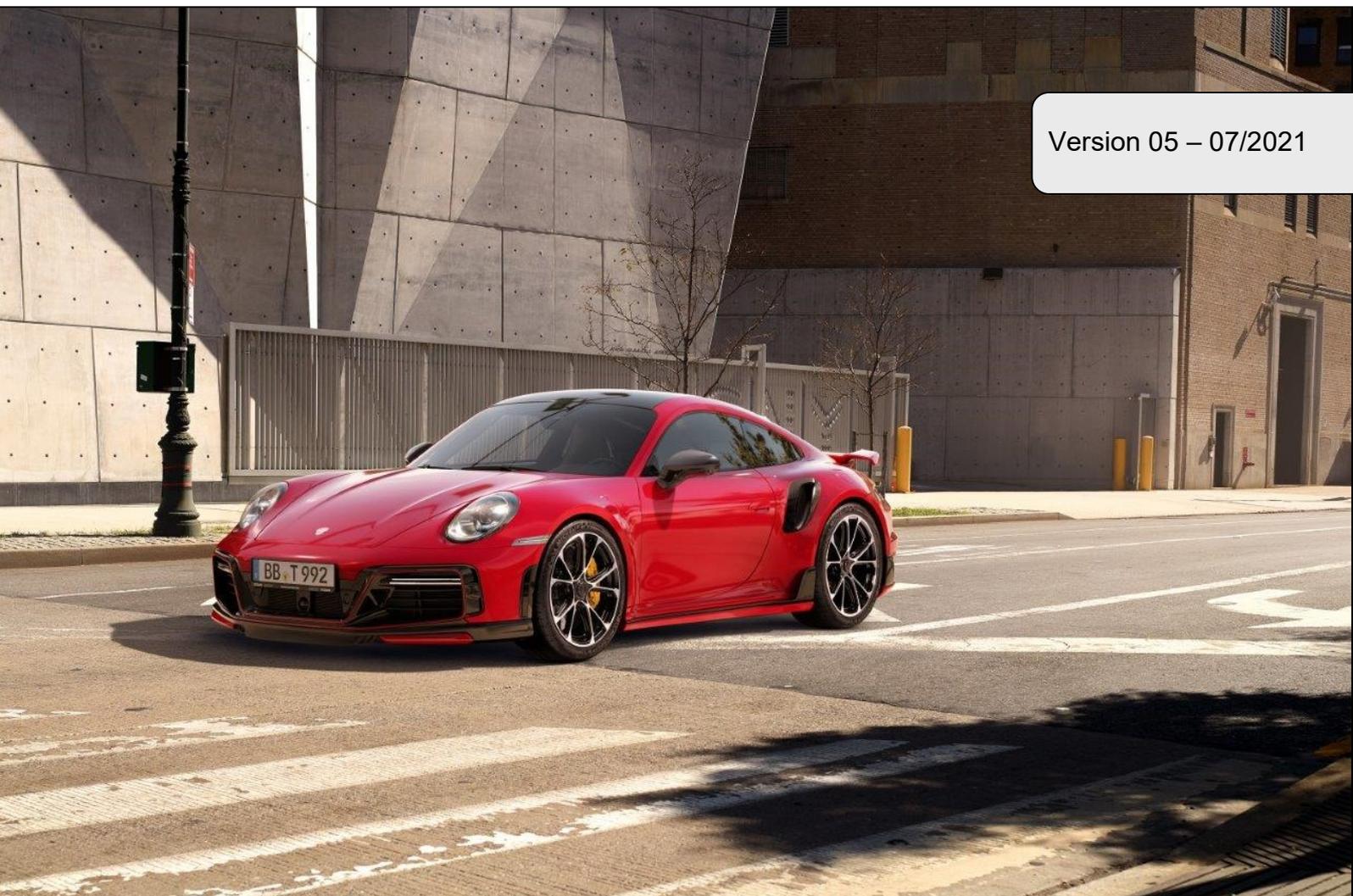


ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for 992 Turbo/Turbo S

Part-no. 092.100.181.009	Front apron
Part-no. 092.100.357.009	Side skirts
Part-no. 092.100.580.009	Rear diffuser
Part-no. 092.100.584.009	Air outlet for rear apron
Part-no. 092.100.600.009	Roof spoiler
Part-no. 092.100.880.009	Rear spoiler
Part-no. 092.121.480.009	Carbon air intake
Part-no. 092.121.600.009	Carbon roof spoiler
Part-no. 092.121.880.009	Carbon rear spoiler

Version 05 – 07/2021



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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> <div style="display: flex; justify-content: space-around; align-items: center;">    </div>	  

 	<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



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

Help and support

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

Check TECHART aero-kit parts kit for completeness

Quantity	Part number	Part name
1	092.100.181.009	Front Apron
Consisting of:		
1	092.100.181.100	Front apron, blank
2	058.100.150.101-01	Bracket parking sensor
1	092.100.181.110	Front spoiler, blank
1	092.100.181.115	Cover towing hook, blank
1	092.100.181.150SW	Main carrier, black matt
1	092.100.181.170	Insert, bottom front right
1	092.100.181.171	Insert, bottom front left
1	092.100.181.172	Insert, bottom front center
1	092.100.181.200	Canards right
1	092.100.181.201	Canards left
1	092.100.181.210	Air shaft right, blank
1	092.100.181.211	Air shaft left, blank
1	092.100.181.220	Panel at turn signal right
1	092.100.181.221	Panel at turn signal left
2	092.100.181.600	Panel without camera
1	092.100.181.990	Accessory kit front apron
2	092.100.181.206	Sheet metal, bracket parking sensor
4	092.100.181.401	Bracket front apron "1"
4	092.100.181.402	Bracket front apron "2"
2	092.100.181.403	Bracket front apron "3"
1	092.100.181.404	Bracket front apron "4"
1	092.100.181.405	Bracket front apron "5"
1	092.100.181.406	Bracket front apron "6"
2	092.100.181.407	Bracket front apron "7"
22	001900M05	Speed nut, M 5
22	50001900M5X16A27380	Fillister head screw with flange M 5x16 A2
12	0029004.8/16.7X11	Speed nut, 4.8/16.7x11.0, yellow galvanized
12	0039004816A2SW	Collar screw, Torx 4.8x16, A2, black
2	000.100.999.9961	Collar screw for plastic PT50 x 25 pointed
2	01090006X16X8	Washer, 6,3x16x8, plastic black
6	0039004.2X951025	Sheet metal screw fillister head with flange 4.2x9.5
6	0009002.9X9.5	Sheet metal screw fillister head, 2.9x9.5
1	000910949110	BETACLEAN 3300 8 ml
1	000910219252T	Betaprime 5404, 15ml
1	092.140.181.009	Set stone protection foil front spoiler, 2 parts
1	00091089010073	Bond + seal black 300 ml

Part set options

1	+92.100.181.100	V01: without air outlet grille
---	-----------------	--------------------------------

1	+92.100.181.101/103	V01: Air outlet grille paintable / custom color
Consisting of:		
1	092.100.182.100	Air outlet right
1	092.100.182.101	Air outlet left
1	092.140.182.009	Cutting template for air outlet grille R & L

1	+92.100.181.111/113	V02: Insert top, paintable / custom color
Consisting of:		
1	092.100.182.180	Insert top

1	+92.100.181.114	V02: Insert top in carbon "glossy"
Consisting of:		
1	092.121.182.180G	Insert top carbon glossy

1	+92.100.181.115	V02: Insert top in carbon "matt"
Consisting of:		
1	092.121.182.180M	Insert top carbon matt

ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for 992 Turbo

Quantity	Part number	Part name
1	092.100.357.009	Side skirts
Consisting of:		
1	092.100.357.100	Side skirt right, blank
1	092.100.357.101	Side skirt left, blank
1	092.100.357.110	Side skirt insert right, blank
1	092.100.357.111	Side skirt insert left, blank
20	0009014,8X1693614816	Rivet truss head 4.8x16 black
1	092.140.357.009	Set stone protection foil, side skirt 10 parts
1	00091089010073	Bond + seal black 300 ml

Quantity	Part number	Part name
1	092.100.580.009	Rear diffuser
Consisting of:		
1	092.100.580.100	Diffuser, blank
1	092.100.580.200	Air duct center rear, blank
1	092.100.580.500	Heat shield
1	092.100.580.990	Accessory kit rear diffuser
1	092.100.580.220	Bracket right rear diffuser
1	092.100.580.221	Bracket left rear diffuser
2	010900105X21X2	Washer, 10.5x21x2, plastic
14	0039004816A2SW	Collar screw Torx 4.8x16, A2, black
2	0029004.8/19.0X12.7	Speed nut 19mm x 4.8mm
2	0029004.8/19.7X16	Speed nut, 4.8/19.7x16.0, yellow galvanized
5	000.100.999.999	Collar screw for plastic PT 50 x 16 pointed
1	092.140.357.009	Set stone protection foil, side skirt 2 parts
1	00091089010073	Bond + seal black 300 ml

Part set options

1	+92.100.580.001	V01: for vehicles with "standard exhaust system"
Consisting of:		
1	092.100.580.111	Frame, standard

1	+92.100.580.003	V01: for vehicles with "sport exhaust system"
Consisting of:		
1	092.100.580.110	Frame, sport exhaust unit

1	+92.100.580.101 / 103	V02: Fins paintable / custom color
Consisting of:		
1	092.100.500.126	Diffusor fins right outside, blank
1	092.100.500.127	Diffusor fins left outside, blank
1	092.100.500.128	Diffusor fins right inside, blank
2	092.100.500.129	Diffusor fins left inside, blank

1	+92.100.580.111 / 113	V03: Insert paintable / custom color
Consisting of:		
1	092.100.580.180	Insert

1	+92.100.580.114	V03: Insert in carbon "glossy"
Consisting of:		
1	092.121.580.180G	Insert top carbon glossy

1	+92.100.580.115	V03: Insert in carbon "matt"
Consisting of:		
1	092.121.580.180M	Insert top carbon matt

ASSEMBLY INSTRUCTIONS**TECHART Aero-Kit for 992 Turbo**

Quantity	Part number	Part name
1	092.100.584.009	Air outlet for rear apron
Consisting of:		
1	092.100.584.100	Air outlet with fin right, blank
1	092.100.584.101	Air outlet with fin left, blank
1	092.140.584.009	Set stone protection foil air outlet rear apron 2 parts
1	00091089010031	Bond + seal black 70 ml
1	000910219252T	Betaprime 5404, 15ml
1	000910949110	BETACLEAN 3300 8 ml

Quantity	Part number	Part name
1	092.1__600.009_	Roof spoiler
Consisting of:		
1	092.1__60.100_	Roof spoiler
1.1	000961894910-95	Trim adhesive tape 6 mm x 0.95
1	00091089010031	Bond + seal black, tube 70ml

Quantity	Part number	Part name
1	092.100.880.009	Rear spoiler
Consisting of:		
1	092.100.800.100	Rear spoiler
2	001900M06X12912	Hexagon socket head screw, (A2K), M 6x12, galvanized

Quantity	Part number	Part name
1	092.121.880.009_	Carbon rear spoiler glossy / matt
Consisting of:		
1	092.121.800.100	Rear spoiler
2	001900M06X12912	Hexagon socket head screw (A2K), M 6x12, galvanized
2	092100885210	Bracket profile top
2	0009014X127337	Rivet truss head 4.0x12 aluminum

Quantity	Part number	Part name
1	092.121.480.009	Carbon air intake glossy / matt
Consisting of:		
1	092.121.480.100	Carbon air intake right
1	092.121.480.101	Carbon air intake left
1	000910219252T	Betaprime 5404, 15ml
1	000910949110	BETACLEAN 3300 8 ml
1	00091089010073	Bond + seal black, tube 300ml



Note the painting directions, bullet point 2.

