

# ASSEMBLY INSTRUCTIONS

## TECHART Aerodynamic Fender

Part-no. 092.121.250.009 for 992 GT3
















Version 01 – 12/2022








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### I Important safety information

All of the necessary work must be performed by qualified persons with an appropriate level of expertise.

	<p style="text-align: center;"><b>⚠ WARNING</b></p> <p>Vehicle lifts with an insufficient lifting capacity can collapse under the weight of the vehicle and crush any persons standing underneath.</p> <p>Compare the weight of the vehicle with the lifting capacity of your vehicle lift. The weight of the vehicle must not exceed the lifting capacity of your vehicle lift. The weight of the vehicle can be found in the vehicle operating manual.</p>	
	<p style="text-align: center;"><b>⚠ WARNING</b></p> <p>Risk of injury from electric current.</p> <p>Switch off the ignition and disconnect the battery when working on the vehicle electrical/electronic systems.</p>	
   	<p style="text-align: center;"><b>⚠ WARNING</b></p> <p>Risk of fire and explosion from ignition of windshield cleaning agents/antifreeze and their vapors.</p> <p>Risk of poisoning from ingesting windshield cleaning agents/antifreeze and breathing in their vapors.</p> <p>Risk of injury due to irritation caused by windshield cleaning agents/antifreeze coming into contact with eyes, skin and other parts of the body.</p> <p>Wear protective clothing and safety glasses. Avoid naked flames, fire and sources of ignition. Avoid contact with eyes, skin and other parts of the body. Do not eat, drink or smoke when handling windshield cleaning agents/antifreeze. Do not breathe in vapors and ensure adequate ventilation. Keep windshield cleaning agents/antifreeze only store them in sealable original containers.</p>	  
  		

 	<p style="text-align: center;"><b>CAUTION</b></p> <p>Risk of injury from hands and arms being crushed, cut or lacerated when working with sharp-edged and bulky objects.</p> <p>Wear protective clothing and protective gloves. Keep limbs out of narrow and inaccessible areas of the vehicle and/or avoid dangerous situations by using special tools and suitable aids.</p>	 
	<p style="text-align: center;"><b>CAUTION</b></p> <p>Risk of injury to back, muscles, joints, tendons and ligaments from lifting and carrying heavy and/or bulky objects.</p> <p>Lift and transport heavy and/or bulky objects with the help of other people and/or with suitable aids.</p>	
	<p style="text-align: center;"><b>NOTICE</b></p> <p>Before starting the assembly procedure, carefully read the assembly instructions in full and pay attention to the safety information and sequence of the individual operation steps.</p>	

## II Preparation

### Number of people required



For the installation of this product at least two persons are needed.

### Assembly time



It takes at least 8.5 hours to assemble this product.

### Help and support

If you have any technical queries, please contact us immediately:  
[support@techart.de](mailto:support@techart.de)

**Check TECHART aerodynamic fender parts kit for completeness**

Quantity	Part-Number	Part Designation
<b>1</b>	<b>092.121.250.009</b>	<b>Aerodynamic Fender</b>
Consisting of:		
1	092.121.250.100	Aerodynamic Fender right
1	092.121.250.101	Aerodynamic Fender left
1	092.121.250.200	Frame R, Air outlet Fender
1	092.121.250.201	Frame L, Air outlet Fender
1	092.100.250.230	Grille Air outlet Fender R
1	092.100.250.231	Grille Air outlet Fender L
1	092.100.250.240	Insert with "TECHART" Lettering Fender R
1	092.100.250.241	Insert with "TECHART" Lettering Fender L
<b>1</b>	<b>092.100.250.990</b>	<b>Accessory Kit Fender</b>
Consisting of:		
1	092100250400	Washer wheel house front
3	00091089010073	Bond + Seal black 300 ml
2	000910219252T	Betaprime 5404, 15ml
0,3	000901895501440	Vacuum hose, 14x22mm
8	00090150053312	Speed nut M6
2	001900M06W379006	Nut with wave washer, M6, galvanized A2K
2	001900M06986	Hexagon nut self-locking, M 6, galvanized
10	000590502241	Cable tie, metal tongue 4.5x290mm
2	001900M05X20	Washer fender 5.3x20x1.25mm
3	0039004.8X251025	Sheet metal screw fillister head with flange 4.8x25
2	0029004.8/19.0X12.7	Speed nut 19mm x 4.8mm
40	000590501103035	Plastic expansion rivet (5.5-6.4MM)
14	001900M06X20	Washer DIN 522, 6.4x20x1.25mm, galvanized
3	PAF009011	Screw

