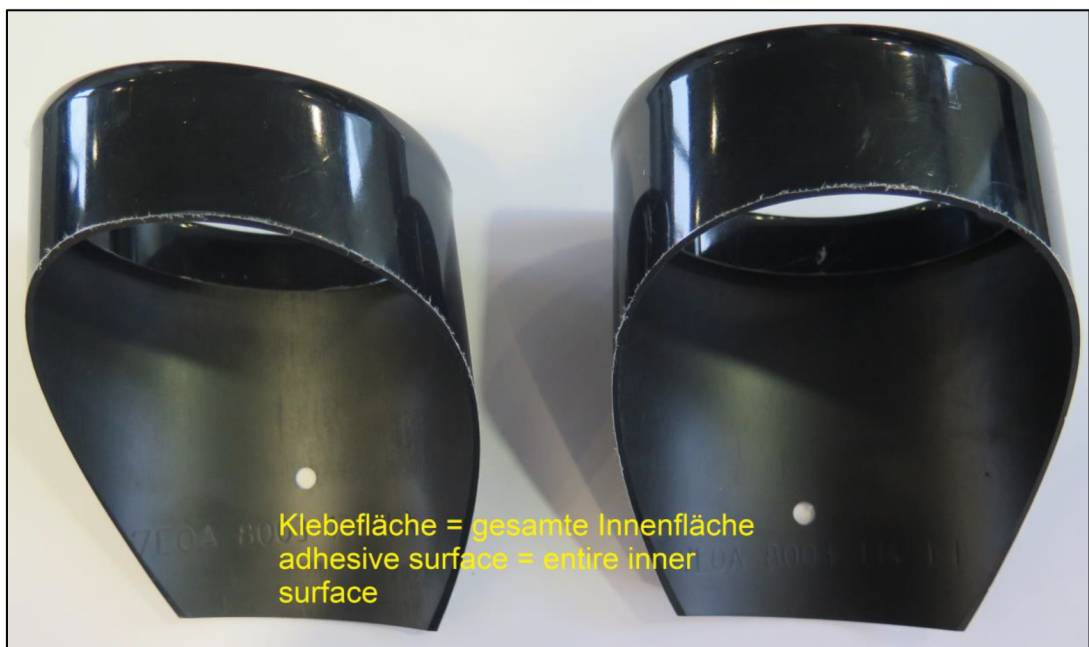


Fig 11: Bonding area ABT end pipes

27. Apply primer as supplied in the recommended adhesive kit to the bonding areas in the ABT end pipes. Allow at least 5 minutes for the primer to dry.

28. Carefully remove the protective foil from the ABT end pipes.



29. **Important:** The location of the individual ABT end pipes is marked on the inner side of the ABT end pipes (Fig. 12). The following markings and meanings apply: LA = left external, LI = left internal, RA = right external, RI = right internal etc.



Fig 12: Identification of the respective installation locations of the ABT end pipes

30. Apply a thin layer of adhesive to the bonding areas of the ABT end pipes.

31. Attach the ABT end pipes to the ABT rear skirt, carefully align them and fix them into the correct position with suitable installation material (e.g. tape). Remove any excess adhesive (Fig. 13).



32. **Important:** Make sure that the underside drainage holes are not blocked by adhesive. Clean if necessary.

33. Wait at least 12 hours before removing any installation material.

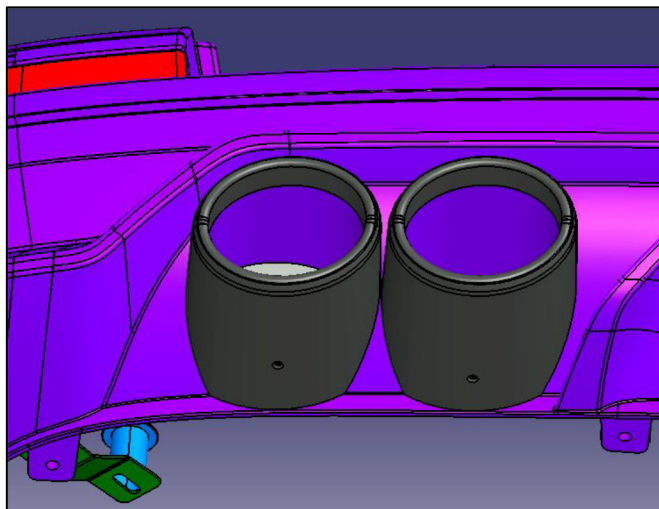


Fig 13: Installed ABT end pipes



34. **Important:** In order to avoid heat damage to the ABT rear skirt by hot exhaust gases, the standard exhaust system must be lowered as described in the following procedure.