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 Prepare vehicle

 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.

1.1 Remove wheels

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

2 Information for painting TECHART parts

2.1 Information for the front apron

- 1 Use adhesive tape only on the top area at the front apron. For that mask the lower part.

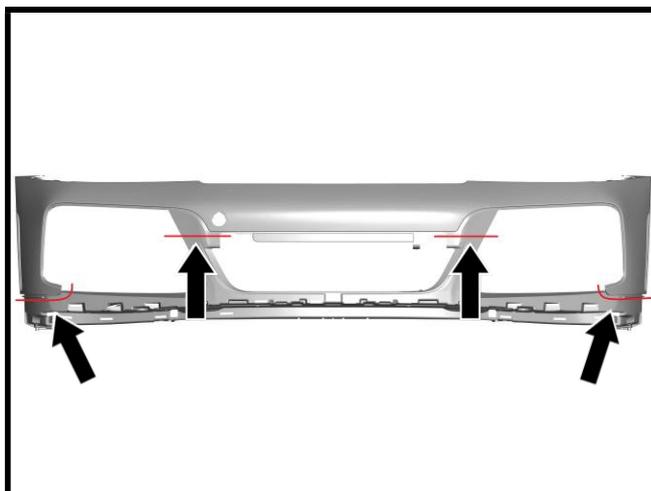


Fig. 01

For V01 with air outlet:

Prior to painting modify the TECHART front apron.

- 2 Stick the TECHART cutting template 092.140.182.009 (4) to the TECHART front apron 092.100.181.100, The bottom edge must be flush with the visible edge.
- 3 Modify the front apron: Cut out the hole of the TECHART cutting template (4).

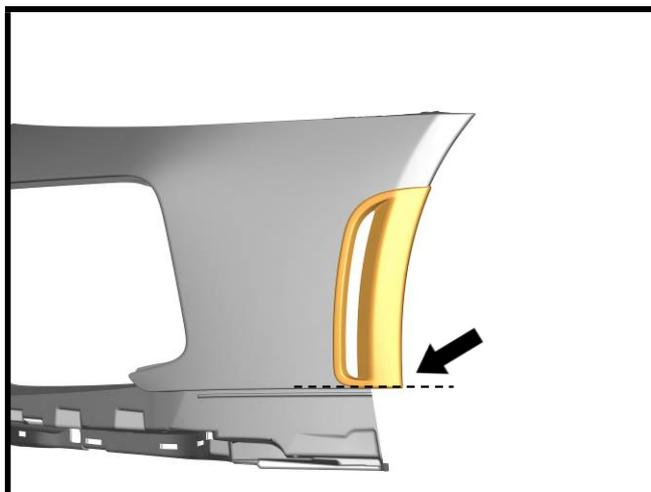


Fig. 02

The following parts of the TECHART front apron don't have to be painted.

A = TECHART air shaft

B = TECHART main carrier

C = TECHART insert bottom, R + L + center

D = TECHART panel at turn signal R + L

E = TECHART canards R + L

These parts are delivered in black.

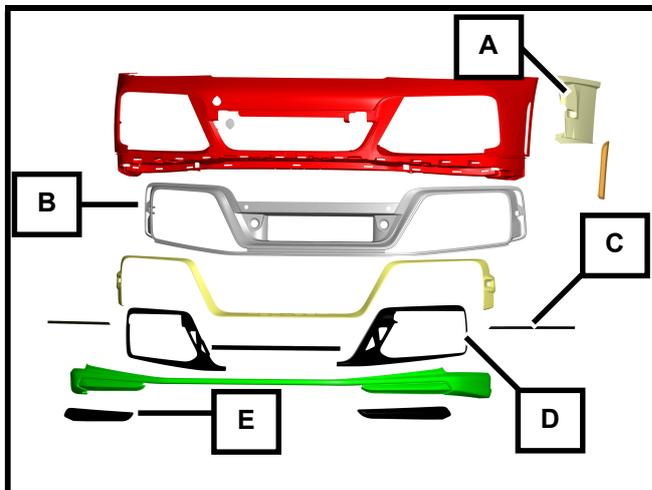


Fig. 02a

The following parts of the TECHART front apron have to be painted in car color or contrasting color.

F = TECHART front apron

G = TECHART insert top, (except carbon)

H = TECHART front spoiler

I = TECHART air outlet (Option V01)

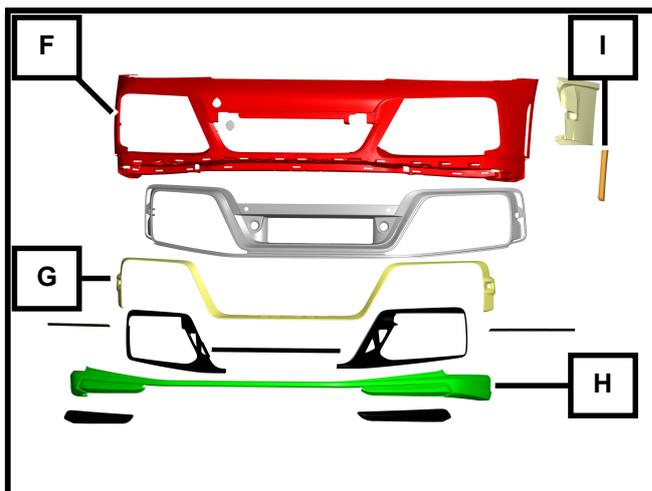


Fig. 02b

The following parts of the TECHART side skirt and the TECHART rear diffusor have to be painted in car color or contrasting color.

J = TECHART side skirt

K = TECHART insert side skirt

L = TECHART diffusor

M = TECHART frame

N = TECHART insert

O = TECHART air duct will not be painted.

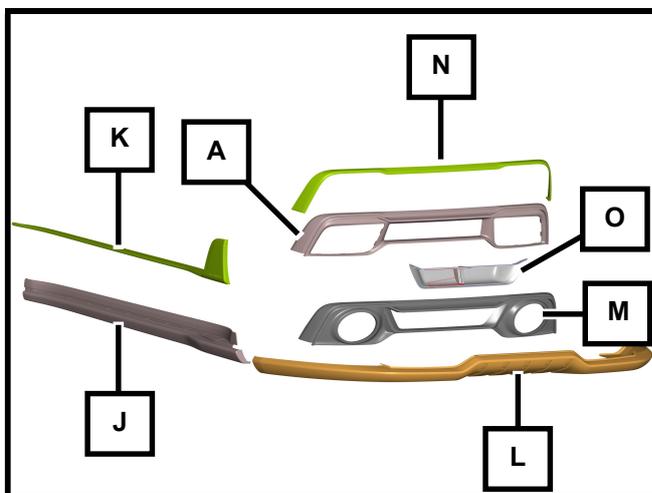


Fig. 02c

3 TECHART front apron**3.1 Detach original front panel**

- 1 Open front flap.
- 2 Dismantle PU-cover of the battery.
- 3 Unclip side PU-cover.
- 4 Detach PU-cover around hood lock.

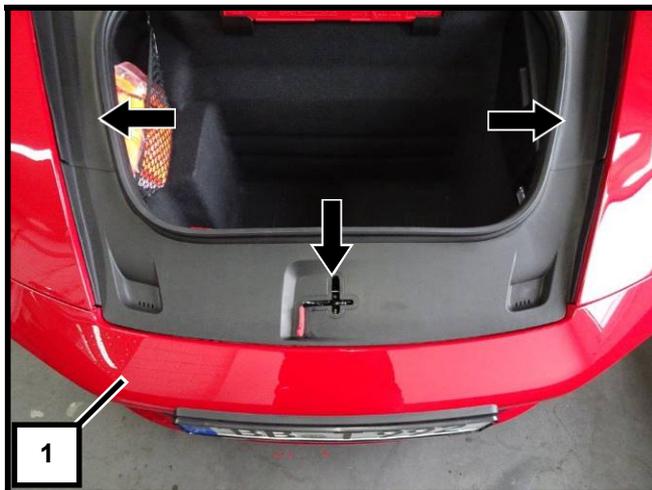


Fig. 03

- 5 Unscrew the top fixing screws (2) from the front apron (1)
- 6 Remove the retaining clips (see arrows) between the headlights and front flap towards the flap.
- 7 Unscrew all screws of the inner wheel house panel.
- 8 Dismantle the inner wheel house panel incl. brake air duct.

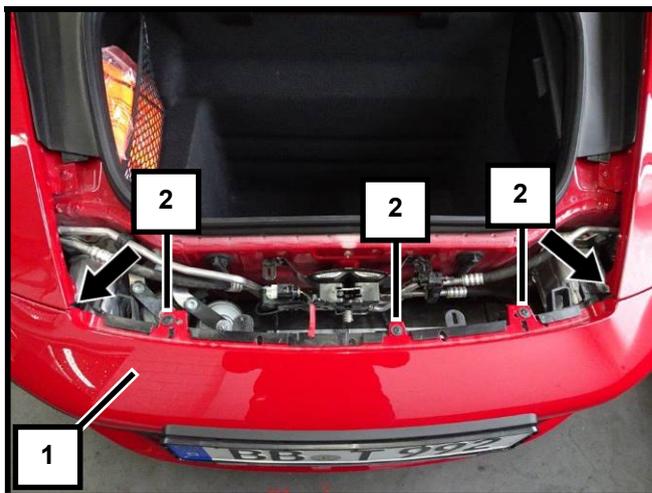


Fig. 04

- 9 Unscrew the fixing screws (3) at the vehicle's bottom side and the brake air duct.
- 10 Detach lower airduct.

