

ASSEMBLY INSTRUCTIONS TECHART Aero-Kit I for Cayenne from MY18

Part-No. 09Y.100.100.009	Front spoiler Turbo non-Turbo
Part-No. 09Y.100.180.009	Front spoiler Turbo
Part-No. 09Y.100.500.009	Rear apron incl. diffuser
Part-No. 09Y.100.510.009	Rear diffuser for SportDesign rear apron
Part-No. 09Y.121.510.009	Diffuser add-on, TECHART diffuser carbon
Part-No. 09Y.1___.650.009	Roof spoiler Turbo
Part-No. 09Y.100.651.009	Roof spoiler non-Turbo
Part-No. 09Y.100.700.009	Rear spoiler panel
Part-No. 09Y.100.710.009	Rear lettering
Part-No. 09Y.121.196.009	Aero-Hood

Version 10 – 01/2023






























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I Important safety information

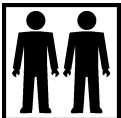
All of the necessary work must be performed by qualified persons with an appropriate level of expertise.

	<p style="text-align: center;"> WARNING</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;"> WARNING</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;"> WARNING</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;"> CAUTION</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;"> CAUTION</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;">NOTICE</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>	
	<p style="text-align: center;">NOTICE</p> <p>All body parts must be prepared and painted in accordance with the attached painting guide.</p>	

II Preparation

Number of people required



At least two people are required to install this product.

Help and support

If you have any technical queries, please contact us immediately:
support@techart.de

Check TECHART Aerokit I parts kit for completeness

1		09Y.100.100.009	Front Spoiler I for non-Turbo
Consisting of:			
	1	09Y.100.100.100	Front Spoiler, blank
	1	09Y.100.180.110	Splitter, black structure
	1	09Y.100.100.190	Shaft right, black structure
	1	09Y.100.100.191	Shaft left, black structure
	1	09Y.100.180.192	Shaft center, blank
	1	09Y.100.180.210	Splitter reinforcement
	2	09Y.100.180.220	Bracket splitter
	2	09Y.100.100.230	Bracket shaft center
	2	00091089010031	Bond + Seal black, Tube 70ml
		09Y.100.180.990	Mounting kit front spoiler
	27	0039004816A2SW	Collar bolt Torx 4.8x16, A2 black
	23	0029004.8/19.0X12.7	Speed nut 19mm x 4,8mm
	12	000100999999	Collar bolt for plastic PT 50x16 with cone point
	4	0029004.8/16.7X11	Speed nut, 4.8/16.7x11.0, yellow galvanized
	12	001900M05X15A2	Washer M 5x15, A2, DIN 9021
	2	0009014,8X1091504864	Blind rivet truss head 4.8x10

1		09Y.100.180.009	Front Spoiler I for Turbo
Consisting of:			
	1	09Y.100.180.100	Front Spoiler, blank
	1	09Y.100.180.110	Splitter, black structure
	1	09Y.100.180.190	Shaft right, black structure
	1	09Y.100.180.191	Shaft left, black structure
	1	09Y.100.180.192	Shaft center, blank
	1	09Y.100.180.210	Splitter reinforcement
	2	09Y.100.180.220	Bracket splitter
	2	09Y.100.180.230	Bracket shaft center
	2	00091089010031	Bond + Seal black, Tube 70ml
		09Y.100.180.990	Mounting kit front spoiler
	27	0039004816A2SW	Collar bolt Torx 4.8x16, A2 black
	23	0029004.8/19.0X12.7	Speed nut 19mm x 4,8mm
	12	000100999999	Collar bolt for plastic PT 50x16 with cone point
	4	0029004.8/16.7X11	Speed nut, 4.8/16.7x11.0, yellow galvanized
	12	001900M05X15A2	Washer M 5x15, A2, DIN 9021

1		09Y.100.500.009	Rear apron incl. diffusor
Consisting of:			
	1	09Y.100.500.100	Rear apron, blank
		or	
	1	09Y.100.500.100SW	Rear apron, black structure
	1	09Y100500125	Diffusor
	1	09Y.100.500.140	Heat protection right
	1	09Y.100.500.141	Heat protection left
	1	09Y.100.500.220	Tail pipe panel right
	1	09Y.100.500.221	Tail pipe panel left
	1	09Y.140.501.009	Foil, black rear diffusor sheet
	2	00091089010031	Bond + Seal black, Tube 70ml
		09Y.100.500.990	Mounting kit rear apron
	12	000.100.999.999	Collar bolt for plastic PT 50x16 with cone pointed
	4	0039004.2X161025	Sheet metal screw, fillister head with flange 4.2x16
	18	001900M05X15A2	Washer M 5x15, A2, DIN 9021
	14	50001900M5X16A27380	Fillister head screw with flange M 5x16 / A2
	14	001900M03685	Hexagon socket head screw, M 5 galvanized
	4	001900M05	Speed nut, M 5
	4	0039004.8X251025	Sheet metal screw fillister head with flange 4.8x25
	4	001900M05X25	Washer, M 5x25, galvanized
		+9Y.100.055.000	V02: without trailer hitch
	4	001900M6X307380A2	Fillister head screw with flange M 6x30 / A2
	4	001900M06986	Hexagon socket head screw, self-locking, M 6, galvanized
	4	001900M06X20	Washer DIN 522, 6,4x20x1,25mm, galvanized
		+9Y.100.056.000	V02: with trailer hitch
	1	058.180.550.500	Cable set reed-contact
	2	0009002.9X9.5	Sheet metal screw, raised countersunk head, 2,9x9.5
	2	8D0.100.805.121B	Clamping pin
	2	8D0100805960	Snap nut
	2	4A0.100.805.137	Rubber disk
	5	000590502221	Cable tie, metal tongue 3.5x140mm in black
	1	09Y.100.500.099B	Instruction sheet for trailer hitch

1		09Y.121.510.009	Rear diffuser for SportDesign rear apron
Consisting of:			
	1	09Y.121.510.100	Diffuser, SportDesign rear
	1	09Y.140.510.009	Cutting template, diffuser
Without trailer hitch			
	4	001900M6X307380A2	Fillister head screw with flange M 6x30 / A2
	4	001900M05986	Hexagon nut self-locking, M 6, galvanized
	4	001900M06X20	Washer DIN 522, 6.4x20x1,25mm, galvanized
With trailer hitch			
	1	058.180.550.500	Cable set Reed contact
	2	0009002.9X9.5	Sheet metal screw fillister head, 2.9x9.5
	2	8D0.100.805.121B	Clamp pin
	2	8D0.100.805.960	Snap nut
	2	4A0.100.805.137	Rubber disk
	5	000590502221	Cable ties metal tongue 3.5x140mm in black
	1	09Y.100.500.099B	Operating manual trailer hitch

and

1		09Y.100.510.009G	Diffuser add-on, TEACHART diffuser carbon glossy
Consisting of:			
	1	09Y.100.510.100G	Diffuser Carbon, glossy
	1	00091089010031	Bond + Seal black, tube 70ml

or

1		09Y.100.510.009M	Diffuser add-on, TEACHART diffuser carbon matt
Consisting of:			
	1	09Y.100.510.100M	Diffuser Carbon, matt
	1	00091089010031	Bond + Seal black, tube 70ml

1		09Y.100.650.009	Roof Spoiler for Turbo
Consisting of:			
	1	09Y.100.650.100	Roof spoiler, blank
	1	00091089010031	Bond + Seal black, tube 70ml

1		09Y.121.650.009	Carbon roof spoiler for Turbo
Consisting of:			
	1	09Y.121.650.100	Roof spoiler, blank
	1	00091089010031	Bond + Seal black, tube 70ml

1		09Y.100.651.009	Roof Spoiler for non-Turbo
Consisting of:			
	1	09Y.100.651.100	Panel right outer side
	1	09Y.100.651.100	Panel left outer side
	1	B95.100.650.110	Panel right inner side
	1	B95.100.650.110	Panel left inner side
	6	000.100.999.999	Collar screw for plastics PT 50 x 16 pointed
	1	00091089010031	Bond + Seal black, Tube 70ml

Part options

1		+9Y.100.651.201	V01: Wing profile paintable with bases
Consisting of:			
	1	09Y.100.651.200	Profile
	1	09Y.100.651.210	Base
	1	001900M06X12912	Hexagon socket head screw, M 6x12, galvanized

or

1		+9Y.100.651.200M	V01: Wing profile Carbon matt
Consisting of:			
	1	058.100.654.200M	Profile roof spoiler Carbon matt

or

1		+9Y.100.651.200G	V01: Wing profile Carbon glossy
Consisting of:			
	1	058.100.654.200G	Profile roof spoiler Carbon matt

1		09Y.100.700.009	Rear spoiler panel
Consisting of:			
	1	09Y.100.700.100	Rear spoiler panel, blank
	1	00091089010031	Bond + Seal black, Tube 70ml

1		09Y.100.710.009	Rear lettering
Consisting of:			
	1	+9Y.100.710.001	V01: Lettering in black

or

	1	+9Y.100.710.002	V01: Lettering in silver
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1		09Y.121.196.009	Aero-engine hood
Consisting of:			
	1	09Y.100.196.100	Shaft R
	1	09Y.100.196.101	Shaft L
	1	00091089010031	Bond + Seal black, tube 70ml

Part options

1		+9Y.121.001.000	V01: Aero hood, paintable
Consisting of:			
	1	09Y.121.196.100	Aero-engine hood

or

1		+9Y.121.001.000G	V01: Aero hood visible carbon glossy
Consisting of:			
	1	09Y.121.196.100G	Aero-engine hood

or

1		+9Y.121.001.000M	V01: Aero hood visible carbon matt
Consisting of:			
	1	09Y.121.196.100M	Aero-engine hood

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 Installation

1 Before Painting

i For vehicles with trailer hitch, the TECHART rear diffuser must be adapted.

- 1 Remove the recessed area and additionally cut 7mm more towards the screw flange.

