



## Workshop Manual

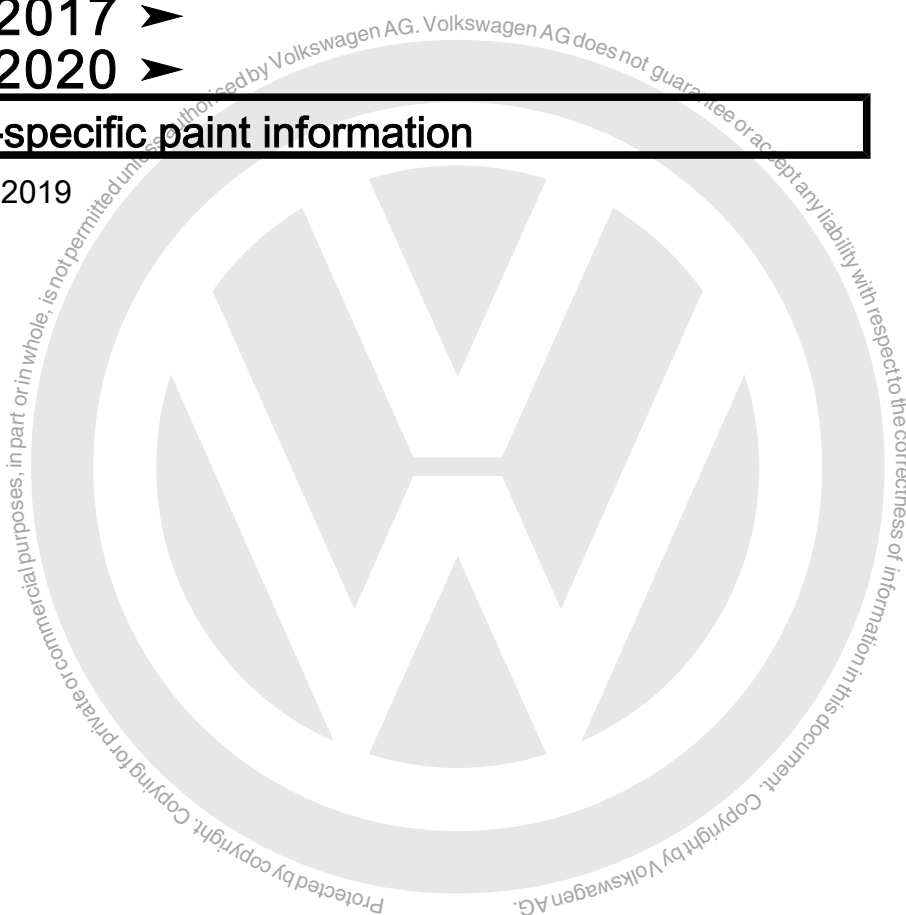
e-up! 2014 ➤

e-up! 2017 ➤

e-up! 2020 ➤

### Vehicle-specific paint information

Edition 10.2019





## List of Workshop Manual Repair Groups

### Repair Group

00 - Technical data

Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.

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## 00 – Technical data

### 1 Explanation of symbols

(VRL012655; Edition 10.2019)

⇒ [“1.1 Sanding”, page 1](#)

⇒ [“1.2 Seam sealing”, page 1](#)

⇒ [“1.3 Cavity sealing”, page 3](#)

#### 1.1 Sanding

**Avoid sanding through to substrate**

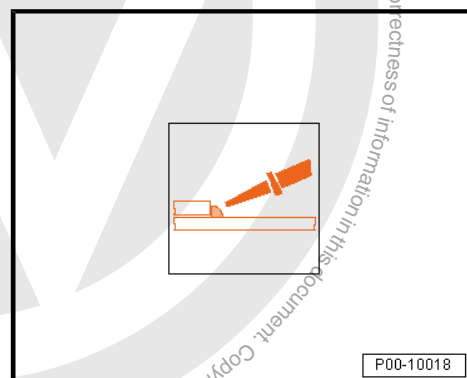
- It is recommended to carefully sand the marked area by hand to avoid “sanding through” the cathodic dip primer.



#### 1.2 Seam sealing

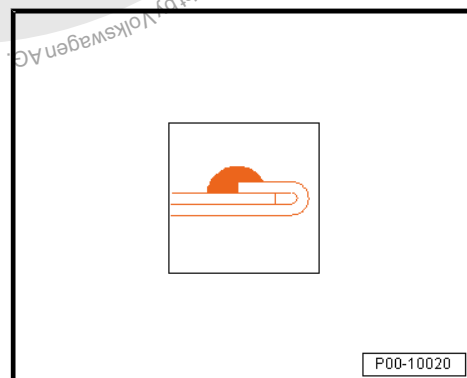
**Sealing**

- Apply sealant.



**Fine seam sealing**

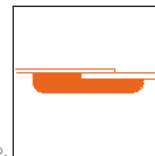
- Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.





### Coarse seam sealing

- Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



P00-10102

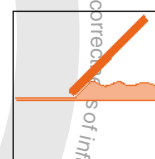
### Smoothing seals

- Sealant in the marked areas must be smoothed following application.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*



P00-10019

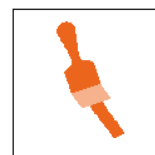
### Brushing seals

- Sealant in the marked areas must be brushed following application.



#### Note

*When brushing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed and that the metal is covered with a sufficiently thick layer of PVC.*



P00-10103

### Sealing the folded seam groove

- The marked areas must be closed following application of sealant to the folded seam groove.



#### Note

*When brushing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC so that the groove in the folded seam remains closed.*



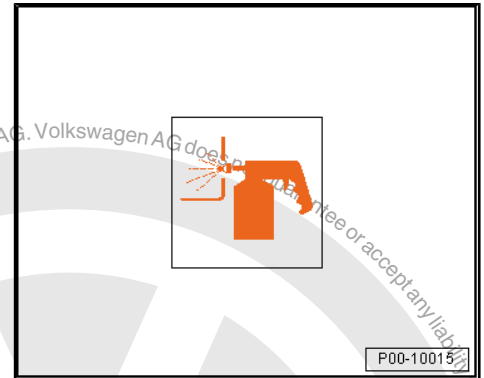
P00-10021



## 1.3 Cavity sealing

### Sealing cavities

- The marked areas must be sealed following body repair.





## 2 Paintwork structure

⇒ ["2.1 Structure of factory finish, cathodic dip primer", page 4](#)

⇒ ["2.2 Structure of factory finish, undercoat", page 5](#)

⇒ ["2.3 Structure of factory finish, base coat", page 6](#)

⇒ ["2.4 Structure of factory finish, clear coat", page 12](#)

### 2.1 Structure of factory finish, cathodic dip primer

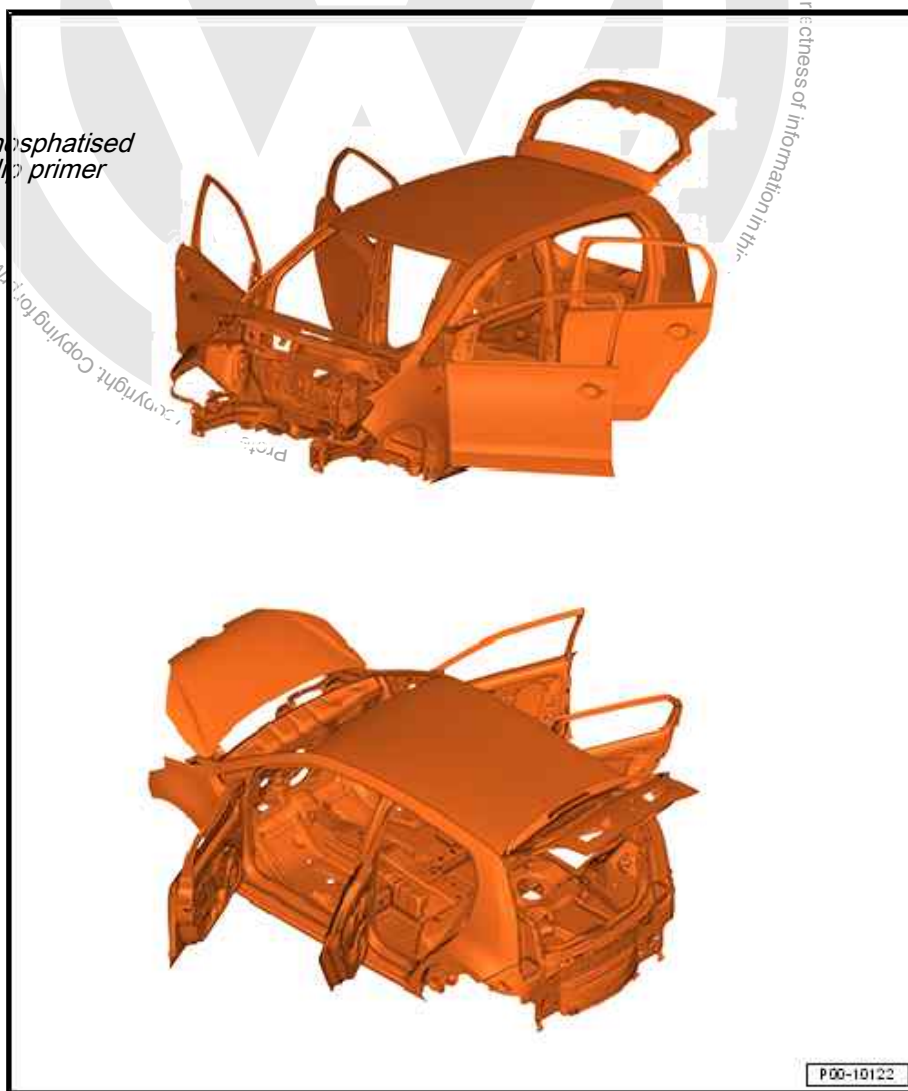
Cathodic dip primer, 4-door

- Cathodic dip primer



Note

*The body in white is phosphatised  
beneath the cathodic dip primer*



P00-10122





## 2.2 Structure of factory finish, undercoat

### Undercoat, 4-door model

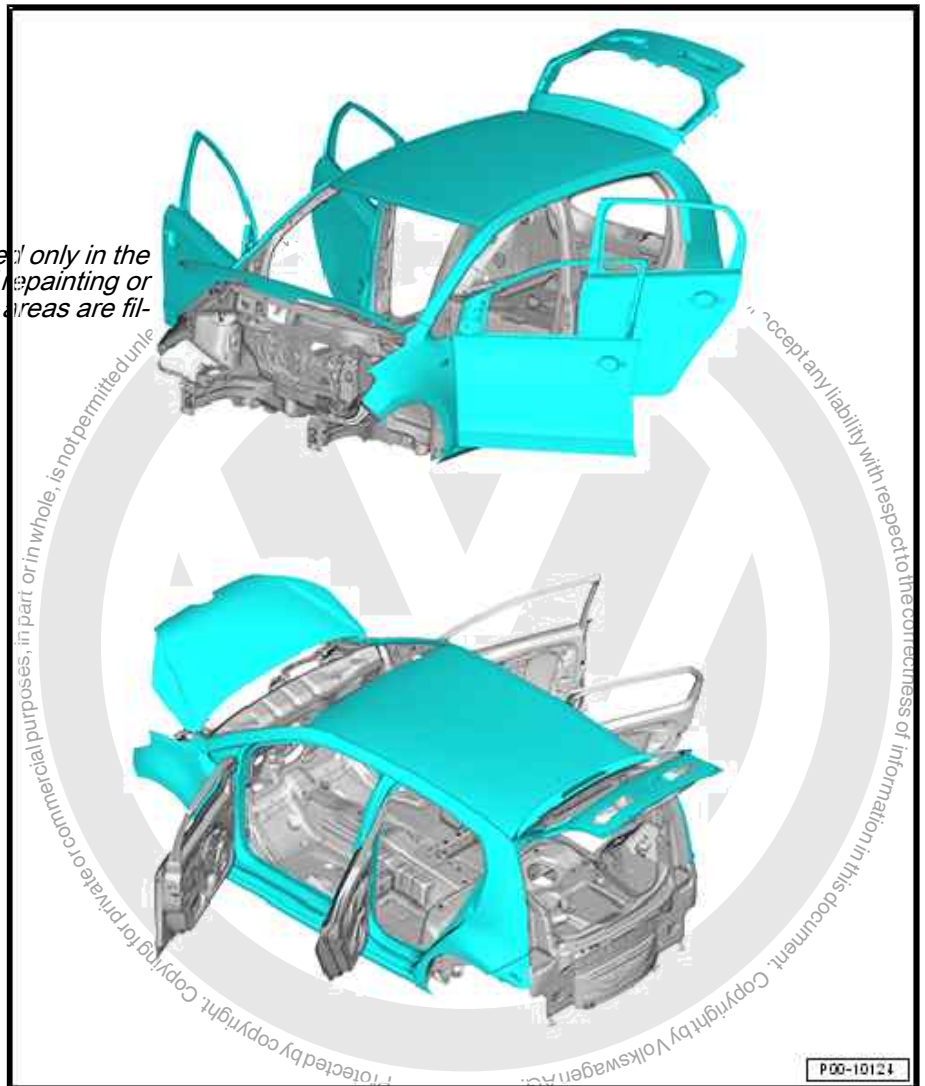
#### - Undercoat

- ❑ The areas of the body shown in colour are undercoated only for certain paint colours.



#### Note

*The undercoat is applied only in the factory. In the event of repainting or repair, these parts and areas are filled.*



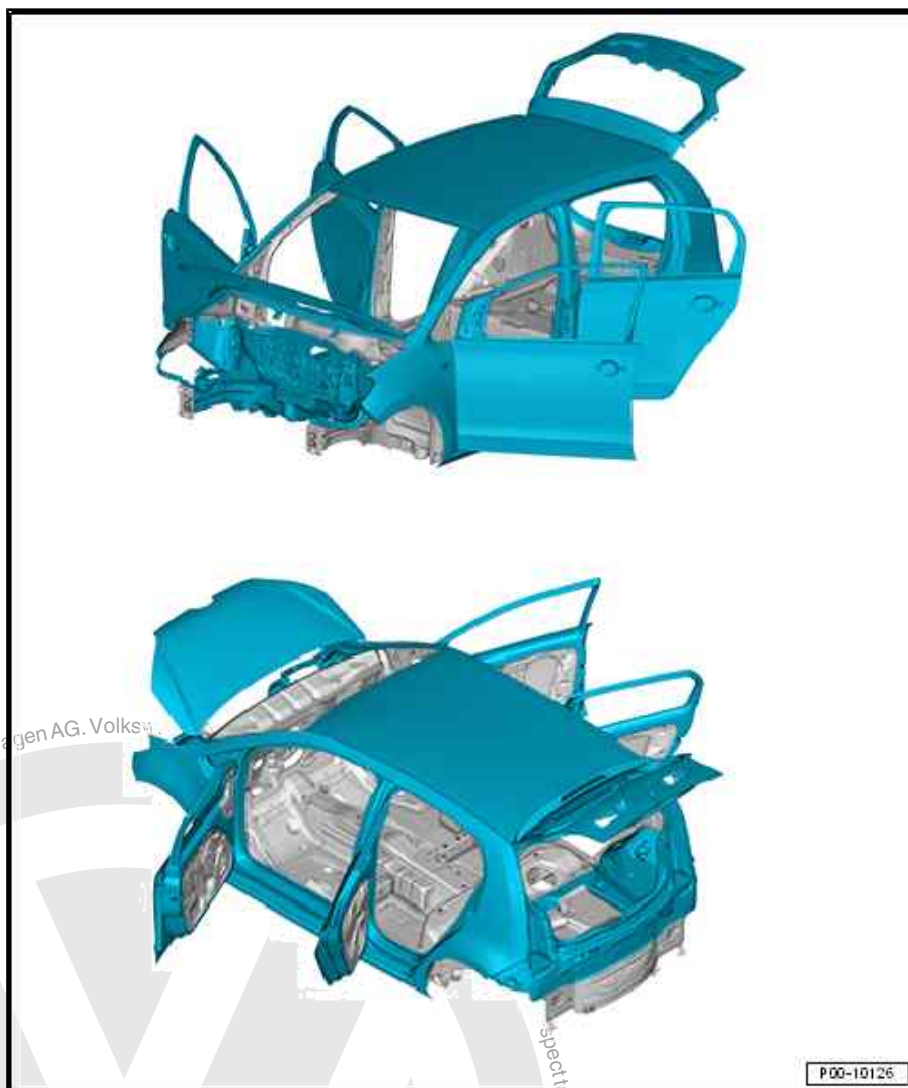


## 2.3 Structure of factory finish, base coat

### Base coat, 4-door model

#### - Base coat

- ☐ Only the coloured areas of the body receive a base coat.

