



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for 971 Panamera

Part-no. 071.100.120.009

Part-no. 071.121.196.009

Part-no. 071.100.810.009

Front spoiler II

Aero engine hood

Rear spoiler II

Version 05 – 06/2019





# ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for Panamera from MY17

## Contents

<b>I</b>	<b>Important safety information .....</b>	<b>3</b>
<b>II</b>	<b>Preparation .....</b>	<b>5</b>
<b>III</b>	<b>Installation .....</b>	<b>11</b>
1	Prepare vehicle .....	11
1.1	Switch off air suspension .....	11
1.2	Remove wheels .....	11
2	TECHART front spoiler II .....	12
2.1	Paint TECHART parts.....	12
2.2	Detach original front apron .....	13
2.3	Install TECHART front apron.....	17
3	TECHART aero engine hood .....	28
3.1	Dismantle the original engine hood .....	28
3.2	Install the TECHART frame .....	29
3.3	Install the TECHART aero engine hood .....	30
4	TECHART rear spoiler II .....	31
4.1	Dismantle the original rear spoiler .....	31
4.2	Affix the TECHART support strip.....	36
4.3	Dismantle the rear spoiler Turbo .....	37
4.4	Dismantle the rear spoiler non-Turbo .....	39
4.5	Modify the mechanism.....	41
4.6	Install the TECHART rear spoiler II .....	47
5	Perform final work on vehicle .....	52
5.2	Final check.....	52
6	Tightening torques .....	52



# ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for Panamera from MY17

## 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/electronics 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>	  
  		



# ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for Panamera from MY17

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



# ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for Panamera from MY17

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## 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](mailto:support@techart.de)



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### Check TECHART parts kit for completeness

<b>1</b>		<b>071.100.120.009</b>	<b>TECHART Front Spoiler II</b>
Consisting of:			
	1	071.100.120.100ZB	Front apron
	1	071.100.120.110	Cover towing hook
	1	071.100.120.120	Wheel arch front R
	1	071.100.120.121	Wheel arch front L
	1	071.100.120.140	Underbody
	1	071.100.120.220	Panel at turn signal R
	1	071.100.120.221	Panel at turn signal L
	1	071.100.120.600	Panel w/o camera
	1	071.100.120.610	Panel w/o ACC, R
	1	071.100.120.611	Panel w/o ACC, L
	1	071.100.120.130	Reinforcement inner wheel house
<b>1</b>		<b>071.100.120.990</b>	<b>Accessory pack front</b>
Consisting of:			
	69	000.100.999.999	Collar screw for plastic PT K 50 x 16 pointed
	10	0001009999961	Collar screw for plastic PT50 x 25 pointed
	7	0039004.8X387981	Sheet metal screw fillister head with flange 4.8x38
	29	001900M05X15A2	Washer M 5x15, A2, DIN 9021
	24	0009014,8X1693614816	Rivet truss head 4.8x16 black
	5	00039004.8X951020	Sheet metal screw flat-head A2 with Torx 4.8x9.5
	2	097.100.181.210	Bracket for spraying nozzle at the air duct
	6	01090006X16X8	Washer, 6.3x16x8, plastic, black
	1	071.100.120.202	Bracket parking sensor, grille R
	1	071.100.120.203	Bracket parking sensor, grille L
	2	000.100.100.101	Adhesive tape for bracket parking sensor
	4	071100120206	Blank holder parking sensor
	2	071100120208	Blank holder parking sensor, grille
	10	0009002.9X137981	Fillister head screw, 2.9x13, black
	11	001900M5X40107380A2	Flattened half-round screw M 5x40
	6	001900M05W379	Nut with wave washer, M 5, yellow galvanized
	5	001900M05	Speed nut, M 5
	2	00090146801220	O-ring, 12 x 2.20
	8	0009014X127337	Rivet truss head 4.0x12 aluminum



# ASSEMBLY INSTRUCTIONS

TECHART Aero-Kit for Panamera from MY17

## Part set options

1		<b>+71.100.005.000</b>	<b>V01: For Panamera non-Turbo without SportDesign-Package</b>
Consisting of:			
	1	971953041C	Lamp left
	1	971953042C	Lamp right
	1	971121333A	Air duct left
	1	971121334A	Air duct right
	1	971807762AOK1	Cover camera
	1	971807997A	Bracket camera

or

1		<b>+71.100.005.001</b>	<b>V01: For Panamera non-Turbo with SportDesign-Package</b>
Consisting of:			
	1	971121333A	Air duct left
	1	971121334A	Air duct right
	1	971807762AOK1	Cover camera
	1	971807997A	Bracket camera

or

1		<b>+71.100.006.000</b>	<b>V01: For Panamera Turbo without SportDesign-Package</b>
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or

1		<b>+71.100.006.001</b>	<b>V01: For Panamera Turbo with SportDesign-Package</b>
Consisting of:			
	1	971121333A	Air duct left
	1	971121334A	Air duct right
	1	971807762AOK1	Cover camera
	1	971807997A	Bracket camera



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

<b>1</b>		<b>+71.100.020.001</b>	<b>V02: Splitter paintable</b>
Consisting of:			
	1	071.100.120.102	Splitter, blank

<b>1</b>		<b>+71.100.030.001</b>	<b>V03: Grille paintable</b>
Consisting of:			
	1	071.100.120.150	Grille right, blank
	1	071.100.120.151	Grille left, blank
	1	071.100.120.152	Grille center, blank
	1	071.100.120.154	Grille bar R top
	1	071.100.120.155	Grille bar L top
	1	071.100.120.156	Grille bar R bottom
	1	071.100.120.152	Grille bar L bottom

<b>1</b>		<b>+71.100.040.001</b>	<b>V04: Air shaft front paintable</b>
Consisting of:			
	1	071.100.120.182	Air outlet grille, blank

<b>1</b>		<b>071.121.196.009</b>	<b>Aero engine hood</b>
Consisting of:			
	1	071.121.199.100	Aero engine hood
	1	071.100.196.200	Frame
	1	00091089010031	Bond + Seal black, tube 70ml



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

<b>1</b>		<b>071.100.810.009</b>	<b>Rear spoiler II</b>
Consisting of:			
	1	071.100.810.100	Base frame
	1	091.100.810.222	Rear spoiler II, base plate right, long
	1	091.100.810.223	Rear spoiler II, base plate left, long
	1	071.100.810.200	Support strip, rear spoiler
	1,15	096.100.820.960	Weather strip straight, black
<b>1</b>		<b>071.100.810.990</b>	<b>Accessory pack rear spoiler II</b>
Consisting of:			
	1	071.100.810.110	Angle bracket R
	1	071.100.810.111	Angle bracket L
	1	071.100.810.130	Bracket support R top
	1	071.100.810.131	Bracket support L top
	1	071.100.810.132	Bracket support R bottom
	1	071.100.810.133	Bracket support I bottom
	1	071.100.810.150	Bracket drive shaft R
	1	071.100.810.151	Bracket drive shaft R
	1	071.100.810.500	Metal sheet, rear spoiler II
	1	0009014,0X107337	Rivet countersunk 4,0x10 aluminum galvanized
	2	001900M5X127380A2	Fillister head screw with flange M 5x12 / A2
	2	01090006X16X8	Grommet, 6.3x16x8, plastic black
	4	0009014,8X1091504864	Rivet truss head 4.8x10
	6	001900M5X207380A2	Raised countersunk head screw with flange 5x20 / A2
	4	0019005083M05	Speed nut, M 5, Type6 transparent galvanized
	2	002900M05/S	Nut with washer, M5, yellow galvanized
	2	001900M8X307385A2	Fillister head screw with flange M 8x25 / A2
	2	0089003698	Hexagon nut self-locking M8
	4	001900M8X1007380	Screw button head M 8x100
	6	50001900M5X16A27380	Flange fillister head screw M 5x16 A2 stainless steel
	4	001900M06	Speed nut, M 6, galvanized
	4	001900M6X127380A2	Fillister head screw with flange M 6x12 / A2
	4	097.100.880.250	Rubber buffer
	2	001900M04X25912	Cylinder head bolt, M 4x25
	2	001900M04X20	Washer, M 4,3x20, galvanized
	4	000590502221	Cable tie with metal tongue 3.5x140mm in black
	1	00091089010031	Bond + Seal black, tube 70ml



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

<b>1</b>		<b>+91.100.810.200</b>	<b>V02: Profile paintable</b>
Consisting of:			
	1	091.100.810.200	Rear spoiler II, wing profile

or

<b>1</b>		<b>+91.121.810.200</b>	<b>V02: Profile in Carbon graphite matt</b>
Consisting of:			
	1	091.121.810.200	Rear spoiler II, wing profile

or

<b>1</b>		<b>+91.121.810.200G</b>	<b>V02: Profile in Carbon graphite glossy</b>
Consisting of:			
	1	091.121.810.200G	Rear spoiler II, wing profile

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 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 Switch off air suspension

- 1 Turn the ignition on.
- 2 At the combination-instrument:
  - Car
  - Vehicle
  - Car-Jack „✓“



Fig. 01

#### 1.2 Remove wheels

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



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### 2 TECHART front spoiler II

#### 2.1 Paint TECHART parts

**i** Prepare and paint all TECHART parts according to the painting instructions.

- i**
- 071.100.120.102 TECHART Splitter
  - 071.100.120.150 TECHART Grille R
  - 071.100.120.151 TECHART Grille L
  - 071.100.120.152 TECHART Grille center
  - 2 Sensors ParkAssist grille
  - 071.100.120.182 TECHART Air outlet (optionally in car color)
- will receive contrasting colors.

- i**
- The following parts must not be painted:
- 071.100.120.120 TECHART wheel arch R, front apron
  - 071.100.120.121 TECHART wheel arch L, front apron

### 2.2 Detach original front apron

- 1 Open engine hood.
- 2 Remove the PU-cover at the engine compartment, for that remove the clips first.

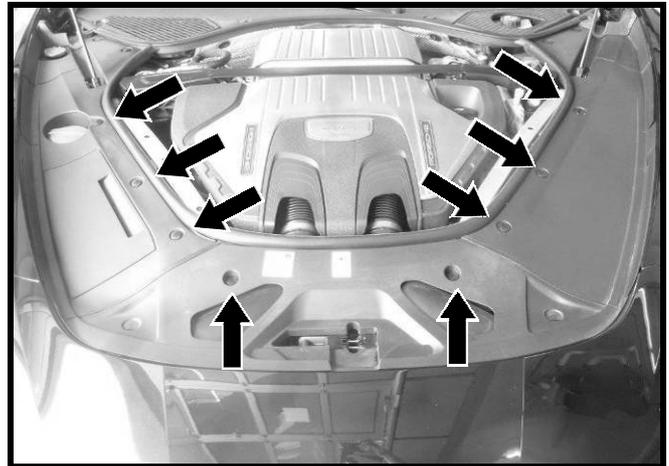


Fig. 02

- 3 Remove the upper 4 fixing screws.

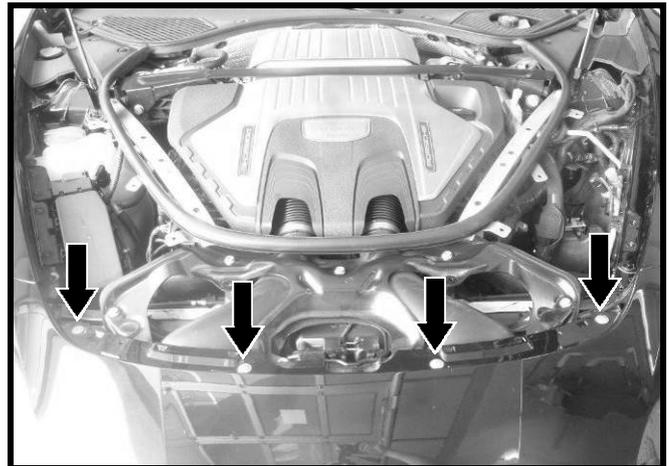


Fig. 03

- 4 Remove the retaining brackets (see arrow) right and left between the headlight and the flap towards the flap.



Fig. 04

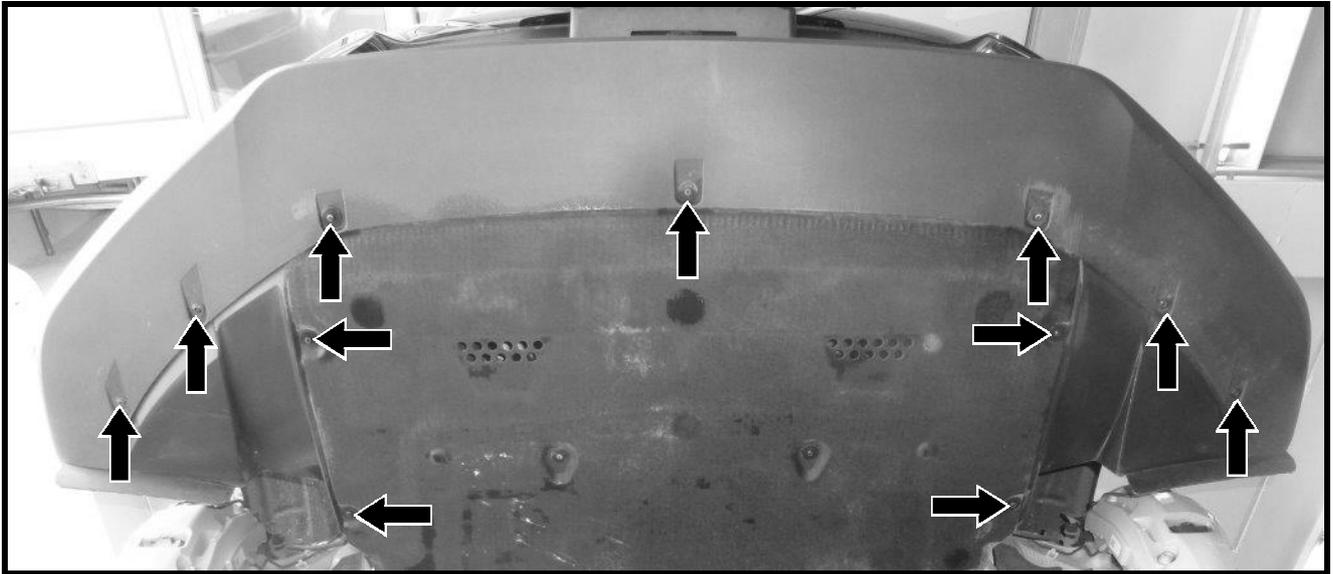


Fig. 05

- 5 Unscrew the fixing screws underneath the vehicle.
- 6 Dismantle the inner lining of the wheel house completely, (all 4).
- 7 Remove the headlights, for that unscrew the fixing screws from the bottom, separate the electrical connections of the headlights, remove the vacuum line and pull out the headlights towards the front.

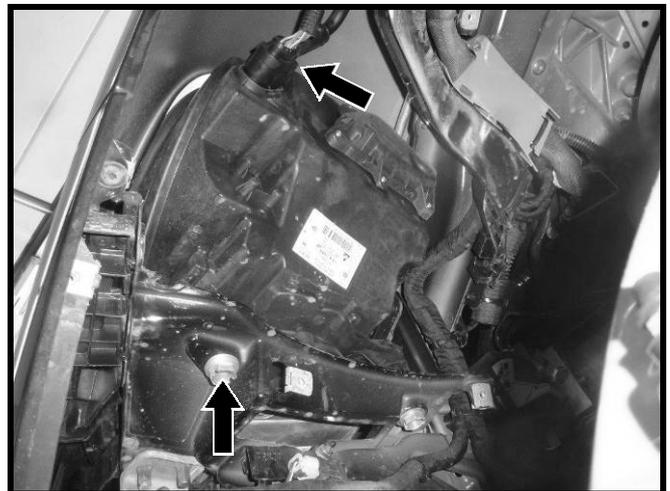


Fig. 06

### Left wheel house

- 8 Unscrew the upper fixing screws in the wheel house.
- 9 Separate the electrical connection.