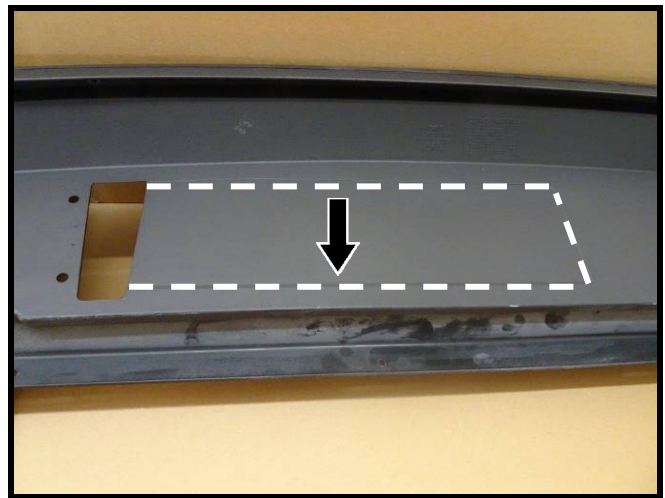


Fig. 01

2 Prepare vehicle

i Before starting work, check that the vehicle is free of defects. Use the PIWIS system tester to read out all of the fault memories of the individual vehicle components and first rectify any faults displayed.

2.1 Switch off level control

- 1 Switch on ignition
- 2 Instrument cluster:
 - SET
 - Vehicle settings
 - Jack mode „✓“



Fig. 02

2.2 Remove wheels and detachable parts

- 1 Raise vehicle at the factory-fitted jacking points
- 2 Detach the wheels.

- 3 Detach original parts
- 3.1 Detach original front panel

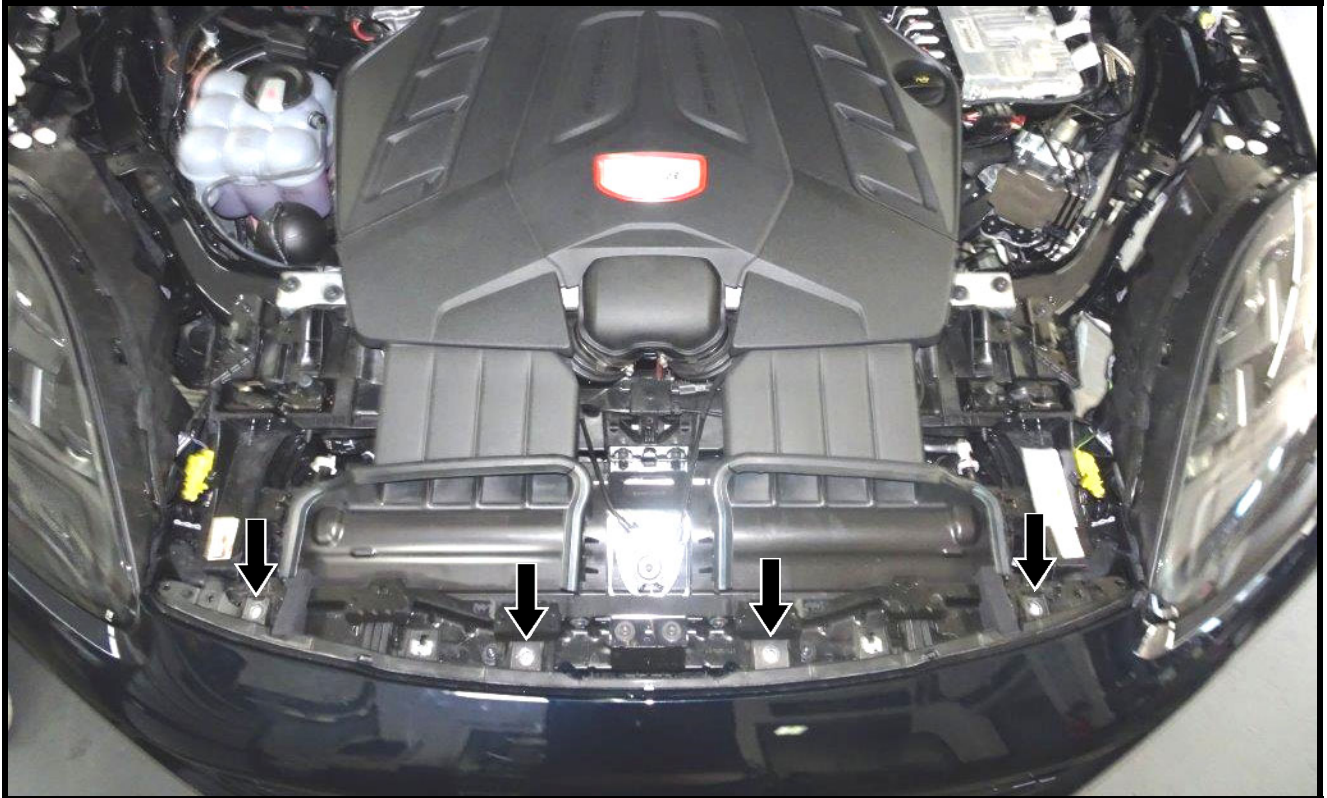


Fig. 03

- 1 Open engine hood.
- 2 Remove hood opener.
- 3 Remove PU-cover around the hood lock.
- 4 Remove upper mounting bolts (see arrows).

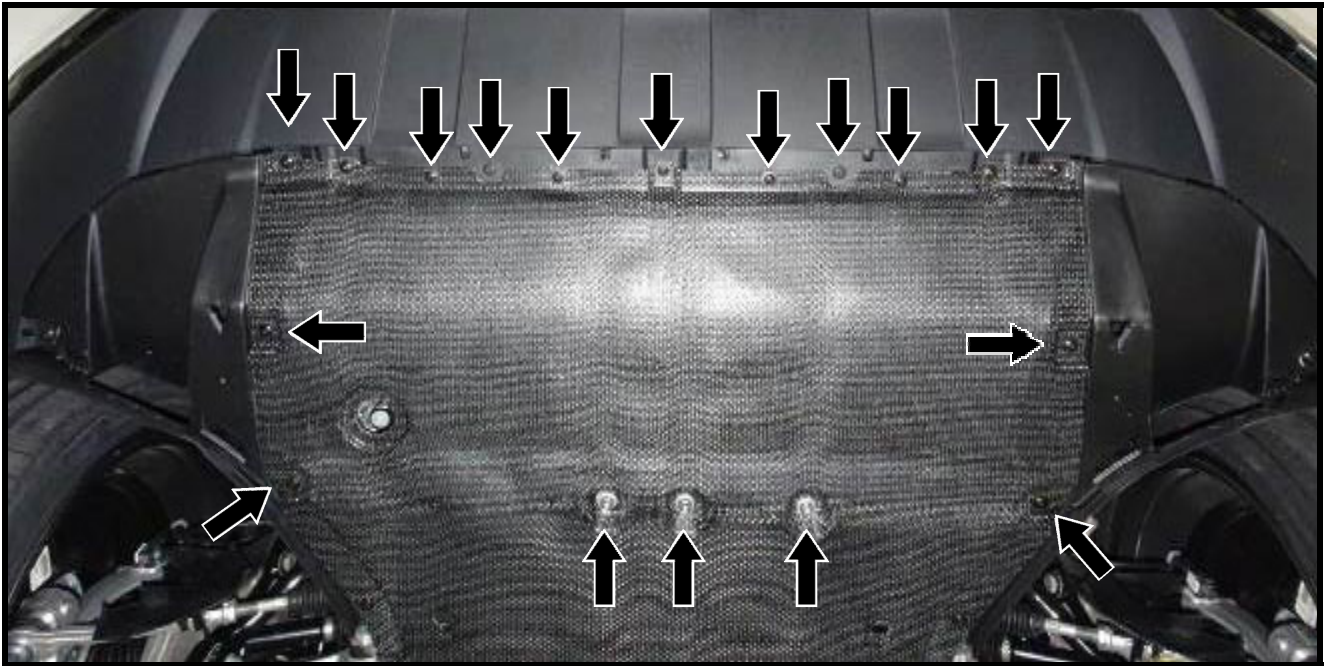


Fig. 04

- 5 Unscrew and remove the underride protection (see arrows).
- 6 Unscrew lower fastening screws.
- 7 Dismantle the front wheel house inner lining.
- 8 Unscrew and unclip the front wheel extension entirely (for that uses the release of wheel house).
- 9 Unscrew the fastening screws (1 each, right and left) from out of the wheel house (see arrow).
- 10 Separate the electrical connection in the left wheel house (see arrow).
- 11 On vehicles with night vision camera: separate the splash water hose (see arrow).

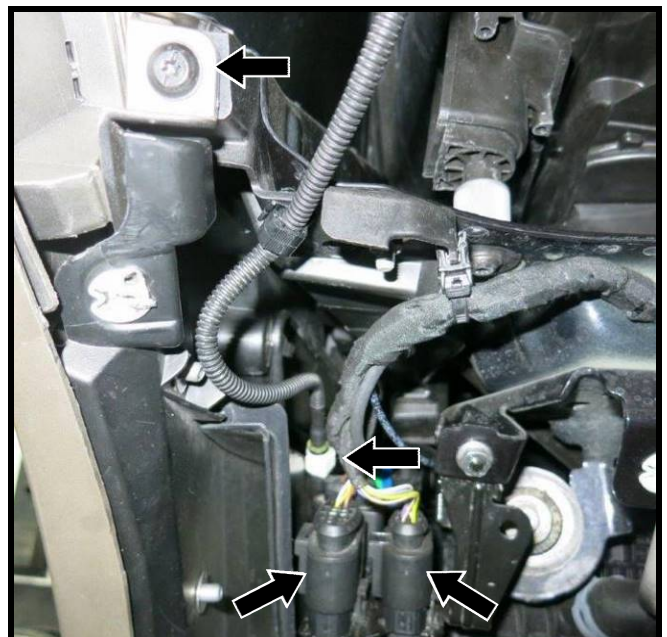


Fig. 05

- 12 Remove the original front panel towards the front.
- 13 Unscrew the original front spoiler / underbody on the sides.
- 14 Remove the license plate bracket.



Fig. 06

- 15 Unclip the original front spoiler / underbody from the front panel.

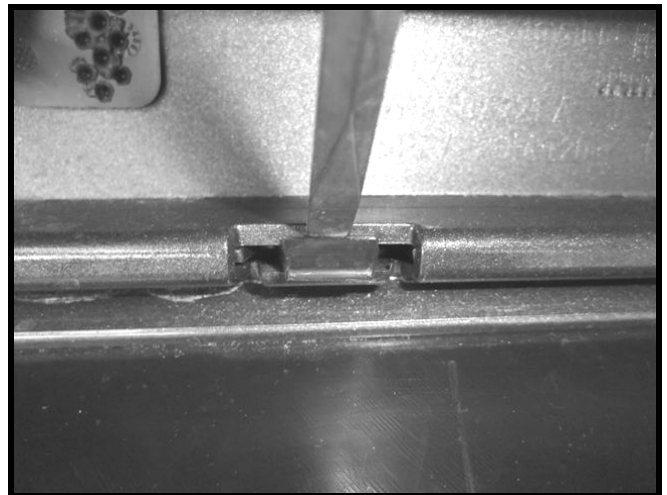


Fig. 07

i The original front spoiler / underbody are no longer required.