**ASSEMBLY INSTRUCTIONS****TECHART Aerodynamic Fender**

and

<b>1</b>	<b>+92.121.250.210FCG</b>	<b>V01: Louvers in Forged Carbon glossy</b>
Consisting of:		
1	092.121.250.210FCG	Louvers Panel Fender, Forged glossy

or

<b>1</b>	<b>+92.121.250.210FCM</b>	<b>V01: Louvers in Forged Carbon matt</b>
Consisting of:		
1	092.121.250.210FCM	Louvers Panel Fender, Forged matt

or

<b>1</b>	<b>+92.121.250.210G</b>	<b>V01: Louvers in Visible carbon glossy</b>
Consisting of:		
1	092.121.250.210G	Louvers Panel Fender, glossy

or

<b>1</b>	<b>+92.121.250.210M</b>	<b>V01: Louvers in Visible carbon matt</b>
Consisting of:		
1	092.121.250.210M	Louvers Panel Fender, matt

Please use the table to check whether all of the required parts are present.

Once parts have been removed from their original packaging, ensure that they are properly handled and stored.

### III Component identification

#### 1 Inner component identification

- i** The inner component designations applied by TECHART must be masked off before painting. These are decisive to TECHART-Support for possible component tracking, complaints or in the event of damage.

- 1 Internal component markings can either be applied directly to the component in the tool or glued in as a label.



Fig. 01

#### 2 Outer component identification

- i** The external component designations applied by TECHART must be masked off before painting. If the external component markings are no longer visible, the component certificate may lose its validity.

- 1 External component identifications are usually attached to the underside of the component in the non-visible area. These can be used as evidence at a traffic control or a technical service since this is a registered TECHART part.



Fig. 02

## **IV Paintwork**

### **1 Material of the component**

**i** It is important that the paintwork matches to the surface which will be painted.

- 1 Before painting, the material to be painted can be read from the inner component identification.

### **2 Adhesive tape and mounting fixtures**

**i** The body tape applied by TECHART is used for later assembly and must be protected over the entire surface before painting.

- 1 The edges of the adhesive body tape must also be free of paint in order not to impair the elasticity of the tape.
- 2 Drilled holes made at the factory that will later be used for screws or rivets may have to be re-drilled to the nominal size depending on the amount of paint.



**V Installation****1 Prepare vehicle****1.1 Dismantle original fender**

**i** Raise the vehicle on the lifting platform.

**Remove the wheels.**

**Dismantle the front according to the assembly instructions for the front air intake panel 092121171099 or the assembly instructions for the front spoiler 092121171099.**

- 1 Disconnect the electrical plug connections on the headlight and unclip the cables.
- 2 Remove headlight by loosening both screws in wheel housing.
- 3 Empty air conditioning system according to manufacturer's instructions.
- 4 Disconnect air-conditioning line (condenser to dryer) at the air-conditioning condenser on the right at the separation point in the headlight cutout and at the dryer in the inner wheel housing. Described in the illustration below.
- 5 Unclip fuel filler cap incl. housing from inside of fenders and remove outward.
- 6 Remove the air-conditioning dryer from the holder.

**i** **Close all open air-conditioning connections and protect them against contamination.**



Fig. 03

- 7 Remove the washer fluid reservoir on the left and its filler neck by loosening two screws.
- 8 Unthread the air-conditioning lines on the right-hand side from the mudguard.
- 9 Undo and remove both mudguards by unscrewing all screws. Dismantle all attachment parts of the fender. Remove the retaining strips for the front apron at the front and turn signals at the side, crash sensors above the headlight seat, and the covers to the door and set them aside.



**The original fenders are no longer needed.**

**2 TECHART aerodynamic fender****2.1 Install TECHART aerodynamic fender**

- 1 Sand and clean the inner adhesive surfaces of the fender around the opening for the TECHART grille air outlet left/right. TECHART recommends a grit size of 180.



Fig. 04



**Both grilles air outlet fender 092.121.250.230/231 must now be machined as follows:**

- 2 Place the grille template on the air outlet and fix it in place with clamps or adhesive tape.
- 3 Drill 16 holes with a diameter of 6 mm in two steps (3 mm) around in the flange. Place the holes inside the meshes. Insert the plastic expansion rivets and press the pins of the expansion rivets in flush.



Fig. 05

- 4 Grind all the top sides of the louvers well and clean them as well (shown in red).
- 5 Grind and clean the drilled flange well from the rear side (shown in green).
- 6 Also grind the rear sides of the CFRP louvers.
- 7 All ground plastic surfaces (no CFRP parts) must be wetted with BETAPRIME 5404 and allowed to dry completely.



Fig. 06

- 8 Apply body adhesive to the primed flange.
- 9 Insert the component into the fender and press it firmly. Press the frame firmly together and fix it in place using adhesive tape or clamps while the adhesive is drying.