Fig. 07

### Right wheel house

- 10 Unscrew the upper fixing screws in the wheel house.
- 11 Separate the electrical connection.
- 12 Separate the water hose in the wheel house.

**(i) Water may run out when the water hose is disconnected. Collect the water in a suitable receptacle.**

- 13 Remove the original front apron towards the front.

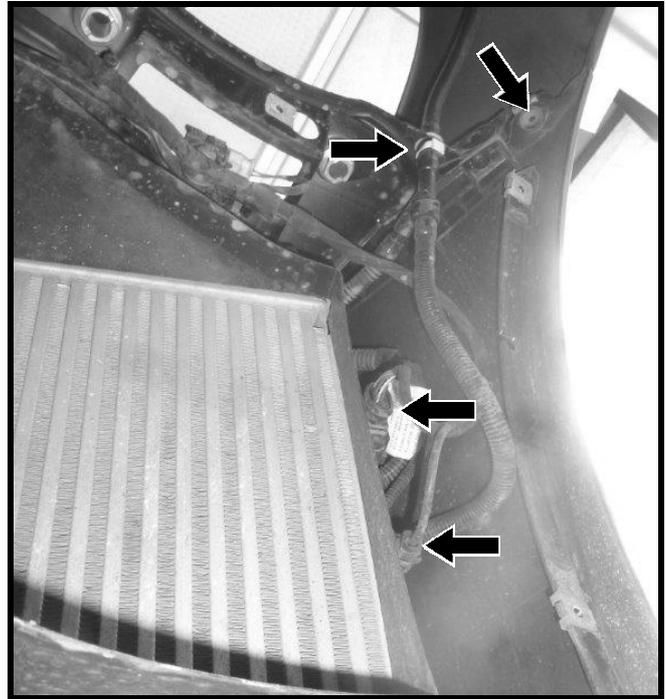


Fig. 08

- 14 Dismantle the line for the headlight washing system.
- 15 Dismantle wiring harness incl. ACC.
- 16 Dismantle the spraying nozzle for the headlight washing system.
- 17 Dismantle the combination lamp, for that unclip the strip in the turn signal from the front apron.
- 18 Dismantle ParkAssist, antennas, crash-sensor and camera incl. bracket.
- 19 Unscrew the insertion for the front apron.

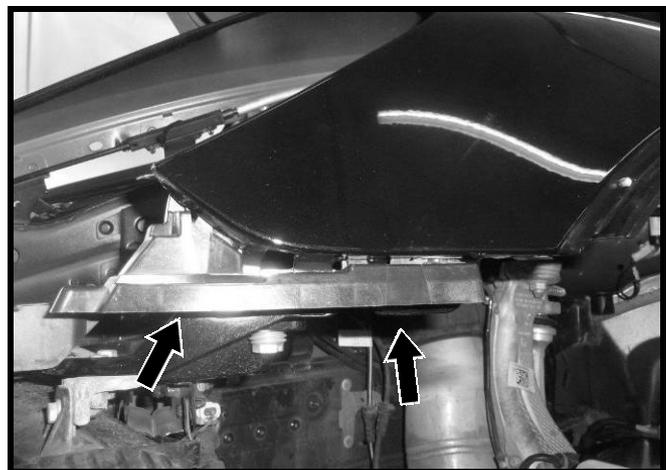


Fig. 09

**(i) The original front apron and the insertion are no longer required.**

### 2.3 Install TECHART front apron

- 1 Tighten the TECHART underbody 071.100.120.140 (1) with the washers 5x15 and the screws 4.8x38 to the original fixing points.

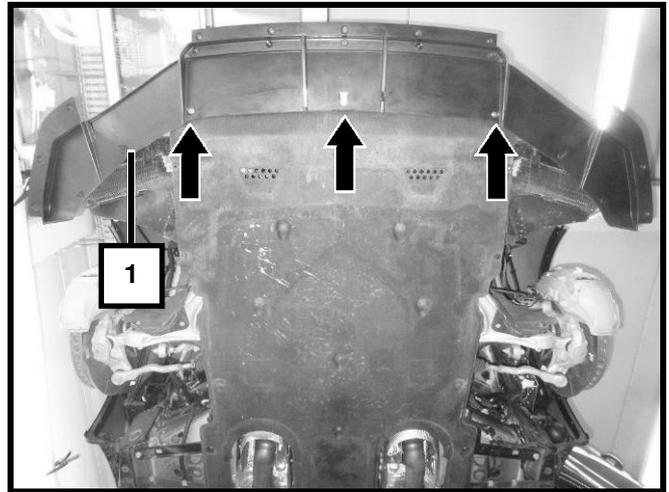


Fig. 10

- 2 Additionally, tighten the TECHART underbody (1) with the screws 5x16 to the vehicle.

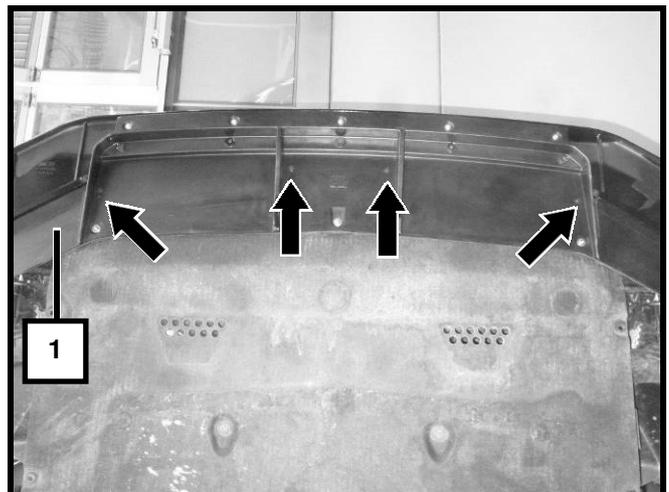


Fig. 11

- 3 Tighten the TECHART trim bars 071.100.120.154 right top (2), 155 left top, 156 right bottom (3) and 157 left bottom with the screws 5x16 into the TECHART grilles R & L 071.100.120.15\_ (4).

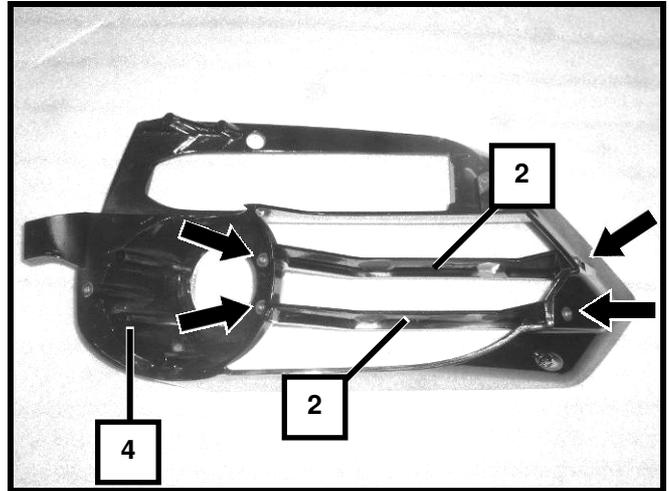


Fig. 12

- 4 Insert the TECHART grilles R and L (4) into the TECHART front apron 071.100.120.100 (5) and tighten with the screws 5x16.

**i** Care for an accurate fit.

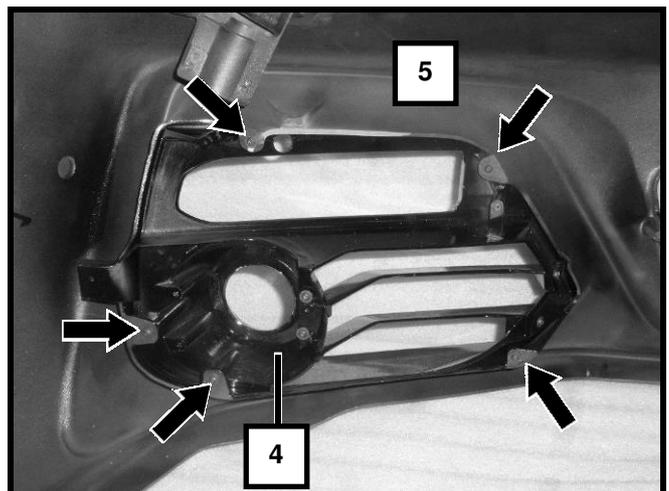


Fig. 13

- 5 Tighten the TECHART grille center 071.100.120.152 (6) on the top with the screws 5x16 into the TECHART front apron (5).

**i** Care for an accurate fit.

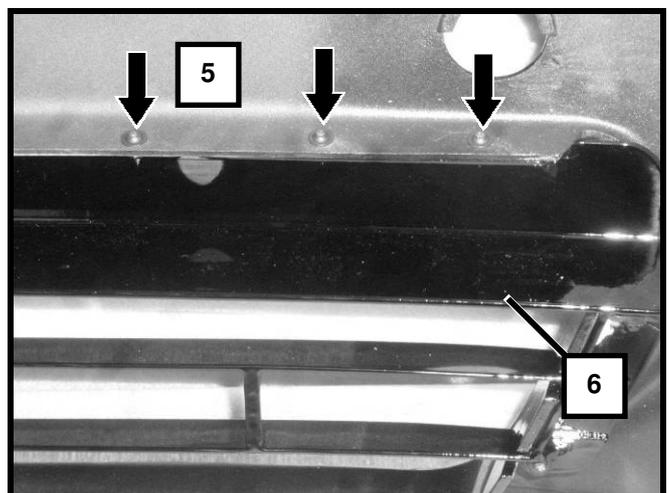


Fig. 14



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 6 Tighten the TECHART grille center (6) right and left with the screws 5x16 into the TECHART front apron (5).

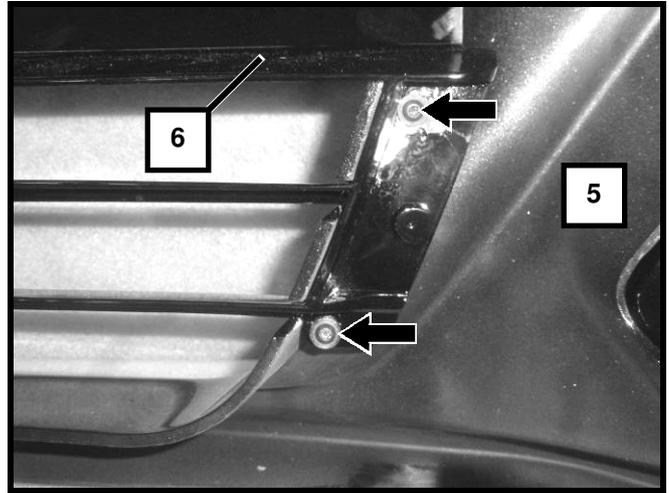


Fig. 15

- 7 Install all ParkAssists (8) in the TECHART bracket parking sensor (9) at the TECHART front apron (5).

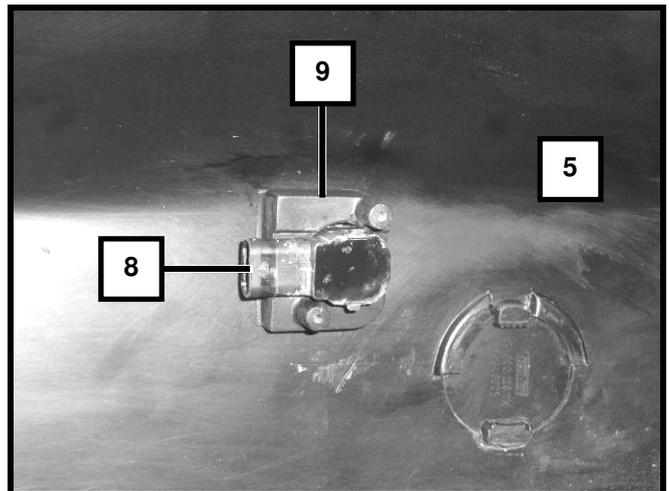


Fig. 16

- 8 Screw the ParkAssist (8) with the screws 2.9x13 and the TECHART sheet metal bracket parking sensor 071.100.120.206 into the TECHART bracket parking sensor (9).

**i** Care for an accurate fit.

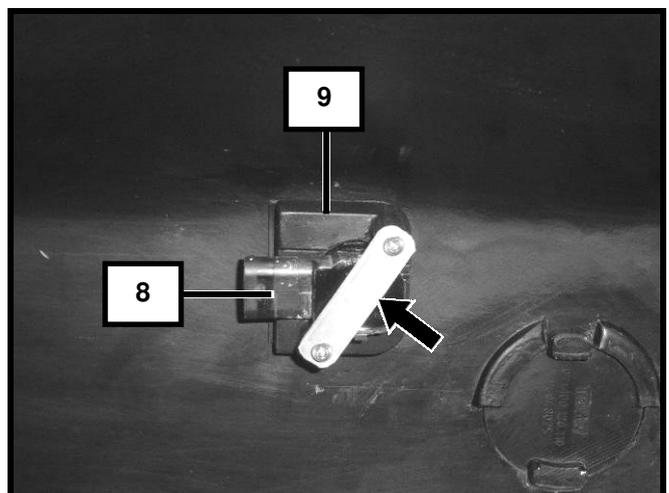


Fig. 17

9 Insert the combination lamp (10) into the TECHART grille (4) and tighten with the screws 5x16.

10 Fasten the TECHART bracket parking sensor grille R and L with the double-sided adhesive tape into the TECHART grille (4).

**i** Care for an accurate fit.

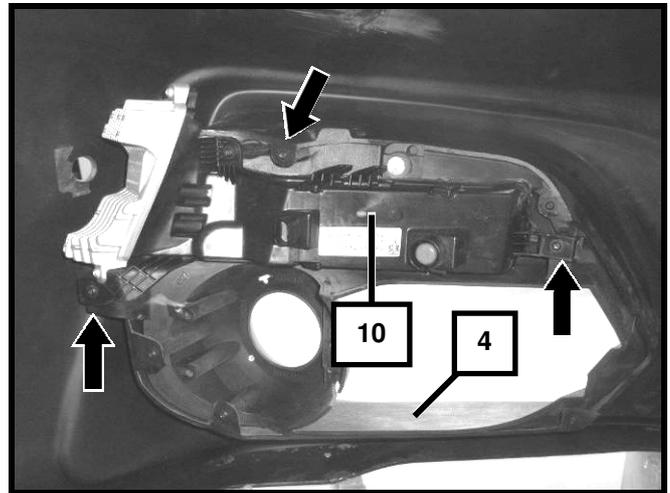


Fig. 18

11 Remove the original rubber stop from the parking sensor and attach the O-ring 12 x 2.20 to the parking sensor.

**i** Install only parking sensors with a straight plug into the grille.

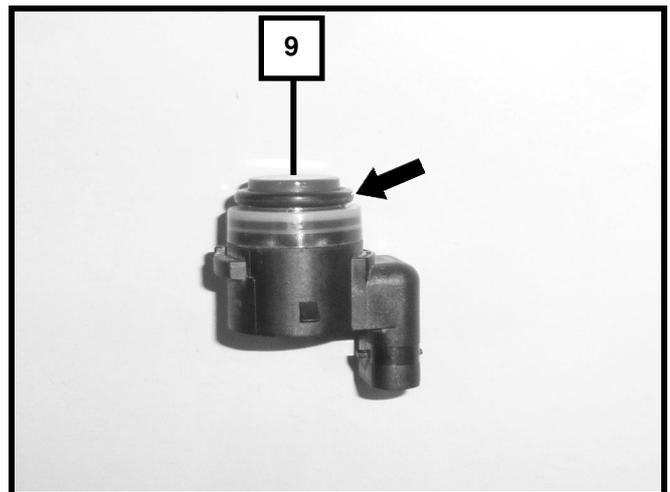


Fig. 19

12 Install the ParkAssist (8) into the TECHART bracket parking sensor (9) at the TECHART grille (10).

13 Tighten the ParkAssist (8) with the screws 2.9x13 and the TECHART sheet metal bracket parking sensor grille 071.100.120.208 into the TECHART bracket parking sensor (9).