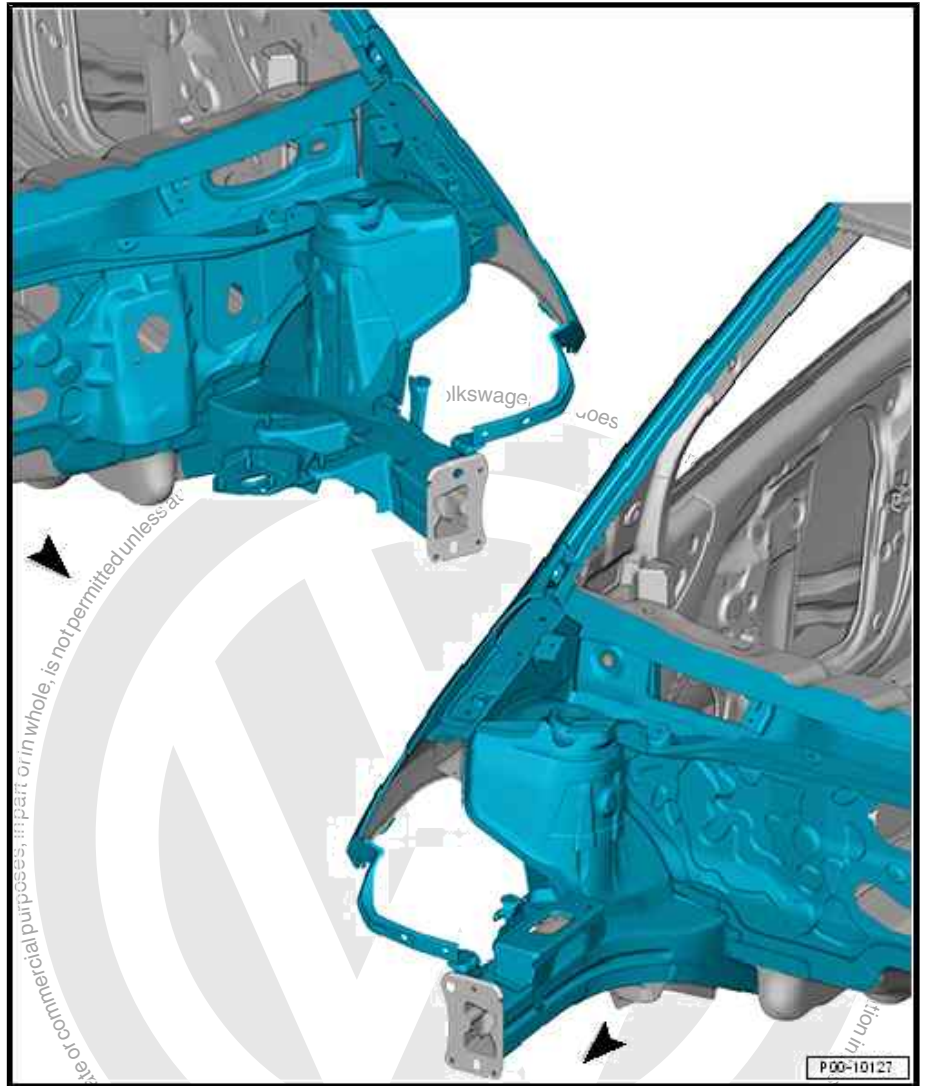


### Base coat, front body



**- Base coat**

- ❑ Only the coloured areas of the body receive a base coat.



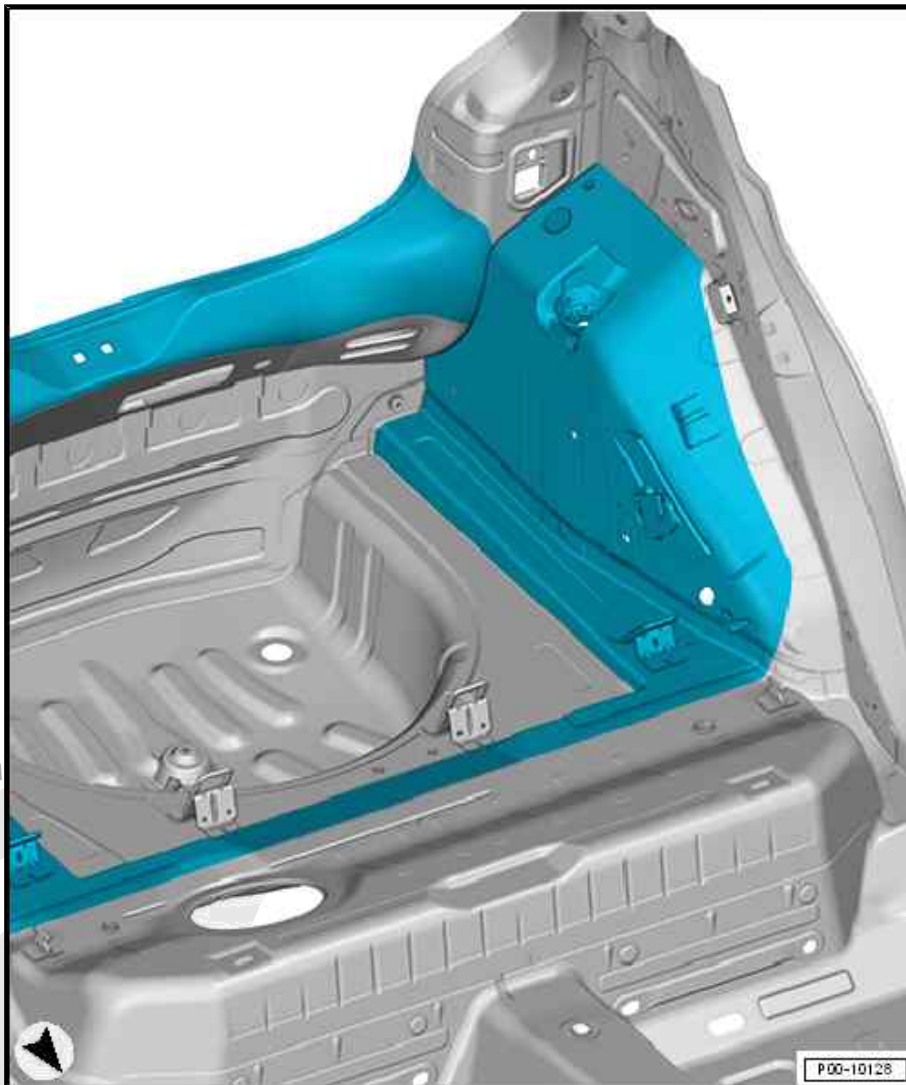
**Base coat, luggage compartment**

Illustration shows left side. The right side is the mirror image.



**- Base coat**

- ☐ Only the coloured areas of the body receive a base coat.

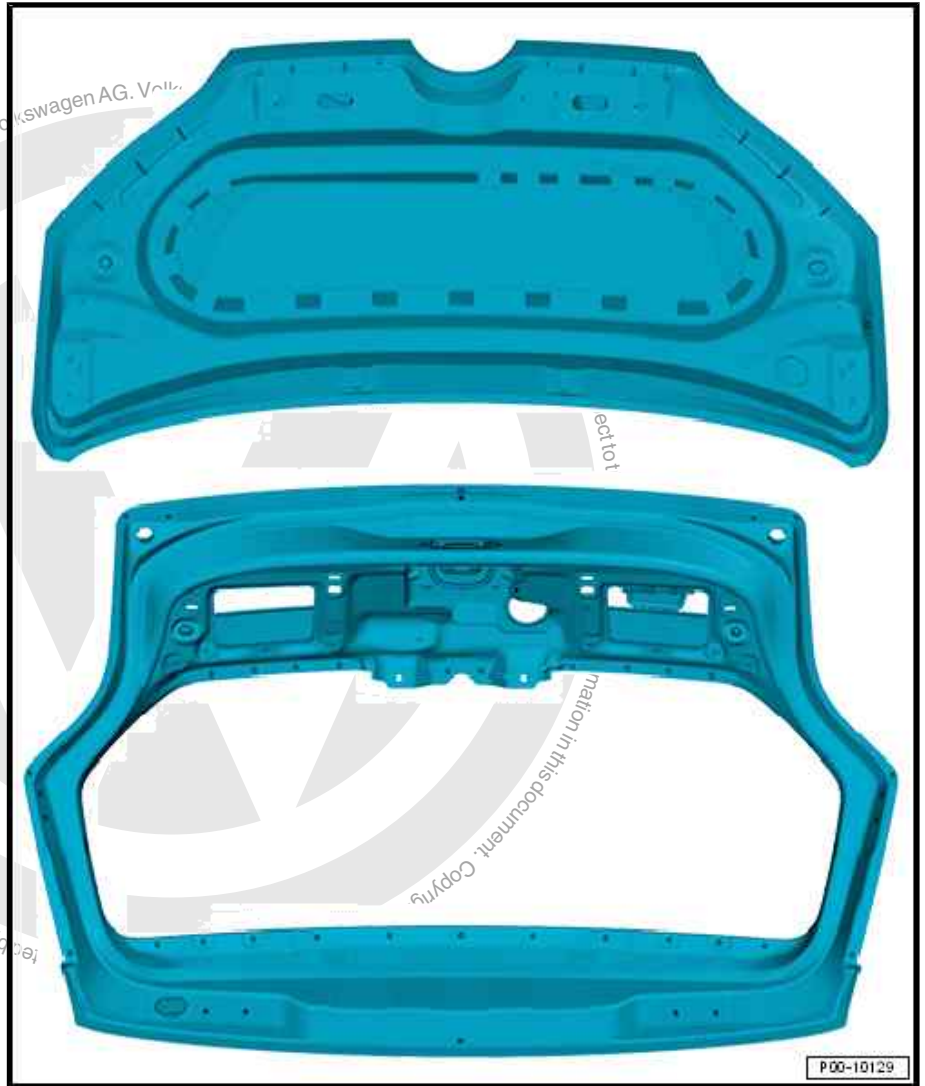


**Base coat, bonnet and rear lid**



**- Base coat**

- ❑ Only the coloured areas of the body receive a base coat.



**Base coat, front door of 4-door**

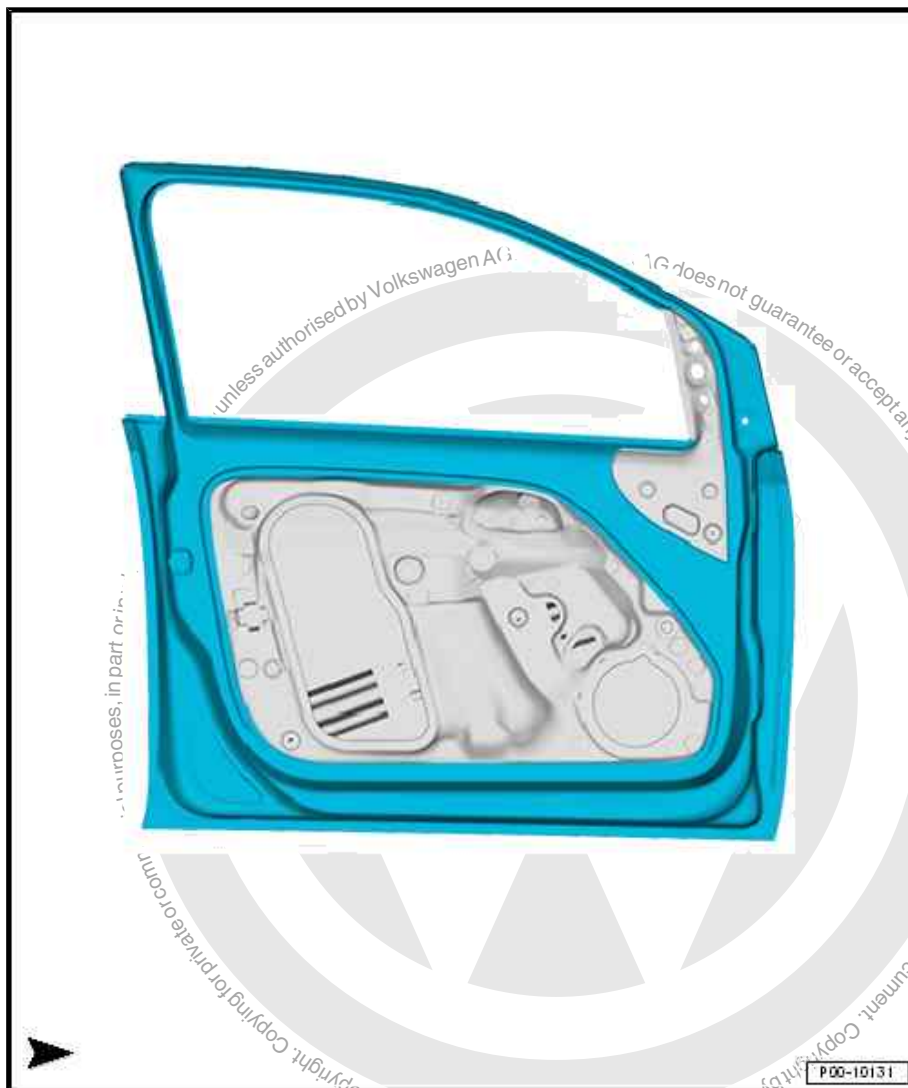
Illustration shows left side. The right side is the mirror image.





**- Base coat**

- ☐ Only the coloured areas of the body receive a base coat.



**Base coat, rear door of 4-door**

Illustration shows left side. The right side is the mirror image.



**- Base coat**

- ☐ Only the coloured areas of the body receive a base coat.



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## 2.4 Structure of factory finish, clear coat

### Clear coat, 4-door model

#### - Clear coat

- ☐ Only the coloured areas of the body receive a clear coat.