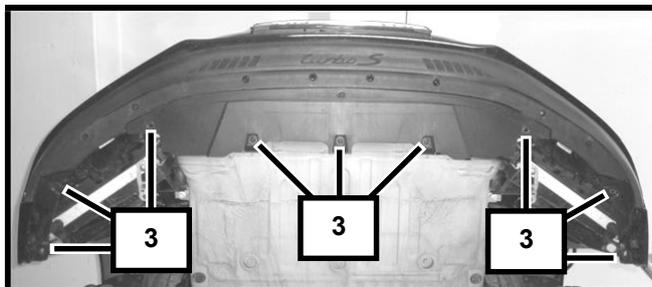


Fig. 05

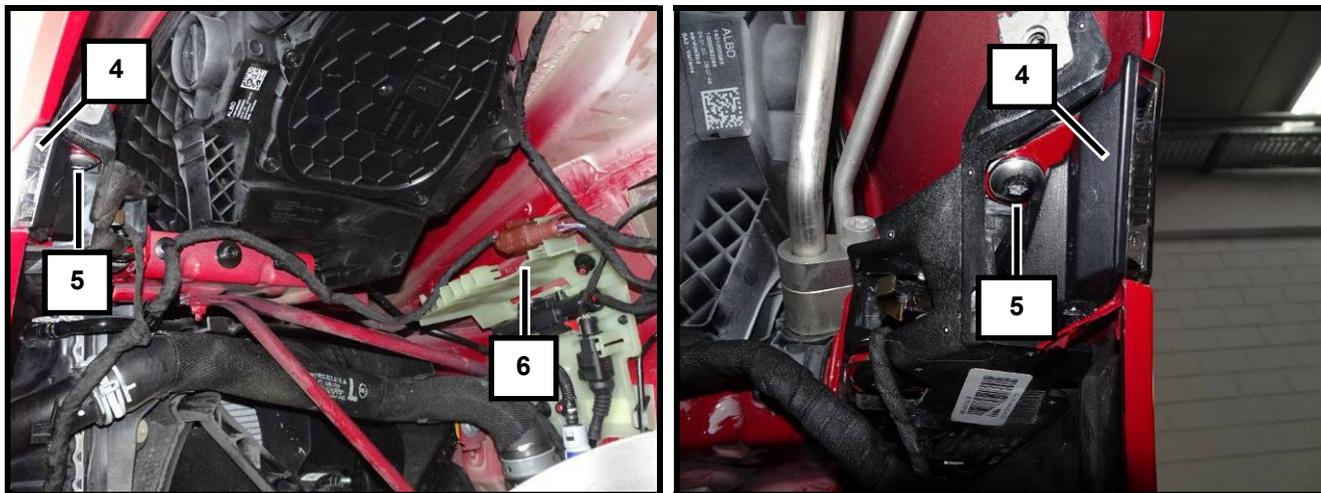


Fig. 06

- 11 Remove side-mounted turn signal (4).
- 12 Unscrew mounting bolts (1 each side) (5) from the side of the wheel arch.
- 13 Disconnect electrical connection (6) on right and left of wheel arch at the headlight console.
- 14 Remove vacuum hoses.
- 15 Unhinge the original front apron on the side and remove towards the front.
- 16 Dismantle the wiring harness, combination lamp, sensors and antenna from the front apron. Unscrew the spoiler and unclip. Unscrew the active front spoiler incl. vacuum lines and unclip.



Fig. 07

- 17 Dismantle the wiring harness right and left incl. sensors, antennas and cameras.
- 18 Dismantle the combination lamp and louver unit.
- 19 Unclip the original front spoiler from the front apron.
- 20 Unscrew the original active front spoiler.

i Original front apron and front spoiler are no longer required.

3.2 Assemble TECHART front apron

- 1 Attach the speed nuts M5 to one side and speed nuts 4.8x11x16 to the other side of the brackets "1", "4" and "5".

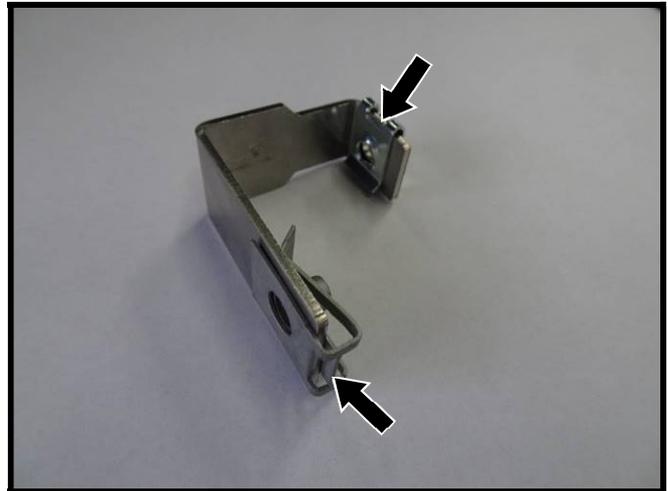


Fig. 08

- 2 Attach speed nuts M5 on both sides of the brackets "2", "3", "6" and "7".

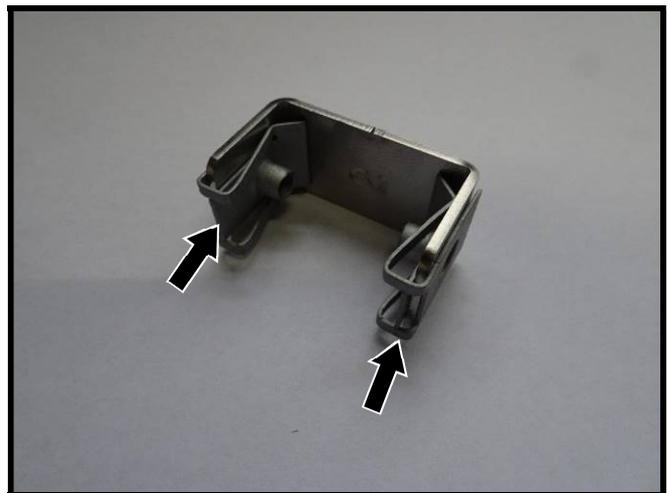


Fig. 09

Right side:

- 3 Tighten the TECHART blank holder "1" (11), "2" (12) and "3" (13) with the screws M5x16 to the TECHART front apron (10).
- 4 Tighten the TECHART blank holder "4" (14) with the screws 4.8x16 to the TECHART front apron (10).

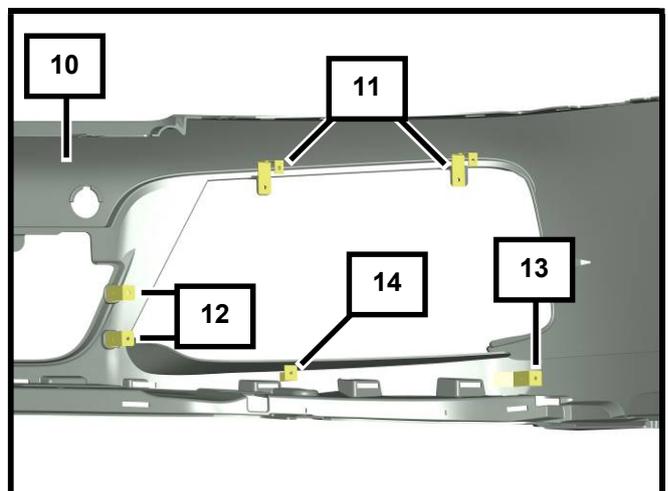


Fig. 10

Left side:

- 5 Tighten the TECHART blank holder "1" (11), "2" (12) and "3" (13) with the screws M5x16 to the TECHART front apron (10).
- 6 Tighten the TECHART blank holder "5" (15) with the screws 4.8x16 to the TECHART front apron (10).

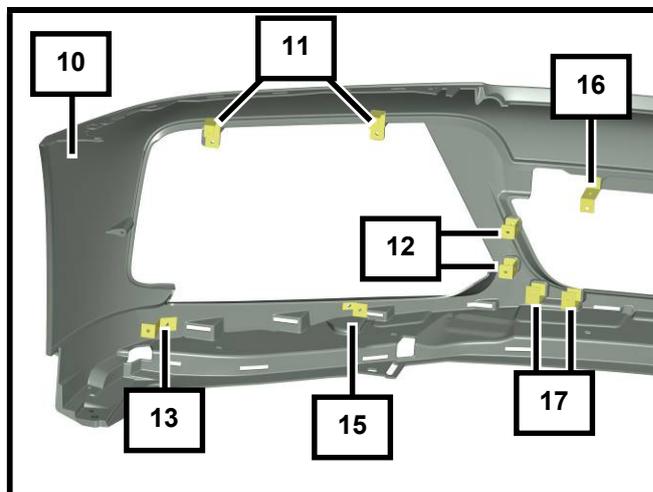


Fig. 11

- 7 Tighten the TECHART blank holder "6" (16) and "7" (17) with the screws M5x16 to the TECHART front apron (10).
- 8 Slide the original active front spoiler to the TECHART front apron (10) and tighten with the original screws from the inside.

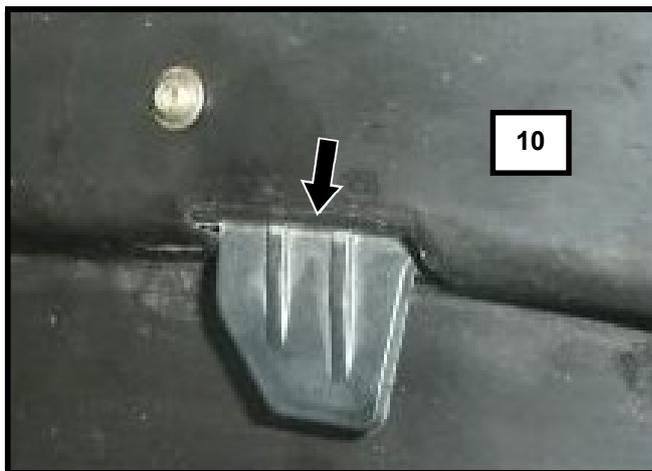


Fig. 12

- 9 Tighten the original active front spoiler at the side with the original screw and the speed nut 4.8x11x16.