**i** Care for an accurate fit.

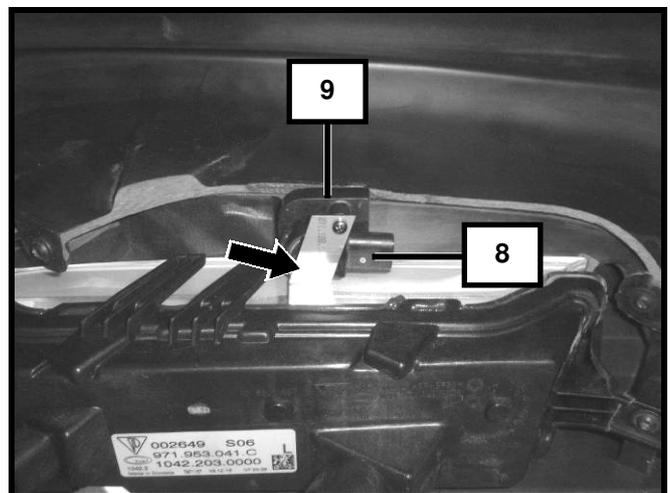


Fig. 20



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 14 Glue the TECHART panel at the turn signal 071.100.120.22\_ (11) to the combination lamp (10) and the TECHART grille (4).

**i** Care for an accurate fit.

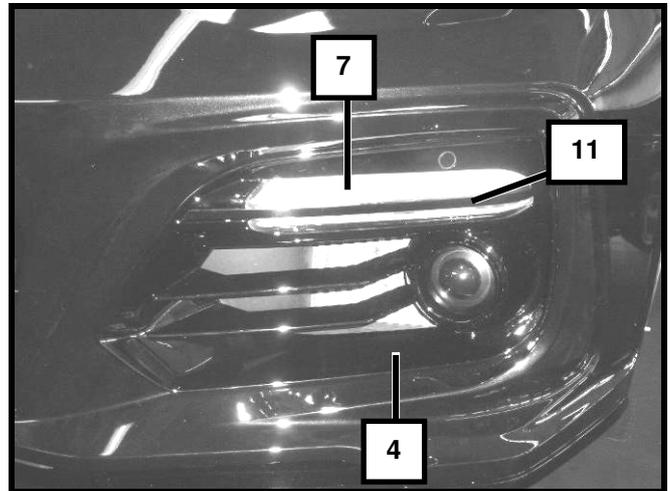


Fig.21

### Vehicles with camera

- 15 Insert the original camera with the bracket (12) into the TECHART grille center (7) and fasten.

**i** The bracket for the Turbo (971807997A) is also enclosed in the non-Turbo-delivery.

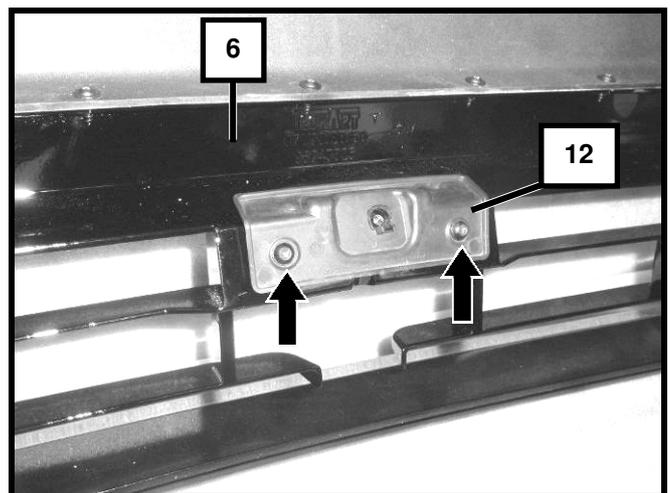


Fig. 22

### Vehicles without camera

- 16 Fasten the TECHART panel camera 071.100.120.600 (13) with the screws 5x16 to the TECHART grille center (6).

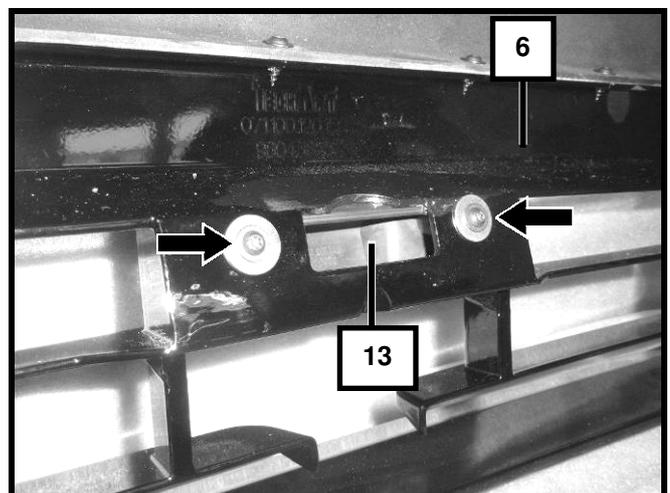


Fig. 23



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 17 Install the TECHART air outlet 071.100.120.182 (14) from the bottom with the screws 5x16 into the TECHART front apron (5).

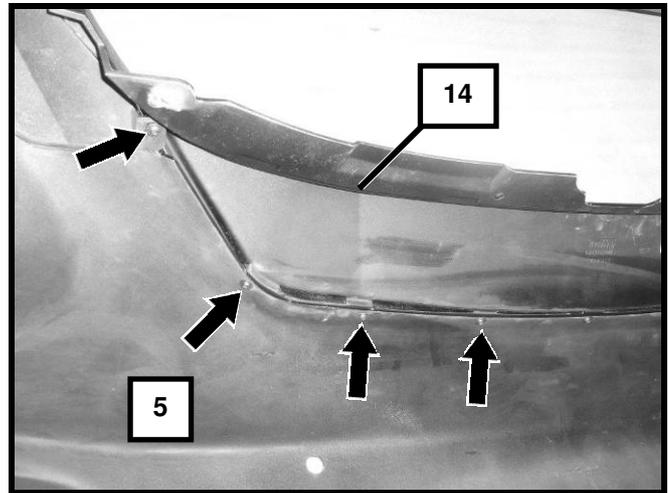


Fig. 24

- 18 Tighten the TECHART air outlet (14) with the screws 5x16 to the TECHART front apron (5).

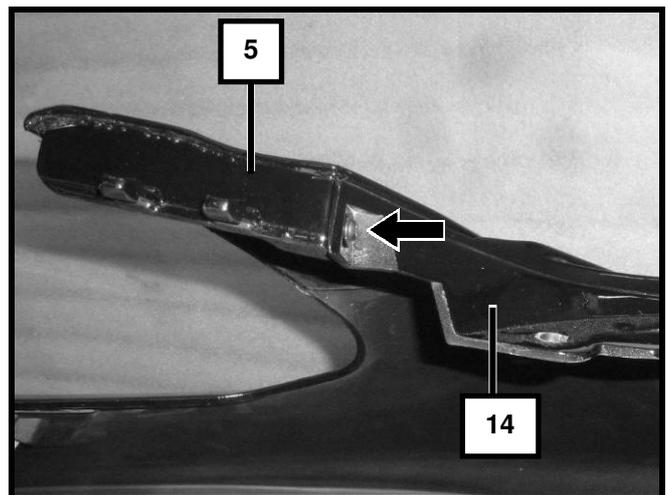


Fig. 25

- 19 Glue the antennas (15) into the TECHART front apron (5).
- 20 Route and install the wiring harness (16) in the front.

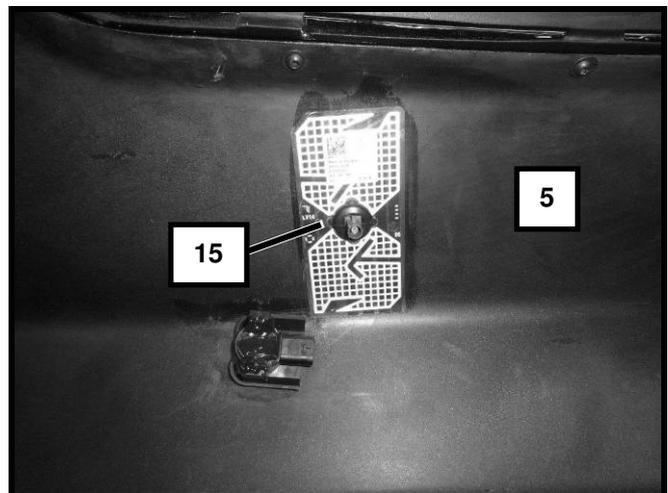


Fig. 26

- 21 Expose and strip the crash sensor cable (17) from the original wiring harness of about 60 cm.
- 22 Install the crash sensor (17) into the TECHART front apron (5) and connect electrically.
- 23 Connect the wiring harness (16) with the combination lamp (10) electrically.
- 24 Connect the wiring harness (16) with the ParkAssist (8) electrically.

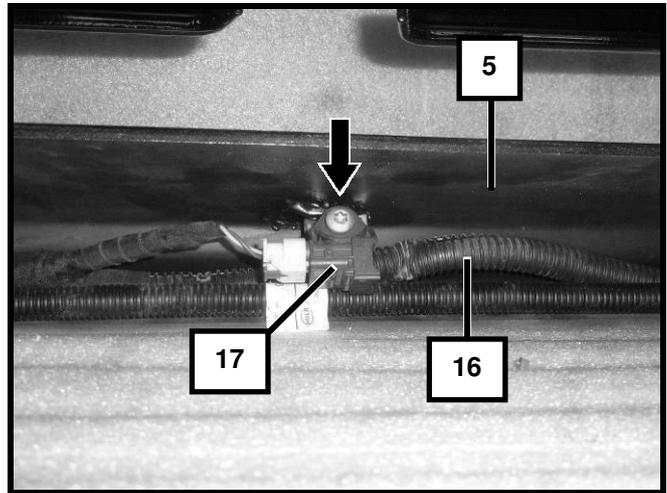


Fig. 27

### Vehicles with ACC

- 25 Connect the ACC sensor (18) with the wiring harness (16).
- 26 Tighten the ACC sensor (18) with the screws 5x25 and the washer black into the TECHART grille R & L (4).

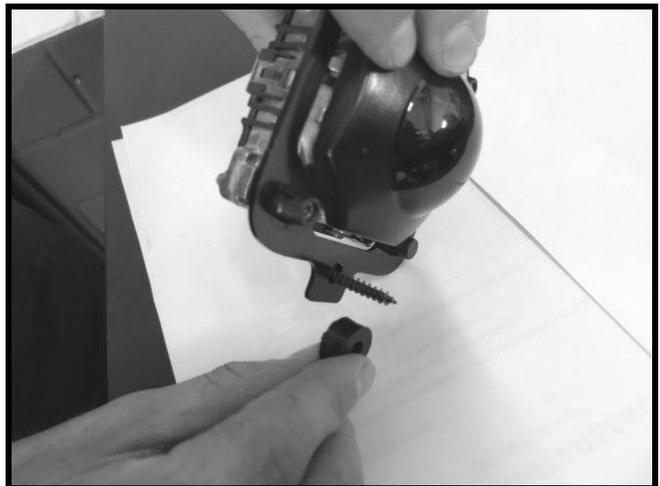


Fig. 28

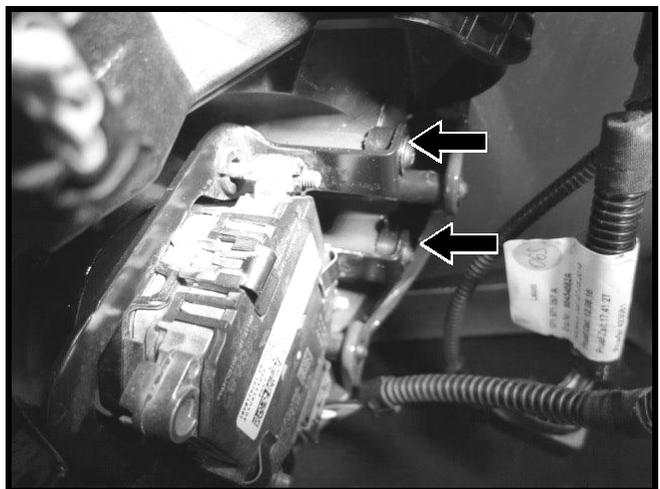


Fig. 29



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### Vehicles without ACC

- 27 Tighten the TECHART panel w/o ACC 071.100.120.61\_ (19) with the screws 5x16 into the TECHART grille R & L (4).

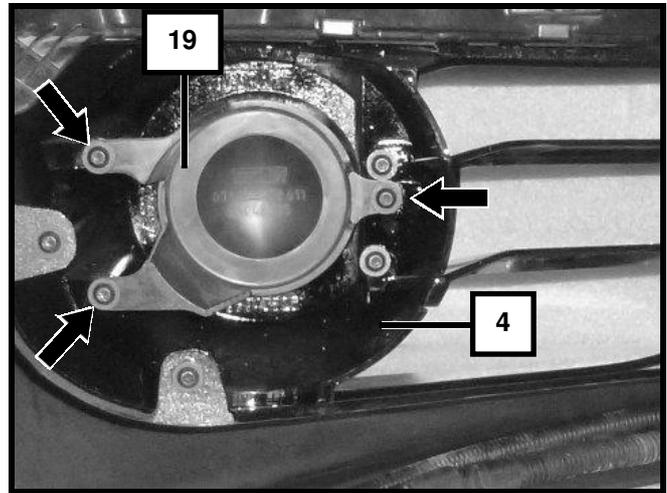


Fig. 30

- 28 Tighten the spraying nozzle headlight washer (20) with the screws 5x16 and the TECHART bracket 097.100.181.210 (21) into the TECHART front apron (5).

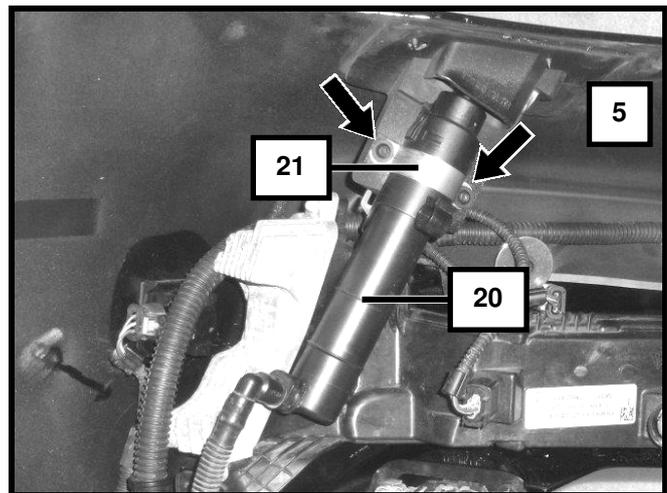


Fig. 31

- 29 Route the hose for the headlight washing system (22) above the TECHART grilles in the TECHART front apron (5).
- 30 Connect the hose for the headlight washing system (22) with the spraying nozzle headlight washing system.

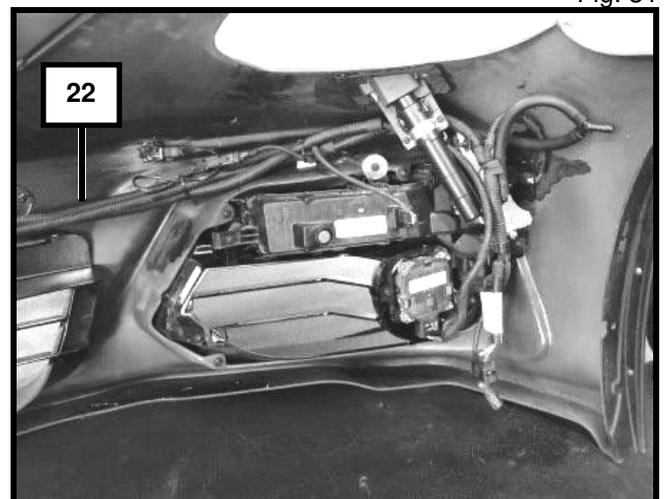


Fig. 32



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 31 Attach 5 speed nuts M5 on the bottom center to the TECHART front apron (5).