3.2 Detach original rear panel (does not apply for SportDesign w/o trailer hitch)

- 1 Unclip the covers on the right and left in the trunk.



Fig. 08

- 2 Remove the mounting screws of the rear lamp (see Arrow).



Fig. 09

- 3 Unclips the cover caps of the rear lamp mounting screws.



Fig. 10

- 4 Remove and detach tail lights (see arrows).
- 5 Dismantle the stop rubber of the tailgate (see arrows).
- 6 Unscrew the rear apron at the top. (see arrows)
- 7 Dismantle the inner wheel arch.



Fig. 11

- 8 Separate the electrical plug right in the wheel house.

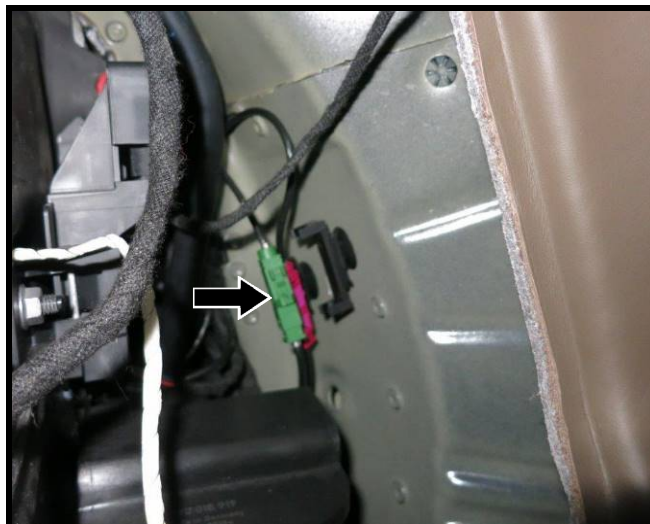


Fig. 12

- 9 Separate the electrical plug left in the wheel house.



Fig. 13

- 10 Unscrew and unclip the rear wheel extension entirely (for that uses the release of wheel house).
- 11 Unscrew the fixing screws of the rear apron.
- 12 Unscrew the heat protection from the bottom.
- 13 Remove the rear apron towards the back and pull out the cables from the body.



Fig. 14

- 14 Unclip the original diffusor/tail pipe panels from the rear panel.

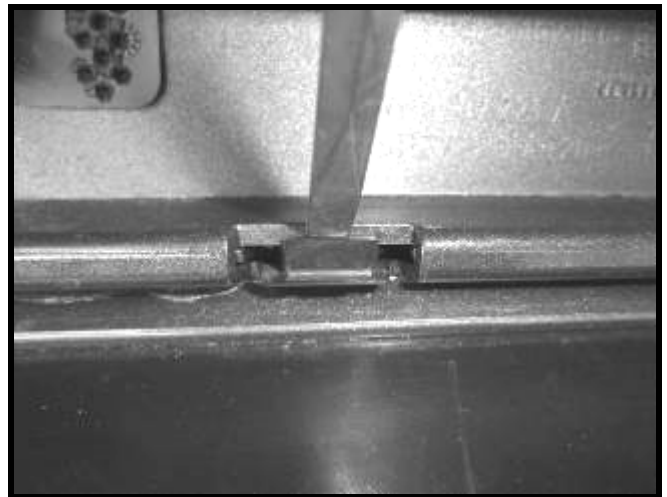


Fig. 15



The original diffusor / tailpipe panels are no longer required.

3.3 Remove the original engine hood

- 1 Remove the nozzles from the engine hood.
- 2 Pull the water hose from the hood.
- 3 Unscrew both arrester hooks.
- 4 Remove the cover of the fixing screws.
- 5 Untighten the hood.



The original engine hood is no longer needed.

4 Installation**4.1 Install TECHART front spoiler**

- i** The gluing surfaces of the TECHART front spoiler, TECHART shaft R, L and center and the original front apron must be dry and free from dust or paint spray mist!

Thoroughly degrease adhesive surfaces on the TECHART front spoiler, TECHART shaft R, L and center and the original front apron with cleaner. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the cleaned surfaces.

- 1 Align and mark the TECHART bracket splitter 09Y.100.180.220 (1) to the cooler console (2). Drill a fixing hole into the cooler console (2) of \varnothing 5mm.
- 2 Attach the speed nut to the TECHART Bracket splitter (1).
- 3 Tighten the TECHART bracket splitter (3) with the screw 4.8x16.

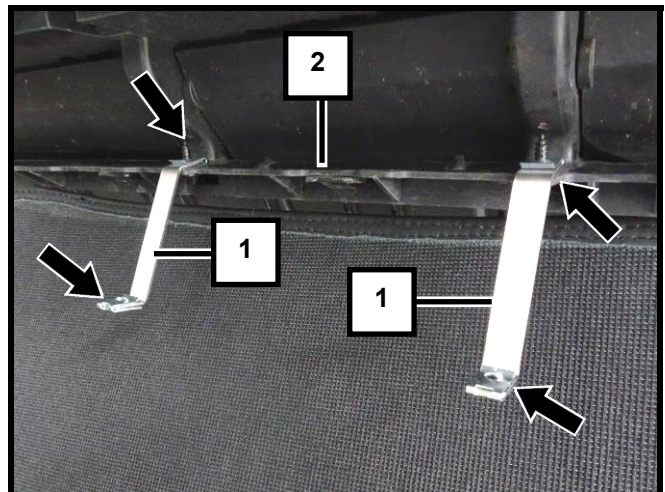


Fig. 16

- 4 Apply PU-adhesive to the bonding area (outer edge shaft r & L at the TECHART front spoiler (3)).
- 5 Glue the TECHART shaft right and left 09Y.100.1_0.19_ (4) into the TECHART front spoiler 09Y.100.1_0.100 (3).

- i** Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

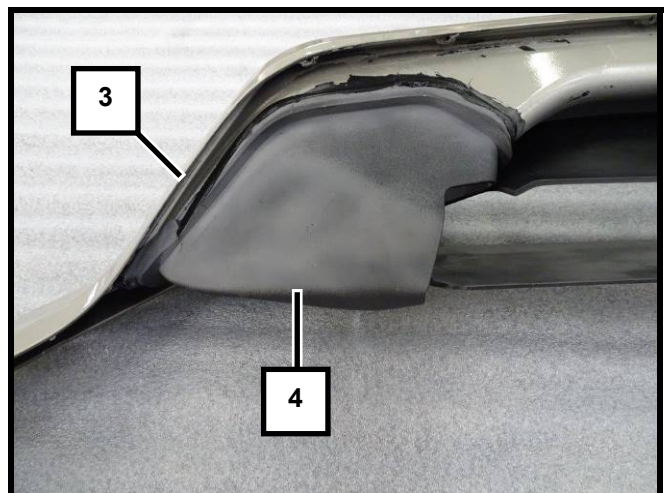


Fig. 17

- 6 Apply PU-adhesive to the bonding area (outer edge shaft center at the TECHART front spoiler (3)).
- 7 Glue the TECHART shaft center 09Y.100.180.192 (5) into the TECHART front spoiler (3).

i Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

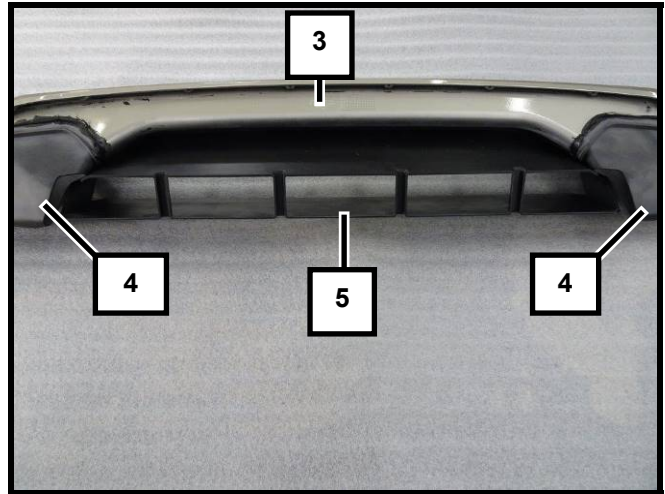


Fig. 18

- 8 Apply PU-adhesive to the front apron (6).

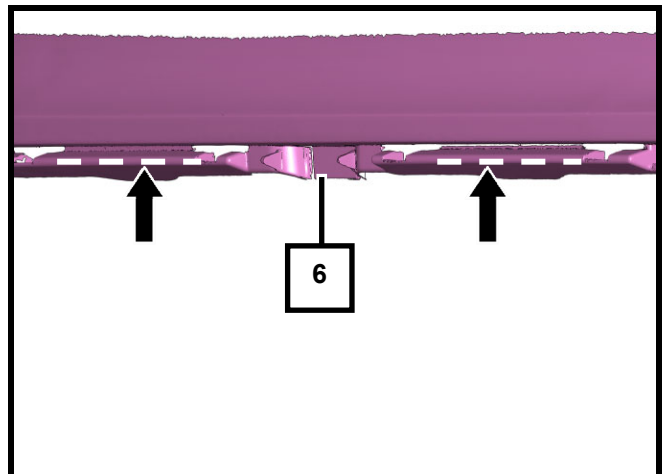


Fig. 19

- 9 Attach the TECHART front spoiler (3) to the front apron and tighten with the screws 5x16.

i Just apply the screws, do not tighten otherwise the outer area (the visible area of the TECHART front apron) will become wavy.

i Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

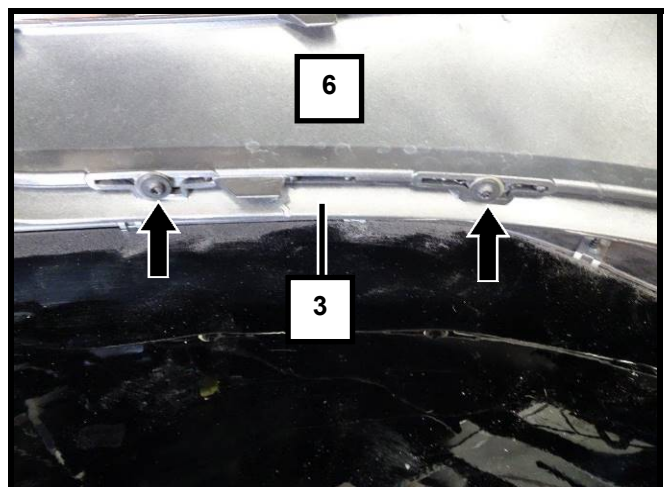


Fig. 20

- 10 Tighten the TECHART front spoiler (3) on the side with the original screw to the front apron (6).