Fig. 13

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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.

- i** Clean the bonding surface of the black high-gloss parts (insert bottom and canard) with Betaclean and prime with Betaprime.

- 10 Apply a thin layer of PU adhesive to the bonding area at the TECHART air shaft 092.100.181.22_ (18).

- 11 Glue the TECHART air shaft (18) to the TECHART front apron.

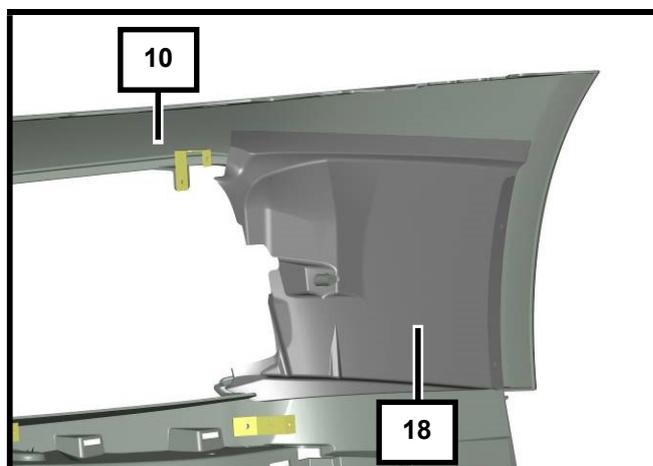


Fig. 14

- 12 Apply a thin layer of PU adhesive to the bonding area at the TECHART main carrier 092.100.181.110 (19).

- 13 Glue the TECHART main carrier (19) to the TECHART front apron.

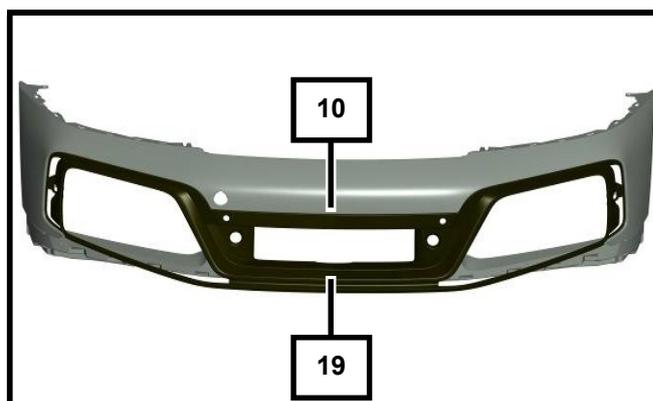


Fig. 15

- 14 Additionally, glue the TECHART main carrier (19) from the inside to the TECHART front apron.

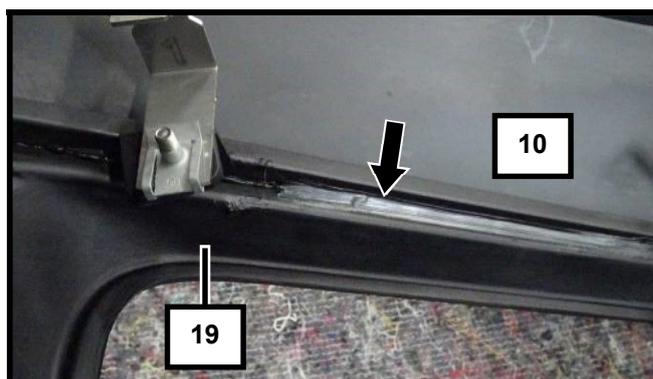


Fig. 16

- 15 Clean the bonding area of the TECHART insert bottom 092.100.181.170/171/172 (20,21 and 22) with Betaclean and prime with Betaprime.
- 16 Apply a thin layer of PU adhesive to the bonding area at the TECHART insert bottom right and left (20, 21).
- 17 Glue the TECHART insert bottom right and left (20, 21) to the TECHART main carrier (19).

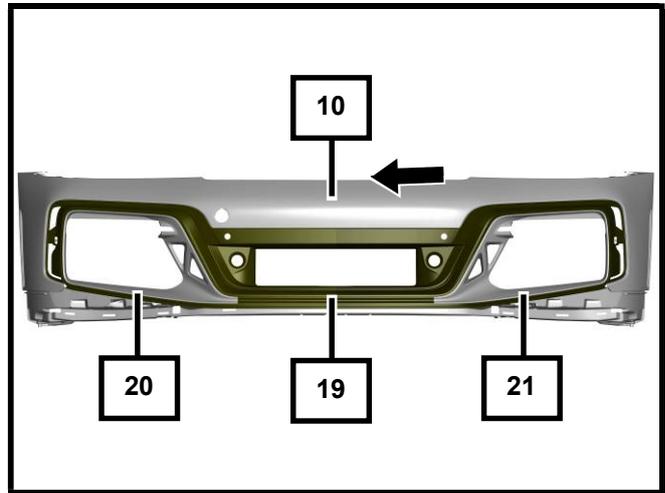


Fig. 17

- 18 Additionally, glue the TECHART insert bottom right and left (20) from the inside to the TECHART main carrier (19).

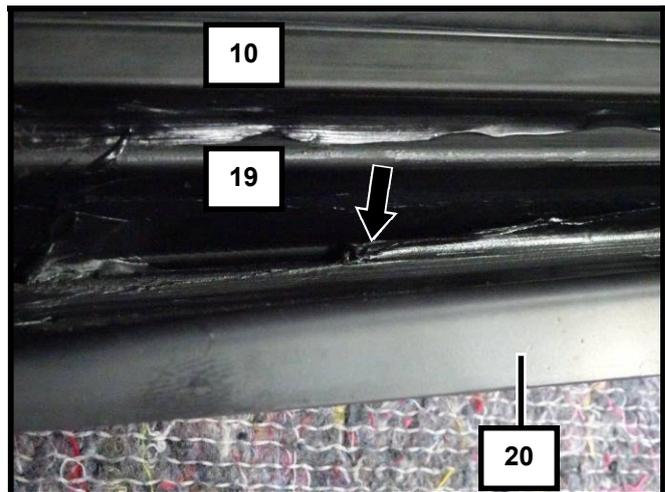


Fig. 18

- 19 Apply a thin layer of PU adhesive to the bonding area at the TECHART insert bottom center (22).
- 20 Glue the TECHART insert bottom center (22) to the TECHART front apron.

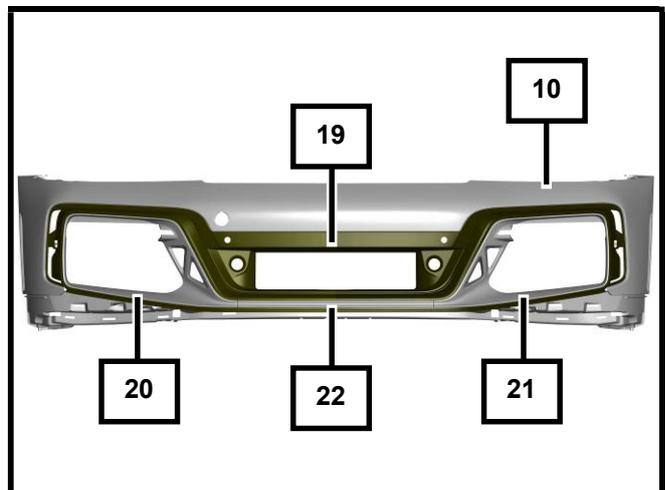


Fig. 19

- 23 Apply a thin layer of PU adhesive to the bonding area at the TECHART insert top 092.100.181.180 (23).
- 24 Glue the TECHART insert top (23) to the TECHART main carrier (19).

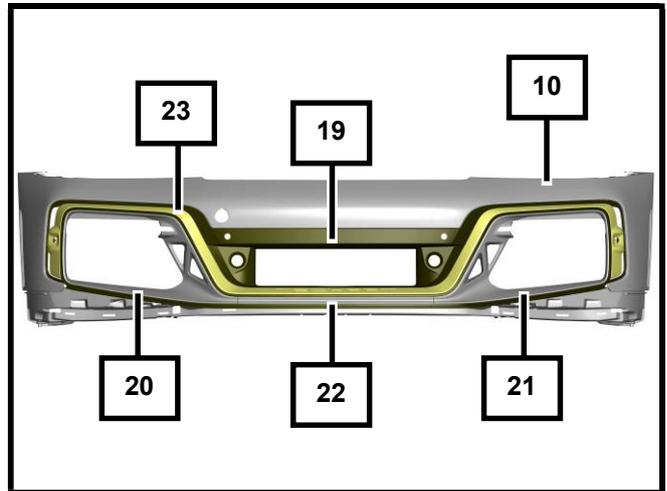


Fig. 20

- i** Check for an accurate fit and clearance when aligning.
Immediately remove any PU adhesive that escapes using a cleaning agent.
Allow to dry for at least 12 hours.

- 25 Insert the original parking sensor to the TECHART bracket parking sensor 000.100.120.100-01 (24).
- 26 Stick the TECHART bracket parking sensor (24) with the double-sided adhesive tape in to the TECHART main carrier (19).

- i** Care for an accurate fit.

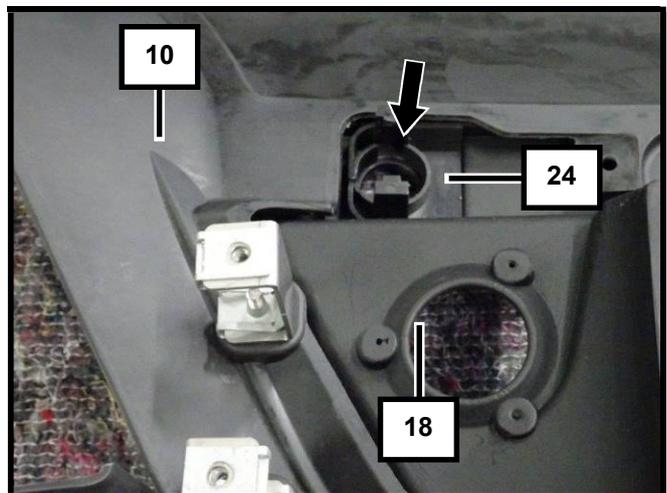


Abb. 21

- 27 Insert the original parking sensor to the TECHART main carrier (19) and tighten with the TECHART blank holder parking sensor 092.100.181.206 (25) and with the screws 2.9x9.5; fix it with PU adhesive, if necessary.