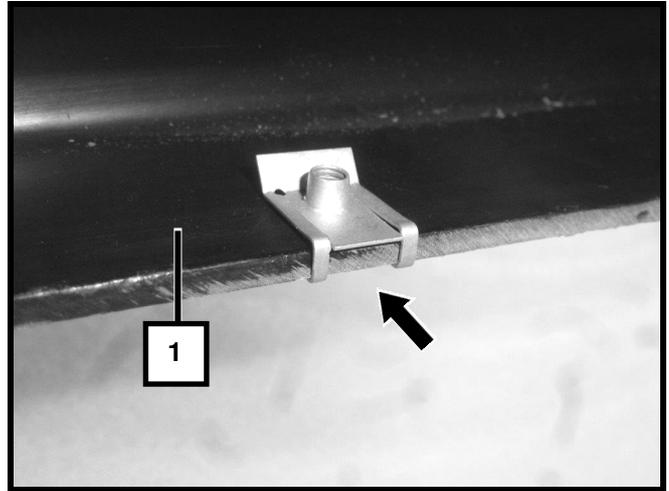


Fig. 33

- 32 Attach the TECHART splitter 071.100.120.102 (23) to the TECHART underbody (1) and tighten in the center from the bottom with the screws 4.9x9.5.

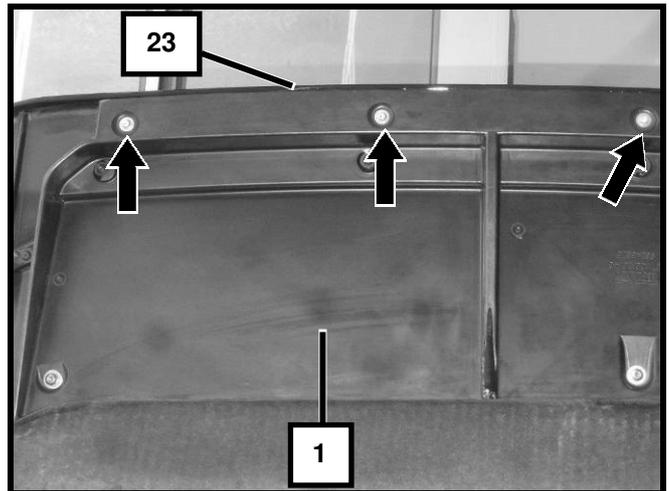


Fig. 34

- 33 Tighten the TECHART splitter (23) in the area of the brake air shaft with the screws 5x16 to the TECHART underbody (1).

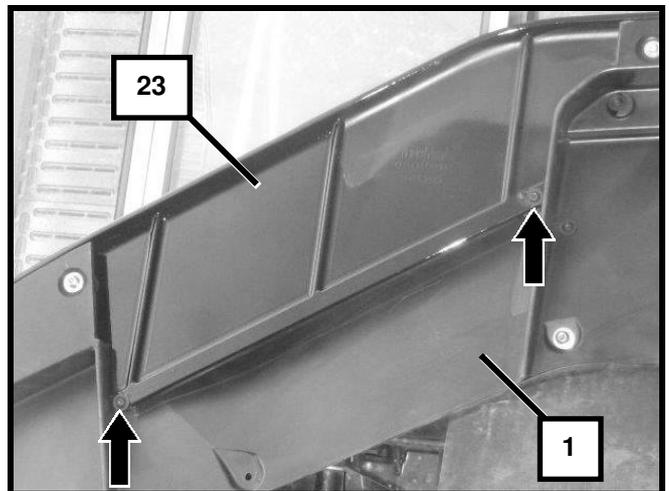


Fig.35

- 34 Mount the TECHART front apron (5) to the vehicle.
- 35 Fasten the TECHART front apron (5) on the bottom outside through the TECHART underbody (1) and splitter (22) with the screws M5x40 and M5 nuts with wave washer.

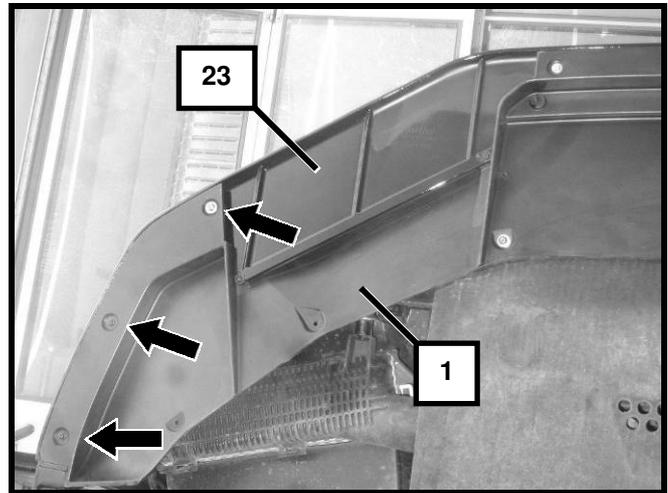


Fig. 36

- 36 Tighten the TECHART front apron (5) on the bottom inside with the screws 4.8x32 and the washers M5x15 to the TECHART underbody (1).

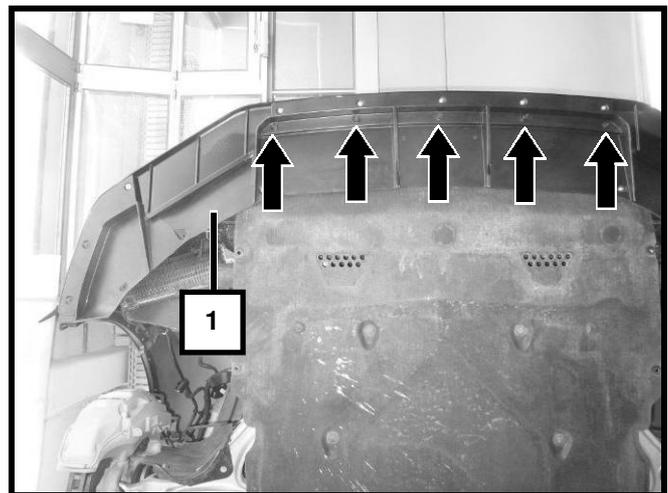


Fig. 37

- 37 Tighten the TECHART front apron (5) at the air outlet (14) with the original screws to the vehicle.
- 38 Insert the retaining clips (see arrows) right and left between the headlight and front flap towards the flap.

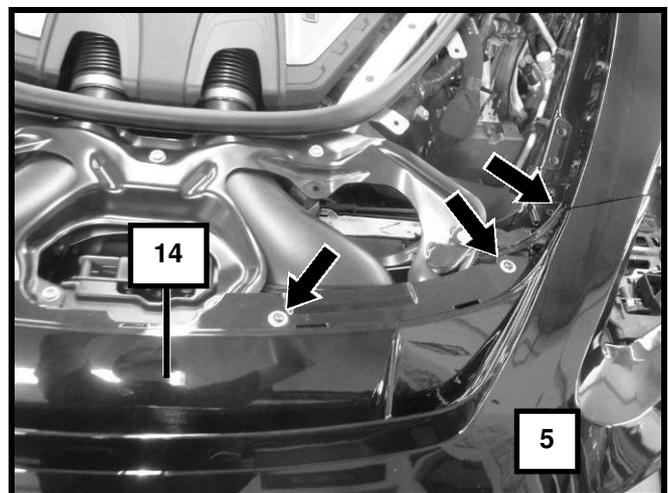


Fig. 38



**Care for an accurate fit.**

39 Tighten the TECHART front apron (5) to the fender.

40 Tighten the TECHART front apron (5) additionally on the top with the screw 5x16 to the fender.



### Care for an accurate fit.

41 Connect the electrical connections and connect the water hose inside wheel arch.

42 Install headlights.

43 Tighten the TECHART Reinforcement inner wheel house 071.100.120.130 (24) with the rivets 4.8x16 and the washers 5x15 to the original inner wheel house front (25).

44 Install the wheel house inner lining completely.

45 Attach the wheels.

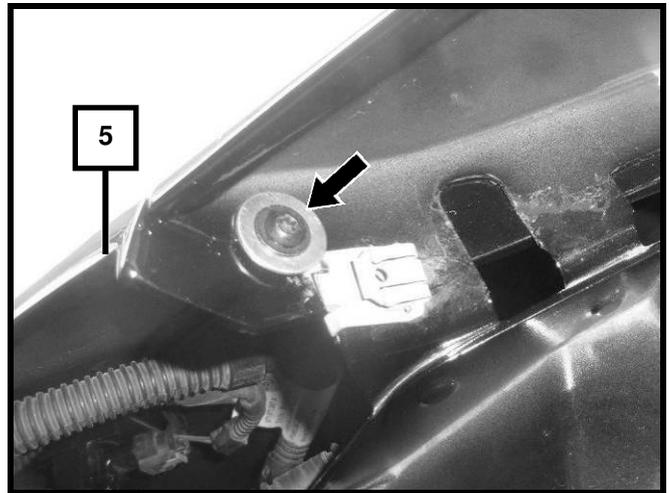


Fig. 39

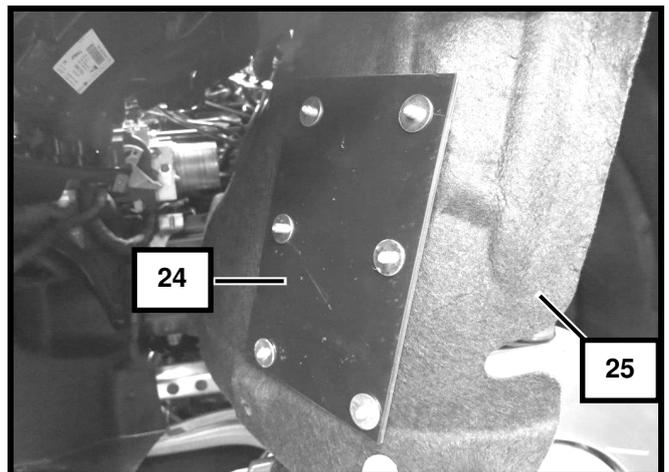


Fig. 40



### Pay attention to the specified tightening torques!

### 3 TECHART aero engine hood

**i** Please check whether the original hood is fitted accurately!

#### 3.1 Dismantle the original engine hood

- 1 Open engine hood.
- 2 Dismantle the spraying nozzle and the water hose and separate the electrical connection.
- 3 Remove the wiring harness and the water hose from the hood.
- 4 Dismantle hood damper.
- 5 Unscrew engine hood from the vehicle.

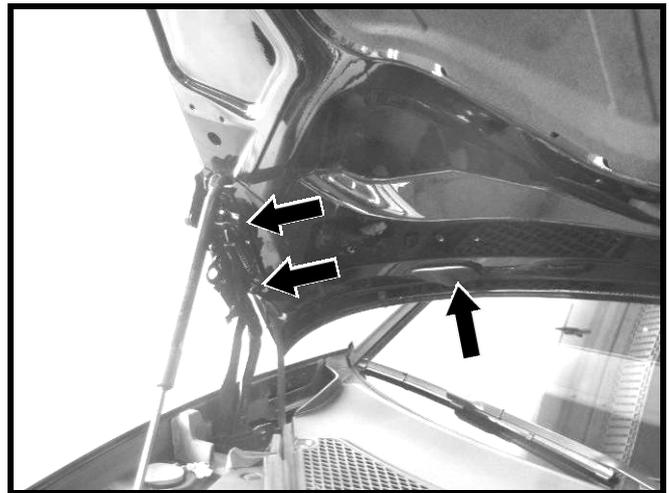


Fig. 41

- 6 Install the arrester hook, the ball pin and the hood emblem from the original engine hood to the TECHART aero-engine hood.

**i** The original engine hood is no longer needed.



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### 3.2 Install the TECHART frame

- i** The bonding surfaces of the TECHART aero engine hood and the TECHART frame must be dry and free of dust!

Use cleaning agent to thoroughly degrease bonding surfaces on the TECHART aero engine hood and the TECHART frame. 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 Apply a thin even coating of PU adhesive to the bonding surfaces to the TECHART frame 071.100.196.200 (24).
- 2 Insert the TECHART frame (24) into the TECHART aero-engine hood 071.121.199.100 (25).

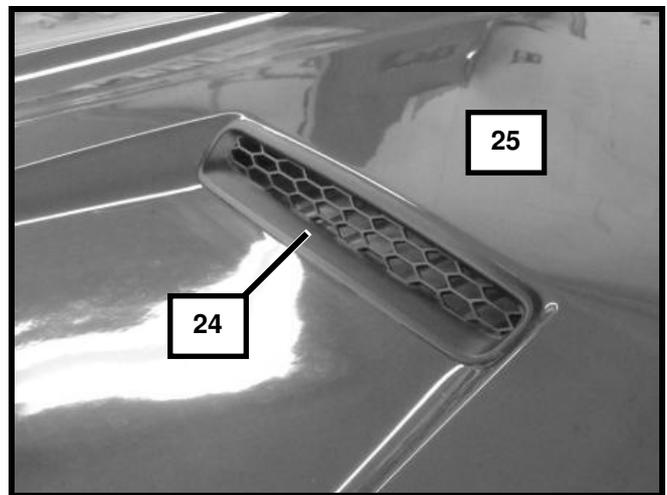


Fig. 42

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

- 3 Fix the TECHART frame in place so that they have firm contact with the surface at all points.

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



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### 3.3 Install the TECHART aero engine hood

- 1 Screw the TECHART aero engine hood onto the vehicle.



**Care for an accurate fit.**

**The height of the hood hinge and the lock can be adjusted.**

- 1 Install the original hood damper
- 2 Install the wiring harness and the water hose into the TECHART aero engine hood.
- 2 Connect the spray nozzles with the water hose and the electrical connections and install them.

### 4 TECHART rear spoiler II

#### 4.1 Dismantle the original rear spoiler

- 1 Turn the ignition on.
- 2 At the combination instrument
  - Drive
  - Spoiler
  - Extend „✓“
- 3 Turn the ignition off.



Fig. 43

- 4 Dismantle the panel at the rear spoiler right and left, for that dismantle the front clip.



Fig. 44

- 5 Unscrew the screw below the spoiler.
- 6 First, press the panel right and left a little to the outside then remove it towards the back.



Fig. 45

- 7 Dismantle the panel at the rear spoiler center, for that dismantle the clips right and left and untighten the screw.
- 8 Remove the panel center incl. the bracket clip below the screw.

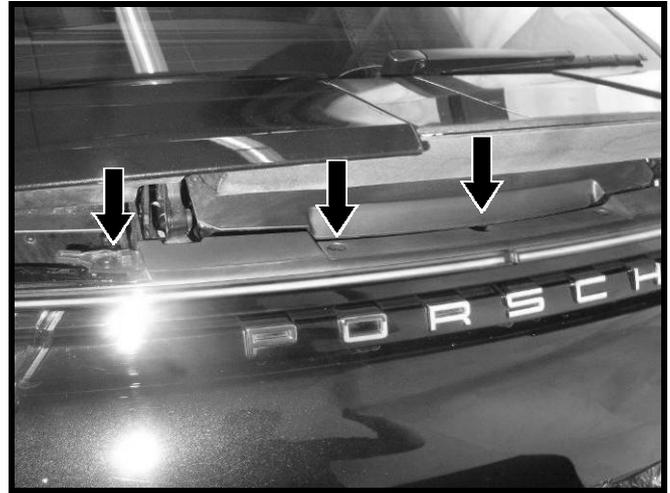


Fig. 46

- 9 Remove the panel with the Porsche-lettering.