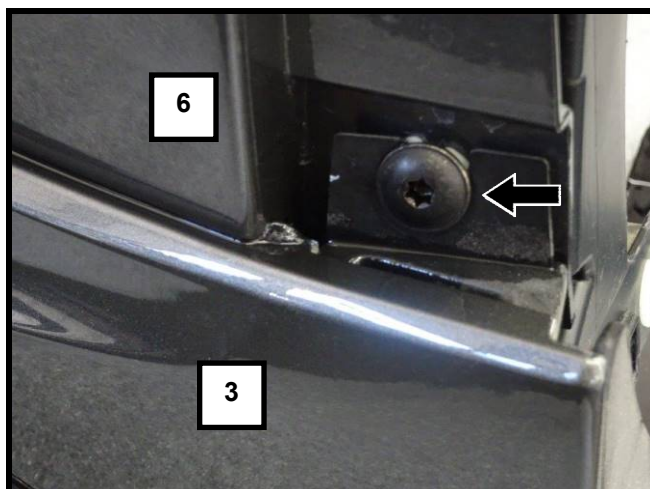


Fig. 21

- 11 Tighten the TECHART bracket shaft center 09Y.100.180.230 (7) with the screws of the TECHART front spoiler (3).
- 12 Clinch the TECHART bracket shaft center (7) with the rivet 4.8x10 to the TECHART shaft center (5), for that drill a hole of \varnothing 5mm into the TECHART shaft center (5).

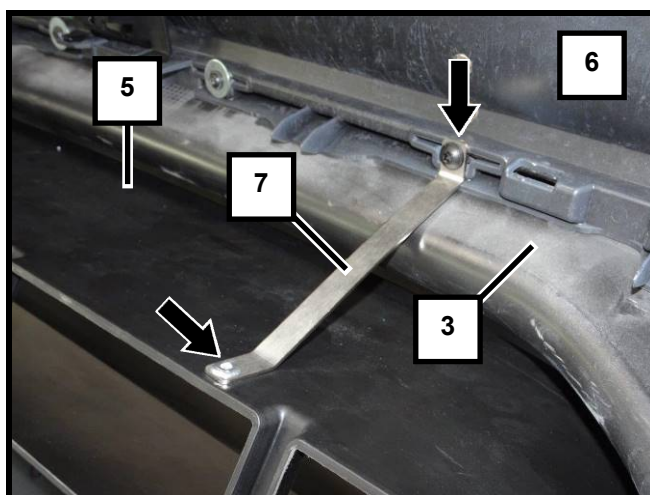


Fig. 22

- 13 Attach the speed nut 4.8x16 on the bottom to the TECHART shaft center (5).

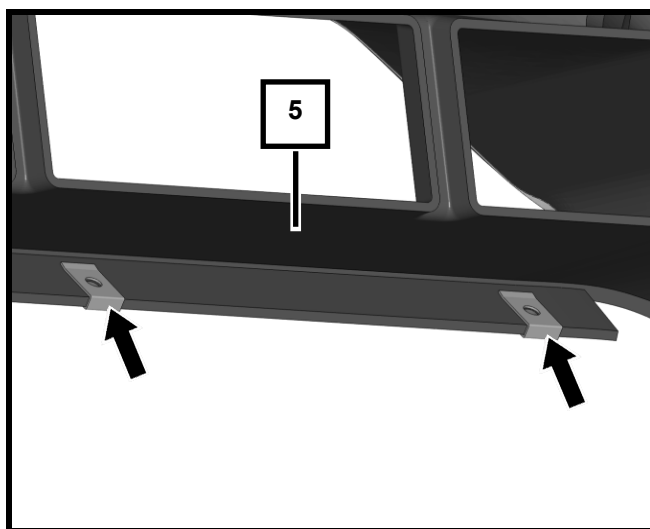


Fig. 23

- 14 Attach the speed nut 4.8x16 to the TECHART front spoiler (3).

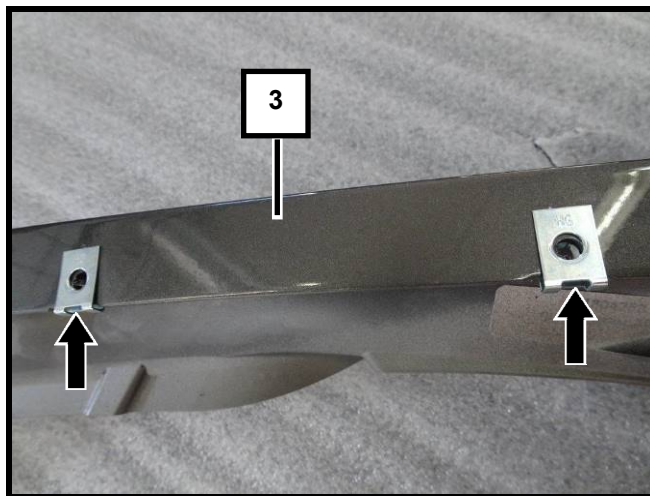


Fig. 24

- 15 Feed the TECHART splitter 09Y.100.180.110 (8) into the TECHART front spoiler (3) and tighten with the screws 4.8x16.

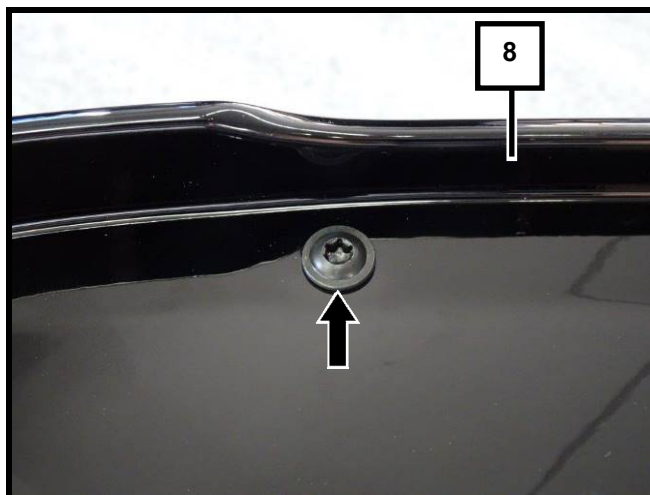


Fig. 25

4.2 Install the original front apron with TECHART front spoiler

i When aligning the TECHART front apron pay attention to the gap widths.

- 1 Slide the front apron with the TECHART front spoiler into the original guides left and right on the vehicle.
- 2 Fasten the front apron with the TECHART front spoiler on the top with the original screws.
- 3 Attach the front apron with the TECHART front spoiler at the fender and tighten with the original screws.
- 4 Tighten the TECHART splitter (8) at the rear only on the outer side and in the center with the original screws.
- 5 Fasten the original underbody (9).

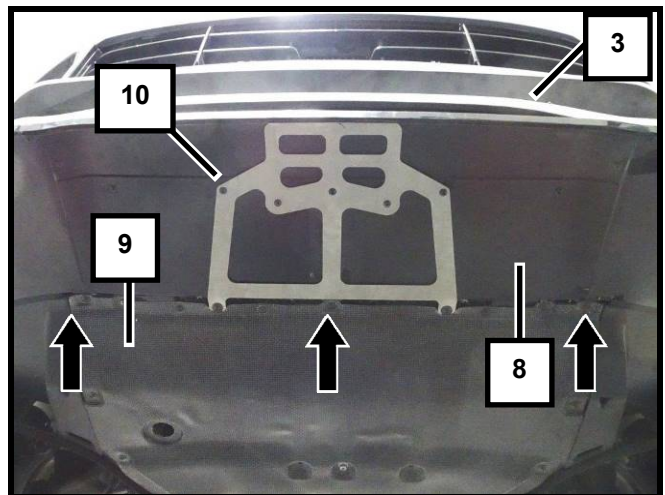


Fig. 26

- 6 Fasten the TECHART reinforcement splitter 09Y.100.180.210 (10) at the rear with the TECHART splitter (8) and with the original screws.

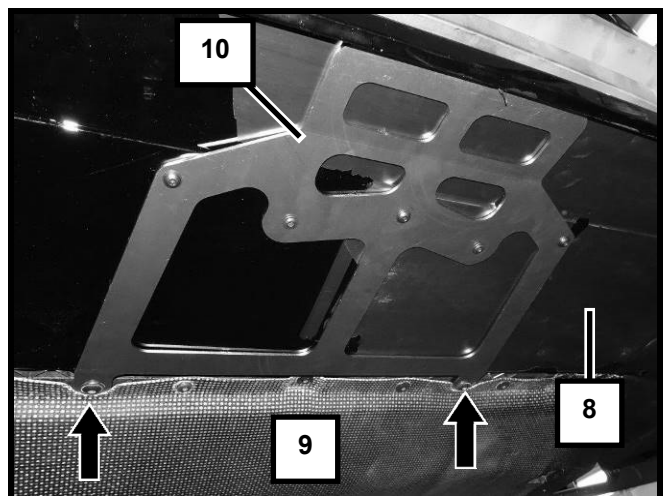


Fig. 27

- 7 Tighten the TECHART reinforcement splitter (10) with the screws 4.8x19 through the TECHART splitter (8) to the TECHART shaft center (5).

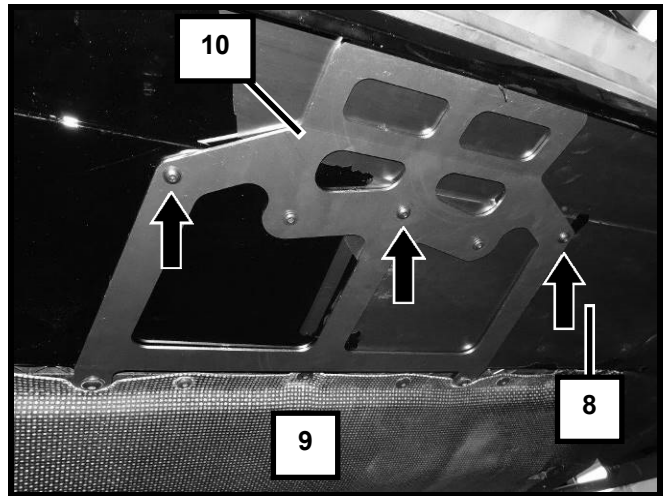


Fig. 28

- 8 Tighten the TECHART reinforcement splitter (10) with the screws 4.8x16 through the TECHART splitter (8) to the TECHART bracket splitter (1). (fig. 14)
- 9 Fasten the TECHART splitter (8) to the remaining fixing points on the bottom with the original screws.
- 10 Connect the electrical connection at the left wheel arch.
- 11 On vehicles with night vision camera: connect the splash water hose.

