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Technical Service Handbook

VIN: **WVWZZZ3CZ6E148876**
 Sales code: **3C5142**
 Engine code: **BKP**
 Official licence plate number:
 Username: **erwin**

Model year: **2006**
 Model description: **Passat Wag. Comfo 103 TDI6-s**
 Gearbox code: **HDV**
 Final drive code:
 Service advisor name:

Basic filtering of vehicle description

Brand	Model year	Sales model	Engine code	Gearbox code	Final drive code
V	2006	3C% - Passat	%	%	%

VIN ranges	Production date
WVWZZZ3CZ6E000001 - 999999	-

Technical product information

Transaction No.: **2021832/11**

Body/equipment: corrosion inside doors on fold

Release date: 10-Apr-2013

Customer statement / workshop findings

Customer statement:

- Corrosion/paint penetration on the inner door (illustration 1, red arrows).

Workshop findings:

- Corrosion in the door folds (illustration 1, red arrows).

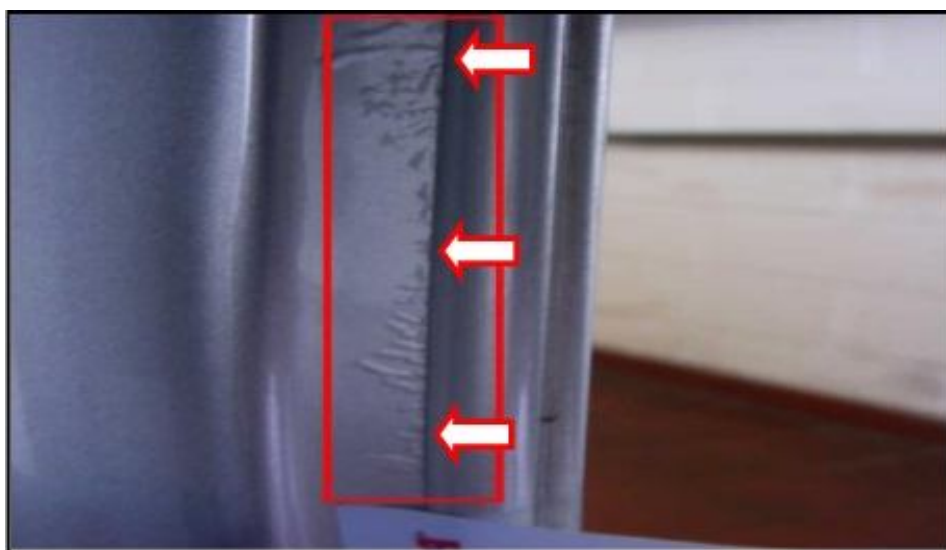


Illustration 1 (fold of front right door)

Technical background

Fluctuations in the production process of the fold bonding.

Production change

Improved fold bonding.

- From Chassis No.: WVW ZZZ 3C Z A E 020131
- From Chassis No.: WVW ZZZ 3C Z A P 020551

Measure

1. Repair the door fold

or

2. Replace the front/rear door



After removing the corrosion and cleaning the affected area, apply the 2-K-Epoxid filler (part number: LLS Max 220) as anti-corrosion treatment. Reapply the seam sealing. Paint inner door and wax door fold.

With corrosion in the fold area of the door hinges remove the door/hinge according to the repair manual.

1. Repair the door fold

Paint only the inner door panel.

If the door fold is only lightly corroded (no through-corrosion), proceed as follows:

- Protect the outer door area against damage - stick adhesive tape on the edge of the outer panel to avoid further paint damage.
- Remove corrosion and fine seam sealing in the damaged area - we recommend the use of a pneumatic brush grinder **VAS 6446**.
- Apply the anti-corrosion treatment LLS MAX 220 according to the pre-treatment described in the paint repair manual - a further layer is not necessary.
- Fine seam sealing according to the paint repair manual - chapter: Brand-specific information/restore seam sealing.

Note: Check the upper fold area to the channel strip. If the corner area of the metal sheathing is open (illustration 3, red circle), close it according to the above instructions with fine seam sealing.



Illustration 2

- Restore the paint structure according to the paint repair manual.
- Apply cavity wax according to the paint repair manual - chapter: corrosion - anti-corrosion treatment - additions and welded parts.

Apply the cavity wax (part number: D 330 KD1 A2) specifically from the inside in the door fold from top to bottom till it drips off on the lower edge of the door (drain).

2. Replace the /rear door

Apply the cavity wax also on the new part as described above according to the paint repair manual.

- Replace the door according to the repair manual.

Warranty accounting instructions

Service number/damage code/manufacturer: 5751/0002/061 or 063
5851/0002/161 or 163



- The labour times are correct at the time of publication. The time units (TU) may differ slightly, if the repair catalogue has been updated. The information in the repair operations catalogue applies, except for the open time items (... 99).
- The necessary time for using the Offboard Diagnostic Information System Service/VAS PC tester is not included; it must be accounted separately with the print-out of the tester.