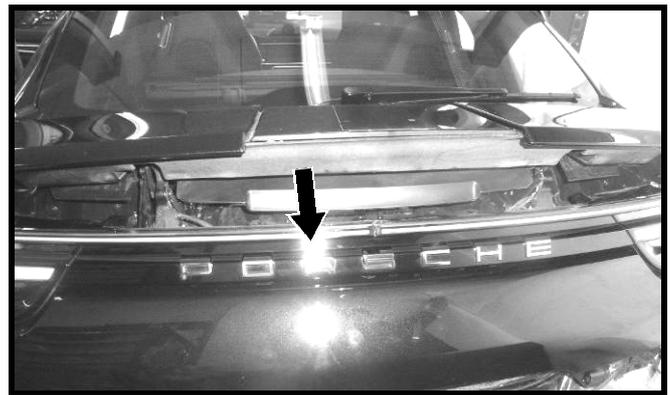


Fig. 47

- 10 Remove the panel at the taillight.
- 11 Untighten the taillights at the tailgate side.

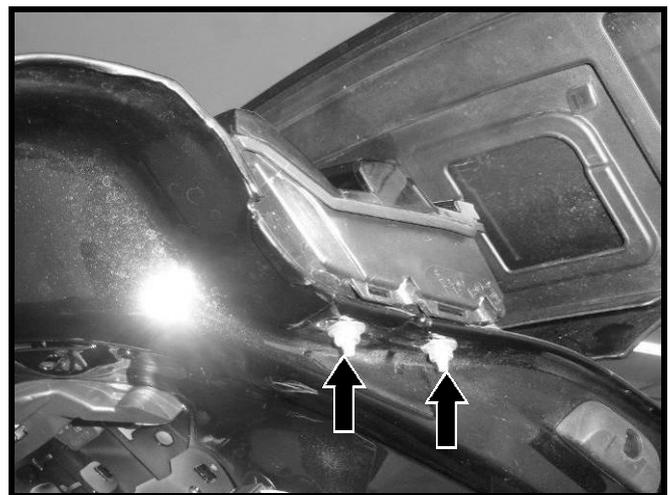


Fig. 48

- 12 Untighten the taillights at the tailgate center.
- 13 Remove taillights, separate the electrical connection and remove it.

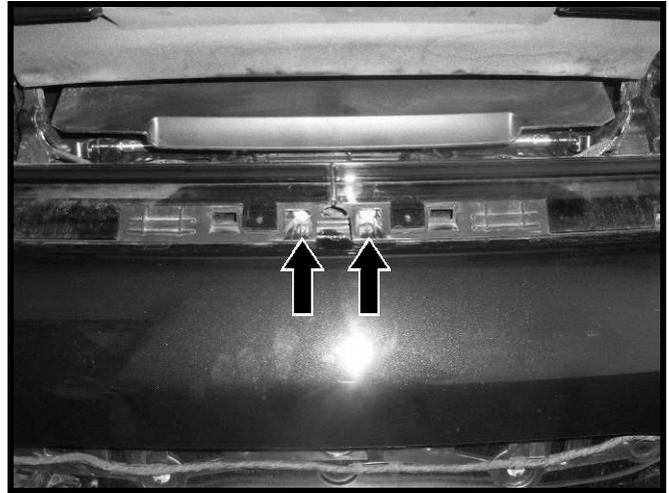


Fig. 49

- 14 Unscrew the rear spoiler and the taillight.

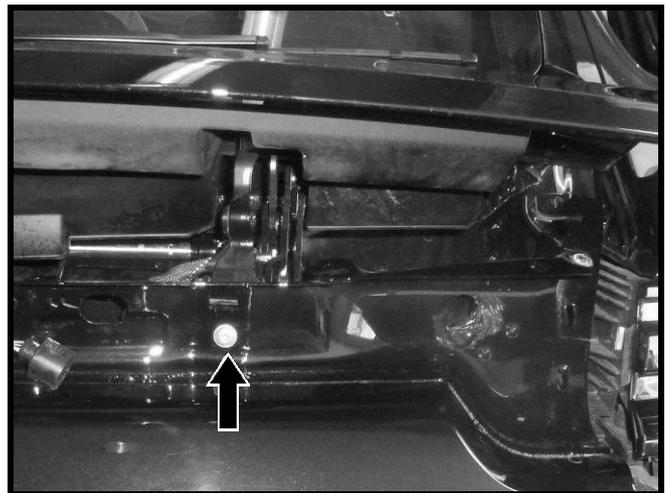


Fig. 50

- 15 Dismantle the tailgate panel, for that:

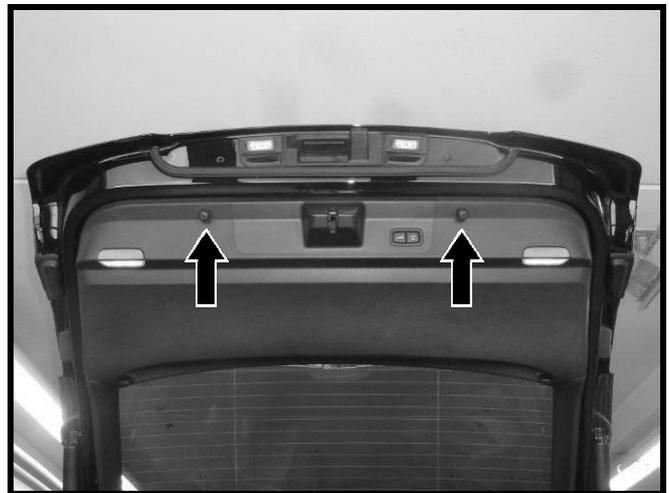


Fig. 51

- 16 Unscrew the stoppers.

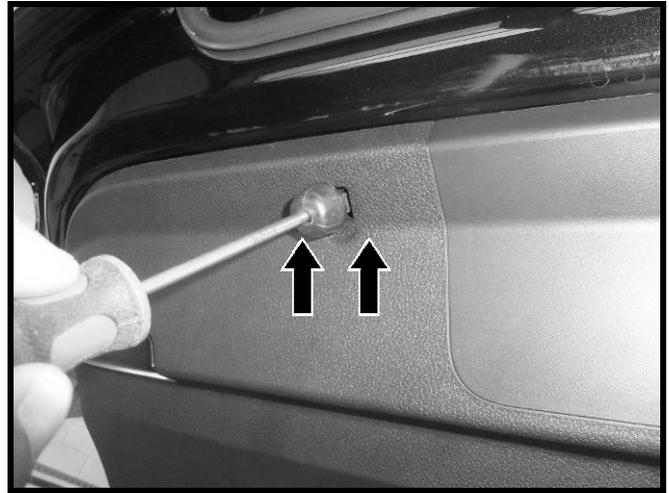


Fig. 52

- 17 Remove the tailgate panel.  
18 Separate the electrical connections.  
19 Remove the tailgate panel entirely.

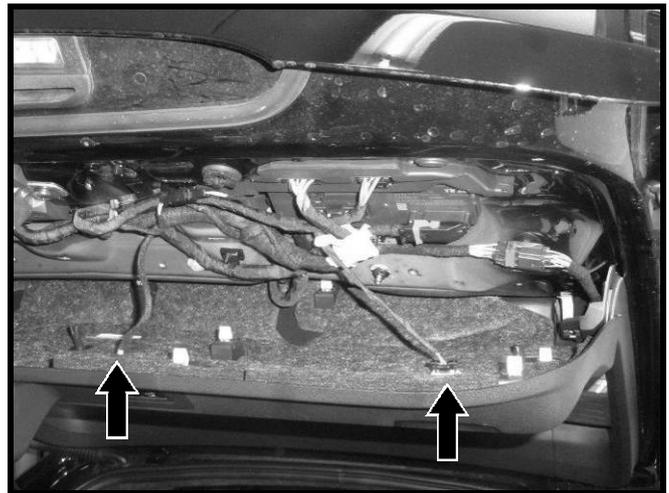


Fig. 53

- 20 Remove the plug from the rear spoiler at the control unit.

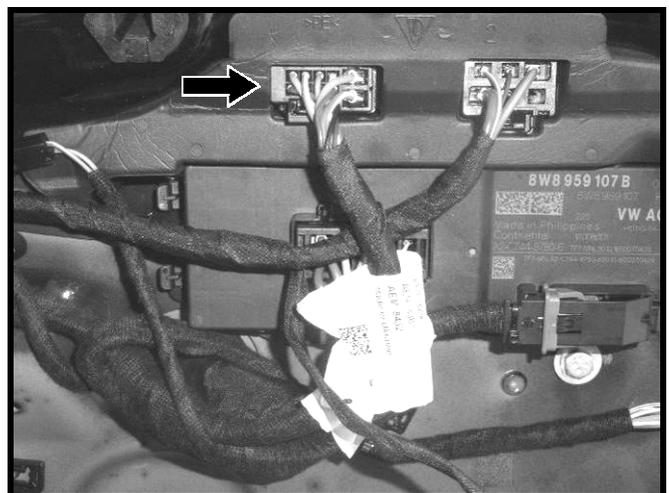


Fig. 54

- 21 To dismantle the tailgate control unit lift both flaps and push the control unit towards the vehicle center.

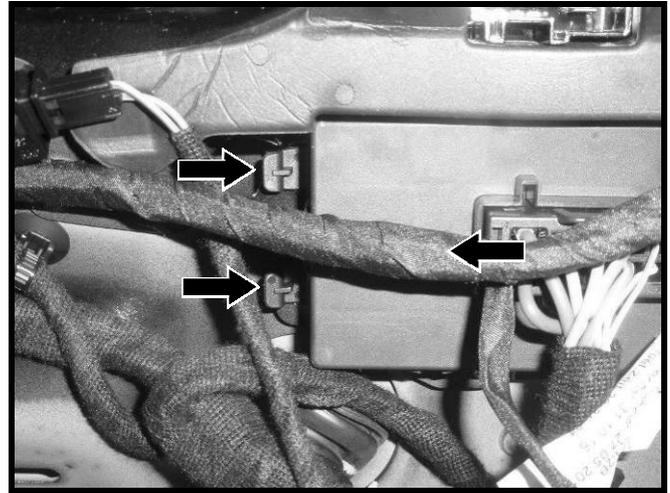


Fig. 55

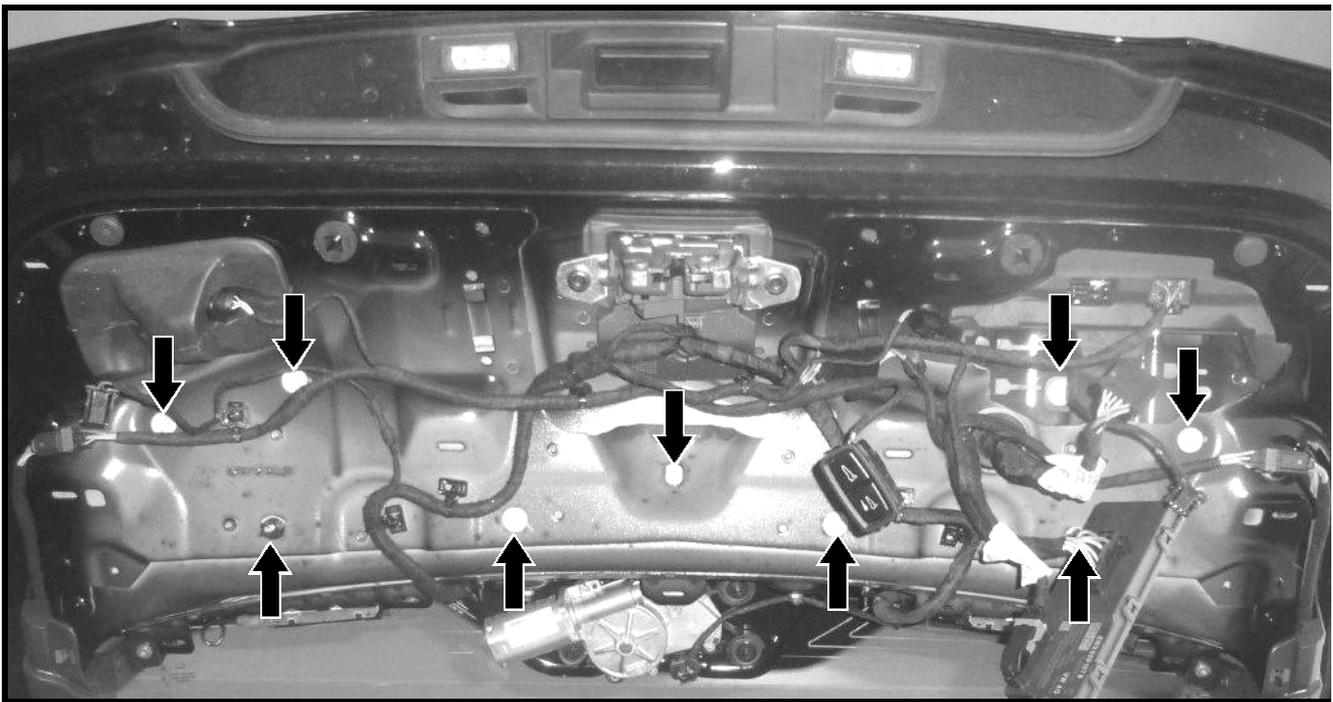


Fig. 56

- 22 Remove all screws and nuts from the rear spoiler.  
23 Remove the rear spoiler completely towards the top.

 **Caution, do not damage the vehicle.**



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### 4.2 Affix the TECHART support strip

- i** The bonding surfaces of the TECHART support strip and tailgate must be dry and free from dust or paint spray mist.

Use a cleaning agent to thoroughly degrease the bonding surfaces of the TECHART support strip and 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.

- 1 Apply PU-adhesive to the bonding surface of the TECHART support strip 071.100.810.200 (26).
- 2 Affix the TECHART support strip into the tailgate.
- 3 Secure TECHART support strip with adhesive tape so that it contacts the surface firmly at all points.

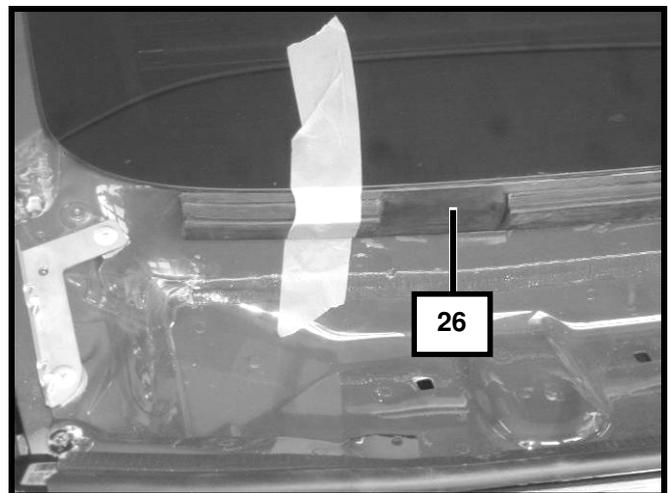


Fig. 57

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

### 4.3 Dismantle the rear spoiler Turbo

- 1 Remove front rear spoiler panel.

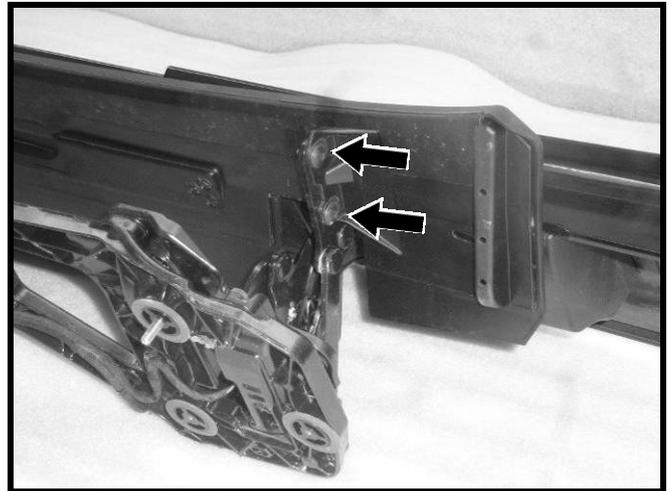


Fig. 58

- 2 Unscrew the bottom cover at the rear spoiler and remove towards the back.