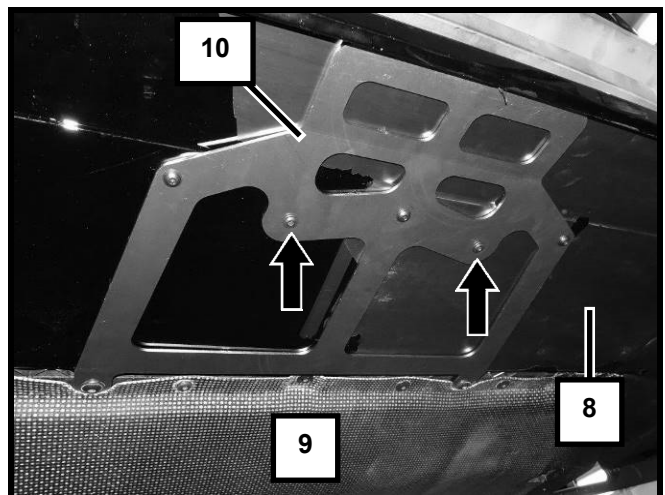


Fig. 29

4.3 Install TECHART rear apron

i The bonding surfaces on the TECHART rear diffuser and original rear apron must be dry and free from dust and paint spray mist.

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART rear diffuser and original rear apron. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the surfaces after they have been cleaned.

- 1 Separate the bracket at the rear apron.



Fig. 30

- 2 Separate the reinforcement between the both fixing points on the bottom side.



Fig. 31

- 3 Stick the TECHART foil 09Y.140.501.009 to the rear holding sheet (12).

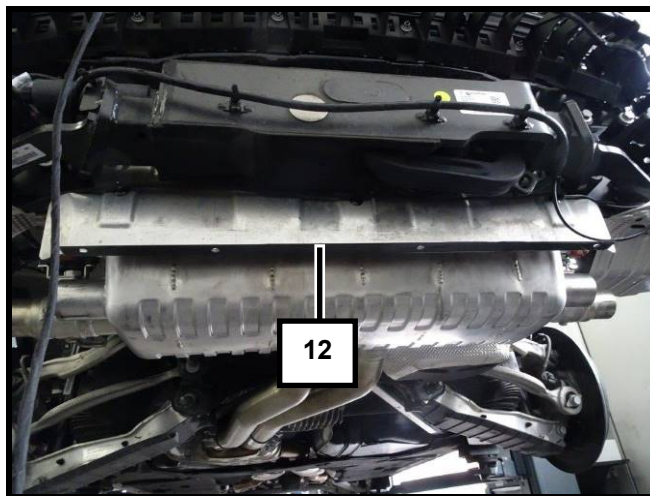


Fig. 32

- 4 Tighten the TECHART heat protection 09Y.100.500.14_ (13) with the screws M5x16, washer 5x15 and nut M5 self-locking to the TECHART rear apron 09Y.100.500.100 (14).

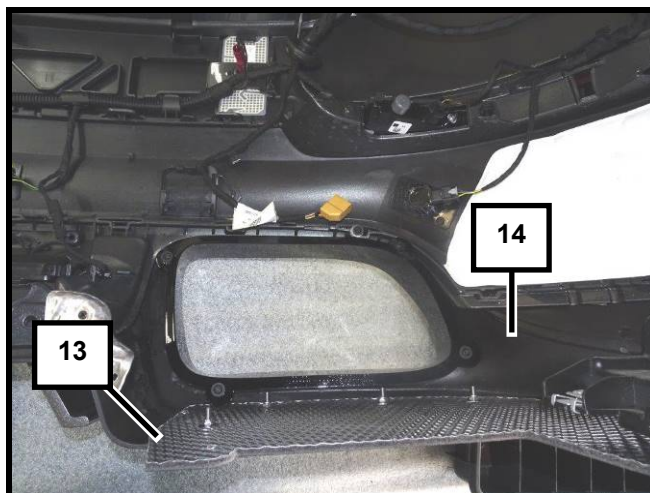


Fig. 33

- 5 Tighten the TECHART tail pipe panels 09Y.100.500.22_ (15) with the screws 5x16 into the TECHART rear apron (14).

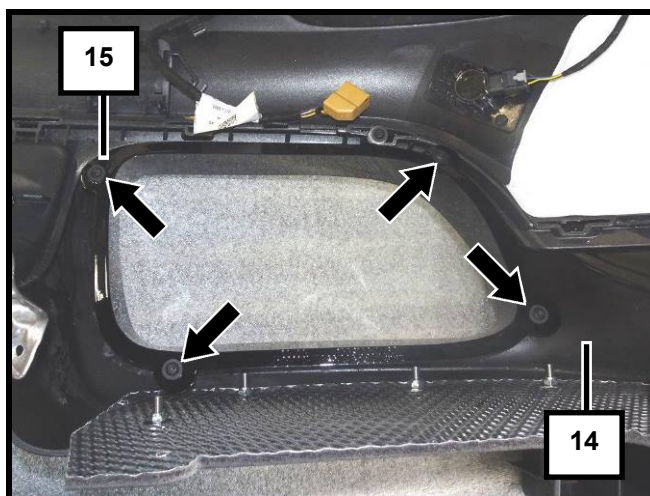


Fig. 34

- 6 Apply the PU-adhesive to the original rear apron (16).
- 7 Attach and align the TECHART rear apron (14) to the rear apron.

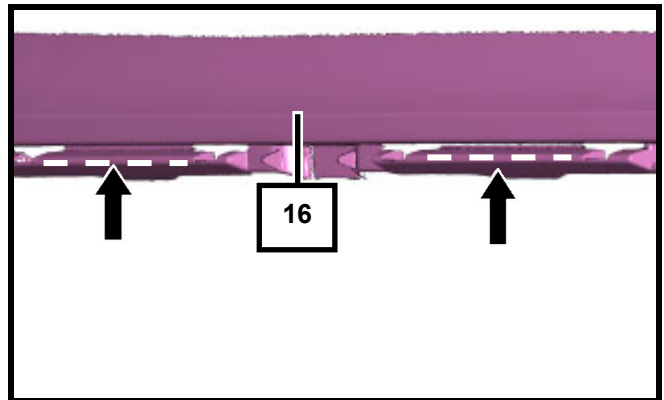


Fig. 35

- 8 Screw the TECHART rear apron with the screws 4.2x16 and the washers to the four fixing points in the center of the rear apron (16). The outer side will be glued.

i Just apply the screws, do not tighten otherwise the outer area (the visible area of the TECHART rear apron) will become wavy.

- 9 Jam the TECHART rear apron (16) with 4 screws 5x16 (b) in center.

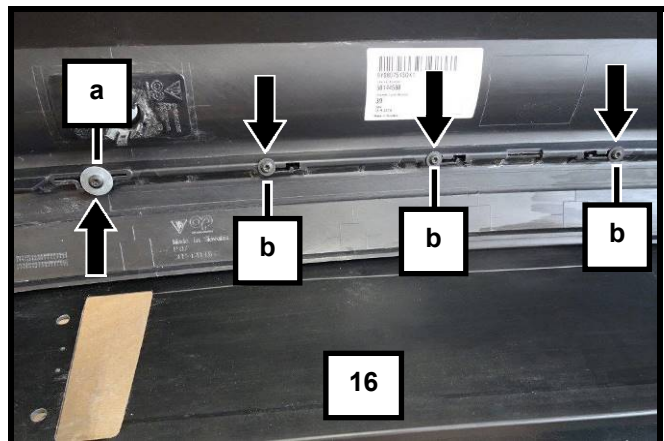


Fig. 36

i Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape. Allow to dry for at least 12 hours.

Afterwards the screw 5x16 can be removed again.

- 10 Glue the sensors and cable to the TECHART rear diffuser (14).
- 11 Attach the speed nuts 4.8x16 to the TECHART rear diffuser (14).

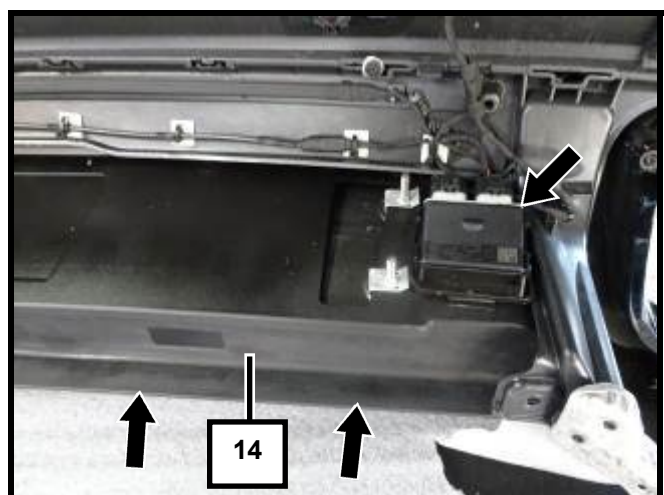


Fig. 37

For vehicles without trailer hitch

- 12 Tighten the TECHART diffusor 09Y.100.500.125 (26) with the screws M6x30, washer 6.4x20 and the nuts M6 self-locking to the TECHART rear diffusor (26).



Care for an accurate fit.

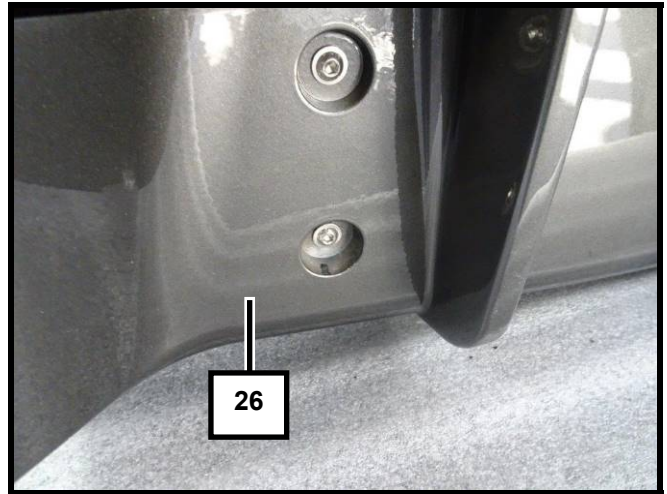


Fig. 38

4.4 Install TECHART AeroKit I assembly kit for electronic trailer hitch

- 1 Open the flap on the right of the trunk.
- 2 Dismantle the vehicle's rear right ventilation.
- 3 Lay the TECHART cable set with reed-contact 058.180.550.500 (27) through the rubber stop at the side piece into the vehicle.
- 4 Unclip the switch of the trailer hitch from the side lining.