Fig. 07

**i** The drying time of the body adhesive must be at least 12 hours.

- 10 Fit 1x M6 sheet metal nut per side on the inside of the fender at the bottom towards the door.
- 11 Slide on 3x M6 sheet metal nut for mounting the fastening strip on the front fender (see arrows in next figure). Do not tighten this screw connection completely.

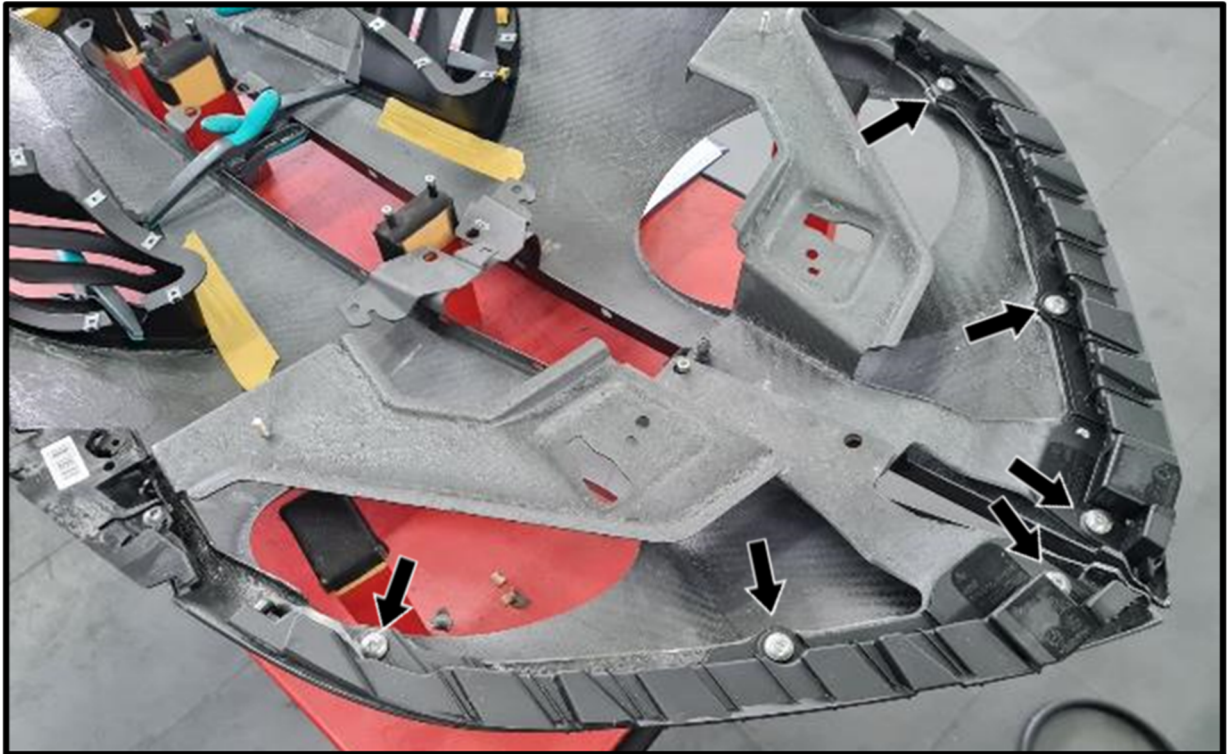


Fig. 08

- 12 Cut off both plastic tabs on the turn signal holders of the side turn signals as marked.
- 13 Mount the turn signal holder on the fender, fastening the rear screw points as for the original screw connection. At the front screw point (marked by a red circle), lock an M6 screw using an M6 nut with a wave washer. Do not tighten this screw connection completely.

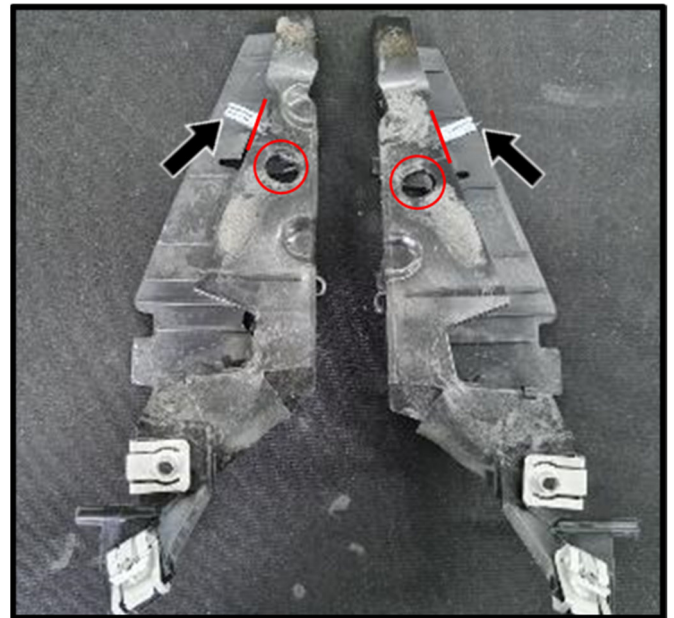


Fig. 09

- 14 Fasten both crash sensors with the original screws and the supplied M6 nuts self-locking and washers 6x20mm.