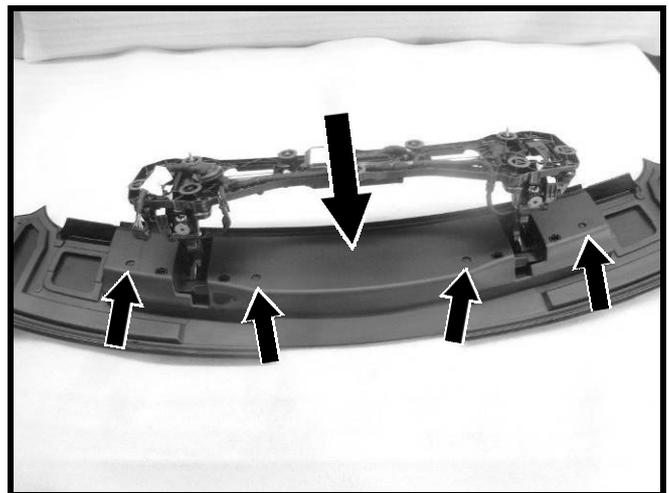


Fig. 59

- 3 Unclip the fuse of the flap-drive shafts and remove the drive shafts from the drive.

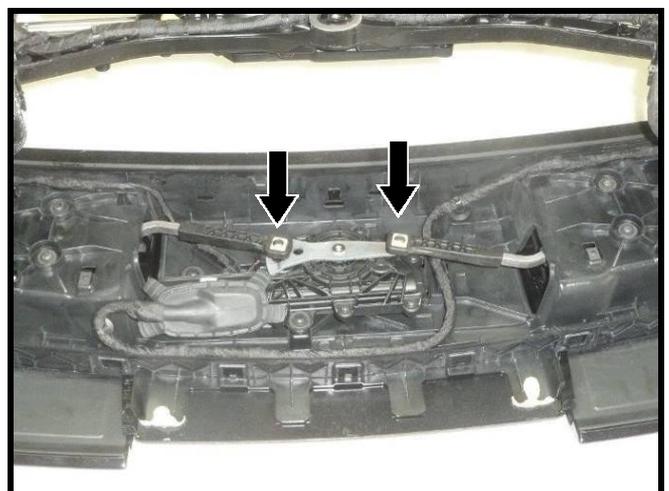


Fig. 60

- 4 Unscrew and remove the flaps.

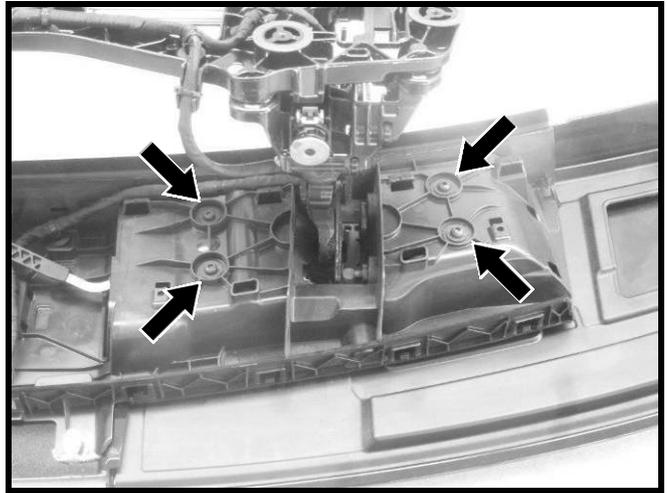


Fig. 61

- 5 Unscrew the center part.

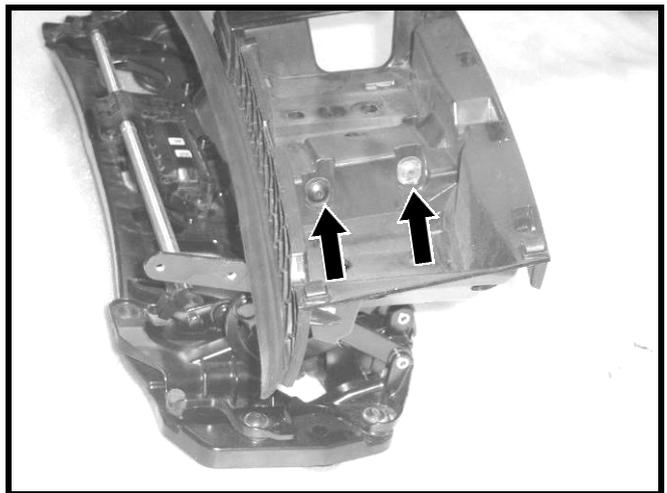


Abb. 62

- 6 Unscrew and remove the drive (flaps) at the center part for that unthread the wiring harness from the center part.

- 7 Remove center part.

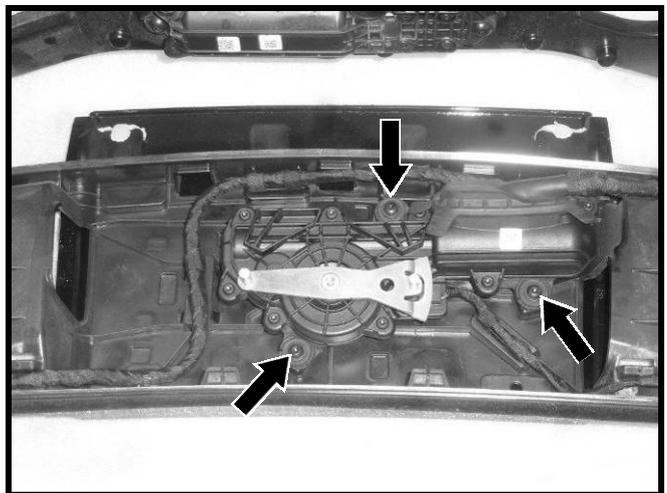


Fig. 63

**i** The original rear spoiler panel front, bottom cover, flaps and center piece are no longer needed.

### 4.4 Dismantle the rear spoiler non-Turbo.

- 1 Dismantle front rear spoiler panel.

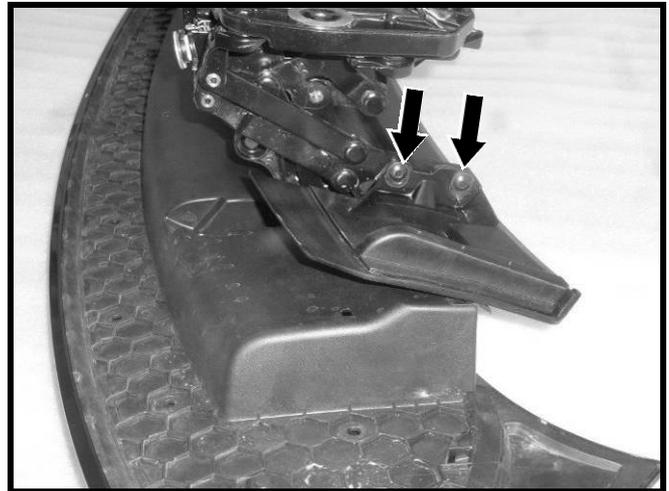


Fig. 64

- 2 Unclip the front panel at the rear spoiler.

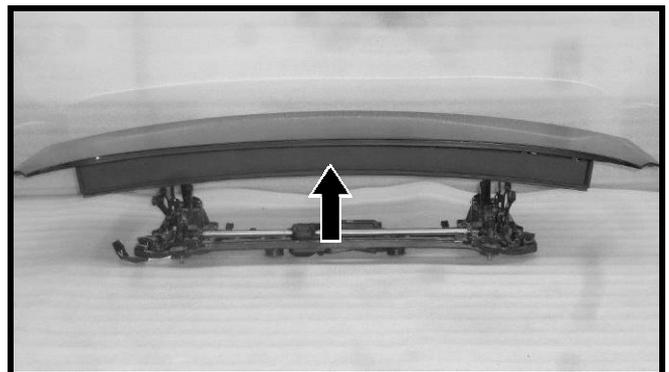


Fig. 65

- 3 Dismantle rear spoiler top part.

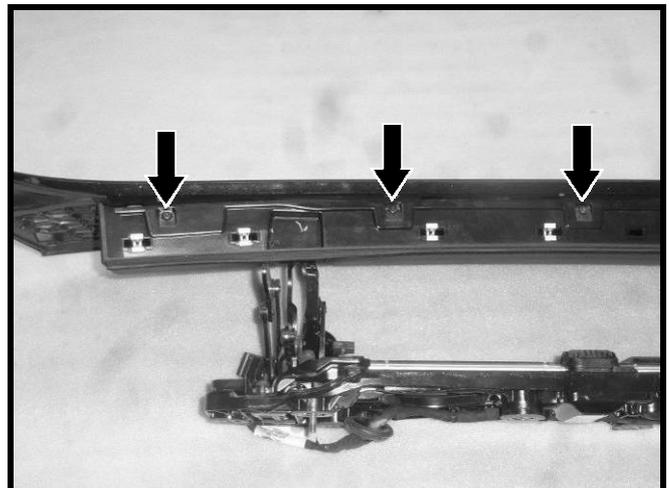


Fig. 66



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 4 Dismantle rear spoiler bottom part.

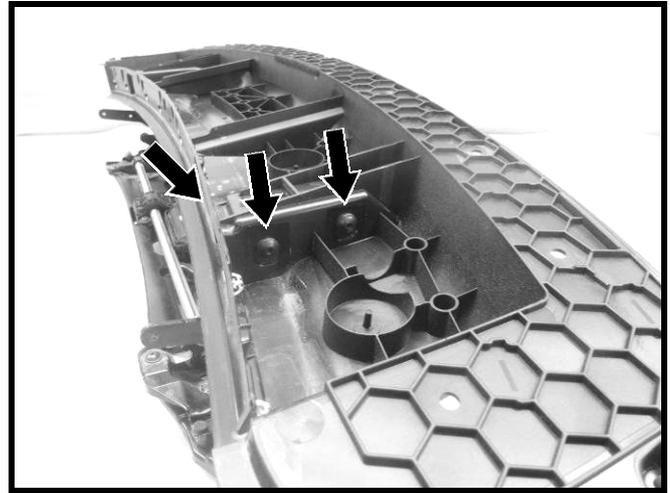


Fig. 67

### 4.5 Modify the mechanism

- 1 Remove 2 circlip on each side from the bolt of the deflection.
- 2 Knock out the bolt with a pin.

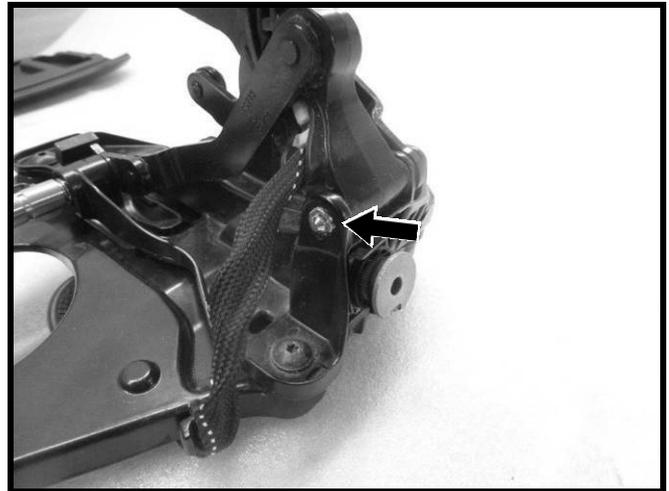


Fig. 68

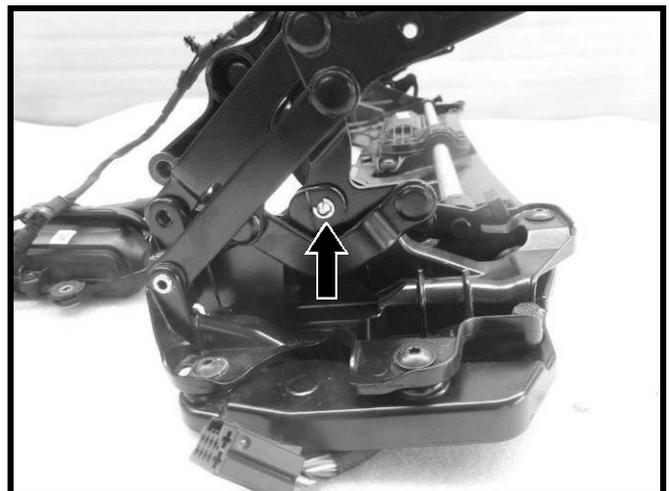


Fig. 69

- 3 Remove one fuse of each side from the bolt of the deflection.
- 4 Press the bolt with a screwdriver out and then remove it.

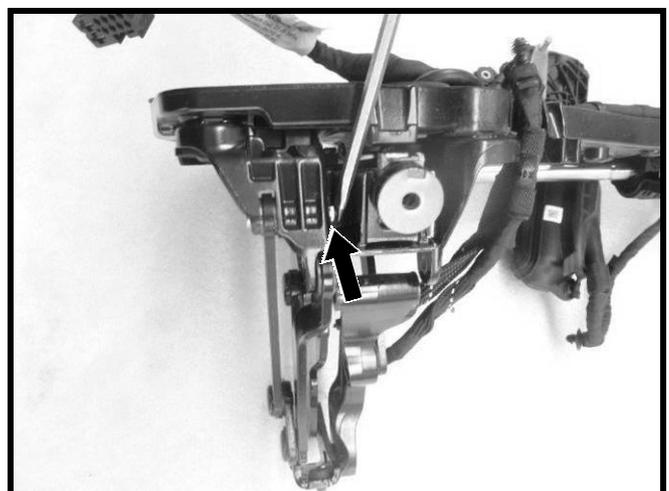


Fig. 70

### For Turbo only:

- 5 Pinch off one wiring harness on each side.

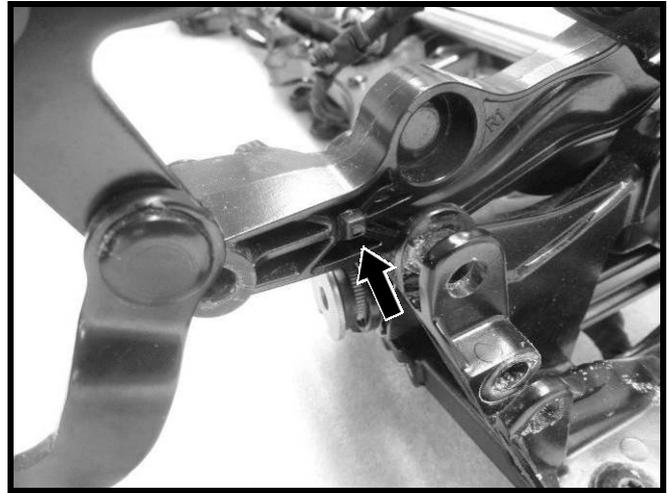


Fig. 71

### For Turbo only:

- 6 Unthread the wiring harness by twisting the deflection.



Fig. 72

- 7 Unscrew the sensor (27) of the mechanism.

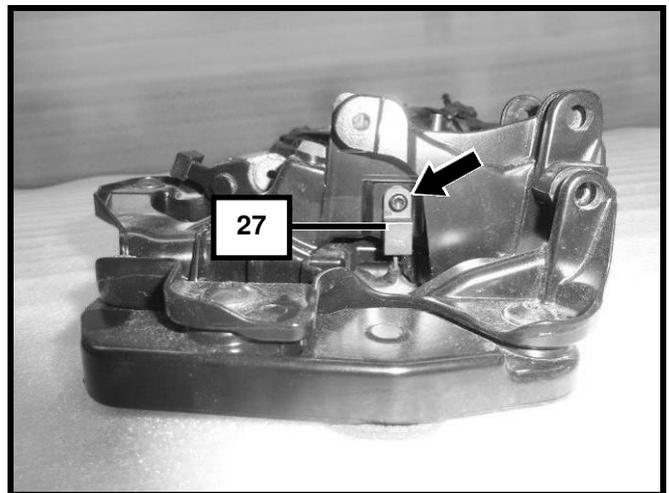


Fig. 73

- 8 Unscrew and remove the left and right mechanism with the drive shaft.
- 9 Separate the deflection from the drive shaft, for that cutoff the bolts.
- 10 Remove the deflection with the drive shaft from the mechanism.