35. Support the standard silencer -2- with suitable materials and remove the fixing bolts -1- of the standard brackets (Fig. 14).



Caution! Risk of injury: Before commencing, support the exhaust system with suitable materials.

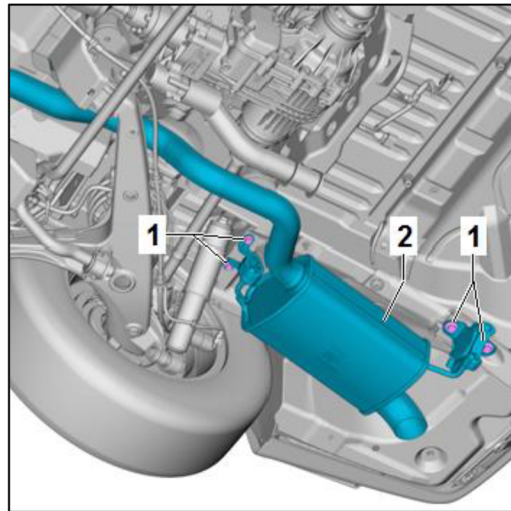


Fig 14: Attachment of the rear silencer

36. Mount the standard brackets on the vehicle with the supplied spacers. For the front bracket use the M8x45 mm screws and the Ø20x15 mm spacers; for the rear bracket use the M10x50mm screws and the Ø20x20mm spacers.

Note: Tightening torque: M8: 23 Nm, M10: 60 Nm



37. Attach the supplied ABT emblem in the previously cleaned, intended recess in the ABT rear skirt (Fig. 15).

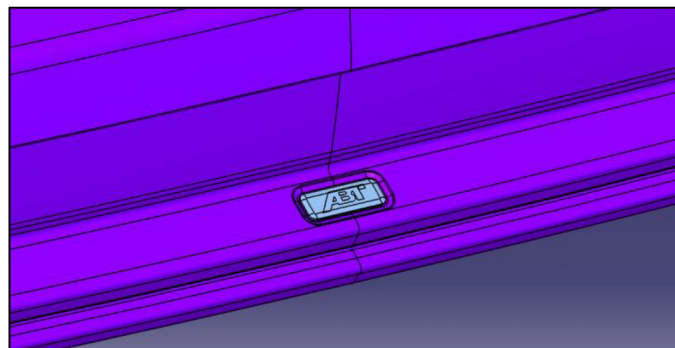


Fig 15: Recess for ABT emblem (arrow)



38. **Disclaimer:** ABT Sportsline is not liable for any loss or damage of any kind caused by improper installation and/or by the mishandling of the ABT rear product and supplied or recommended fitting materials. Deviation from the above-stated Installation procedure, in particular the use of other than the supplied or recommended mounting materials, can lead to invalidating the user's vehicle operation permit with the appropriate legal consequences.

Painting cycle for primed body parts made of the material <PUR>



Note: ABT Sportsline recommends all paint works to be carried out by a specialist workshop.



Important: All bodywork parts must be free from tension during all work processes and be stored with consideration of the later installation conditions. ABT assumes no liability for warped components caused by improper storage during the installation or painting process. During painting, ensure that the moulded nameplate remains legible.

1. Check unpainted body parts for accuracy of fit on the vehicle before painting. Make necessary adjustments with suitable tools if required. In the event of any doubt, please contact our technical support department on +49 (0) 831 57140-905.
2. Check the factory-fitted covers for the bonding surfaces for completeness and correct seating. Complete or replace any existing flaws or loose covers.
3. Store the bodywork component according to its later installation without tension on suitable painting racks.
4. Roughen the foundation thoroughly with sandpaper (wet: P800-P1000 **or** dry: P320-P360). Do not sand through the factory primer.
5. **Note:** Any areas that are sanded through must be treated with a suitable plastic adhesive primer in accordance with the manufacturer's instructions.
6. Smooth visible edges if necessary.
7. Fill any occurring pores with a suitable filler.
8. **Tip:** For bright metallic paint colours, sand the bodywork component with the following grades: Wet: P1200 **or** dry: P400.
9. Clean the bodywork component thoroughly with a suitable cleaner (e.g. Silicone remover) and allow to dry completely.
10. Dilute the basecoat in accordance with the respective manufacturer's specifications and apply to the prepared bodywork component. Follow the drying times specified by the manufacturer.
11. Elasticise the 2K clear acrylic lacquer by adding approximately 20% plasticiser and mix it with the required amount of hardener as per the manufacturer's instructions.
12. Apply the clear lacquer to the bodywork component in accordance with the manufacturer's instructions.
13. Allow the fresh lacquer to dry at a temperature of approx. 35°C.

Typographical errors and technical changes/amendments reserved!



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