- i** Care for an accurate fit.

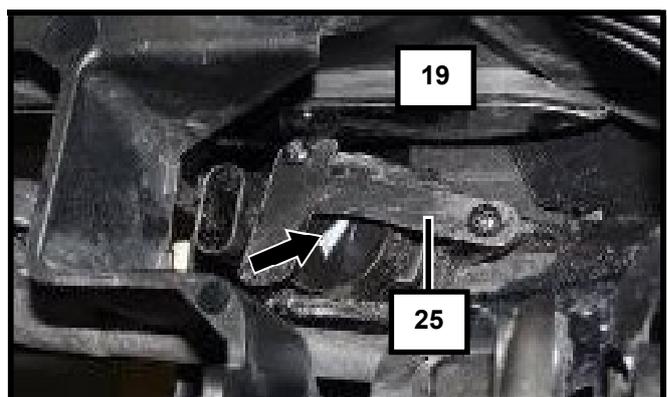


Fig. 22

- 28 Glue the TECHART panel Insert right and left 092.100.181.174/5 (26) to the side of the air intake bottom at the TECHART insert right and left (20, 21).

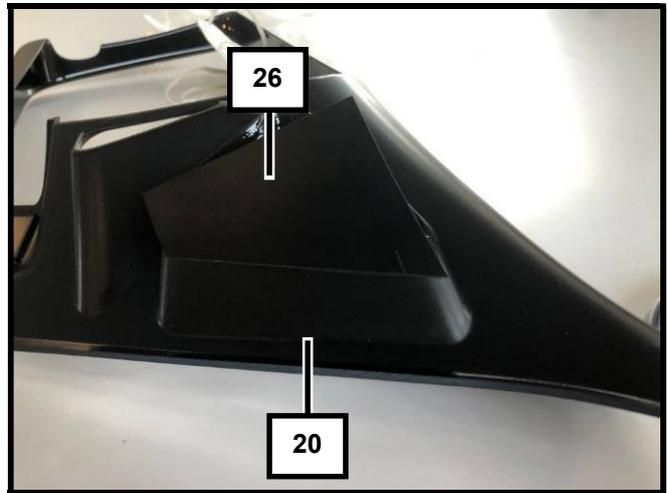


Fig. 23

- 29 Screw the original night vision camera to the TECHART bracket "6" (16) und "7" (17), which are fastened to the TECHART front apron, (10) with the screws M5x16.

- 30 Tighten the TECHART panel without camera 092.100.181.600 (27) with the screws 4.2x9.5 to the TECHART main carrier (19).

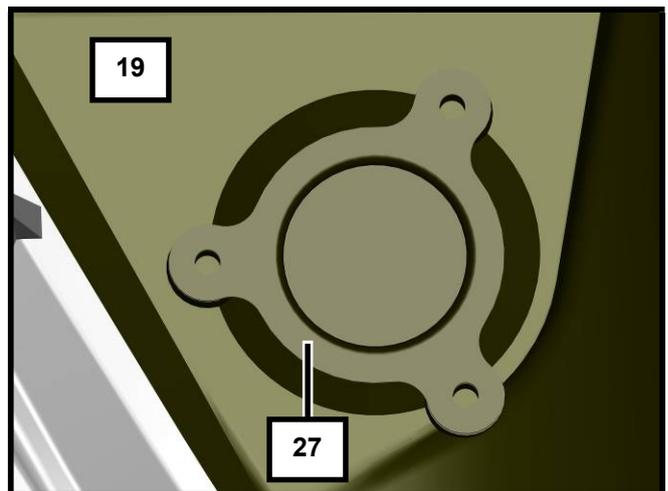


Fig. 24

- 31 Tighten the original combination lamp (28) on the top with the screws 4.8x16 to the TECHART bracket "1" (11).

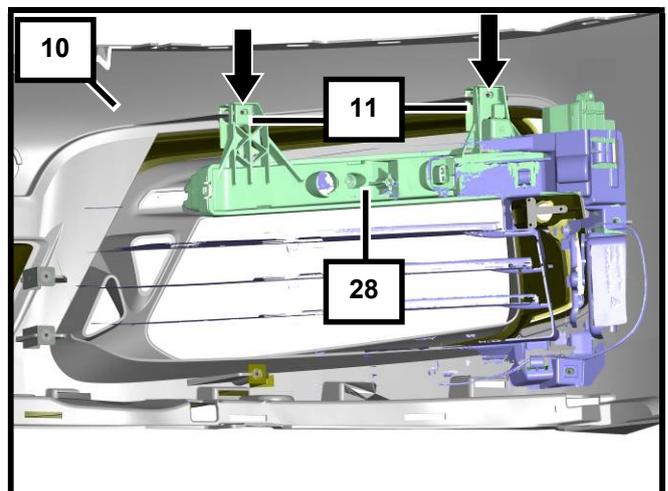


Fig. 25

- 32 Tighten the original louver unit (29) with the screws M5x16 to the TECHART bracket "2" (12), "3" (13) and "4" (14).
- 33 Tighten the original louver unit (29) through the original combination lamp (28) from the outside with the original screw to the TECHART front apron (10).

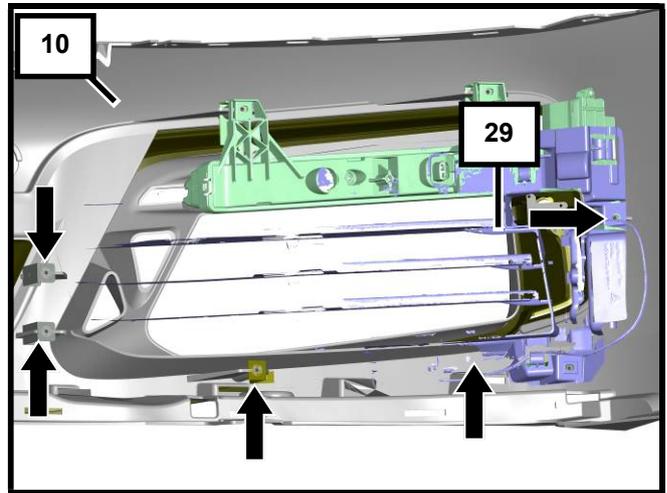


Fig. 26

- 34 Snap the TECHART cover towing hook 092.100.181.115 into the TECHART front apron.
- 35 On vehicles with front camera there is a crack for a recess on the inside of the TECHART main carrier (19). Modify the TECHART main carrier (19). Install the front camera with the original panels to the TECHART main carrier (19).
- 36 Fasten both original wiring harnesses to the TECHART front apron and connect with all sensors.
- 37 Connect the original antennas with the wiring harness and glue with PU-adhesive to the front apron.
- 38 Attach the entire TECHART front apron to the vehicle and tighten with the original screws to the original fixing points.
- 39 Glue the TECHART panel at the turn signal right and left 092.100.181.220/1 (30) with PU-adhesive to the combination lamp (28) and TECHART insert right and left (20, 21).

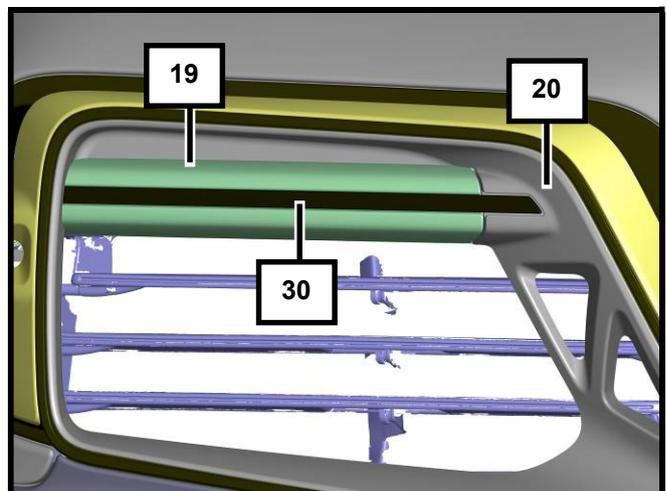


Fig. 27

- 39 Apply PU-adhesive to the bonding area of the TECHART front spoiler 092.100.181.110 (31).
- 40 Glue the TECHART front spoiler (30) to the TECHART front apron (10) and the TECHART main carrier (19).
- 41 Tighten the TECHART front spoiler bottom with the washer 16x8 and the screws 5x25 to the TECHART front apron.

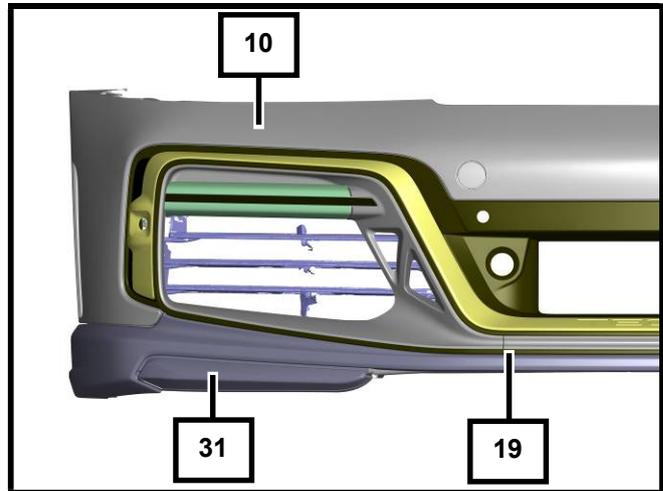


Fig. 28

- 42 Clean the bonding area of the TECHART Canards right and left 092.100.181.200/1 (32) with Betaclean and prime with Betaprime.
- 43 Apply PU-adhesive to the bonding area of the TECHART Canards right and left (32).
- 44 Glue the TECHART Canards right and left (32) to the TECHART front apron.

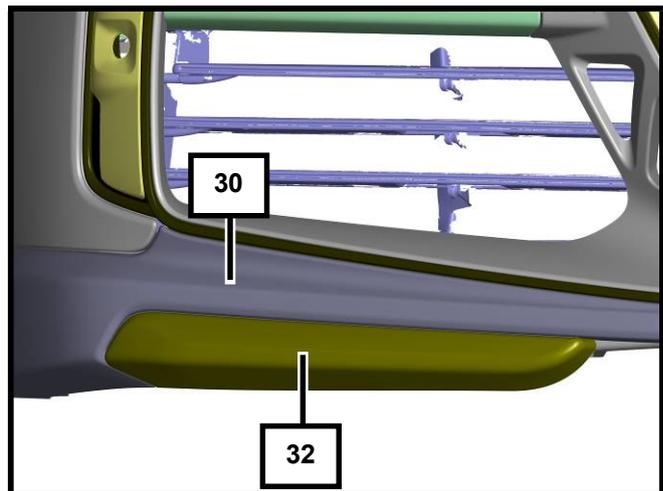


Fig. 29

For V01 with air outlet:

- 45 Apply PU-adhesive to the bonding area of the TECHART air outlet (33).
- 46 Glue the TECHART air outlet (33) to the TECHART front apron.