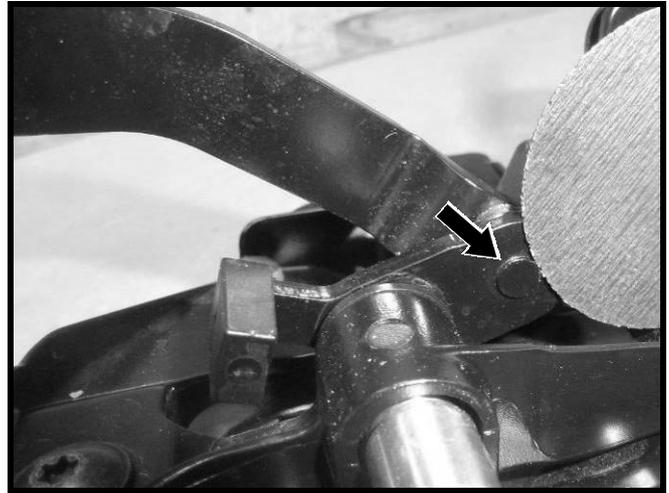


Fig. 74

**i** The original deflections are no longer needed.

- 11 Cutoff the guide pin at the sensor (27).

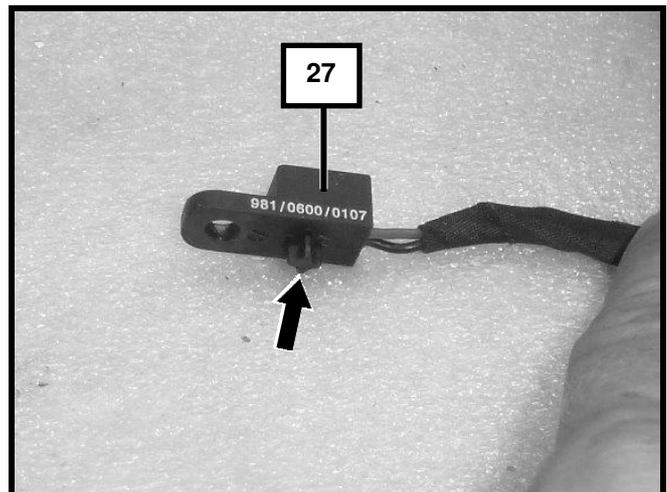


Fig. 75

- 12 Clinch the TECHART metal sheet 071.100.810.500 (28) with the rivet 4x10 to the drive shaft. Clinch left.

**i** Pay attention to the position, see picture.

The rivet has to be inserted from the sheet metal side, see picture.

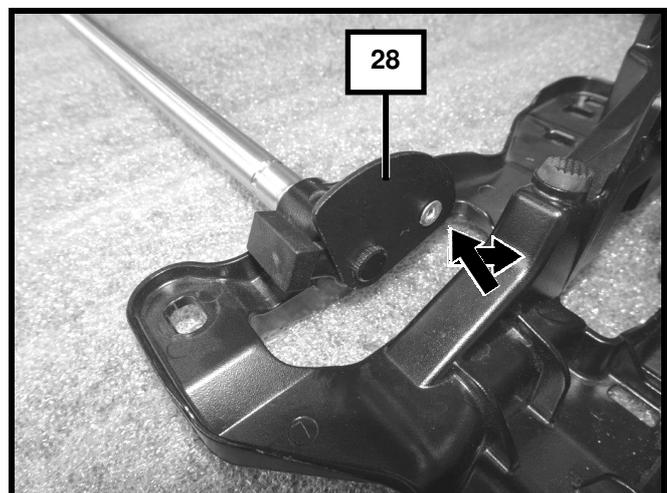


Fig. 76

- 13 Route the sensor, for that unclip the wiring harness.

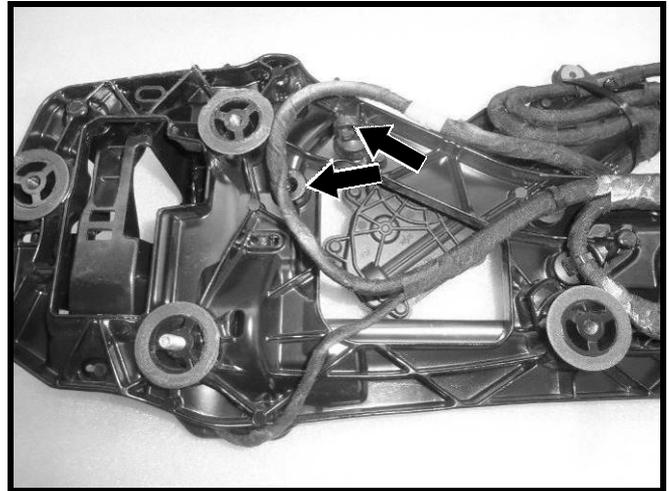


Fig. 77

- 14 Install the left mechanism. Make sure that the sensor (27) is positioned within the left mechanism.

**i** Care that the drive shaft is positioned in the center (distance to the stop left and right and to the stop of the mechanism)

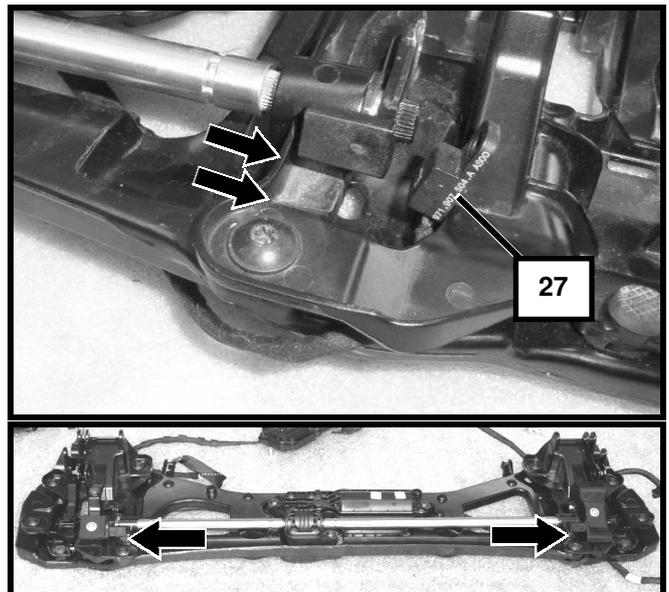


Fig. 78

- 15 Insert the sensor (27) into the TECHART bracket drive shaft L 071.100.810.151 (29) and secure with PU-adhesive.

**i** Make sure that the sensor is flush to the front.

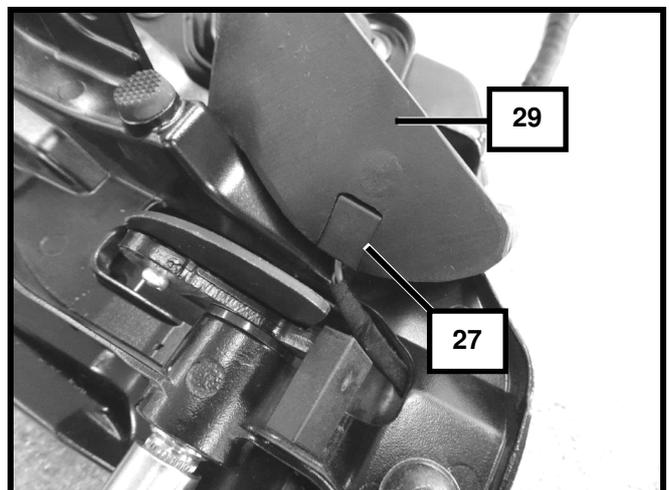


Fig. 79

- 16 Tighten the TECHART bracket drive shaft L (29) with the screw M5x12 to the base frame, for that drill a hole of  $\varnothing$  4.2mm and cut a M5 thread.

**i** Pay attention that the sensor fits perfectly and is not twisted.

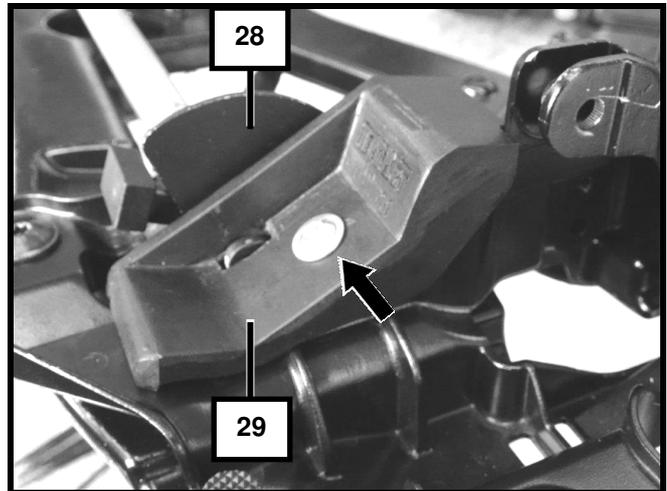


Fig. 80

- 17 Tighten the TECHART bracket drive shaft R (30) with the screw M5x12 to the base frame, for that drill a hole of  $\varnothing$  4.2mm and cut a M5 thread.

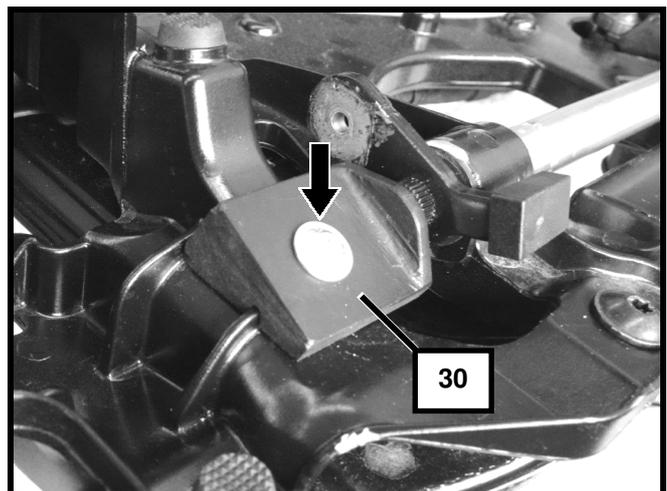


Fig. 81

**i** Care for an accurate fit.  
The bracket drive shaft fits only in one position.

- 18 Remove the adjusting nut towards the bottom.

**i** The adjusting nut is no longer needed.

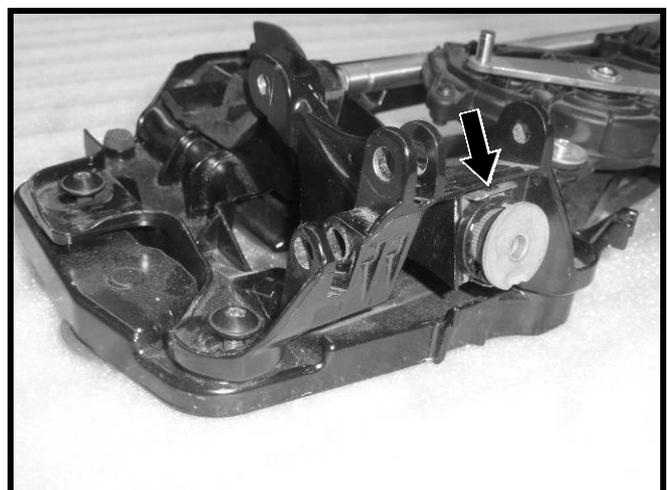


Fig. 82

### For Turbo only:

- 19 Tighten the drive unit (flaps) to the base frame, for that unclip the wiring harness, then drill 2 holes of  $\varnothing$  3.3mm and cut a M4 thread.

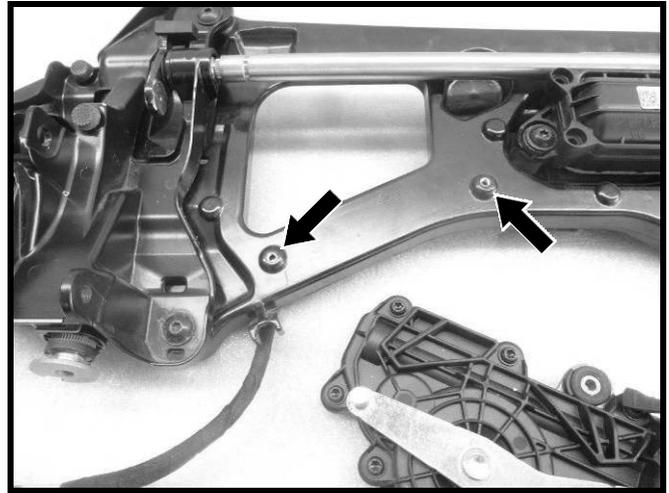


Fig. 83

- 20 Tighten the drive unit (flaps) with the grommets 6.3x16x8 (spacers), the washer M4x20 and the screws M4x25 to the base frame.

- 21 Secure the cables with cable ties.

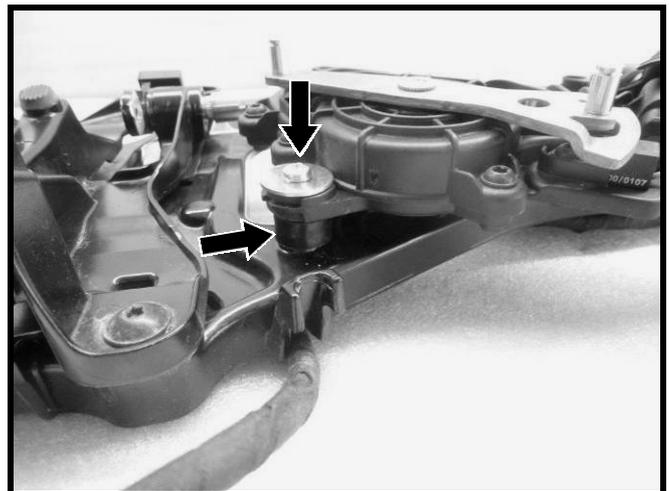


Fig. 84

### 4.6 Install TECHART rear spoiler II

- 1 Modify tailgate metal sheet.
- 2 Cutoff the marked part.

**i** Clean the cut area and protect from corrosion.

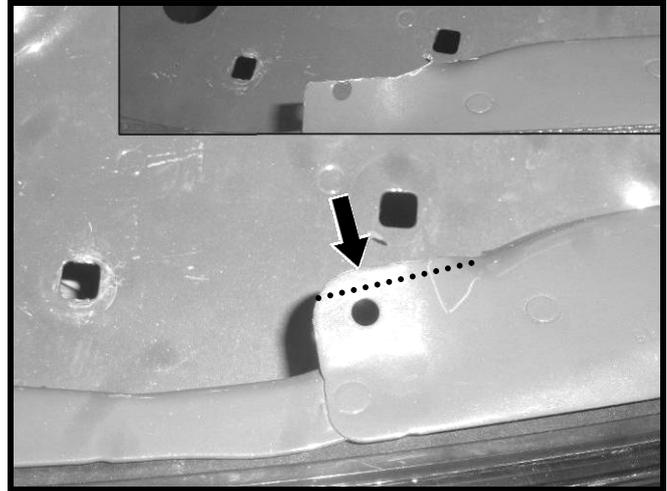


Fig. 85

- 3 Clinch the TECHART angle bracket R + L 071.100.810.11\_ (31) with the rivets 4.8x10 into the tailgate.  
Attach on the top to the original flap and on the bottom to the inside of the angle of bend at the metal sheet and then drill a hole of  $\varnothing$  5mm.