**i** During the following assembly of the left and right fender, it must be aligned and adjusted at the A-pillar bracket with the body washers included in the fender accessory pack. Due to tolerances in the component and vehicle, different gap dimensions may occur.

- 15 Place the left fender on the car and screw it to the original fasteners. Use the M6x25mm screw supplied in the mudguard accessory pack for the upper screw point of the left mudguard. Do not tighten the screws completely. If comparable distances occur at other screw points, the longer M6x25mm screws must also be used there.
- 16 Insert the removed air-conditioning line between the dryer and the condenser into the right fender. With the help of an additional person, mount the fender including the inserted line to the vehicle. Do not tighten the screws completely, yet.
- 17 The air-conditioning lines are attached to the original attachment points by means of the clips, the screws of the lines are not yet tightened.

**i** If no TECHART aero hood is installed during the subsequent assembly process, the screws of the A-pillar as well as the screws of the A/C dryer must be tightened completely.  
If the TECHART aero hood is installed, this assembly step must be completed before the fenders are finished, since the gap dimensions of the front end can still be adjusted with the washer fluid reservoir removed.

**3 Mounting the washer fluid reservoir****3.1 For vehicles without night vision assistant**

- 1 Reconnect the plugs and the water hose to the pump and the water level indicator.
- 2 Screw the washer fluid reservoir to the original mounting points.
- 3 Insert the filler neck into the tank and fasten it with the original screw.

 **If the vehicle is equipped with night vision assistant, the installation must be carried out as described below.**



**1.2 For vehicles with night vision assistant**

- 1 Remove the upper pump and the rubber seal from the original washer fluid reservoir.
- 2 Fit the adhesive base with a 3.6x200mm cable tie and mount it on the pump. Place the cable tie in a groove of the pump. Do not remove the adhesive pad yet.
- 3 Hold the pump with the adhesive base in the cutout against the rear wall to determine and mark the drill hole.
- 4 Drill a 10.5mm clearance hole in the reservoir. Rinse it out thoroughly; no drilling residue should remain in the container.



Fig. 10

- 5 Press the rubber seal into the hole and clean the adhesive area of the container.
- 6 Peel off the transfer foil of the adhesive pad.
- 7 Insert the pump into the rubber seal and press it firmly against the wall of the container.
- 8 Cut open the original wash water hose at the connection endings to the connecting piece in order to remove it.
- 9 Connect the provided PVC hose to the connector and connect it with a supplied 1-ear clamp.



Fig. 11

- 10 Push the corrugated tube onto the PVC tube from the other side.
- 11 Prepare the second side in the same way as the first with a 1-ear clamp and the connector.
- 12 Reconnect the hose and electrical connectors to the pump and the tank.
- 13 Route the water hose of the night vision camera to the front behind the frame of the fender along the hood as shown in the picture.
- 14 Insert the washer fluid reservoir and tighten it with the original screws.
- 15 Insert the filler neck into the tank and fasten it with the original screw.



Fig. 12

**4 Montage TECHART Aerodynamic Kotflügel**

- 1 Insert the wheel housing shells at the front and tighten all screws. The wheel housing is now not trimmed under the grille as shown, but uncut above it.
- 2 Now, as the line indicates, the contour of the grille must be cut out with an approx. 1cm inwardly reduced cutout.
- 3 After trimming, the wheelhouse shell is pushed behind the air outlet and mounted.



Fig. 13

**5 Completion air conditioning/ cooling system**

- 1 Refill and bleed cooling system according to manufacturer's instructions.
- 2 Also refill air-conditioning system according to manufacturer's instructions.
- 3 Filling quantity with R1234yf or R134a according to manufacturer's instructions.

**6 Finish vehicle**

- 1 Make sure that the air conditioner and the system are filled.
- 2 Clear the entire fault memory. (PIWIS 3)
- 3 Perform an A/C compressor run-in with the PIWIS tester.
- 4 Mount wheels, observe torques according to manufacturer's instructions. For wheels with 5-hole fastening, the wheel bolts are tightened to 160 Nm. For wheels with center lock, tighten them to 600 Nm, loosen them by 90° and then tighten them again to 600 Nm. CAUTION, the wheels must be freely suspended.
- 5 Carry out a test drive with the vehicle and then check the vehicle for leaks and check the fault memory. If there are any faults, rectify them.

# TECHART

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