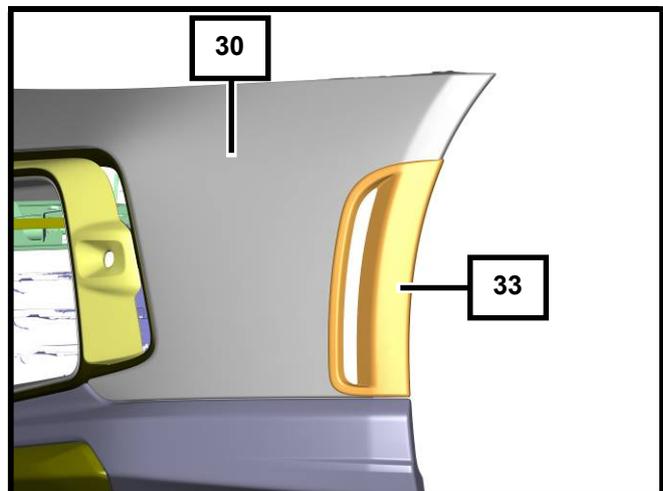


Fig. 30



Check for an accurate fit and clearance when aligning.

Immediately remove any PU adhesive that escapes using a cleaning agent.

Allow to dry for at least 12 hours.

- 47 Connect the electrical plug connection (6) at the wheel house.
- 48 Connect the side turn signal (4) electrically and install.
- 49 Install the air duct on the bottom.
- 50 Install the wheel house inner lining.
- 51 Install the PU-cover front.
- 52 Stick the stone protection foil 092.140.181.009 to the TECHART front spoiler (30).

4 TECHART side skirts

4.1 Install TECHART side skirts

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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 Apply an even layer of PU-adhesive to the bonding area of the TECHART side skirts 092.100.357.100/1 (40).
- 2 Slide the TECHART side skirt (40) over the serial side skirt and glue it to the vehicle.

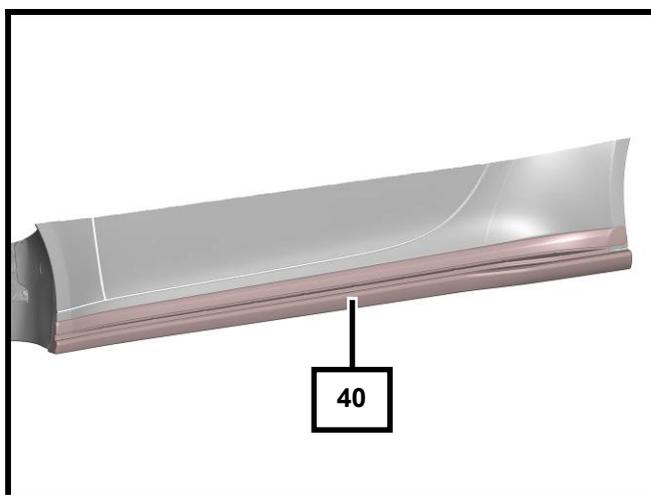


Fig. 31

- 3 Apply an even layer of PU-adhesive to the bonding area of the TECHART insert side skirt 092.100.357.110/1 (41).
- 4 Glue the TECHART insert side skirt (41) to the TECHART side skirt (40).

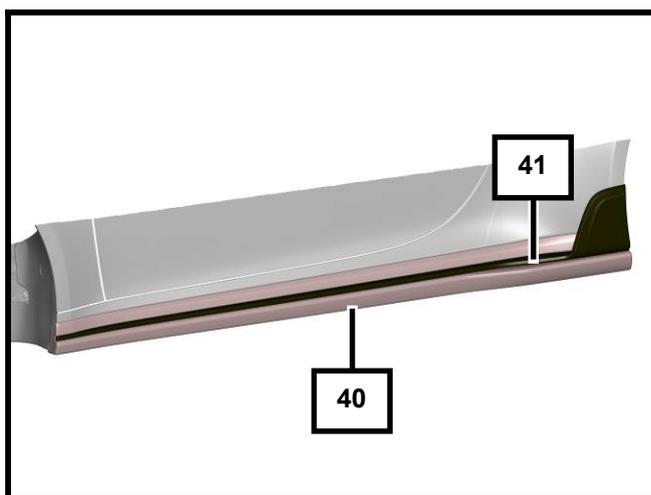


Fig. 32

- i** Check for an accurate fit and clearance when aligning.
Immediately remove any PU adhesive that escapes using a cleaning agent.
Allow to dry for at least 12 hours.

- 5 Drill holes of $d=5\text{mm}$ on the bottom for the fixation of the TECHART side skirts (40).
- 6 Clinch the TECHART side skirt (40) with the rivets 4.8×16 to the original side skirt.
- 7 Stick the TECHART stone protection foil to the wheel arch area.

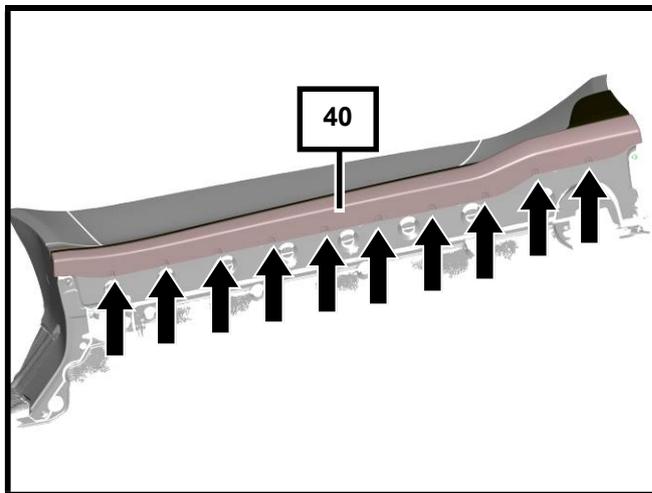


Fig. 33

5 TECHART Rear diffusor**5.1 Detach original rear apron**

- 1 Turn ignition on.
- 2 Extend the rear spoiler.
- 3 Turn ignition off.

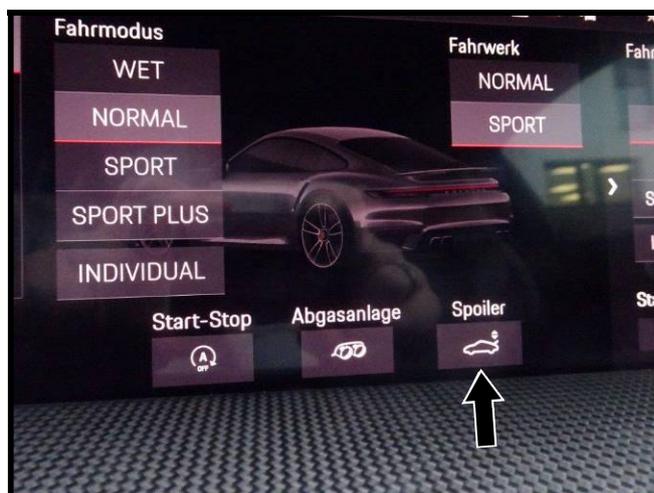


Fig. 34

- 4 Remove the screws below the rear spoilers.



Fig. 35

- 5 Remove the screws for the spoiler base frame.
- 6 Carefully remove the base frame over the spoiler supports.
- 7 Disconnect the center mounted brake lamp.



Fig. 36

- 8 Unscrew the strip lighting fixture, pull it out and separate both electrical connections.

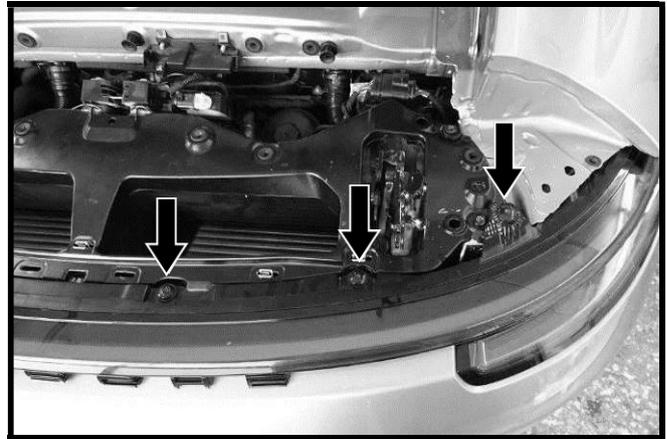


Fig. 37

- 9 Unscrew the taillamp and disconnect the electrical connection.
- 10 Unscrew the screws of the rear apron on the top.
- 11 Unscrew the screws of the rear apron in the wheel house. For that loosen the inner wheel house panel.
- 12 Unscrew the screws of the rear apron on the bottom.

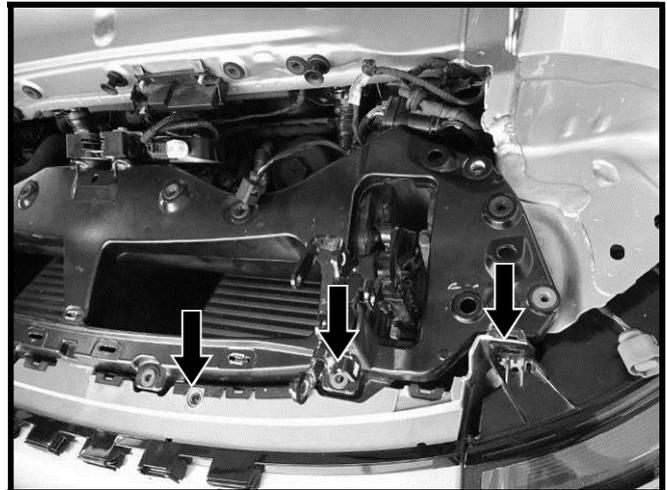


Fig. 38

- 13 Separate the electrical connections of the rear apron in the area of the taillights.
- 14 Remove the rear apron towards the rear.
- 15 Unscrew the tailpipe panels.
- 16 Unclip the PU-panels from the rear apron.
- 17 Unclip the rear apron bottom part.