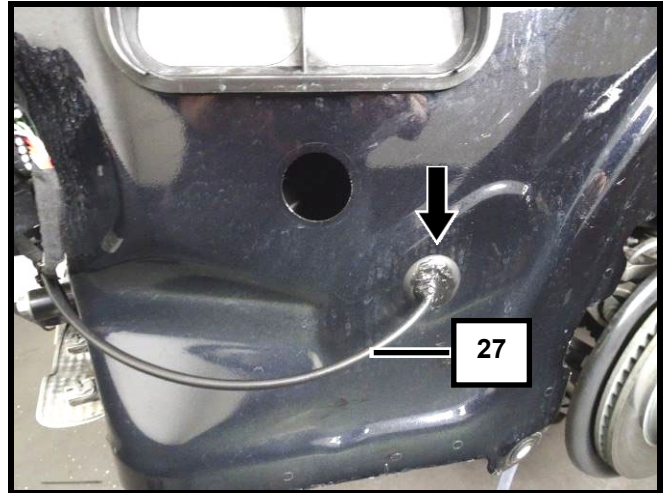


Fig. 39

- 5 Unclip plug.
- 6 Unpin pin 8 yellow/violet from the plug.
- 7 Pin in the white cable from the TECHART wiring harness into the original plug.
- 8 Pin in the cable yellow/black into the TECHART plug pin 1.

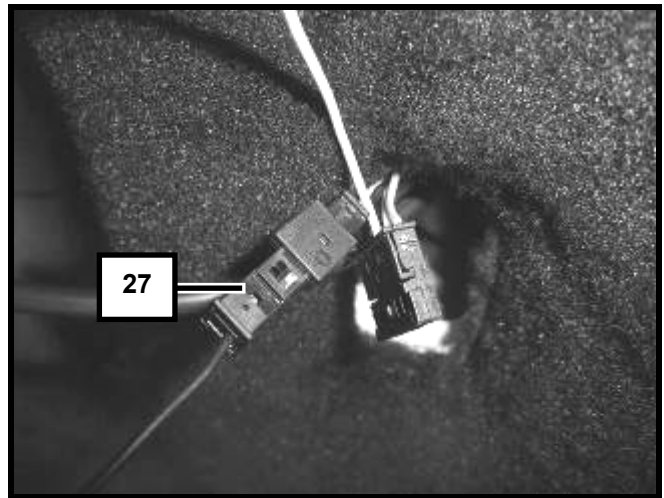


Fig. 40

- 9 Pin in the black cable of the TECHART wiring harness in to the TECHART mating plug Pin 1.
- 10 Connect the TECHART plugs.
- 11 Lay the TECHART reed-contact and allow overlapping for about 150mm.
- 12 Secure the TECHART wiring harness with cable ties.

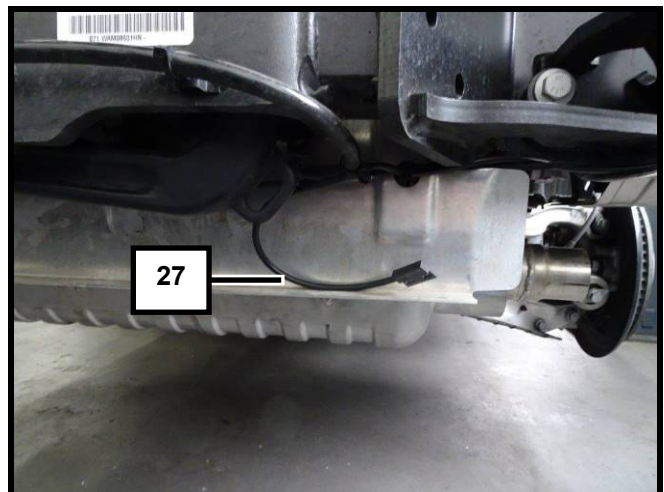


Fig. 41

- 13 Glue the reed-contact magnet with PU adhesive into the provided curb at the TECHART diffusor (26), in the correct direction.

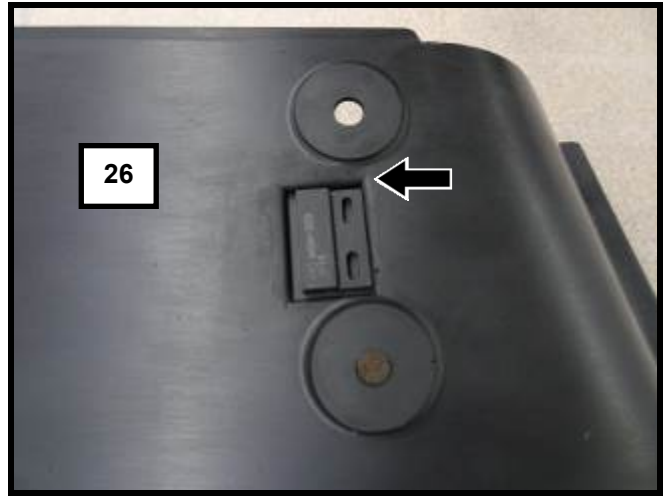


Fig. 42

4.5 Install original rear apron to TECHART rear apron

i Pay attention to the gap dimensions when aligning the TECHART rear apron.

- 1 Slide on rear apron with TECHART rear diffuser.
- 2 Screw the rear apron with the TECHART rear diffuser on the top with the original screws.
- 3 Connect electrical connector in left wheel arch.
- 4 Tighten the TECHART rear diffuser (20) to the original sheet with the original screws.

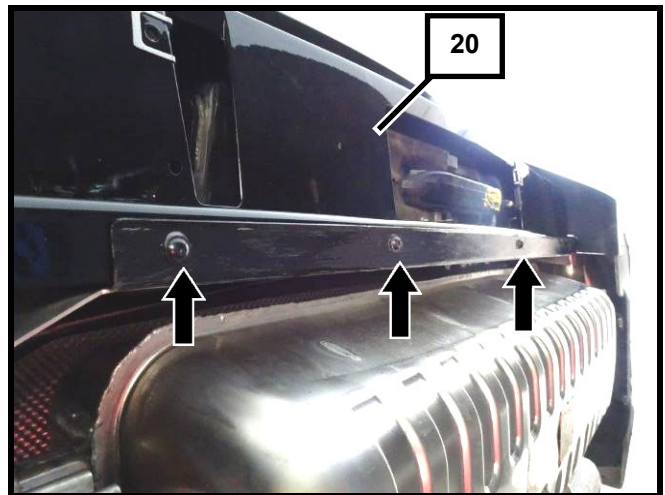


Fig. 43

Vehicles with electrical trailer hitch

- 5 Attach the snap nut 8D0.100.805.960 to the TECHART rear diffusor (20).
- 6 Tighten the TECHART cable set with Reed-contact (27) with the screws 2.9x95 to the TECHART rear diffusor (20).

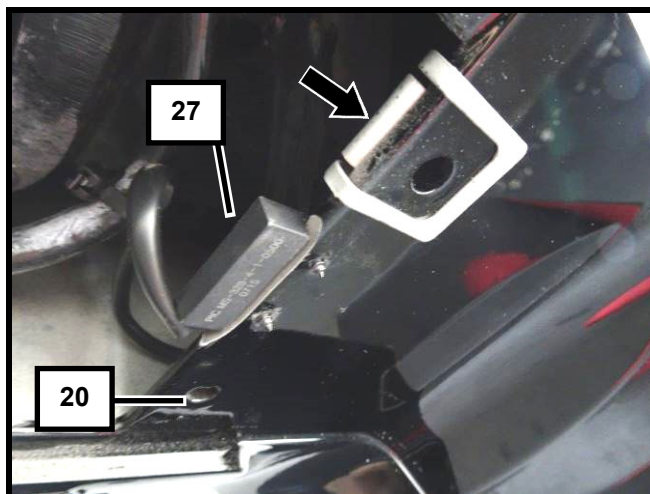


Fig. 44

- 7 Push the clamp pin into the rear hole of the TECHART diffusor (26) and secure it with the rubber disk on the top.
- 8 Feed the TECHART diffusor (26) into the TECHART rear diffusor (20) and lock with the clamping pin.

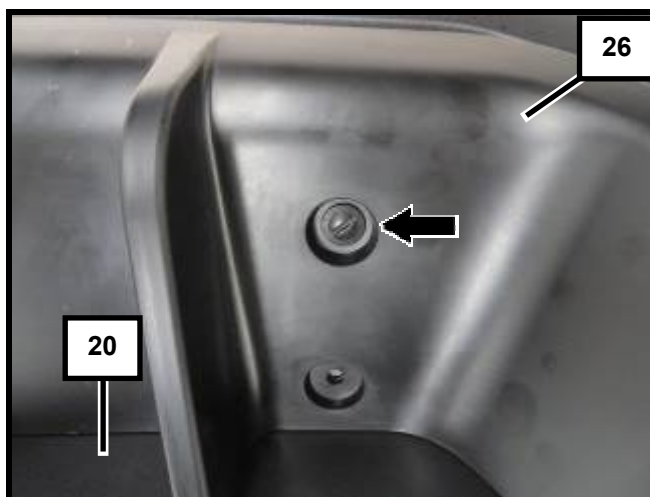


Fig. 45

4.6 Install TECHART diffuser add-on 09Y.121.510.009_

i If included in the scope of delivery, the diffuser add-on is installed before installing the SportDesign rear diffuser.

- 1 Sand the rear of the diffuser attachment with sandpaper. TECHART recommends a grain size of 180 to 240.
- 2 Also sand the diffuser. In order to determine the component seat, the attachment can be put on in advance.
- 3 Thoroughly clean both parts after sanding.
- 4 Apply a bead of adhesive to the rear of the carbon component, first all around and then over the entire surface, making sure that there is a distance of at least 6mm to the edge to prevent the adhesive from oozing out.
- 5 Place the diffuser attachment on the diffuser and fix it with adhesive tape.