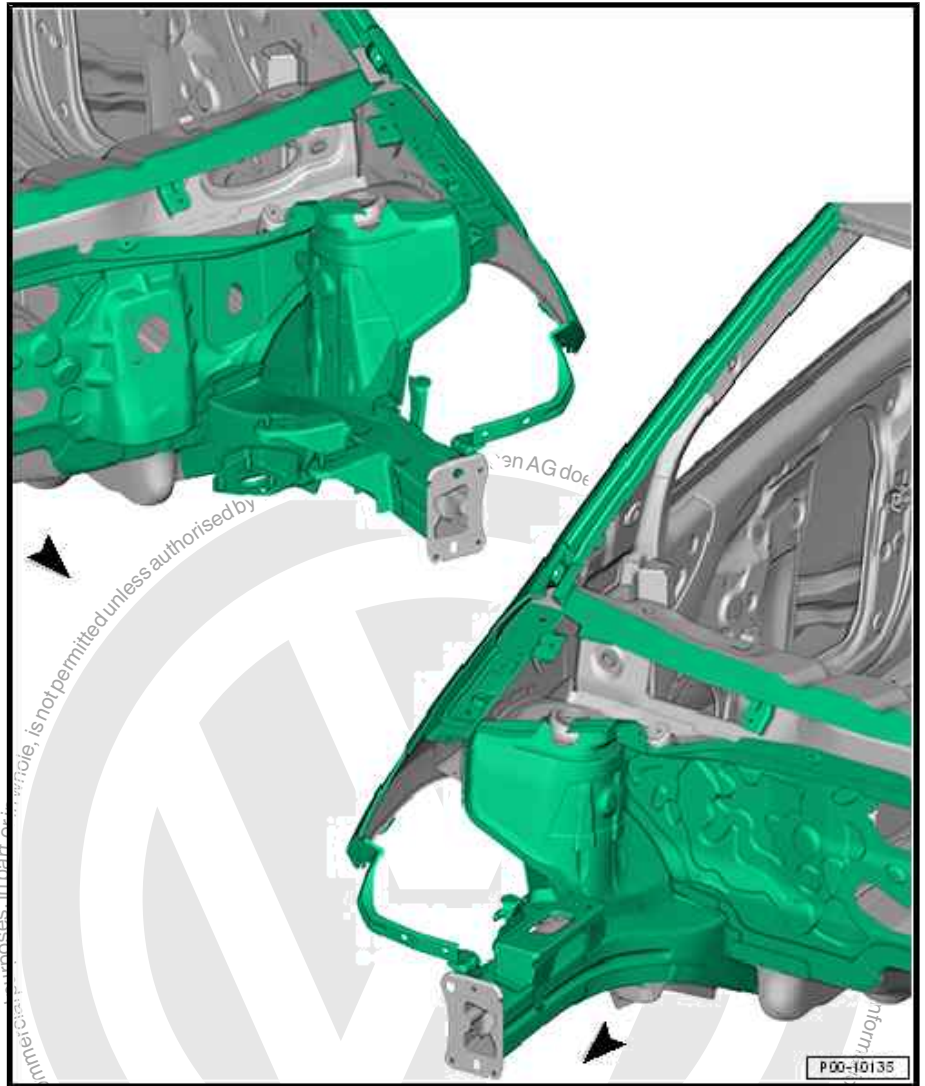
### Clear coat, front body





**- Clear coat**

- ☐ Only the coloured areas of the body receive a clear coat.

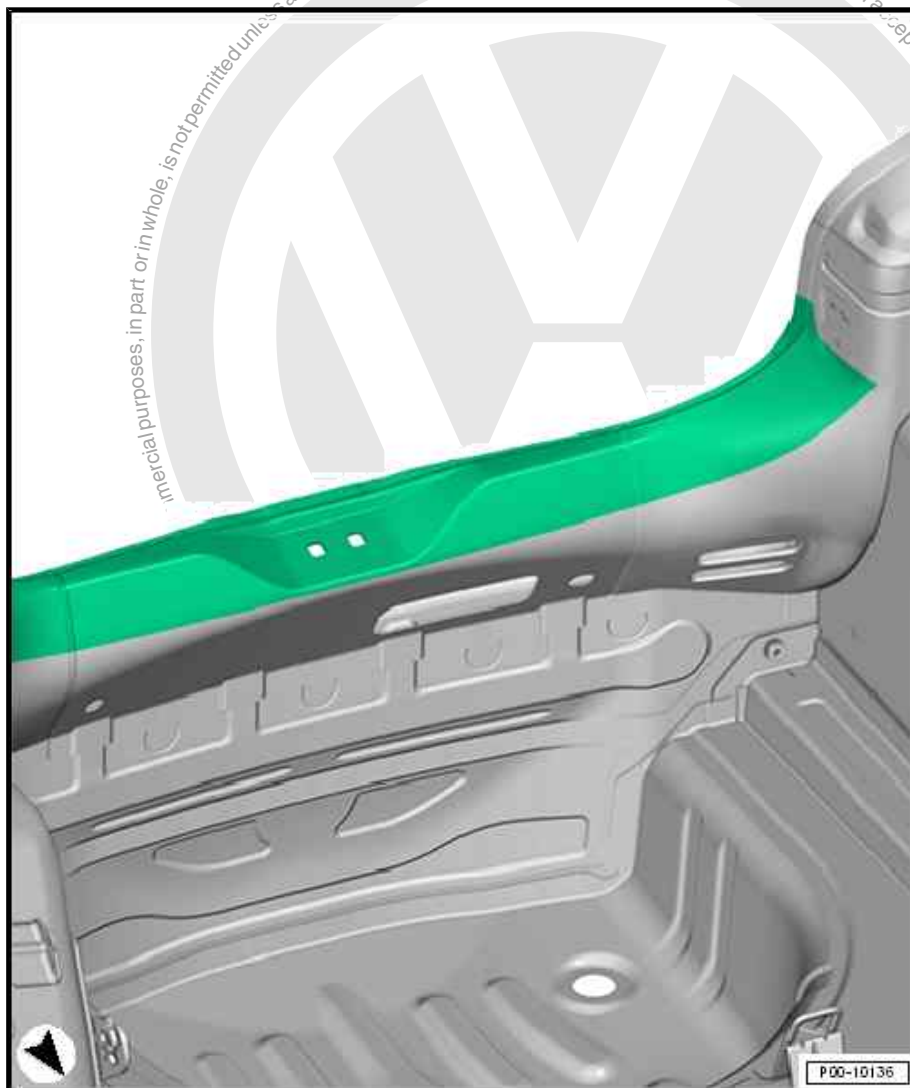


**Clear coat, luggage compartment**



- Clear coat

- ☐ Only the coloured areas of the body receive a clear coat.

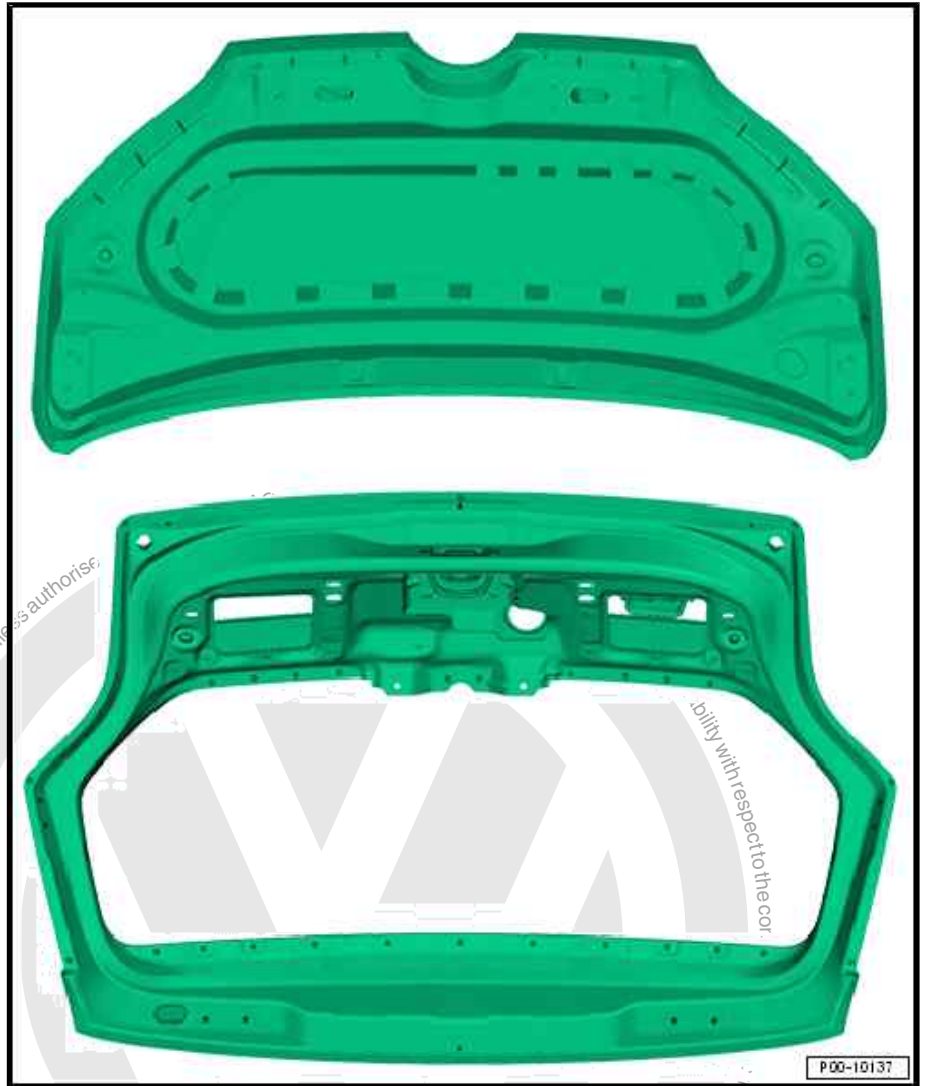


Clear coat, bonnet and rear lid



**- Clear coat**

- ☐ Only the coloured areas of the body receive a clear coat.



**Clear coat, front door of 4-door**

Illustration shows left side. The right side is the mirror image.



- **Clear coat**

- ☐ Only the coloured areas of the body receive a clear coat.



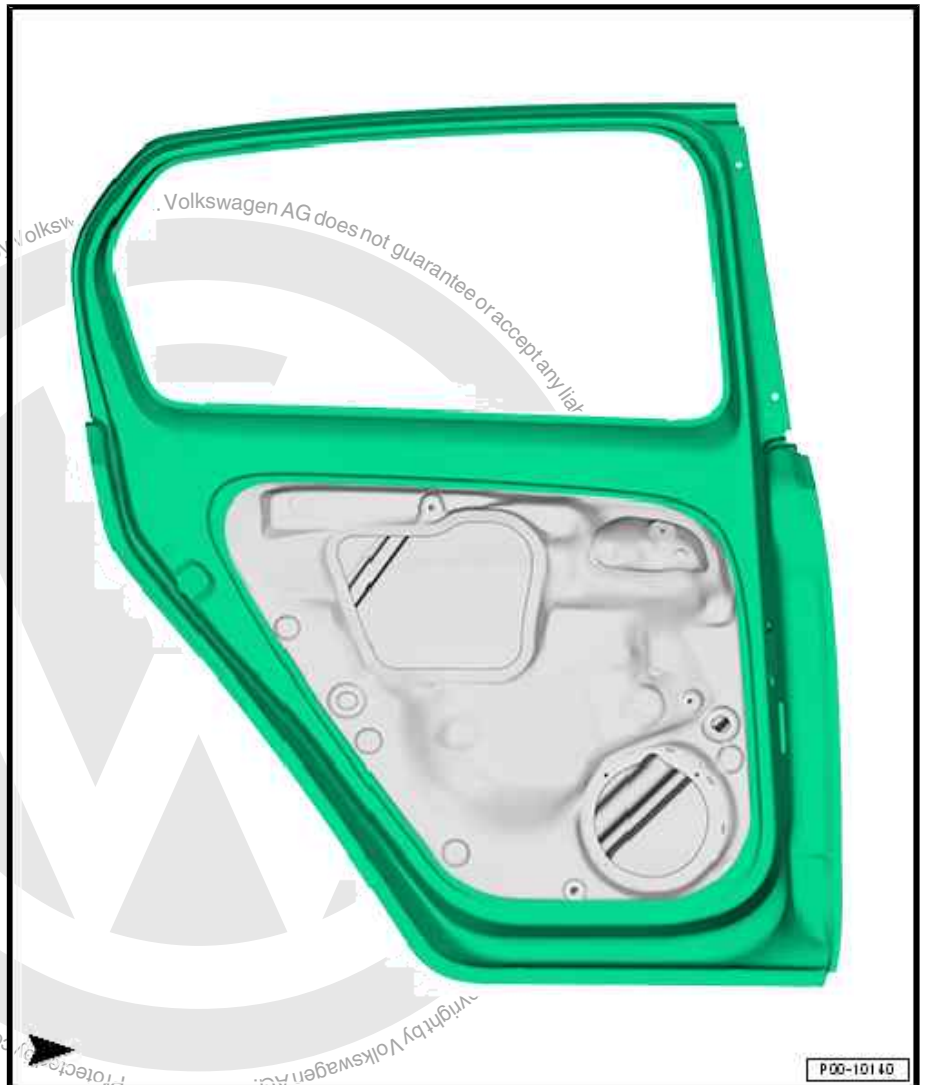
**Clear coat, rear door of 4-door**

Illustration shows left side. The right side is the mirror image.



- Clear coat

- ☐ Only the coloured areas of the body receive a clear coat.