Accounting with APOS:

Repair fold of front door(s)

	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3B*				
Main operation	57 51 19 00	Remove and install front door (only with corrosion in fold area of door hinges!)	30 TU	—
Main operation	70 59 19 00	Remove and install front door trim	30 TU	—

Main operation	70 59 20 00	Remove and install 2 front door trims	50 TU	—
Associated operation	57 51 41 99	Repair 1 front door (remove corrosion)	30 TU 1)	—
Associated operation	57 51 51 99	Seal off 1 front door (seam sealing)	20 TU 1)	—
Associated operation	57 11 19 99	Remove and install 1 door handle	10 TU 1)	—
Associated operation	57 51 79 99	Paint 1 front door	90 TU 1)	3 ME

The repair operations include all the work of this TPI.

Repair fold of rear door(s)

Passat 3B*

Main operation	58 51 19 00	Remove and install rear door (only with corrosion in fold area of door hinges!)	30 TU	—
Main operation	70 73 19 00	Remove and install 1 rear door trim	30 TU	—
Main operation	70 73 20 00	Remove and install 2 rear door trims	50 TU	—
Associated operation	58 51 41 99	Repair 1 rear door (remove corrosion)	30 TU 1)	—
Associated operation	58 51 51 99	Seal off 1 rear door (seam sealing)	20 TU 1)	—
Associated operation	58 11 19 99	Remove and install 1 door handle	10 TU 1)	—
Associated operation	58 51 79 99	Paint 1 rear door	90 TU 1)	3 ME

The repair operations include all the work of this TPI.

1) Use the above times only for this TPI.

Repair fold of front door(s)

	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3C*				

Main operation	57 51 19 00	Remove and install front door (only with corrosion in fold area of door hinges!)	30 TU	—
Main operation	70 59 19 00	Remove and install door trim	30 TU	—
Main operation	70 59 20 00	Remove and install 2 door trims	50 TU	—
Associated operation	57 65 55 99	Replace 1 outer seal for front door	50 TU 1)	—
Associated operation	57 65 56 99	Replace 2 outer seals for front door	90 TU 1)	—
Associated operation	57 51 41 99	Repair 1 front door (remove corrosion)	30 TU 1)	—
Associated operation	57 51 51 99	Seal off 1 front door (seam sealing)	20 TU 1)	—
Associated operation	57 11 19 99	Remove and install 1 door handle	10 TU 1)	—
Associated operation	57 51 79 99	Paint 1 front door	90 TU 1)	3 ME
The repair operations include all the work of this TPI.				
Repair fold of rear door(s)				
Passat 3C*				
Main operation	58 51 19 00	Remove and install rear door (only with corrosion in fold area of door hinges!)	30 TU	—
Main operation	70 73 19 00	Remove and install 1 door trim	40 TU	—
Main operation	70 73 20 00	Remove and install 2 door trims	70 TU	—
Associated operation	58 64 19 99	Replace 1 outer seal for front door	50 TU 1)	—
Associated operation	58 64 20 99	Replace 2 outer seals for front door	90 TU 1)	—
Associated operation	58 51 41 99	Repair 1 rear door (remove corrosion)	30 TU 1)	—
Associated operation	58 51 51 99	Seal off 1 rear door (seam sealing)	20 TU 1)	—

Associated operation	58 11 19 99	Remove and install 1 door handle	10 TU 1)	—
Associated operation	58 51 79 99	Paint 1 rear door	90 TU 1)	3 ME
The repair operations include all the work of this TPI.				

1) Use the above times only for this TPI.

Wax door(s)

	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3B*, 3C*				
Main operation	51 01 75 00	Wax body	30 TU	—
Associated operation	51 01 75 50	Wax body	10 TU	—
The repair operations include all the work of this TPI.				
Paint preparation time for door repair				
Main operation	51 01 71 99	Prepare painting (paint 1x door)	50 TU	—
Main operation	51 01 71 99	Prepare painting (paint 2x doors)	110 TU	—
Main operation	51 01 71 33	Prepare painting (paint 3x doors)	190 TU	—
Main operation	51 01 71 33	Prepare painting (paint 4x doors)	190 TU	—
The repair operations include all the work of this TPI.				

Replace front door(s)

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	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3B*				
Main operation	57 51 19 00	1 Remove and install front door	30 TU	—
Associated operation	57 51 55 50	1 Replace front door	160 TU	—
Associated operation	51 01 71 53	Prepare painting	160 TU	—
Associated operation	57 51 61 50	Paint 1 new front door	130 TU	10 ME
The repair operations include all the work of this TPI.				
Replace rear door(s)				
Main operation	58 51 19 00	1 Remove and install rear door	30 TU	—
Associated operation	58 51 55 50	1 Replace rear door	160 TU	—
Associated operation	51 01 71 53	Prepare painting	160 TU	—
Associated operation	58 51 61 50	Paint 1 new rear door	110 TU	9 ME
The repair operations include all the work of this TPI.				

