

Technical Bulletin

Model
911C2/4

Group
5

Subject: Rear Side Panel Support Modified

Part Identifier
5355

Number
9003

ATTENTION: Service Manager/Service Technician

Models Affected: *911 Carrera 2 and 911 Carrera 4 (Coupe Only)
Up to VIN 96 — LS 45 0067*

Model Year: 1989 (K) and 1990 (L)

Concern: Vibration of the rear side panels (fenders) can cause cracks in the area of the tail lights (Figure 1).

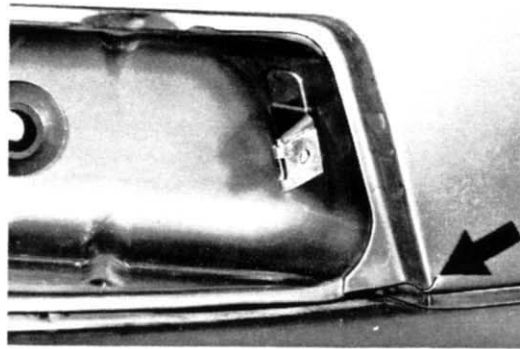


Figure 1

Modification:

New side cover panel brackets with additional support installed (Figure 2).

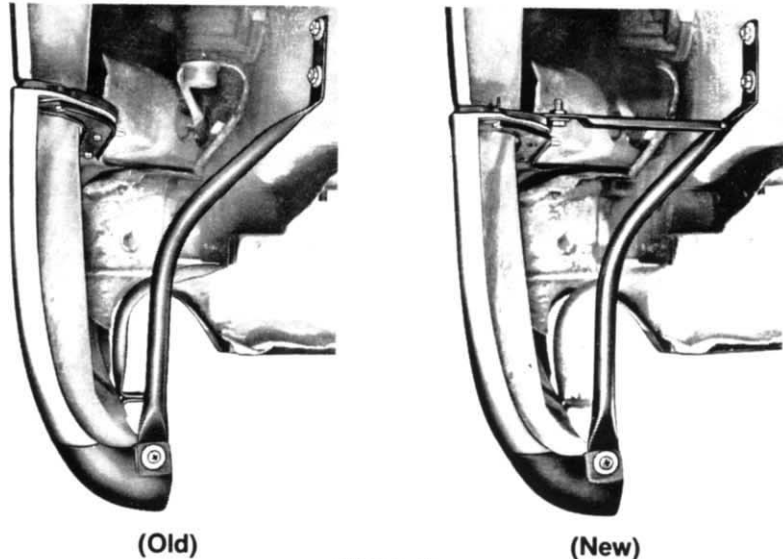


Figure 2

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Vehicle Information:

Supports installed as of VIN 96 __ LS 45 0068.
All vehicles up to the above VIN should be repaired and checked for cracks when the vehicle is in the workshop for normal service or other repairs.

Repair Information:

Work Procedure 1: No cracks in the area of the tail lights.

Replacing support brackets left and right.

1. Lift vehicle on hoist and remove rear wheels.
2. Remove front support bracket for bumper cover panel.
3. Remove lower screw for rear support bracket.
4. Remove screws fastening the side bumper cover panel to the rear side panel (Figure 3).
5. Bolt new support bracket to the inside of wheel housing (Figure 4).

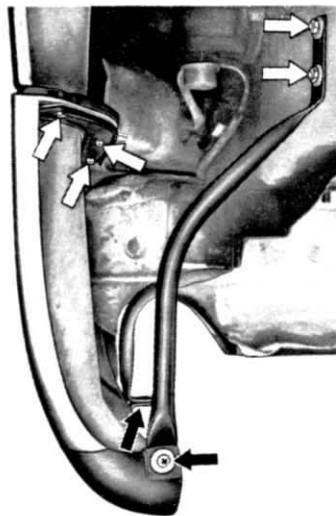


Figure 3



Figure 4

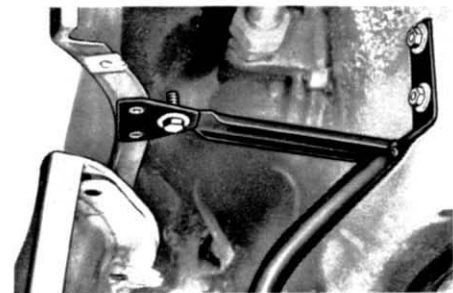


Figure 5

6. Attach fastening plate (see Parts information) to new support bracket so it contacts the lower surface of the panel edge flange. Pull the bumper cover panel slightly outwards and mark the bore holes on the edge flange (Figure 5).
7. Remove fastening plate and drill 5mm holes in the marked area (Figure 4).