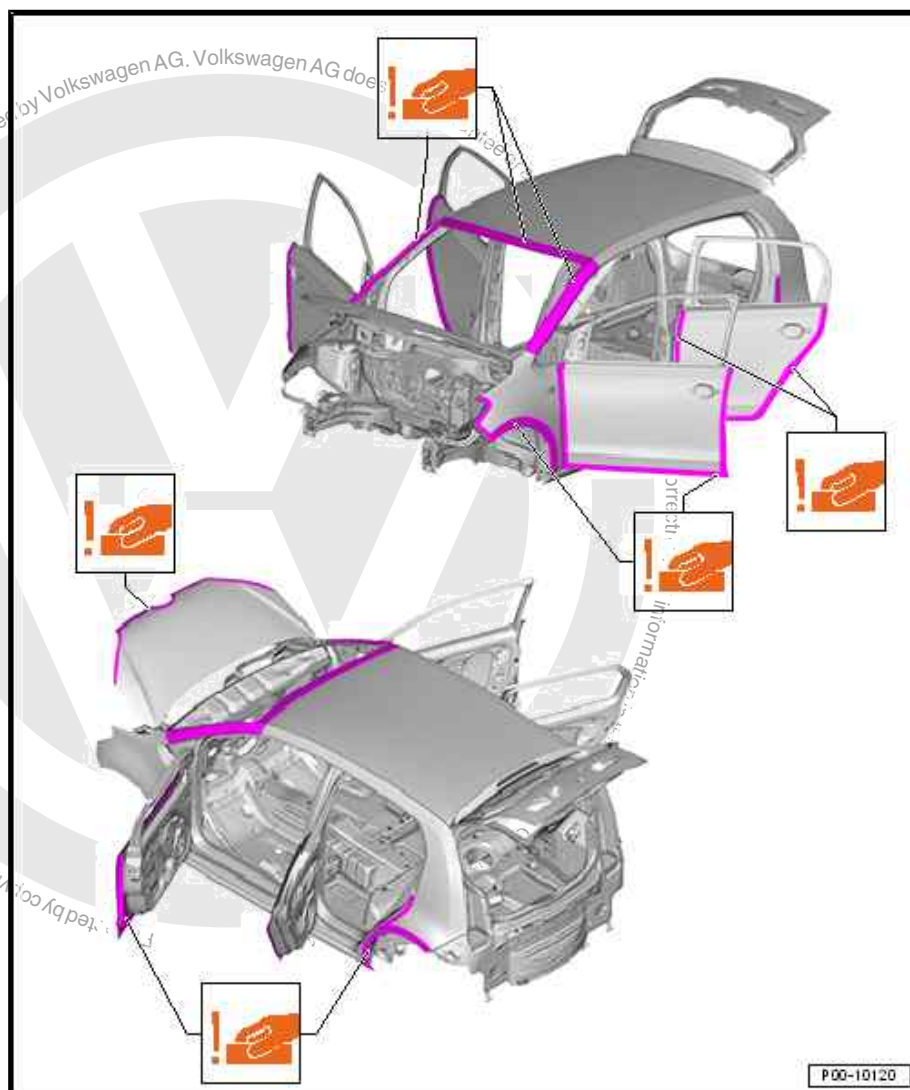


### 3 Areas exposed to stone chipping

⇒ **"3.1 Body areas exposed to stone chipping", page 18**

#### 3.1 Body areas exposed to stone chipping

Body overview, 4-door

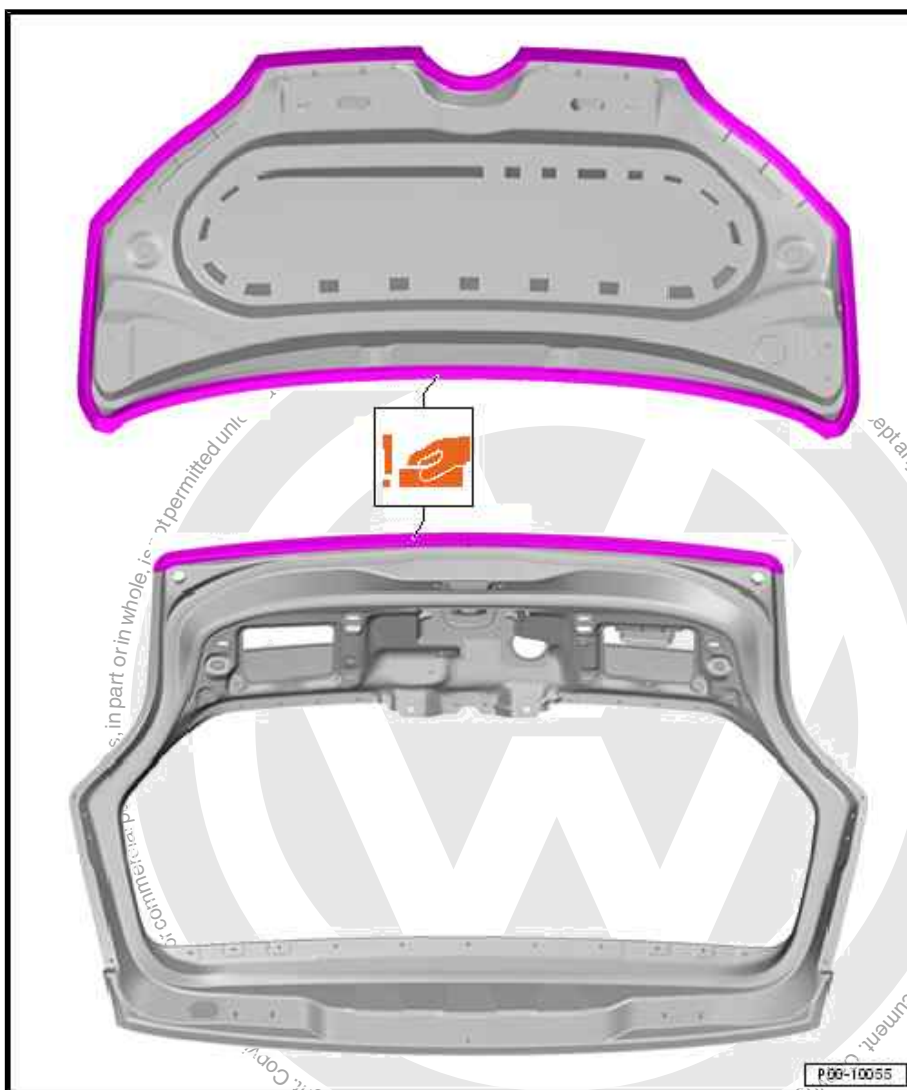


#### Note

- ◆ *The marked areas are exposed to stone chipping.*
- ◆ *When sanding these areas, note thickness of the paint structure and avoid sanding through. This is the only way to ensure long-term corrosion protection.*
- It is recommended to carefully sand the marked area by hand to avoid "sanding through" the cathodic dip primer.

**Bonnet and rear lid**





#### Note

- ◆ *The marked areas are exposed to stone chipping.*
- ◆ *When sanding these areas, note thickness of the paint structure and avoid sanding through. This is the only way to ensure long-term corrosion protection.*
- It is recommended to carefully sand the marked area by hand to avoid “sanding through” the cathodic dip primer.



## 4 Masked sectors

⇒ "4.1 Masking areas, front body", page 20

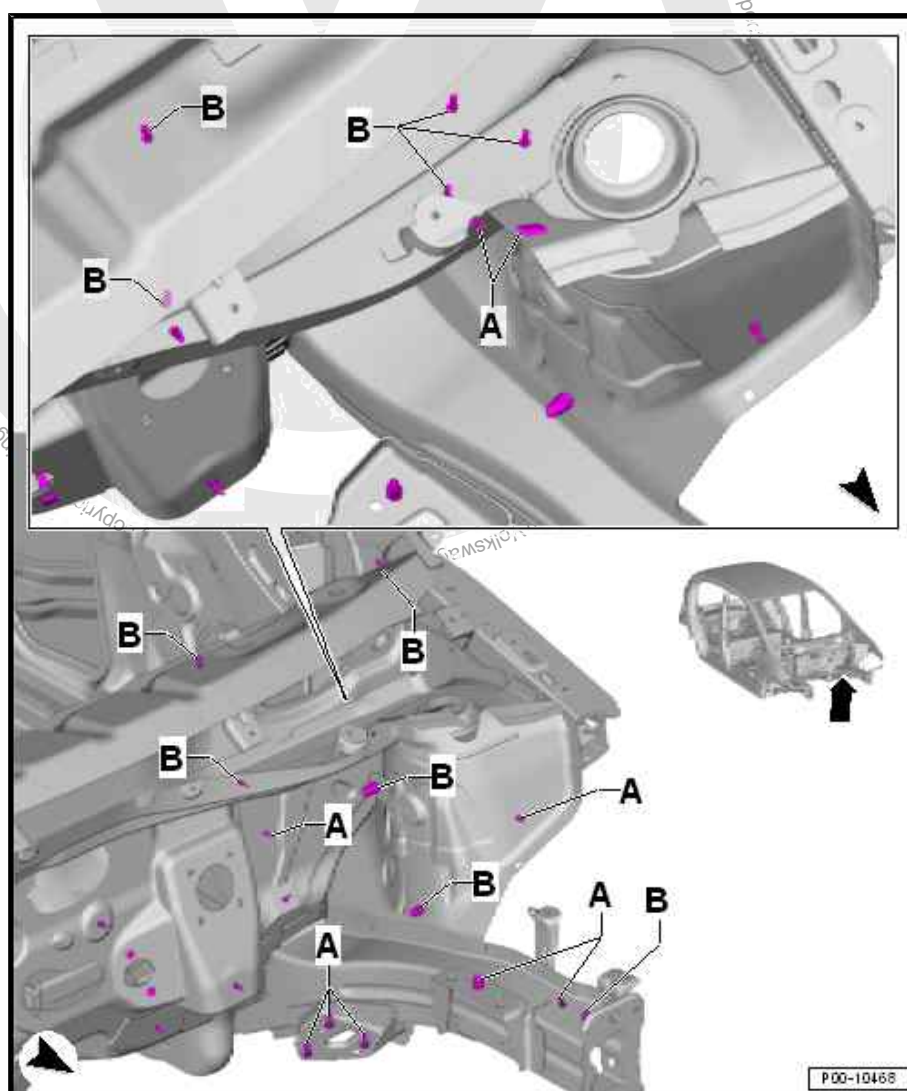
⇒ "4.2 Masking areas, rear body", page 27

### 4.1 Masking areas, front body

#### Masking areas, left engine compartment

A - Masking surfaces and threads free of sealant and wax

B - Threads and contact surfaces free of paint, sealant and wax



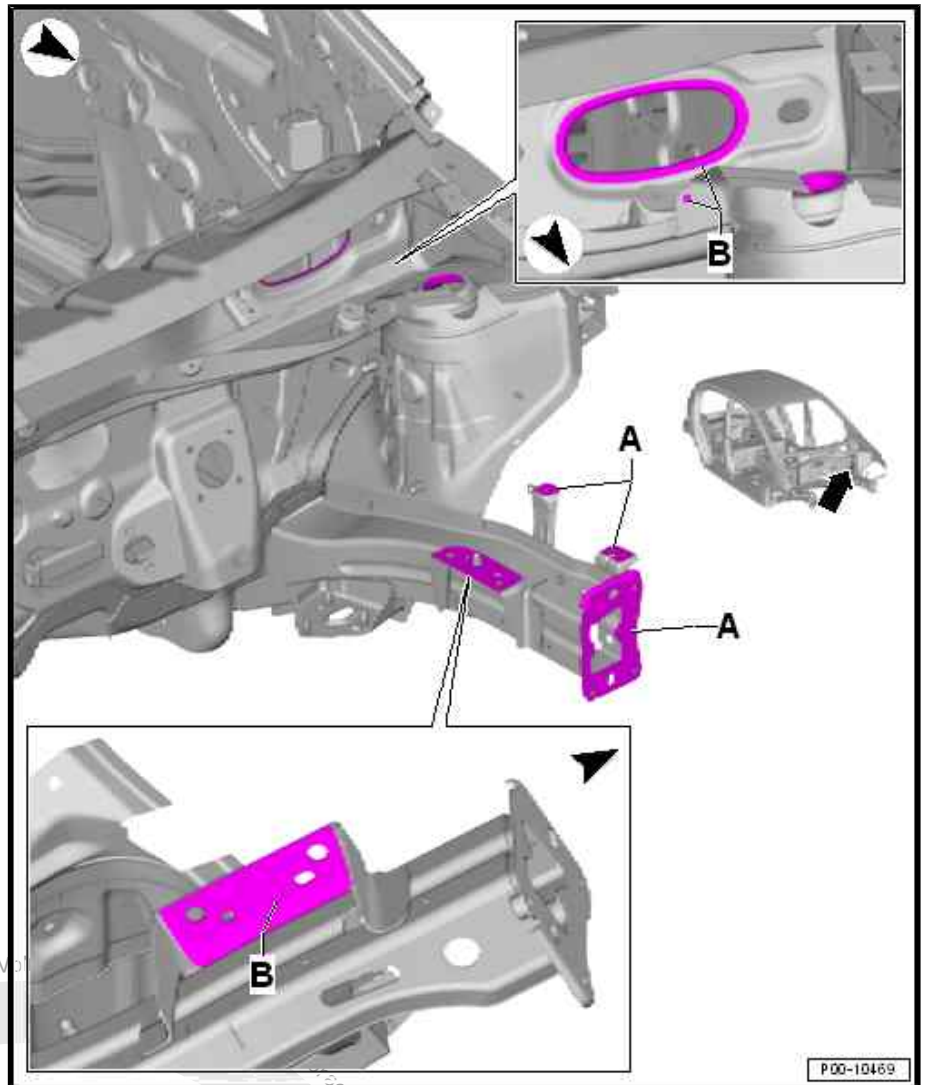
#### Masking areas, left engine compartment





**A - Masking surfaces and threads free of sealant and wax**

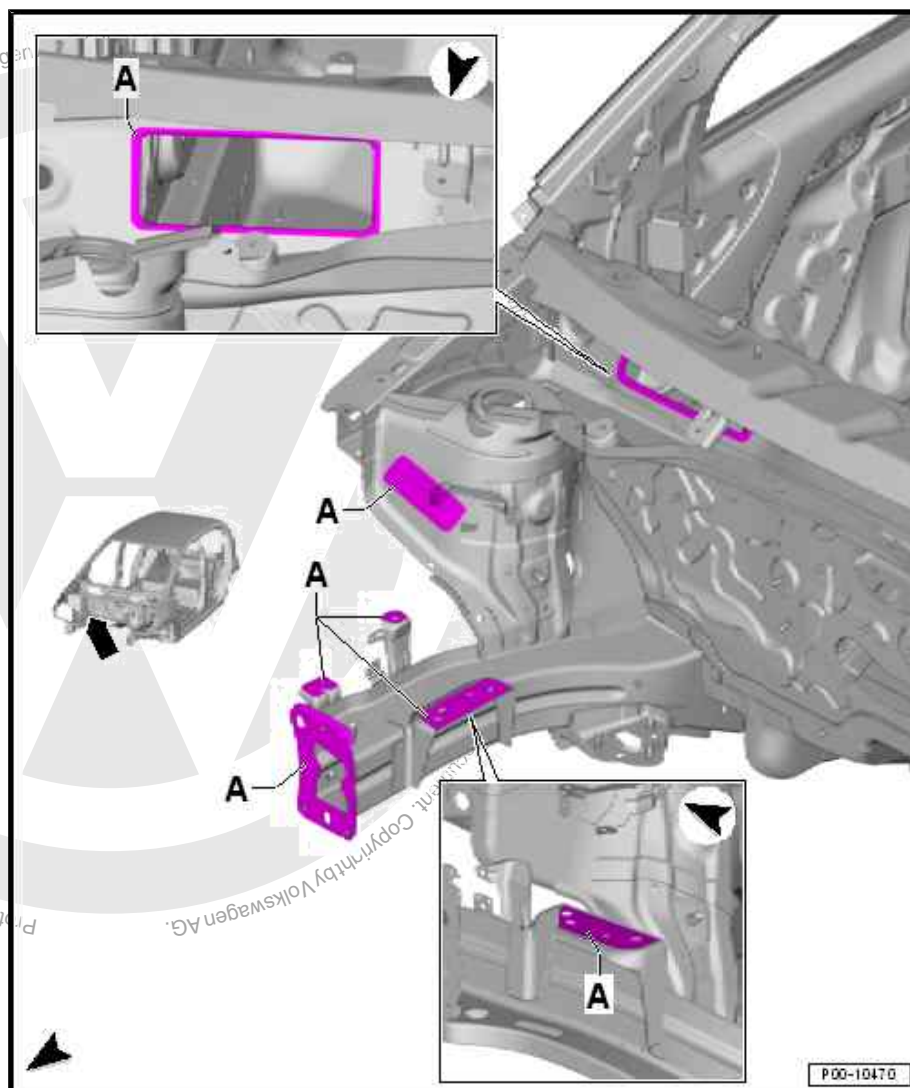
**B - Threads and contact surfaces free of paint, sealant and wax**