**i** Clean the cut area and protect from corrosion.

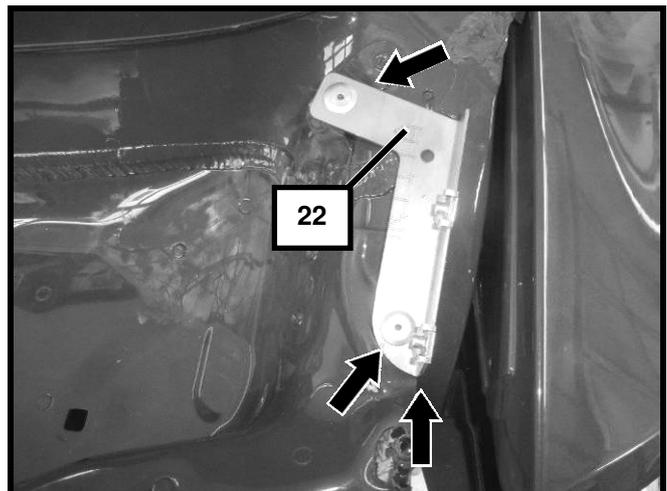


Fig. 86

- 4 Attach the metal sheet M5 to the TECHART angle bracket R + L (31).

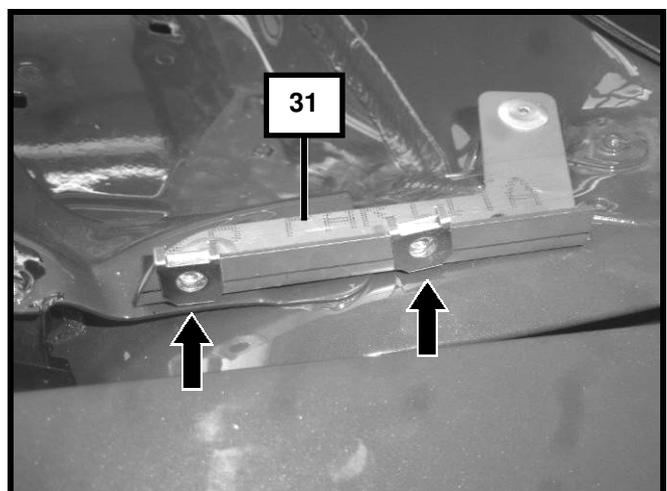


Fig. 87

# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 5 Tighten the TECHART base plate 091.100.810.222/3 (32) with the screws M8x100, TECHART bracket support top 071.100.810.130/1 (33) and the nuts M8 self-locking to the TECHART base frame 071.100.810.100 (34).

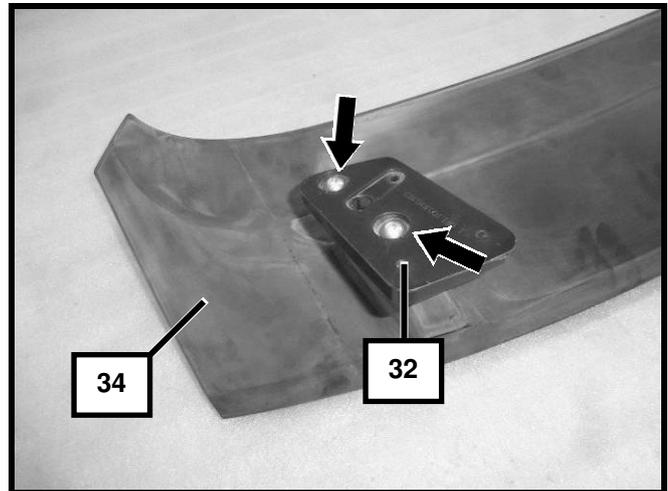


Fig. 88

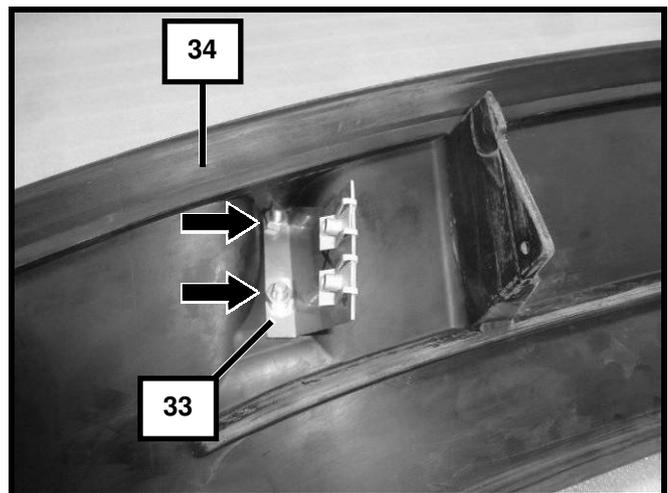


Fig. 89

- 6 Fasten the TECHART bracket support bottom (35) with the original screws to the mechanism.

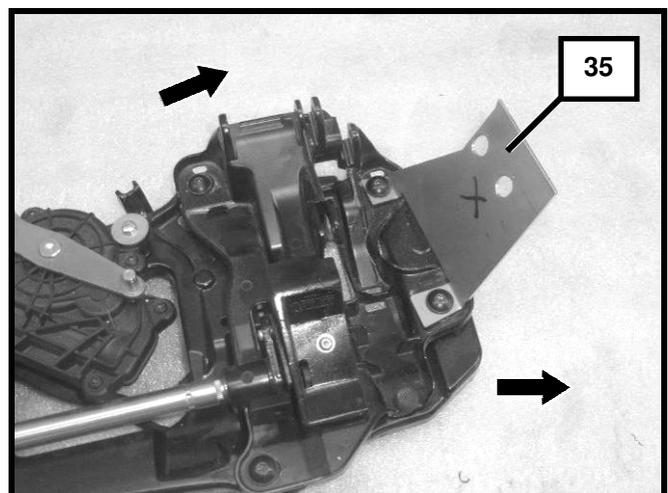


Fig. 90



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 7 Attach the TECHART base frame (34) to the mechanism.
- 8 Attach the TECHART base frame with the screws M8x25 and the nuts M8 self-locking to the rear of the mechanism, but do not tighten yet.

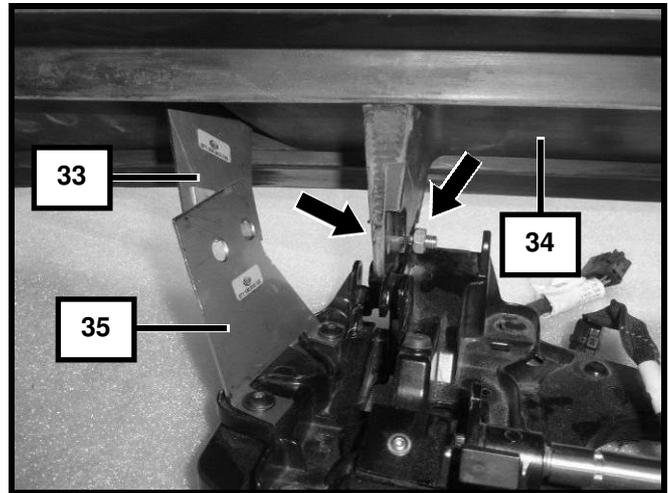


Fig. 91

- 9 Attach the TECHART base frame (34) with the screws M5x20 and the nuts with the washers M5 at the front of the mechanism, but do not tighten yet. The nut with the washer is between both bars of the mechanism.

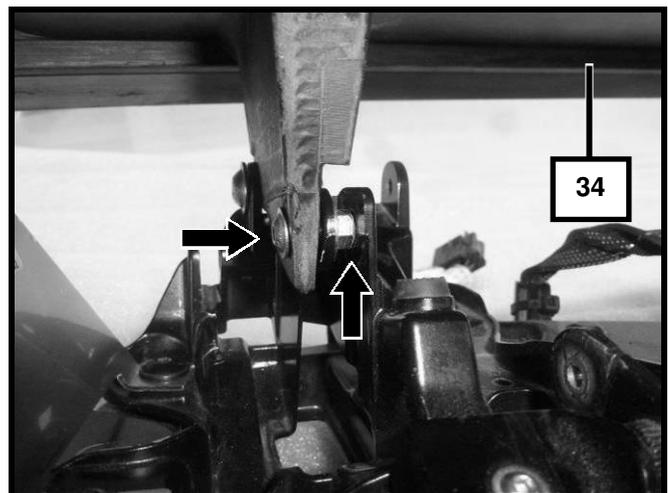


Fig. 92

- 10 Attach the speed nut M6 to the TECHART bracket top (33).
- 11 Tighten the TECHART bracket support top (33) and the TECHART bracket support bottom (35) with the screws M6x12.

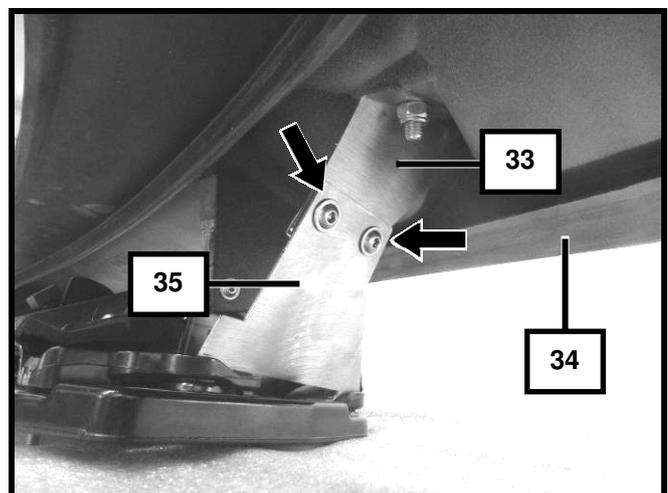


Fig. 93



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 12 Tighten the TECHART wing profile 091.1\_\_810.200 (36) with the screws M5x16 to the TECHART base plate long (32).
- 13 Tighten all screws M5, M6 and M8 to the TECHART base frame (34), mechanism and TECHART bracket support.

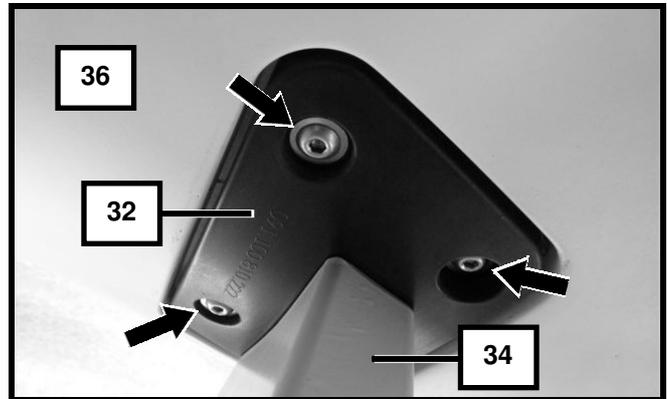


Fig. 94

- 14 Insert the 4 rubber stops 097.100.880.250 (37) bottom into the TECHART base frame.

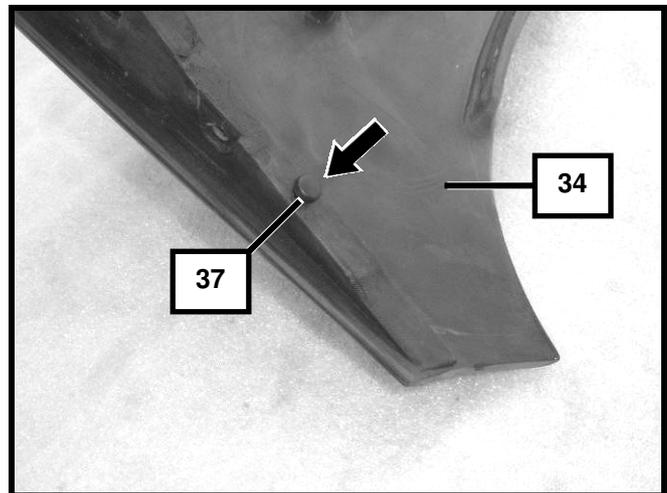


Fig. 95

- 15 Attach the weather strip straight 096100820960 to the tailgate.
- 16 Install the taillights to the tailgate side.
- 17 Install the panel with the Porsche-lettering.

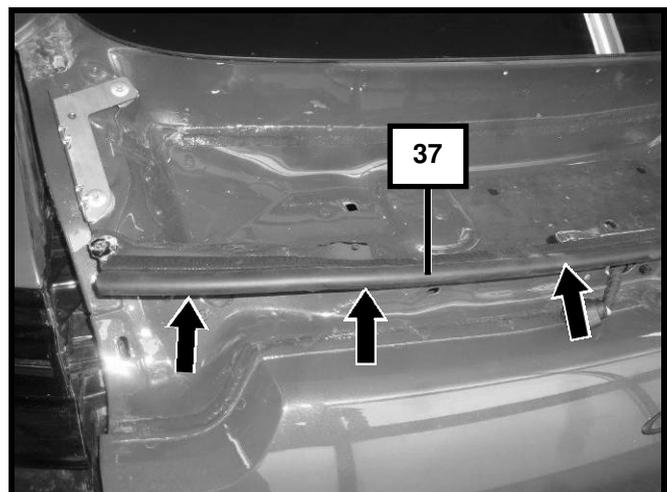


Fig. 96



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

- 18 Thread the TECHART rear spoiler with the mechanism into the tailgate and fasten with the original screws und the nuts to the mechanism.

**i** Care for an accurate fit.

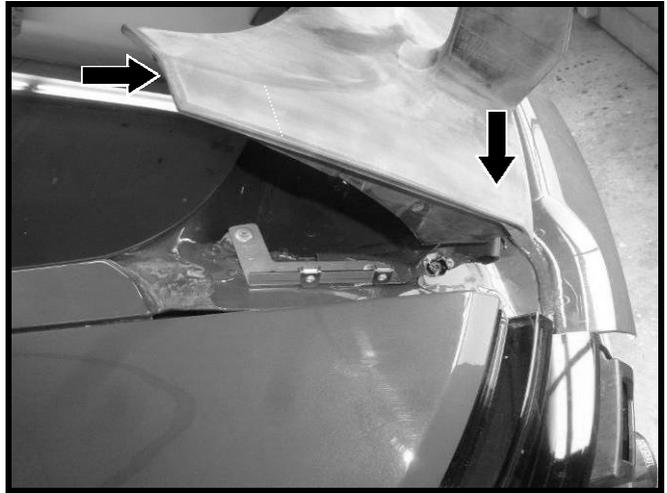


Fig. 97

- 19 Tighten the TECHART base frame (34) right and left with the screws M5x12 to the TECHART angle bracket (31).

**i** Care for an accurate fit.

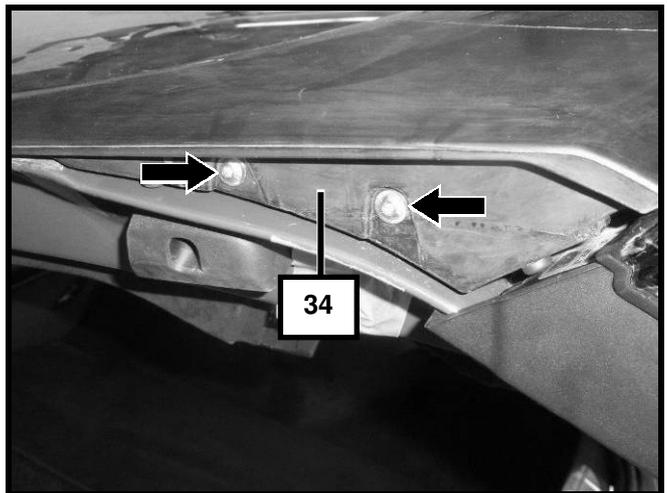


Fig. 98

- 20 Install tailgate control unit.  
21 Insert the plug of the rear spoiler to the control unit.  
22 Install tailgate panel.



# ASSEMBLY INSTRUCTIONS

## TECHART Aero-Kit for Panamera from MY17

### 5 Perform final work on vehicle

#### 5.1 Final check

- 1 Perform a general function check on vehicle.
- 2 Calibrate the sensors on vehicles with ACC.

**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.

### 6 Tightening torques

Location	Description	Type	Basic value
Wheel on wheel hub	M 14 x 1.5	Tightening torque	160 Nm



# ASSEMBLY INSTRUCTIONS

**TECHART Aero-Kit for Panamera from MY17**



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