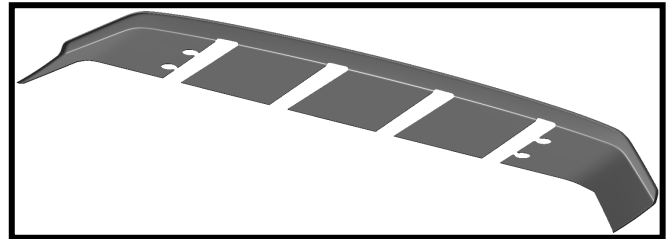


Fig. 46

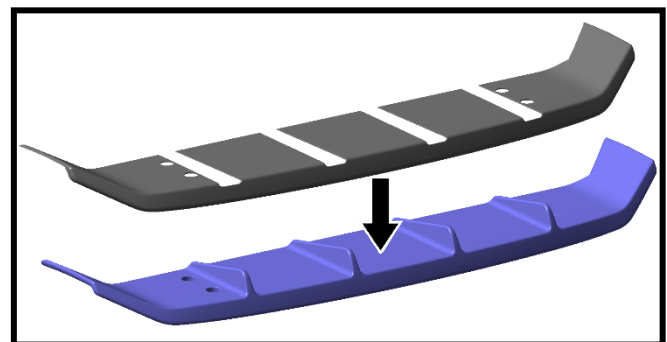


Fig. 47

4.7 Install TECHART rear diffuser for SportDesign rear apron

- 1 Stick the TECHART cutting template diffuser 09Y.140.510.009 (28) to the original rear apron (29).
- 2 Modify rear apron, drill four holes $d = 8\text{mm}$ and clear the recess for the speed nut.

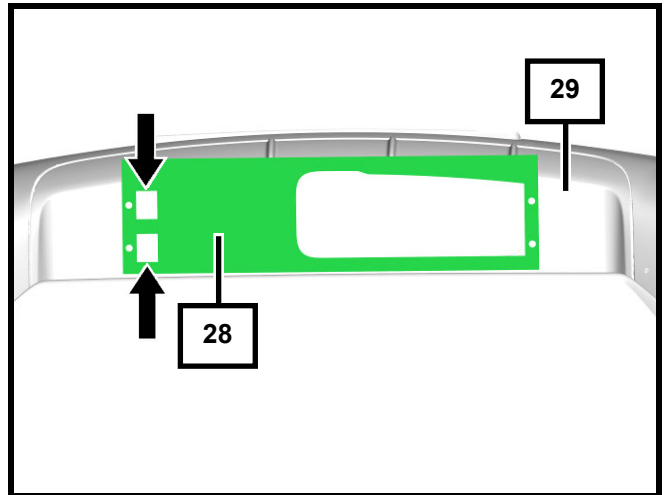


Fig. 48

Vehicles without trailer hitch

- 3 Tighten the TECHART diffuser 09Y.100.510.100 (30) with the screws M6x30, washer 6.4x20 and the nuts M6 self-locking to the TECHART rear diffuser (29).

i Care for an accurate fit.

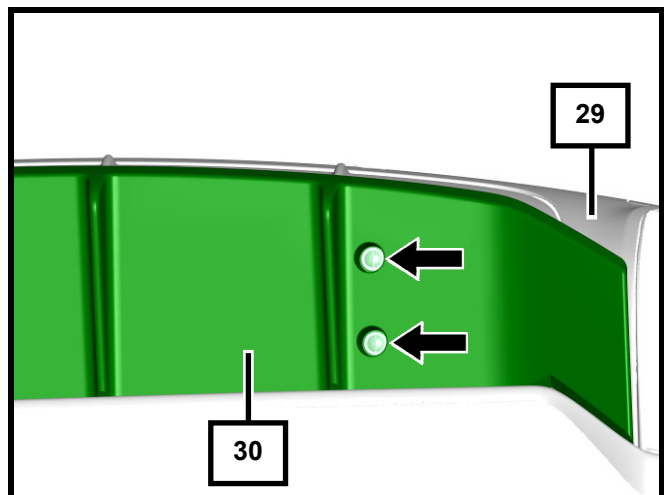


Fig. 49

For vehicles with trailer hitch

- 4 Proceed with bullet point 4.4 and 4.5 of these assembly instructions.

5 TECHART roof spoiler for Turbo

i The bonding surfaces on the TECHART roof spoiler and original roof spoiler must be dry and free from dust and paint spray mist.

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART roof spoiler and original roof spoiler. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the surfaces after they have been cleaned.

5.1 Install TECHART roof spoiler Turbo

- 1 Apply PU-adhesive to the bonding area of the TECHART roof spoiler 09Y.1__650.100 (31).

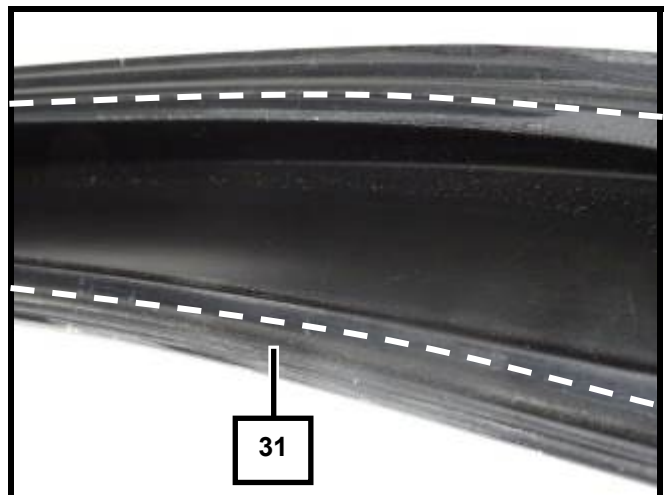


Fig. 50

- 2 Attach and align the TECHART roof spoiler (31).

i Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

Allow to dry for at least 12 hours.



Fig. 51

6 TECHART roof spoiler non-Turbo

i The bonding surfaces on the TECHART roof spoiler and original roof spoiler must be dry and free from dust and paint spray mist.

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART roof spoiler and original roof spoiler. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the surfaces after they have been cleaned.

6.1 Install TECHART roof spoiler non-Turbo

Do not execute on carbon profile.

- 1 Tighten the TECHART base 09Y.100.651.210 (32) with the screws M6x12 to the TECHART profile 09Y.100.651.200 (33).

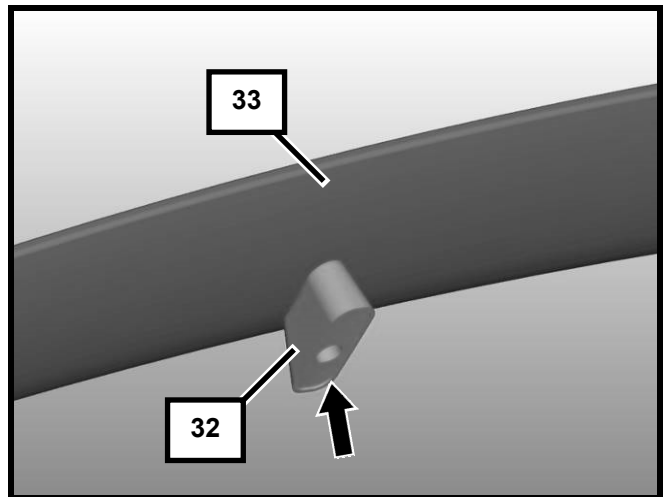


Fig. 52

- 2 Fasten the TECHART panel inner side B95.100.650.110/111 (34) with the screws 5x16 to the TECHART profile (33).

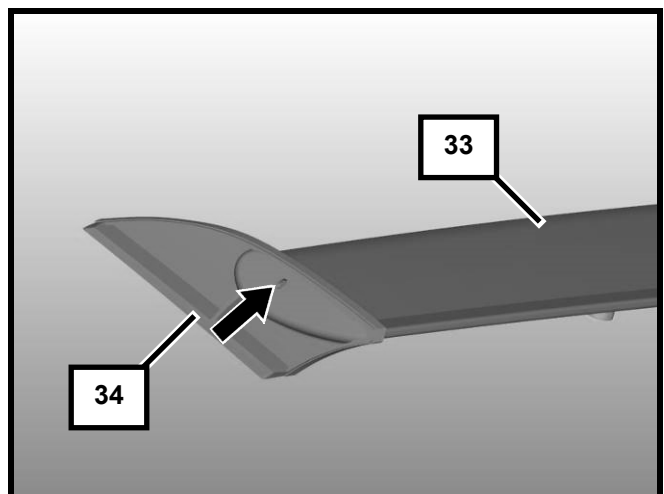


Fig. 53

- 3 Apply PU-adhesive to the bonding surface of the TECHART panel inner side (34) and TECHART base (32).
- 4 Attach and align the TECHART profile (33) incl. TECHART panel inner side (34) and TECHART base (32) to the original roof spoiler and tighten with the screws 5x16.

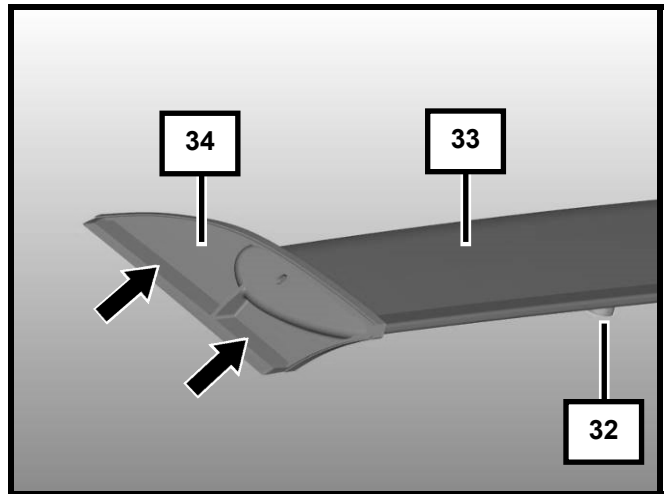


Fig. 54

- 5 Apply PU-adhesive to the bonding surface of the TECHART panel outer side 09Y.100.651.100/101 (35).
- 6 Glue the TECHART panel outer side (35) to the TECHART panel inner side (34).