**Masking areas, right engine compartment**



**A - Masking surfaces and threads free of sealant and wax**

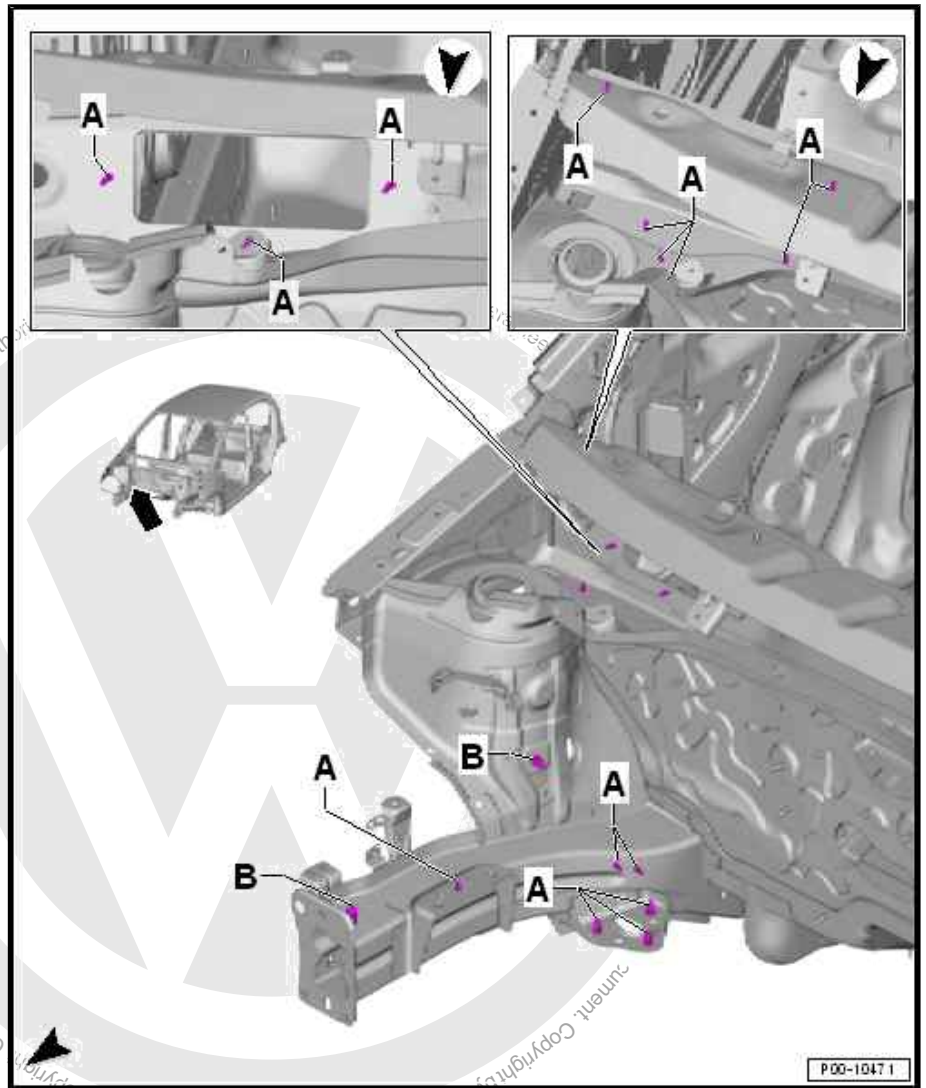


**Masking areas, right engine compartment**



**A - Masking surfaces and threads free of sealant and wax**

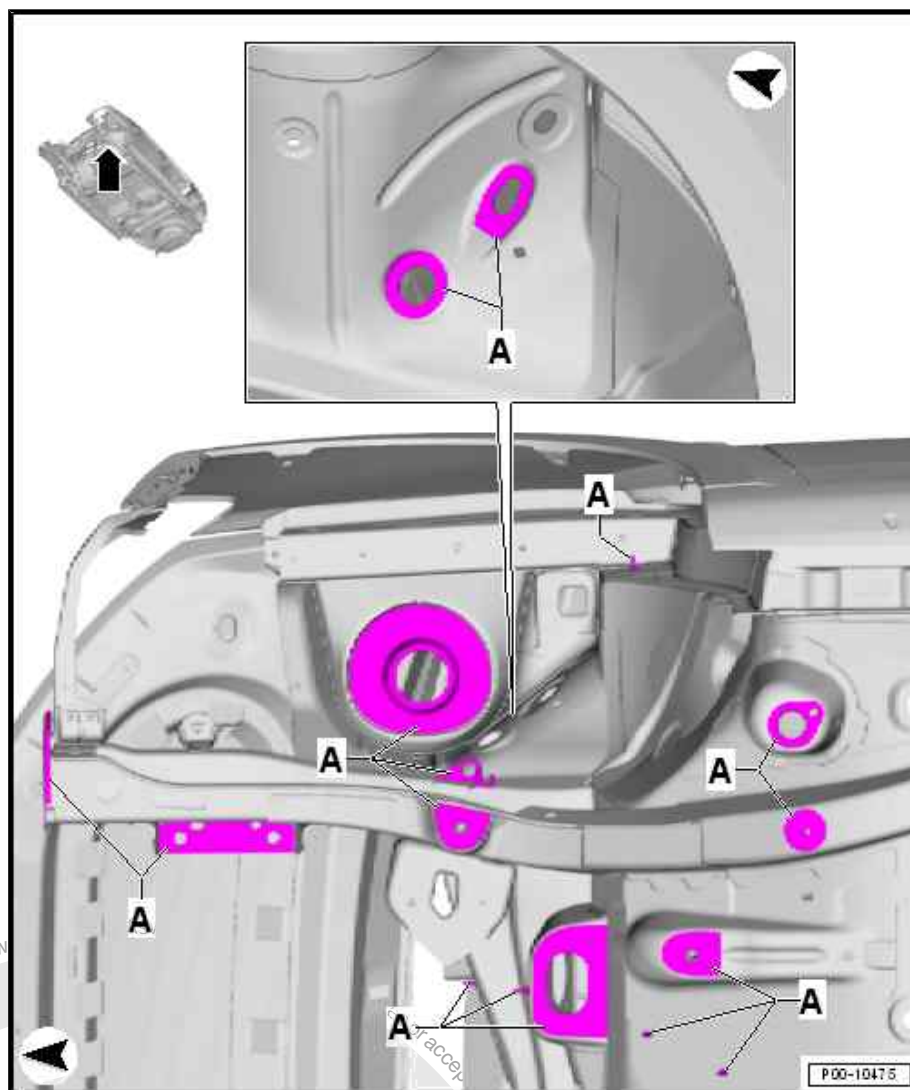
**B - Threads and contact surfaces free of paint, sealant and wax**



**Masking areas, front left wheel housing**

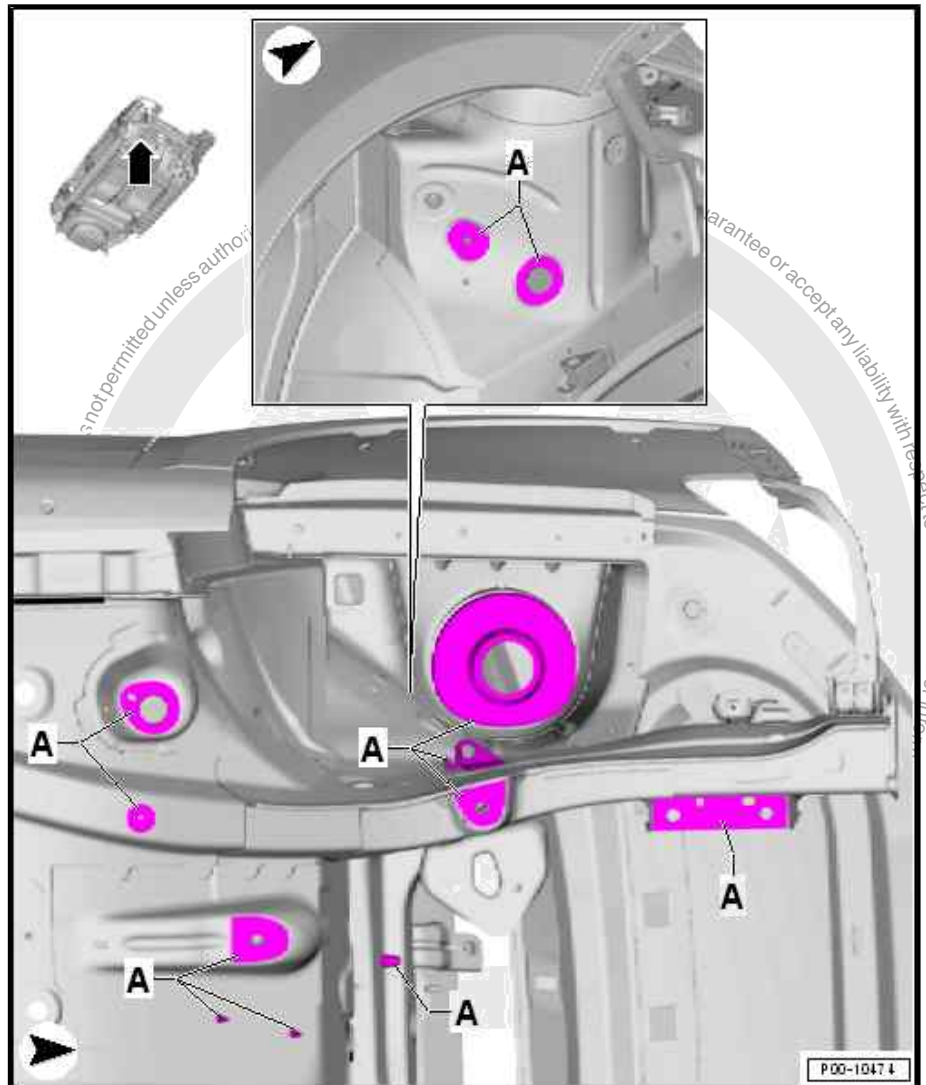


### Masking areas, front right wheel housing





**A - Masking surfaces and threads free of sealant and wax**

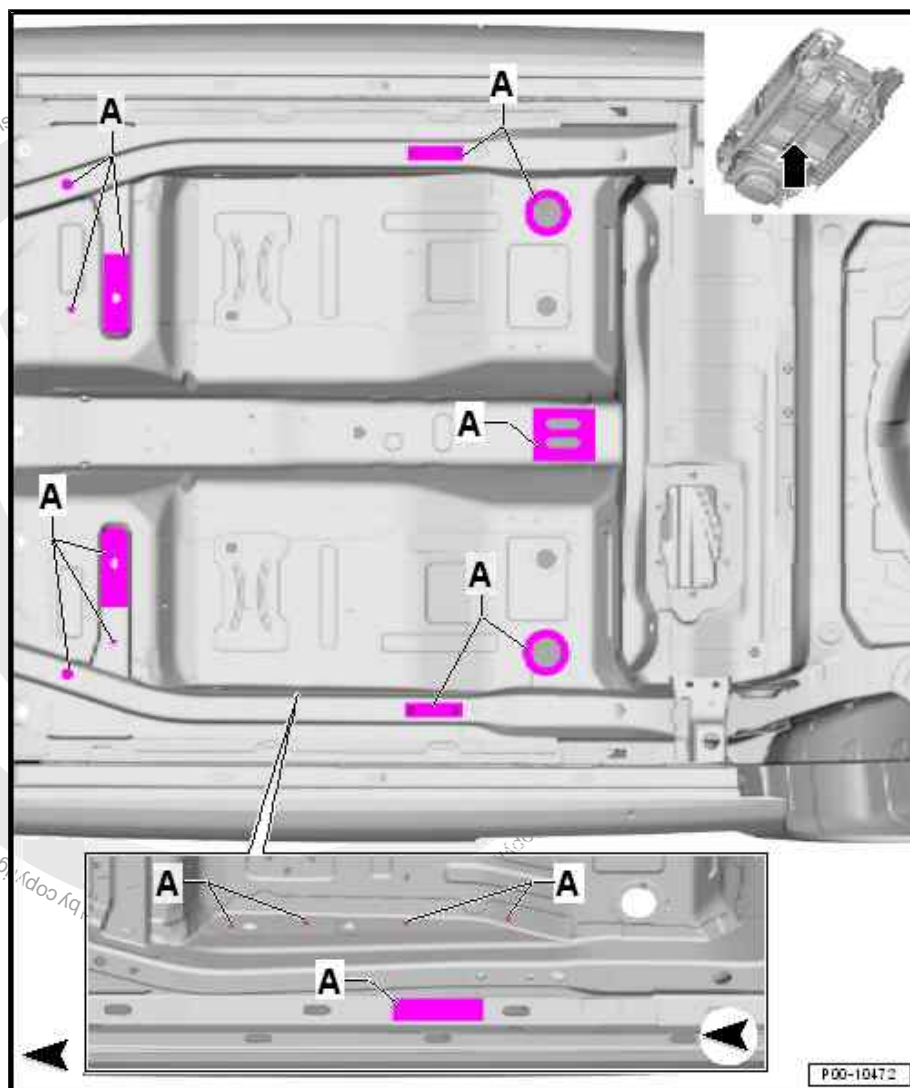


#### Masking areas, central underbody

The left side is shown in the magnifying glass view. The right side is the mirror image.