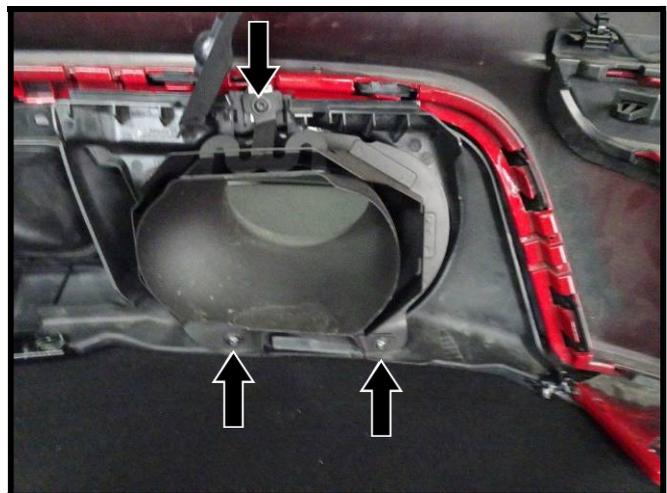


Fig. 39

i The original rear apron bottom part is no longer needed.

5.2 Assemble TECHART rear diffuser

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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 Apply an even layer of PU-adhesive to the bonding surface to the TECHART diffuser fins
092.100.500.126 right outside (A),
092.100.500.127 left outside (B),
092.100.500.128 right inside (C),
092.100.500.129 left inside (D).
- 2 Glue the TECHART diffuser fins to the TECHART rear diffuser
092.100.580.100 (42) and tighten from rear side with one screw each 5x16. For that drill a hole 15mm deep with d=4mm.

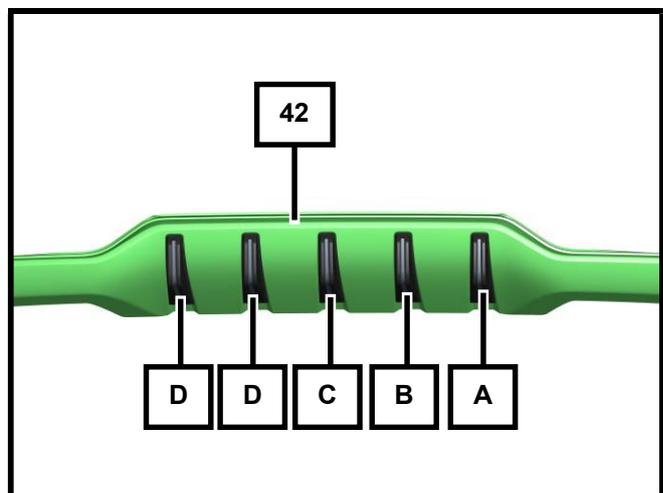


Fig. 40

- i** Check for an accurate fit and clearance when aligning.

- 3 Apply an even layer of PU-adhesive to the bonding surface of the TECHART rear diffuser
092.100.580.100 (42).
- 4 Glue the TECHART rear diffuser (42) to the rear apron.
- 5 Fix the TECHART Diffusor (42) at the edges to the PU-tailpipe panel, from the inside, with the screws 4.8x16 to the rear apron (43); for that pre-drill a hole of d= 3mm.

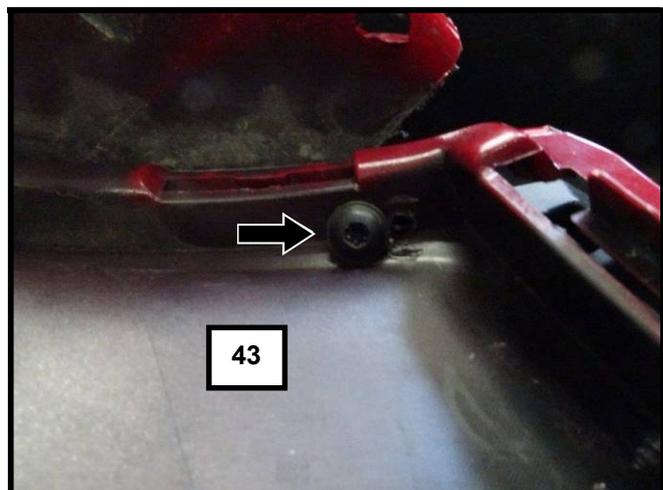


Fig. 41

- 6 Apply an even layer of PU-adhesive to the bonding area of the TECHART frame standard 092.100.580.111 (44) or TECHART frame SportDesign 092.100.580.110 (45).
- 7 Glue the TECHART frame (44,45) to the rear apron (43).
- 8 Von der Innenseite den TECHART Rahmen (44,45) mit den Schrauben 4,8x16 an der Heckschürze (43) fixieren dazu Loch d= 3mm vorbohren.

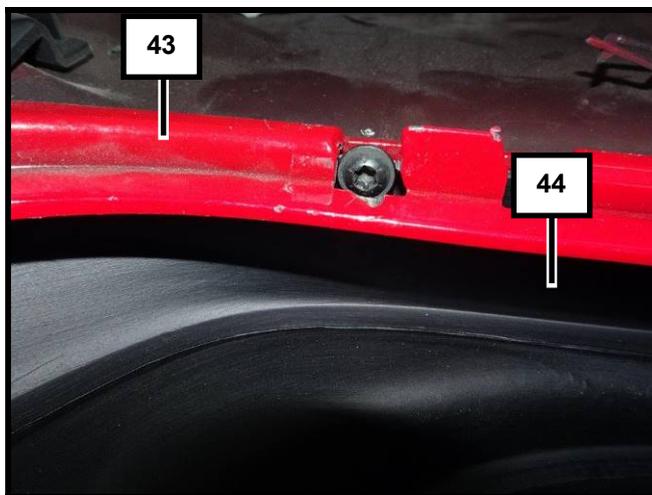


Fig. 42

i Care for an accurate fit when aligning; the TECHART frame needs to fit closely at the rear apron.

Standard tailpipes

- 9 Glue the original airduct (46) with PU-adhesive to the TECHART frame standard (44).

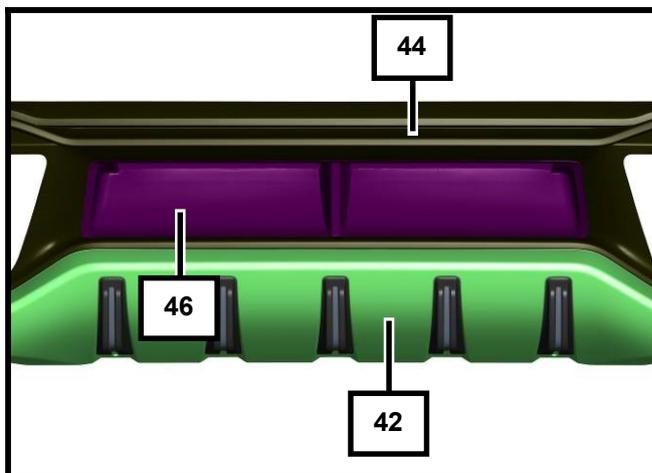


Fig. 43

SportDesign tailpipes

- 10 Glue the TECHART airduct (47) with PU-adhesive to the TECHART frame SportDesign (45).

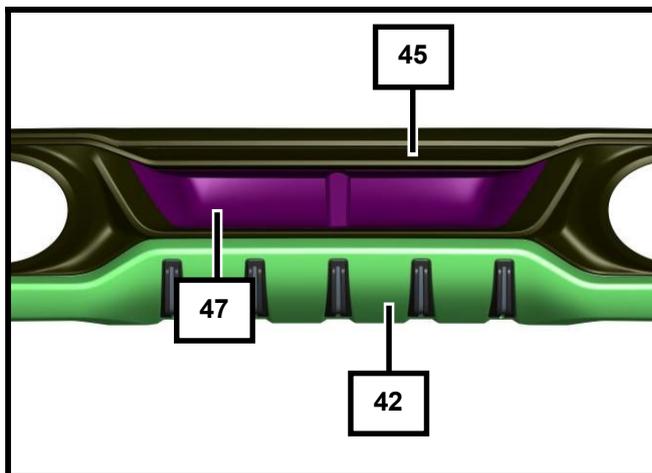


Fig. 44

Proceed for both

- 11 Glue the PU-tailpipe panel (48) with PU-adhesive in to the TECHART frame (44,45).

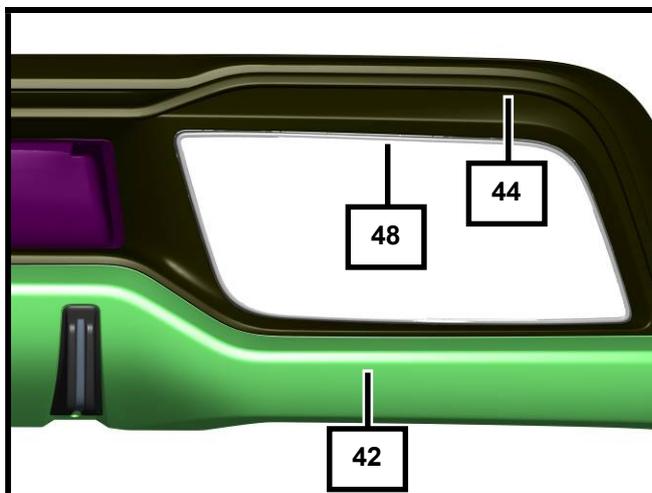


Fig. 45



Check for an accurate fit and clearance when aligning.

- 12 Attach the speed nut 4.8 to the TECHART heat shield 092.100.580.500 (49).
- 13 Tighten the TECHART heat shield (41) with the screw 4.8x16 to the TECHART diffuser (42).

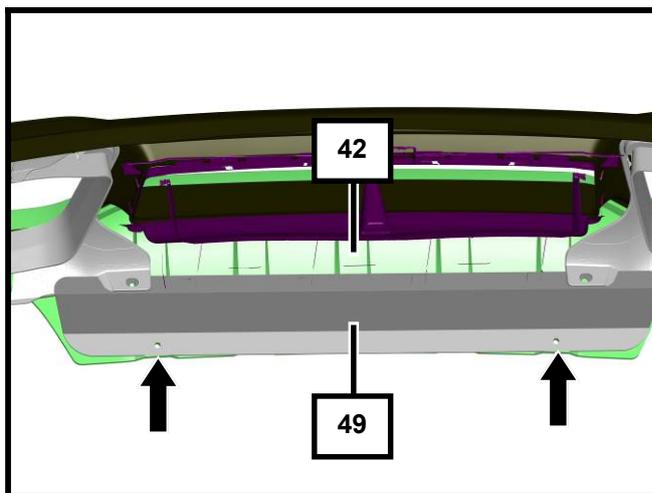


Fig. 46

- 14 Attach the entire rear apron on the vehicle.
- 15 Tighten the rear apron on all fixing points with the original screws.