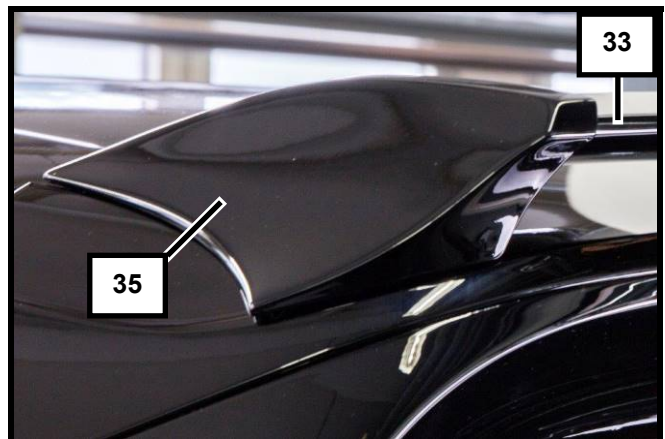


Fig. 55

- i** Die Teile im Klebebereich gut andrücken. Auf Passgenauigkeit achten – gegebenenfalls heraustretenden Kleber mit Reiniger entfernen und mit Klebeband sichern.
- i** Die Trockenzeit muss mindestens 12 Stunden betragen.

7 TECHART rear spoiler panel

i The bonding surfaces on the TECHART rear spoiler panel and on the original tailgate must be dry and free from dust and paint spray mist.

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART rear spoiler panel and on the tailgate. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the surfaces after they have been cleaned.

7.1 Install TECHART rear spoiler panel

- 1 Apply PU-adhesive to the bonding area of the TECHART roof spoiler 09Y.100.700.100 (36).

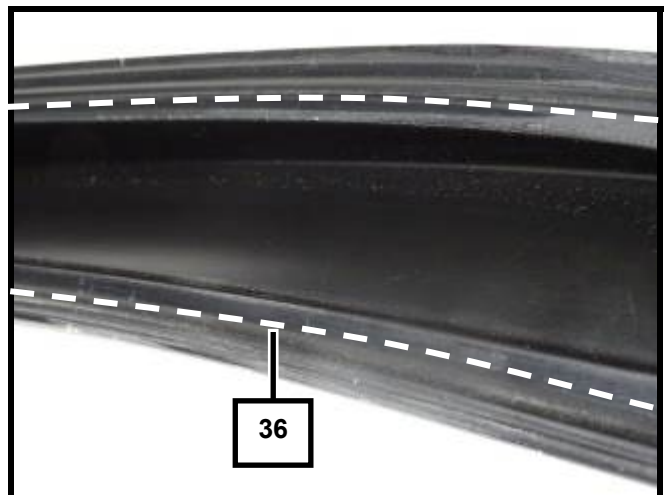


Fig. 56

- 2 Attach and align TECHART rear spoiler panel (36)

i Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

Allow to dry for at least 12 hours.



Fig. 57

8 TECHART rear lettering

- i** Thoroughly degrease the bonding surface for the TECHART rear lettering on the taillight.

Do not touch the surface after it has been cleaned.

8.1 Install TECHART rear lettering

- 1 Remove both endings of the transfer film (red foil on the adhesive tape) of one side for about 1 cm and bend to the outside. Optionally left and right at the same time.
- 2 Position and hold the rear lettering under the guidance of another person. Ensure that the rear lettering is aligned horizontal to the taillight. The beam angle of the taillight of 5° downwards must be ensured.
- 3 While one person is pressing the rear letting another one has to remove the transfer film below the carrier, lengthwise.
- 4 Ensure that the rear lettering won't slip during this process.
- 5 Afterward remove the protecting foil from the single letters.

- i** Press on firmly on the bonding areas. Check for an accurate fit

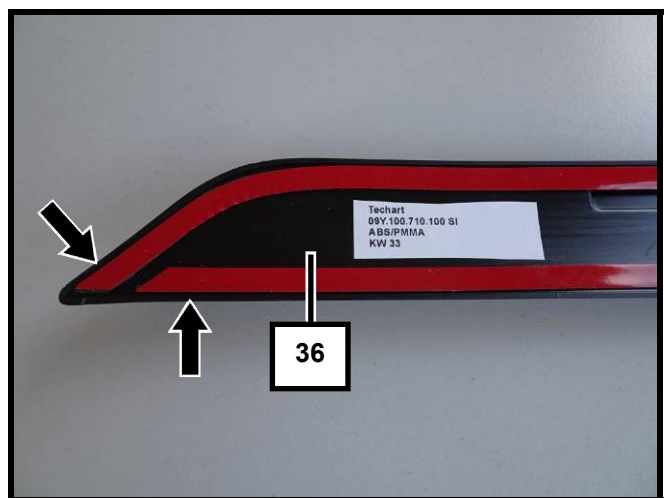


Fig. 58

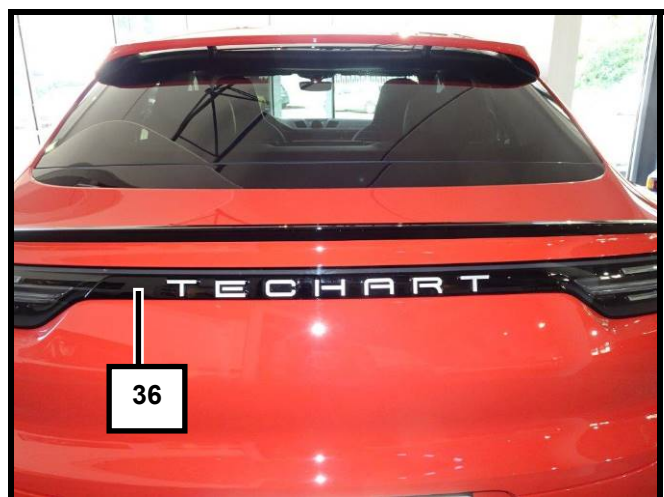


Fig. 59

9 TECHART aero-engine hood

- i** The bonding surfaces on the TECHART aero engine hood and the TECHART shafts must be dry and free from dust and paint spray mist.

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART aero engine hood and the TECHART shafts. Then sand it down using 100-180 grade abrasive paper and finally use cleaning agent to degrease it again.

Do not touch the surfaces after they have been cleaned.

9.1 Install TECHART aero hood

- 1 Apply PU-adhesive to the bonding area of the TECHART shaft 09Y.100.196.10_ (37).
- 2 Glue the TECHART shaft (37) in to the TECHART aero hood 09Y.121.196.100 (38).

- i** Press on firmly in areas coated with adhesive. Check for an accurate fit – remove any escaping PU adhesive with cleaning agent and secure with adhesive tape.

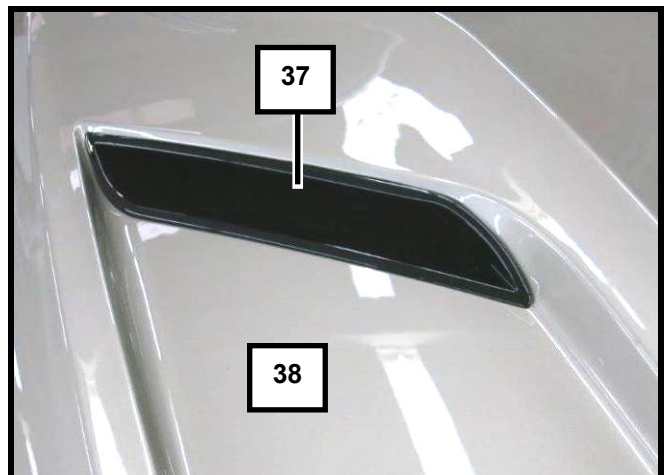


Fig. 60

- i** Allow to dry for at least 12 hours.

- 3 Fasten the TECHART aero-engine hood (38) to the vehicle.
- 4 Install water hose to the TECHART aero-engine hood (38).
- 5 Connect the spraying nozzles with the water hose and install.

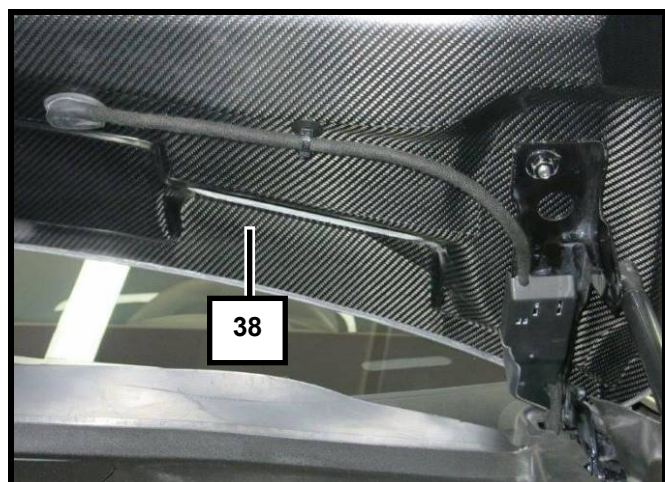


Fig. 61

- 6 Install the arrester hook (39) to the TECHART aero-engine hood (38).

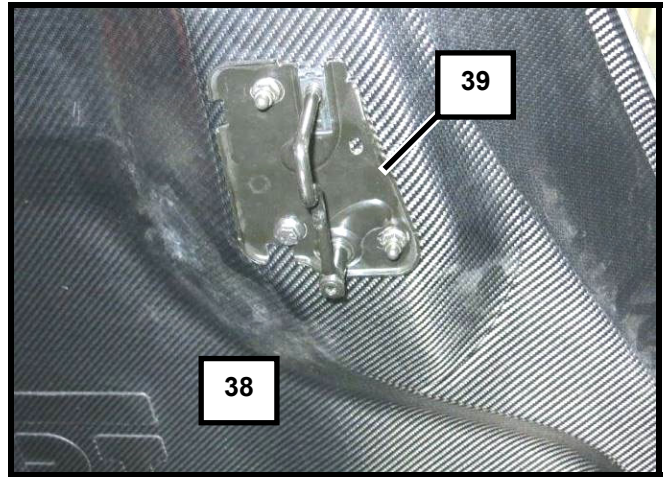


Fig. 62

10 Final assembly**10.1 Original inner wheel arch**

- 1 Install the taillights.
- 2 Feed, tighten and clip in the wheel extensions at the front.
- 3 Feed, tighten and clip in the wheel extensions at the rear.
- 4 Install the wheel house inner lining.


10.2 Perform final work on vehicle**Finishing touches**

- 1 Fit wheels.

 **Observe the specified tightening torques!**

Switch on the level control**Final check**

- 2 Perform a general function check on vehicle.

 **Read out all of the fault memories of the individual vehicle components using the PIWIS Porsche system tester, erase any fault messages displayed and/or rectify faults.**

11 Self-help**11.1 Dismantle the TECHART front apron**

Unclip the TECHART front apron on the side at the turn signal, push the tab upwards, then pull off the front apron only forwards.

Do not pull the TECHART front apron to the side or tear it, otherwise the TECHART front apron may tear.



Fig. 63

TECHART

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