**A - Masking surfaces and  
threads free of sealant and  
wax**



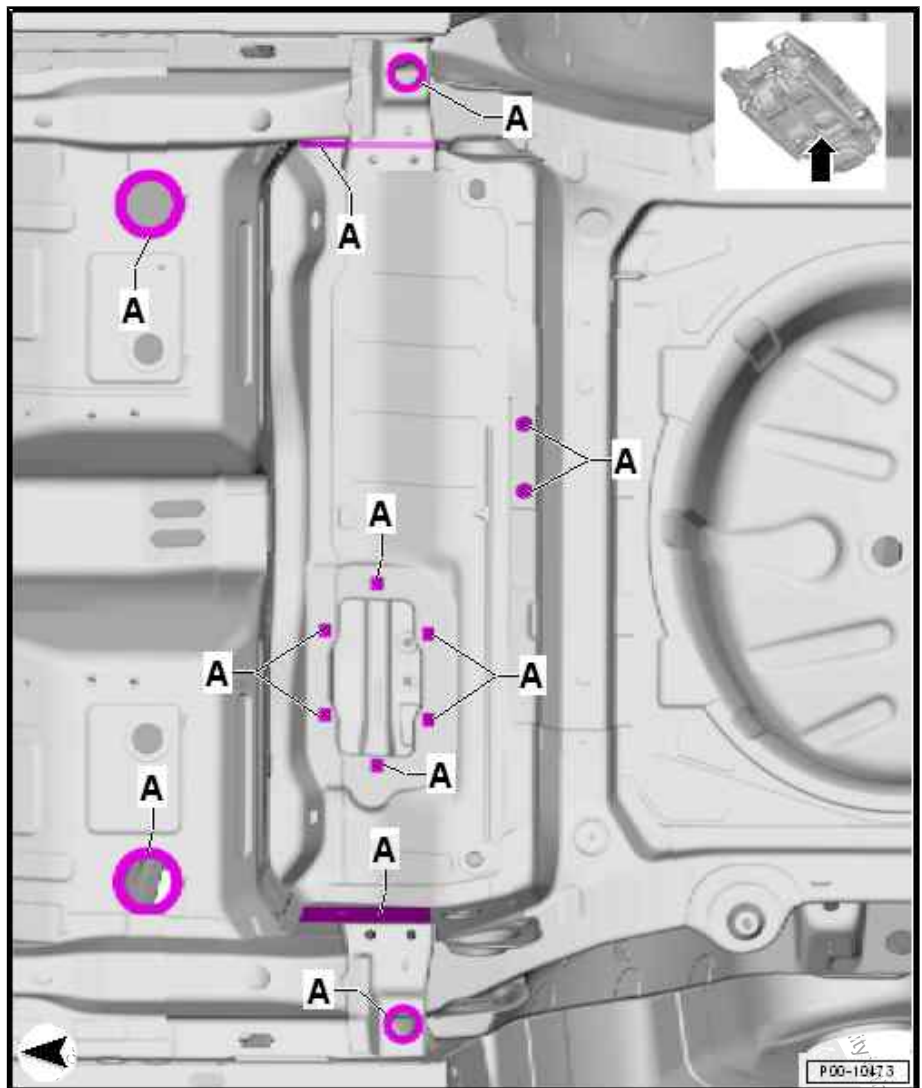




## 4.2 Masking areas, rear body

### Masking areas, rear underbody

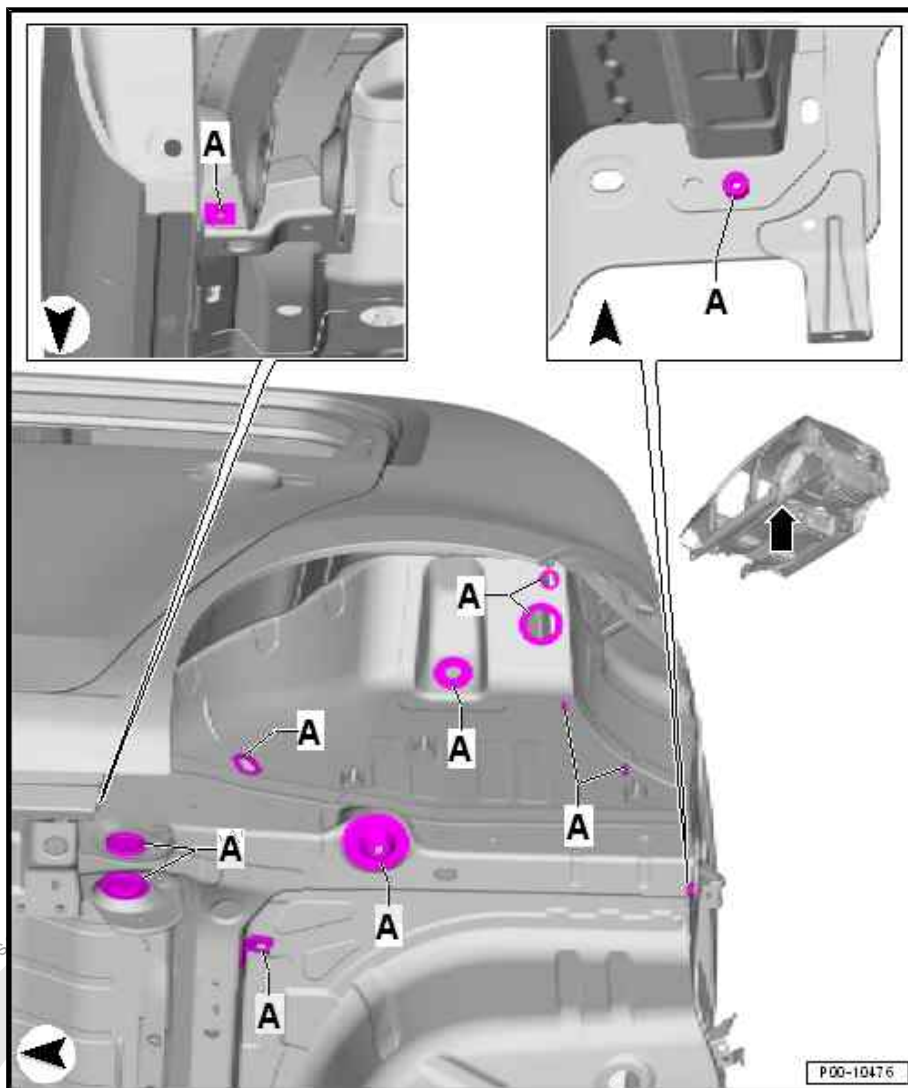
A - Masking surfaces and threads free of sealant and wax



### Masking areas, rear left wheel housing



**A - Masking surfaces and threads free of sealant and wax**

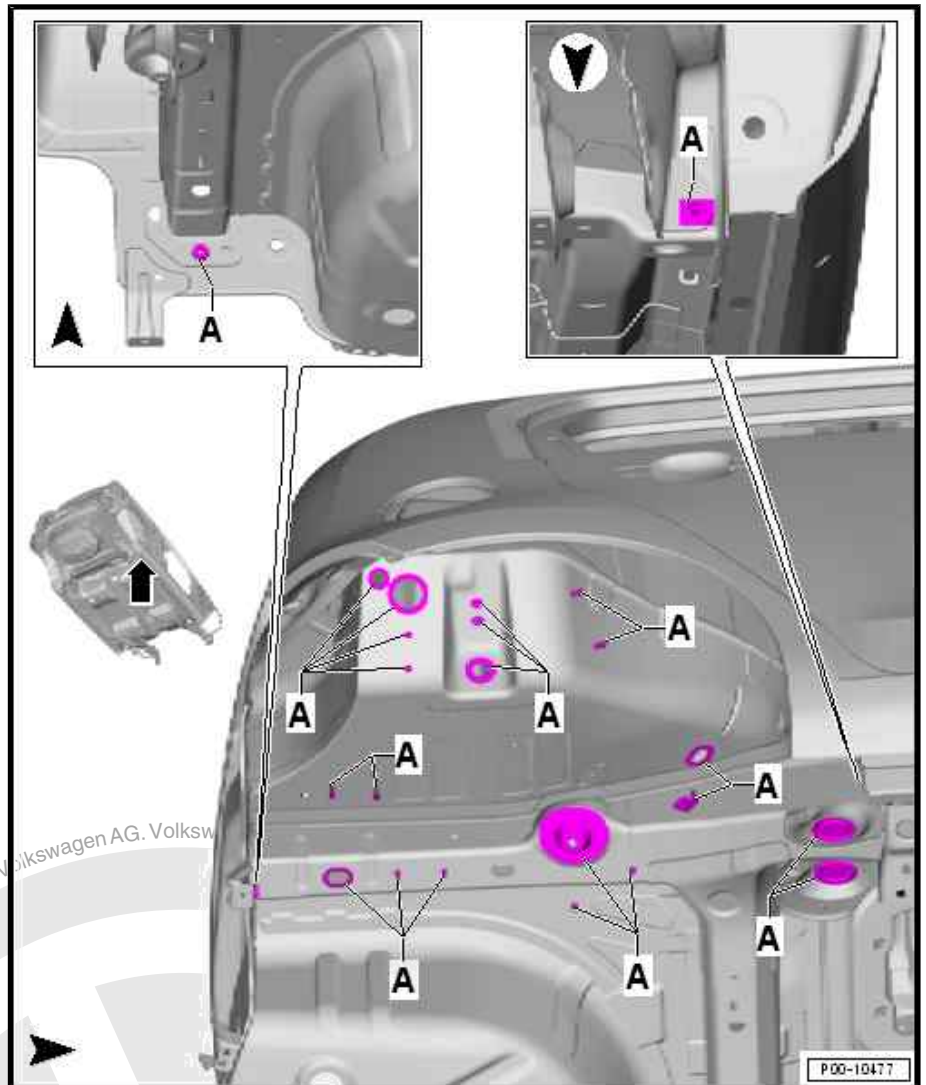


**Masking areas, rear right wheel housing**





**A - Masking surfaces and threads free of sealant and wax**



**Masking areas in area of axle mounting**



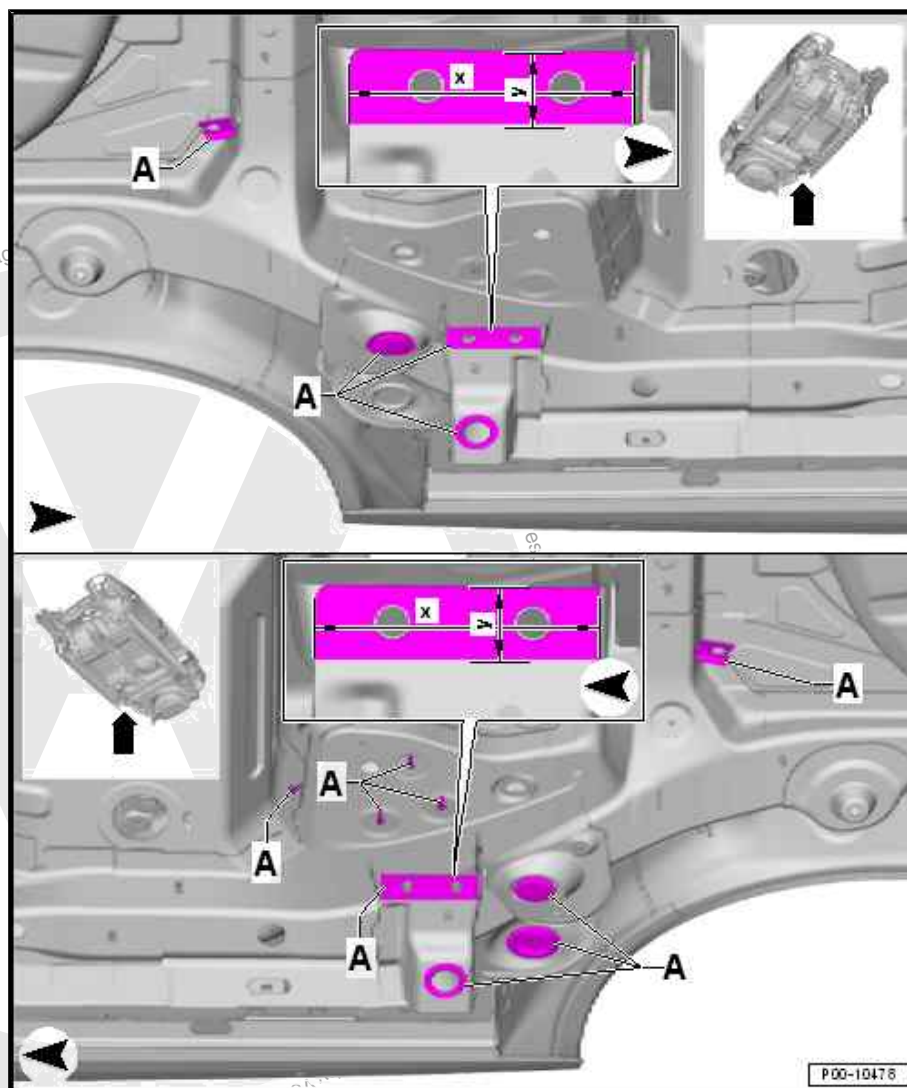
**A - Masking surfaces and threads free of sealant and wax**

- Dimension -x-

□ 105 mm

- Dimension -y-

□ 40 mm



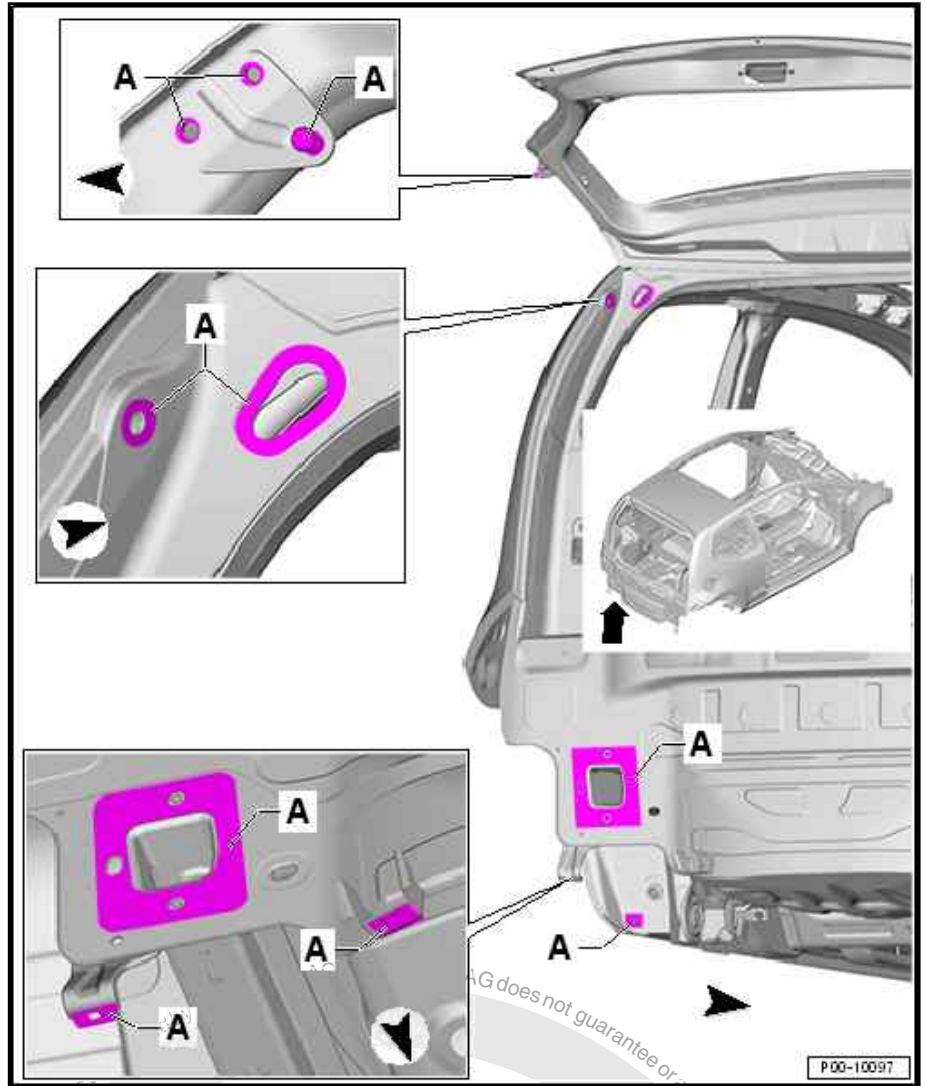
### Masking areas, rear body

Illustration shows left side. The right side is the mirror image.

Illustration shows 2-door model; the 4-door model is analogous.



**A - Masking surfaces and threads free of sealant and wax**





## 5 Seam sealing

⇒ ["5.1 Seam seals, front body", page 32](#)

⇒ ["5.2 Seam seals, middle body", page 39](#)

⇒ ["5.3 Seam seals, rear body", page 44](#)

### 5.1 Seam seals, front body



#### Note

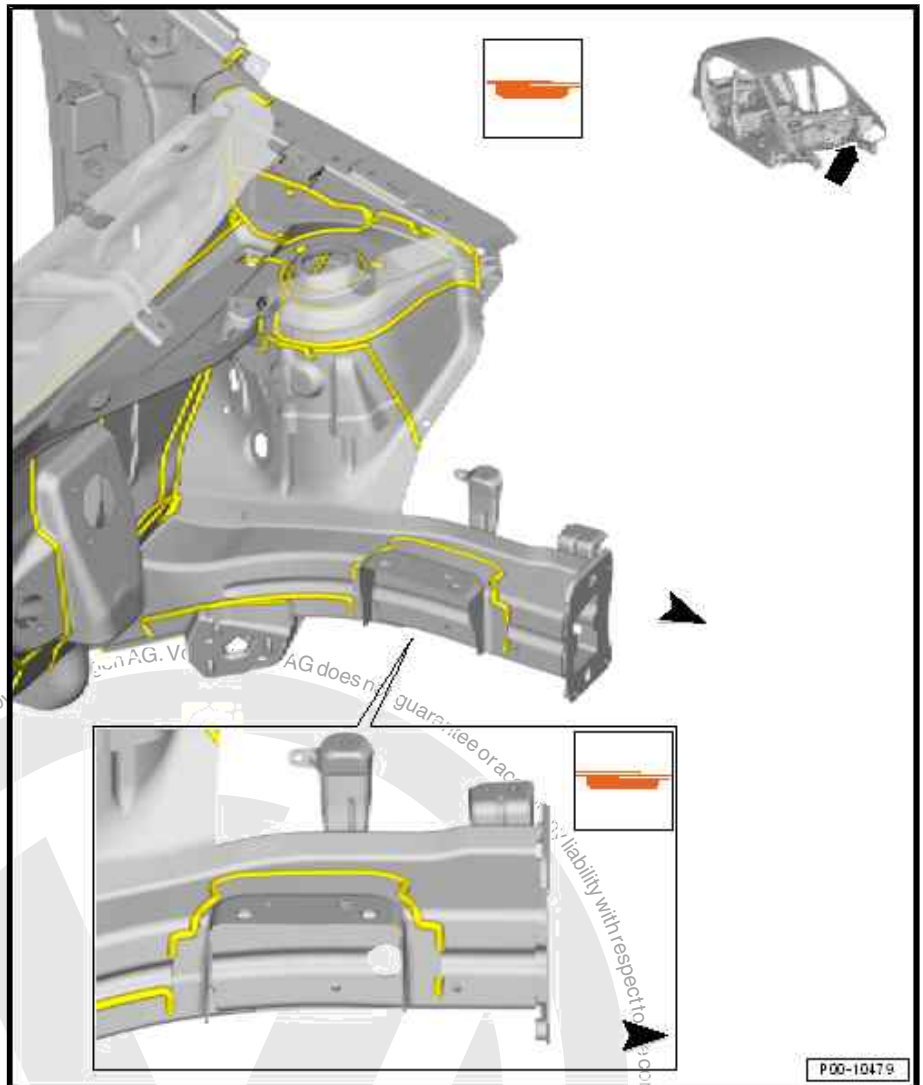
- ◆ *When performing repair work, the seam sealing should be restored to match the original appearance and layer thickness.*
- ◆ *To avoid damage or faulty operation, brush seam seals smooth near parts which must be attached.*
- ◆ *Water drainage holes must remain clear.*
- ◆ *All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the extent of the sealing work.*
- ◆ *Sealant must never be applied to bare substrates. Substrates must always be surfaced first.*

#### Sealing in left engine compartment



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.