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Repair Information (cont.):

8. Deburr bore holes and clean **upper surface** of edge flange around holes.
9. Coat bore holes with anti-corrosion paint. While paint is drying, repeat same work steps on other side of car.
10. Attach fastening plate to **upper surface** of edge flange with rivets (flat rivet head faces down). (Figure 6).

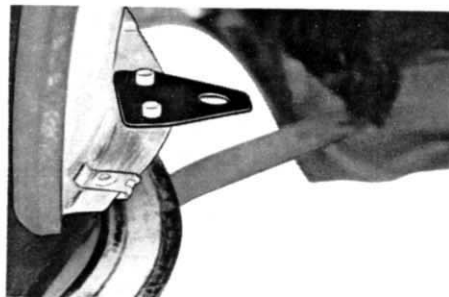


Figure 6

11. Reinstall screws fastening the side bumper cover panel to the rear side panel. Reinstall lower screw for rear support bracket. Attach fastening plate to new front support bracket with screw and washer assembly.
12. Install fastening plate and new support bracket on other side of vehicle.
13. Reinstall rear wheels and torque to 130 Nm (96 ft. lb.).



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Repair Information (cont.):

Work Procedure 2: Cracks in the area of the taillights.

Replacing support brackets left and right.
Welding cracks on one or both sides.
Welding reinforcement plates on inside if necessary.

1. Lift vehicle on hoist and remove rear wheels.
2. Remove complete rear panel, bumper, heat protection, right and/or left taillight assembly. Refer to 911 Carrera 2/4 Workshop Manual Volume I, from page 63-5.
3. Install new support brackets as described in Procedure 1.
4. Clean welding surface in area of cracks inside and outside. Check inside if reinforcement plates (Figure 7) are welded in place. If not, align new reinforcement plate on inside and weld in place (Figure 8). Weld crack from outside. If reinforcement plates are already installed, weld cracks from outside.

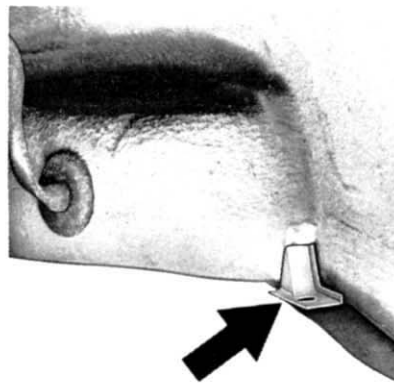


Figure 7

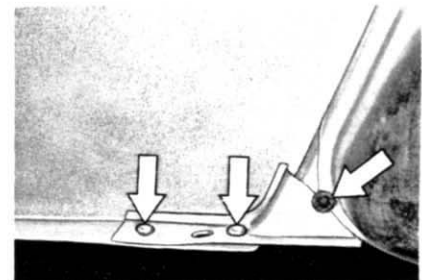


Figure 8

5. Carry out necessary finishing, priming and paint work. Restore undercoating on inside in areas of welding surface. Reinstall bumper, heat protection, rear panel with support brackets and taillights. Reinstall rear wheels and torque to 130 Nm (96 ft. lb.).

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Parts Information:

Replacing support brackets left and right.

- 1 — 964 505 475 00 Support bracket (2 per vehicle)
- 2 — 964 503 469 00 Fastening plate (2 per vehicle)
- 3 — 900 075 268 02 Screw with washer (2 per vehicle)
- 4 — 999 190 128 30 Rivet A 4.8 x 7.4 (4 per vehicle)
- 5 — 999 591 699 02 Nut B4.8 (2 per vehicle)

Installing reinforcement plates (Figure 10) (only if necessary).

- 1 — 964 503 755 00 Reinforcement plate left
- 2 — 964 503 756 00 Reinforcement plate right



Figure 9

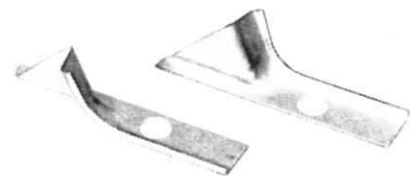


Figure 10

Labor Information:

Damage Code: WL 12 66 000 2
Repair Code: 2

(Note: Paper claims must be submitted until the next DCS download.)

Repair Times: Work Procedure 1

Labor Operation:

53555600

120 TU Installing support brackets with fastening plates left and right.



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Repair Times: Work Procedure 2

Labor Operation: **53551900** 240 TU Welding work with reinforcement plates on one side. Install support brackets left and right. Includes R + R rear panel, heat protection, bumper and taillights. Does not include paint work.

53555602 320 TU Welding work with reinforcement plates on both sides. Install support brackets left and right. Includes R + R rear panel, heat protection, bumper and taillights. Does not include paint work.

Note: Paint work must be claimed using miscellaneous claim code of "P" and the \$ dollar amount must be entered in the miscellaneous cost field.

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