Replace front door(s)

	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3C*				
Main operation	57 51 19 00	1 Remove and install front door	30 TU	—
Associated operation	57 51 55 50	1 Replace front door	160 TU	—
Associated operation	51 01 71 53	Prepare painting	160 TU	—
Associated operation	57 51 61 50	Paint 1 new front door	110 TU	9 ME

The repair operations include all the work of this TPI.				
Replace rear door(s)				
Main operation	58 51 19 00	1 Remove and install rear door	30 TU	—
Associated operation	58 51 55 50	1 Replace rear door	160 TU	—
Associated operation	51 01 71 53	Prepare painting	160 TU	—
Associated operation	58 51 61 50	Paint 1 new rear door	90 TU	7 ME
The repair operations include all the work of this TPI.				

Wax door(s)

	Repair operation number	Designation	Time units (TU)	Material units (ME)
Passat 3C*, 3B*				
Main operation	51 01 75 00	Wax body	30 TU	—
Associated operation	51 01 75 50	Wax body	10 TU	—
The repair operations include all the work of this TPI.				

Accounting with APOS/2:



For the Passat 3B* an accounting in APOS/2 is not possible.

Passat 3C*

Model	Illustration	Position	Number	Designation	Activity	Time in TU	Material units (MU)
Repair fold of front door(s)							
3C*	831-10	10	837701	Left outer door seal	55	*	—

3C*	831-10	10	837702	Right outer door seal	55	*	—
3C*	831-10	1	831055	Remove and install front left door (only with corrosion in fold area of door hinges!)	19	*	—
3C*	831-10	1	831056	Remove and install front right door (only with corrosion in fold area of door hinges!)	19	*	—
3C*	831-10	1	831055	Repair left door	42	30 TU	—
3C*	831-10	1	831056	Repair right door	42	30 TU	—
3C*	831-10	1	831055	Seal off left door (seam sealing)	52	20 TU	—
3C*	831-10	1	831056	Seal off right door (seam sealing)	52	20 TU	—
3C*	837-00	27	837205	Remove and install front left door handle	19	*	—
3C*	837-00	27	837206	Remove and install front right door handle	19	*	—
3C*	LLA-00	8	LA0015	Paint left door	80	90 TU	3 MU
3C*	LLA-00	11	LA0016	Paint right door	80	90 TU	3 MU
3C*	H10-10	1	H10100	Wax body	75	*	—
The repair operations include all the work of this TPI.							
Repair fold of rear door(s)							
3C*	833-10	12	839701	Left outer door seal	55	*	—
3C*	833-10	12	839702	Right outer door seal	55	*	—
3C*	833-10	1	833055	Remove and install rear left door (only with corrosion in fold area of door hinges!)	19	*	—
3C*	833-10	1	833056	Remove and install right rear door	19	*	—

				(only with corrosion in fold area of door hinges!)			
3C*	833-10	1	833055	Repair left door	42	30 TU	—
3C*	833-10	1	833056	Repair right door	42	30 TU	—
3C*	831-10	1	833055	Seal off left door (seam sealing)	52	20 TU	—
3C*	831-10	1	833056	Seal off right door (seam sealing)	52	20 TU	—
3C*	839-00	25	837205	Remove and install rear left door handle	19	*	—
3C*	839-00	25	837206	Remove and install rear right door handle	19	*	—
3C*	LLA-00	10	LLA017	Paint left door	80	90 TU	3 MU
3C*	LLA-00	12	LLA018	Paint right door	80	90 TU	3 MU
3C*	H10-10	1	H10100	Wax body	75	*	—

The repair operations include all the work of this TPI.

Model	Illustration	Position	Number	Designation	Activity	Time units	Material units (MU)
Repair front or rear door(s)							
3C*	STA-06	1	AZ001	Prepare painting (1x door)	72	50	—
3C*	STA-06	1	AZ001	Prepare painting (2x doors)	72	110	—
3C*	STA-06	1	AZ001	Prepare painting (3x doors)	72	190	—
3C*	STA-06	1	AZ001	Prepare painting (4x doors)	72	190	—

The repair operations include all the work of this TPI.

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Model	Illustration	Position	Number	Designation	Activity	Time in TU	Material units (MU)
Replace door(s)							
3C*	831-10	1	831055	Replace left door	55	*	—
3C*	831-10	1	831056	Replace right door	55	*	—
3C*	LLA-00	8	LA0015	Paint left door	61	*	—
3C*	LLA-00	11	LA0016	Paint right door	61	*	—
3C*	H10-10	1	H10100	Wax body	75	*	—
The repair operations include all the work of this TPI.							
Replace rear door(s)							
3C*	833-10	1	833055	Replace left door	55	*	—
3C*	833-10	1	833056	Replace right door	55	*	—
3C*	LLA-00	10	LLA017	Paint left door	61	*	—
3C*	LLA-00	12	LLA018	Paint right door	61	*	—
3C*	H10-10	1	H10100	Wax body	75	*	—
The repair operations include all the work of this TPI.							

Parts information



The part numbers and indexes of this TPI are correct at the time of publication. If the parts catalogue has been updated, use the current part numbers and indexes.

Part number	Designation
LLS Max 220	2-K Epoxid filler
D 330 KD1 A2	Cavity wax