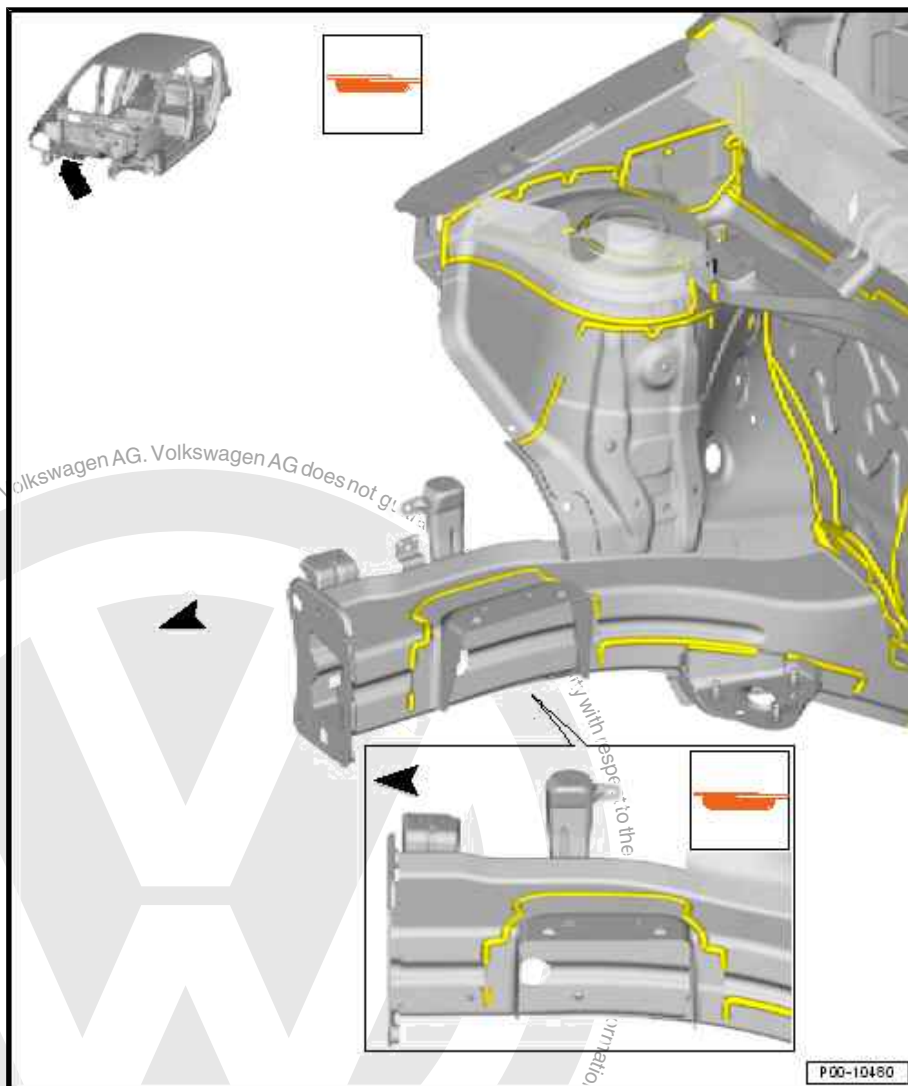


Sealing in right engine compartment



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



#### Sealing in centre engine compartment

The upper figure shows a left-hand drive vehicle.

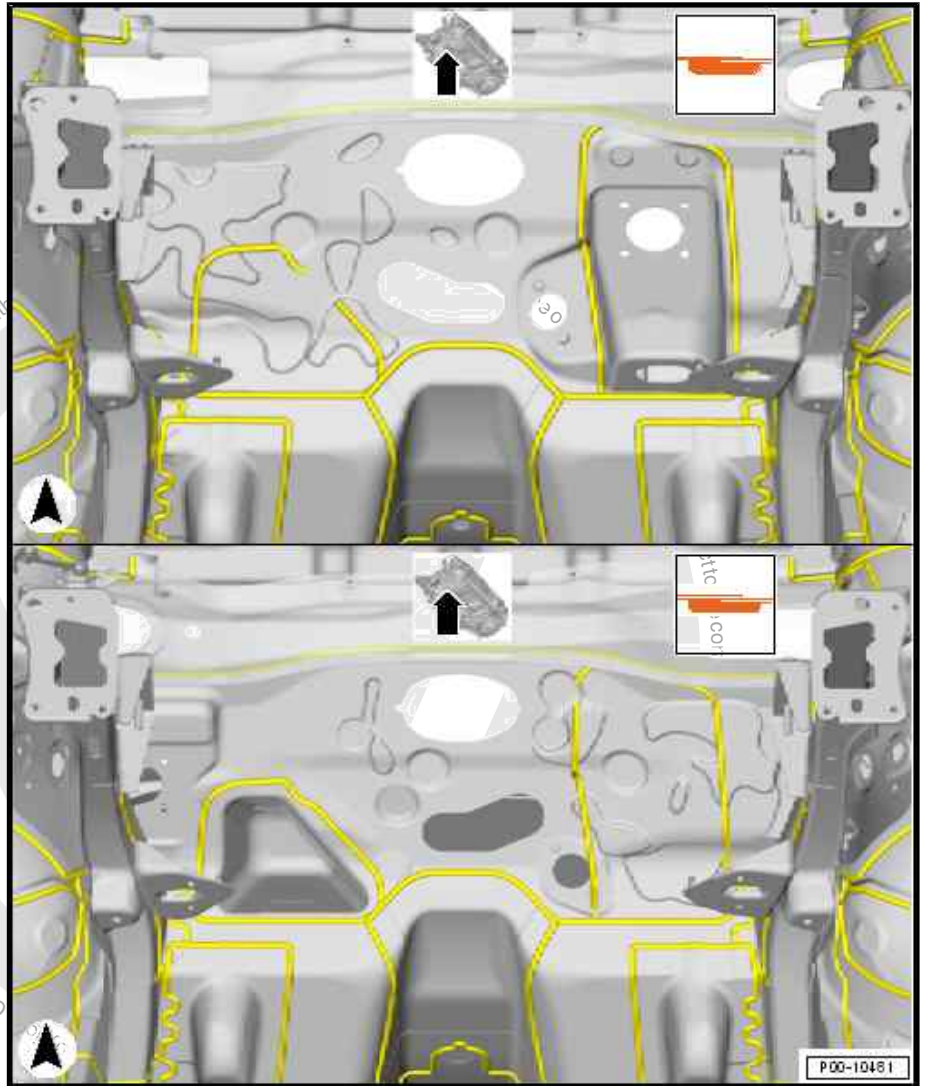
The lower figure shows a right-hand vehicle.





#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.

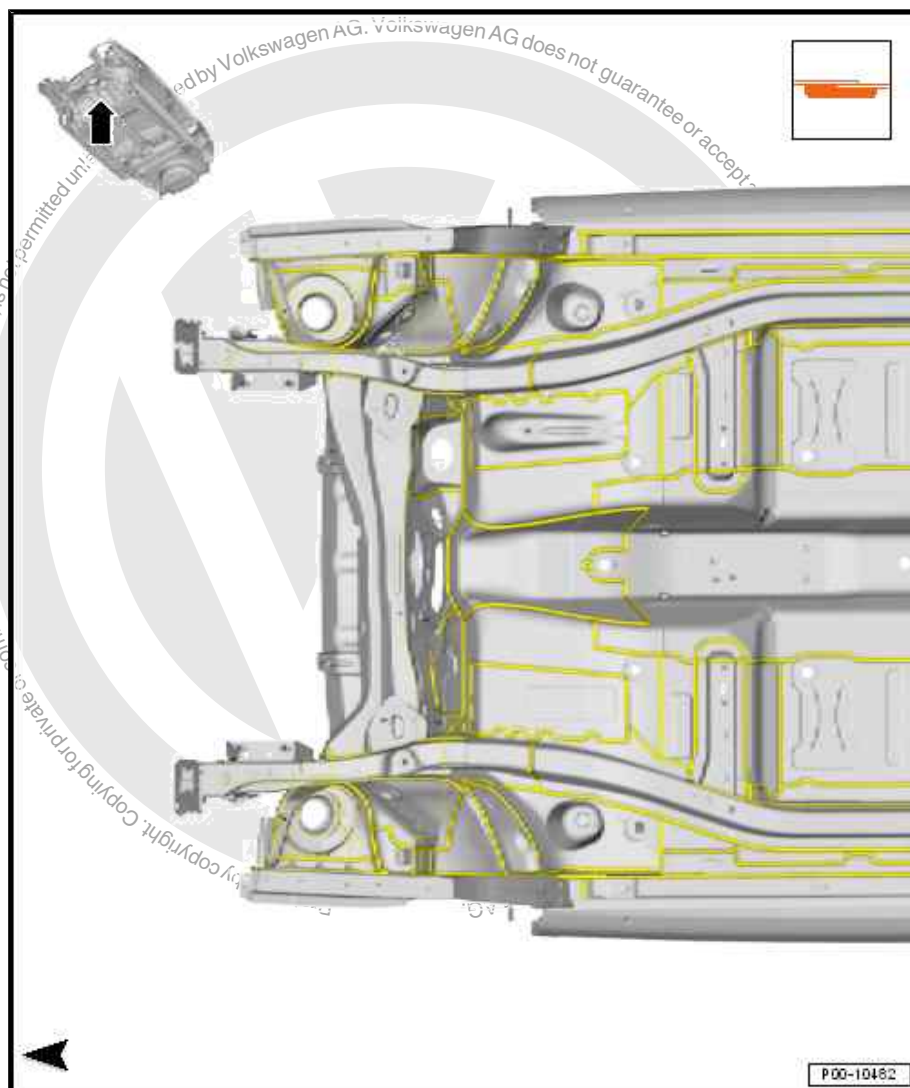


Sealing on front underbody



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



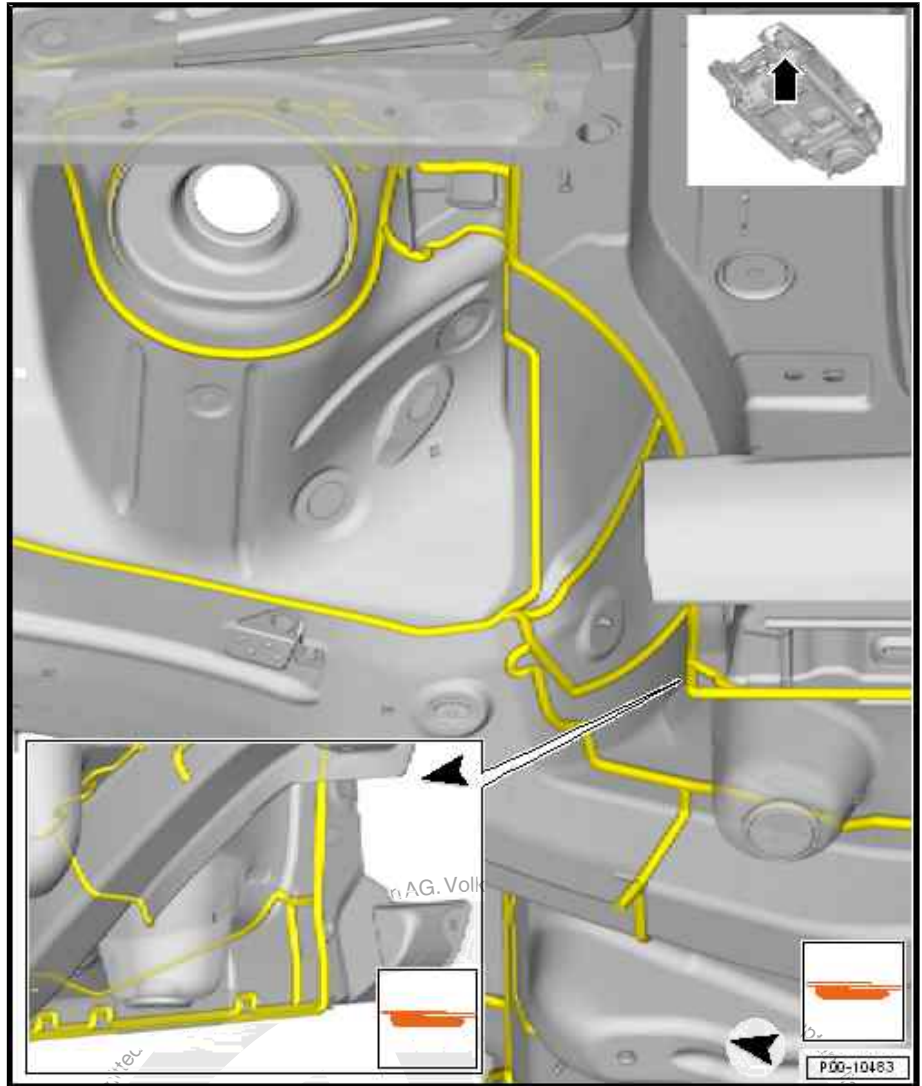
Sealing, front left wheel housing





#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



#### Seam seals, bonnet

Illustration shows left side. The right side is the mirror image.