- 16 Apply a thin layer of PU-adhesive to the bonding area of the TECHART insert 092.100.580.180 (50).
- 17 Glue the TECHART insert (50) to the TECHART frame (44,45).

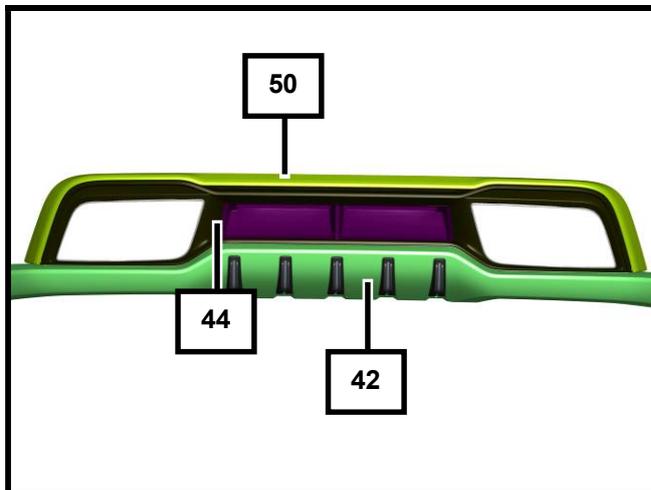


Fig. 47

- 18 Attach the speed nut 4.8x19 to the TECHART bracket rear diffuser right 092.100.580.220 (51) and left 221.
- 19 Tighten the TECHART bracket rear diffuser right (52) and left with the screws 4.8x16 to the vehicle.
- 20 Fasten the TECHART rear apron with the screws 4.8x16 to the TECHART bracket rear apron.

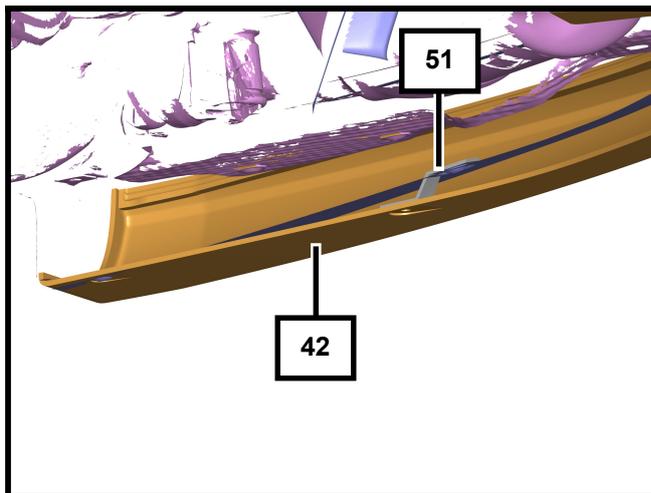


Fig. 48

- 21 Connect the electrical connection of the rear apron.
- 22 Connect the taillights electrically and install.
- 23 Connect the strip lighting electrically and install.
- 24 Install base frame
- 25 Connect the center-mounted brake lamp electrically.
- 26 Install rear spoiler.



Check for an accurate fit and clearance when aligning.

Immediately remove any PU adhesive that escapes using a cleaning agent.

Allow to dry for at least 12 hours.

6 TECHART air outlet rear apron**6.1 Install TECHART air outlet rear apron**

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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.

- i** Clean the bonding surface of the PU blank serial part with Betaclean and prime with Betaprime.

- 1 Apply an even layer of PU-adhesive to the bonding area of the TECHART air outlet 092.100.584.100/1 (52).
- 2 Glue the TECHART air outlet (52) to the rear apron (43).

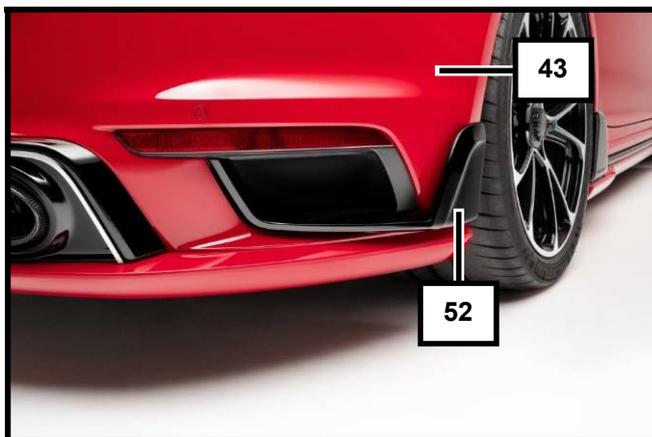


Fig. 49

- i** Check for an accurate fit and clearance when aligning.
Immediately remove any PU adhesive that escapes using a cleaning agent.
Allow to dry for at least 12 hours.

7 TECHART roof spoiler

7.1 Install TECHART roof spoiler

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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 Stick double-sided tape 6mm x 0,95mm into the notch area (a) in the TECHART roof spoiler 092.1__600.100 (53).
- 2 Apply an even coating of PU adhesive to the gluing surface (b) of the TECHART roof spoiler (53).
- 3 Set TECHART trims 2mm below the edge.

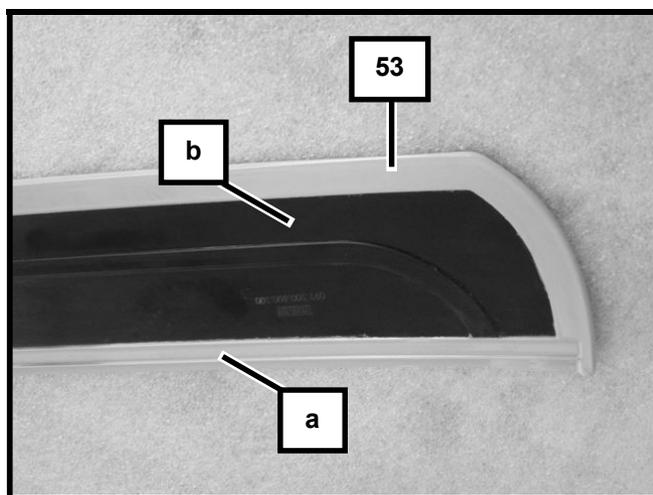


Fig. 50

- i** Press on the parts firmly in the bonding area. Ensure an accurate fit and remove any escaping adhesive with cleaning agent.

- 4 Fix the TECHART roof spoiler in place with adhesive tape so that it has firm contact with the surface at all points.

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

- i** For vehicles with rear window wiper: The original wiper blade has to be shortened by 100mm on the top.

- remove end cap
- shorten the rubber for 100mm
- paste end cap

8 TECHART rear spoiler**8.1 Install TECHART rear spoiler**

- 1 Turn the ignition on.
- 2 Deploy the rear spoiler.
- 3 Turn the ignition off.

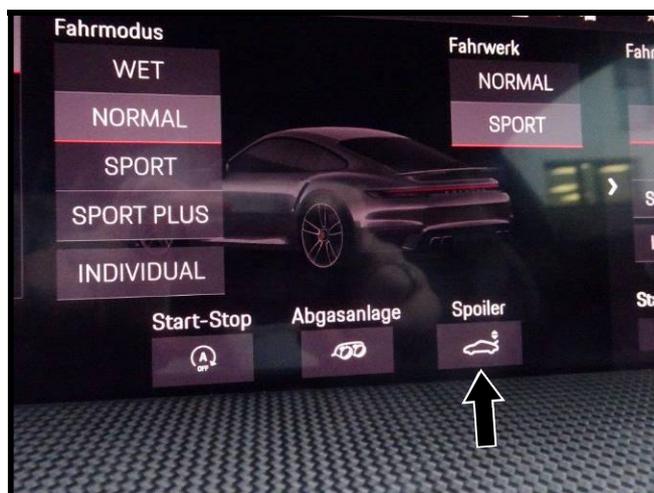


Fig. 51

- 4 Remove the screws below the rear spoiler.



Fig. 52

- 5 Install the TECHART rear spoiler 092.100.880.100 (45) with the screws M6x12.



Fig. 53

i The original rear spoiler is no longer required.

9 TECHART Carbon air intake**9.1 Install TECHART carbon air intake**

- i** The bonding surfaces must be dry and free from dust and paint spray mist!
Use cleaning agent to thoroughly degrease bonding surfaces. Then sand it 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 Apply PU-adhesive to the bonding area of the TECHART carbon air intake 092.121.480.100/1 (54).
- 2 Glue the TECHART carbon air intake (54) to the original air intakes at the side part.

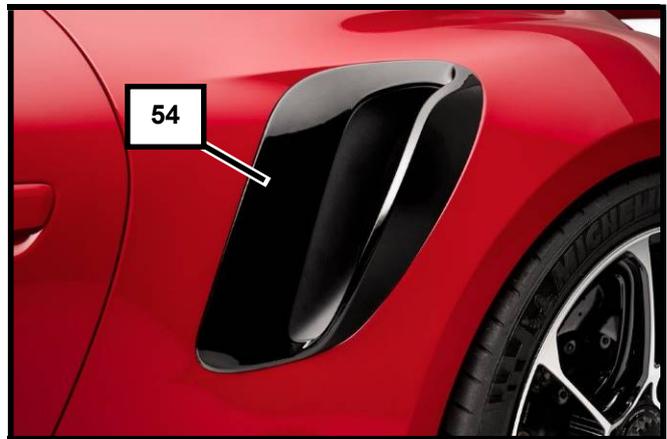


Fig. 54

- i** Check for an accurate fit and clearance when aligning.
Immediately remove any PU adhesive that escapes using a cleaning agent.
Allow to dry for at least 12 hours.

10 Perform final work on vehicle

10.1 Finishing touches

- 1 Attach wheels.

i Observe the specified tightening torques!

10.2 Final check

- 1 Perform a general function check on vehicle.

i 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 Dismantling the TECHART front apron

When dismantling the TECHART front apron release the detent first and then remove the TECHART front apron towards the front.

Do not pull or tear the TECHART front apron towards the outside otherwise it might break.



Fig. 56

TECHART

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