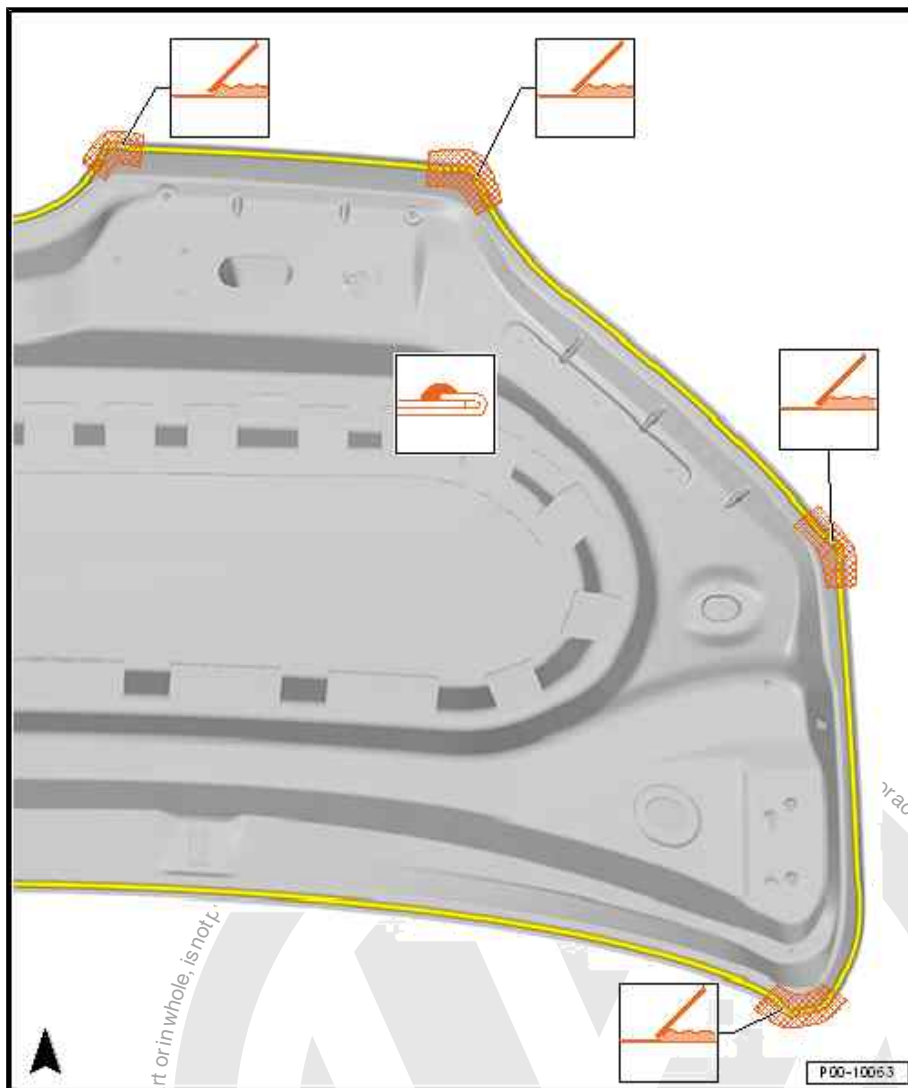


#### - Fine seam sealing

- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*



## 5.2 Seam seals, middle body



### Note

- ◆ *When performing repair work, the seam sealing should be restored to match the original appearance and layer thickness.*
- ◆ *To avoid damage or faulty operation, brush seam seals smooth near parts which must be attached.*
- ◆ *Water drainage holes must remain clear.*
- ◆ *All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the extent of the sealing work.*
- ◆ *Sealant must never be applied to bare substrates. Substrates must always be surfaced first.*

### Seam seals, roof

The left side is shown in the magnifying glass view. The right side is the mirror image.

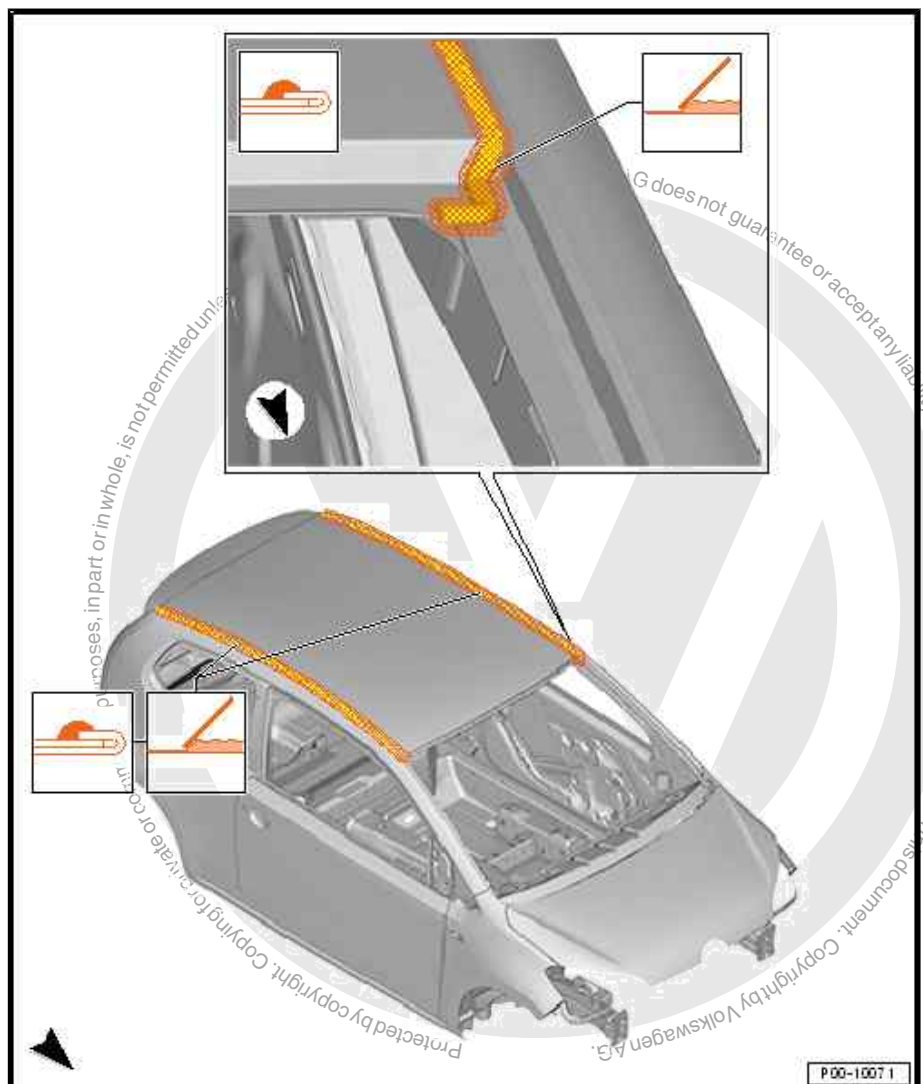
Illustration shows 2-door model; the 4-door model is analogous.

#### - Fine seam sealing

- ☐ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ☐ Sealant in the marked areas must be smoothed following application.





#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*

#### Seam seals, roof with panoramic sunroof

The left side is shown in the magnifying glass view. The right side is the mirror image.

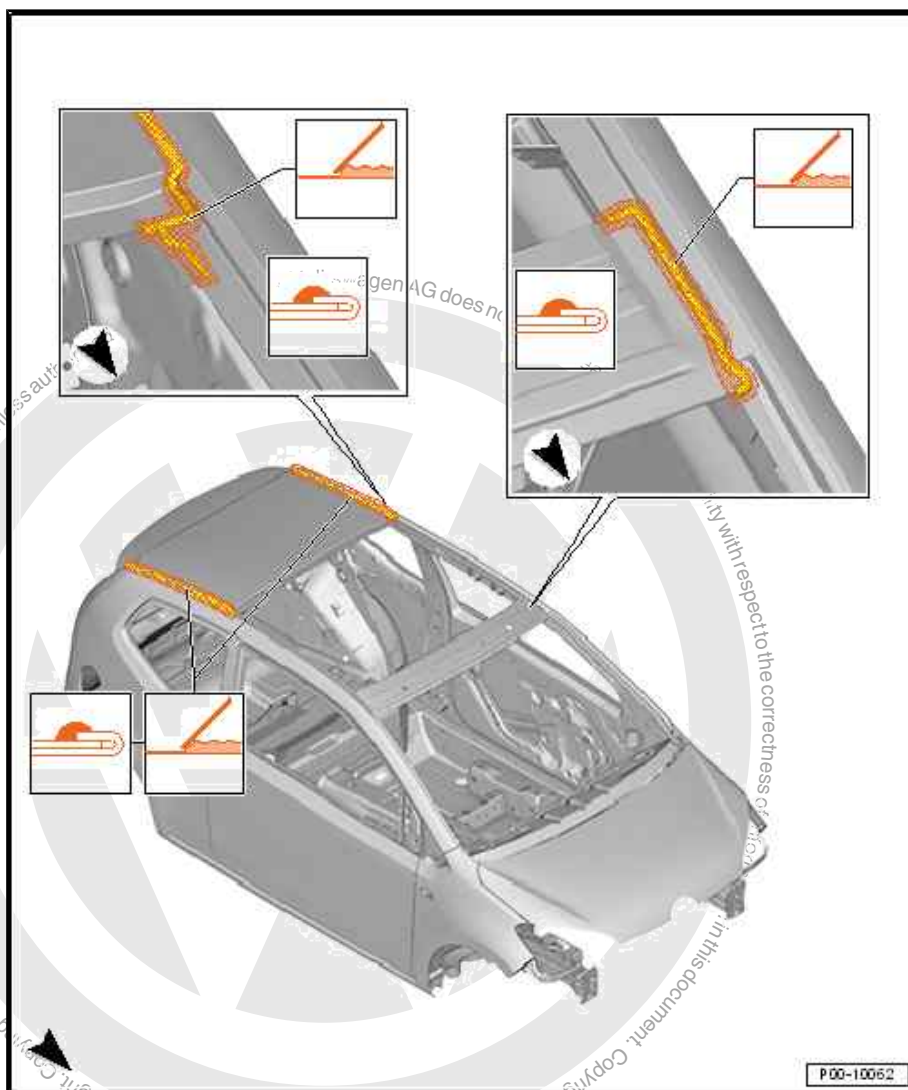
Illustration shows 2-door model; the 4-door model is analogous.

#### - Fine seam sealing

- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*

#### Seam seals, front door of 4-door

Illustration shows left side. The right side is the mirror image.



#### - Fine seam sealing

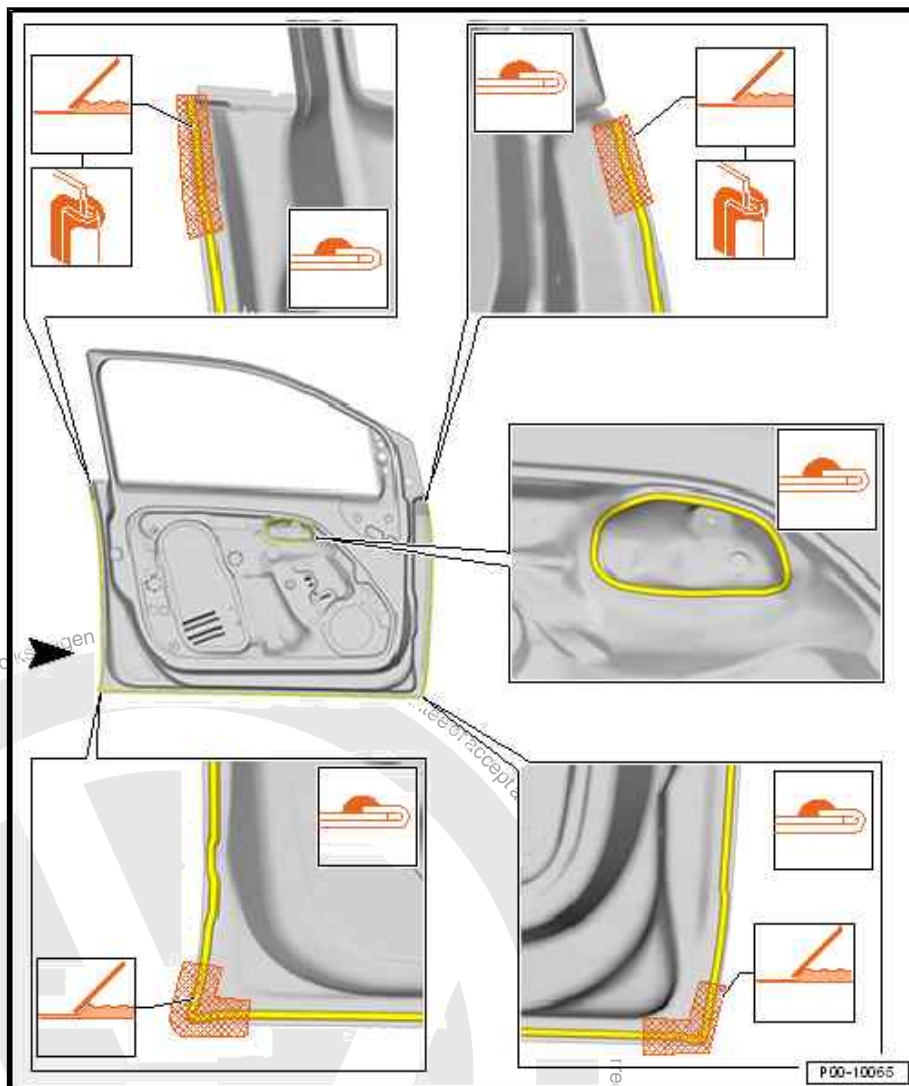
- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.

#### - Sealing the folded seam groove

- ❑ The marked areas must be closed following application of sealant to the folded seam groove.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC so that the groove in the folded seam remains closed.*

#### Seam seals, rear door of 4-door

Illustration shows left side. The right side is the mirror image.





#### - Fine seam sealing

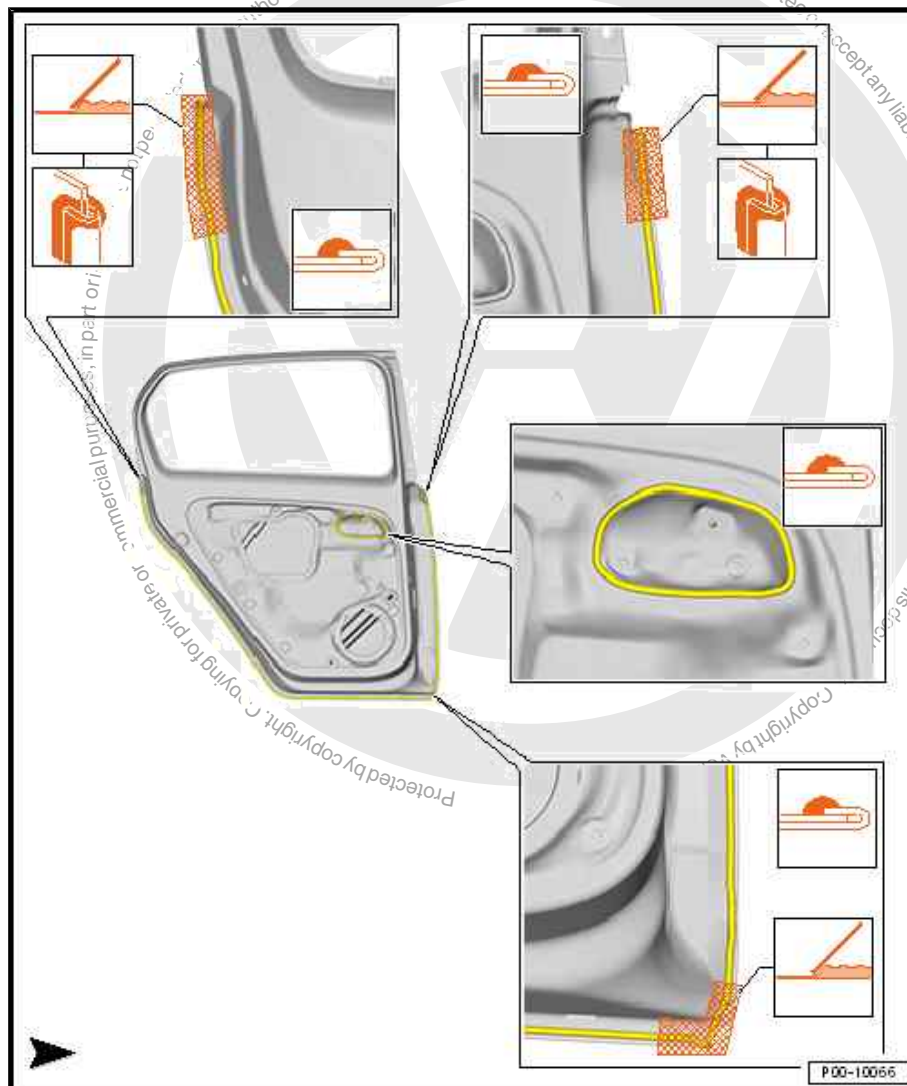
- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.

#### - Sealing the folded seam groove

- ❑ The marked areas must be closed following application of sealant to the folded seam groove.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC so that the groove in the folded seam remains closed.*

#### Seam seals, exterior of rear door of 4-door

Illustration shows left side. The right side is the mirror image.

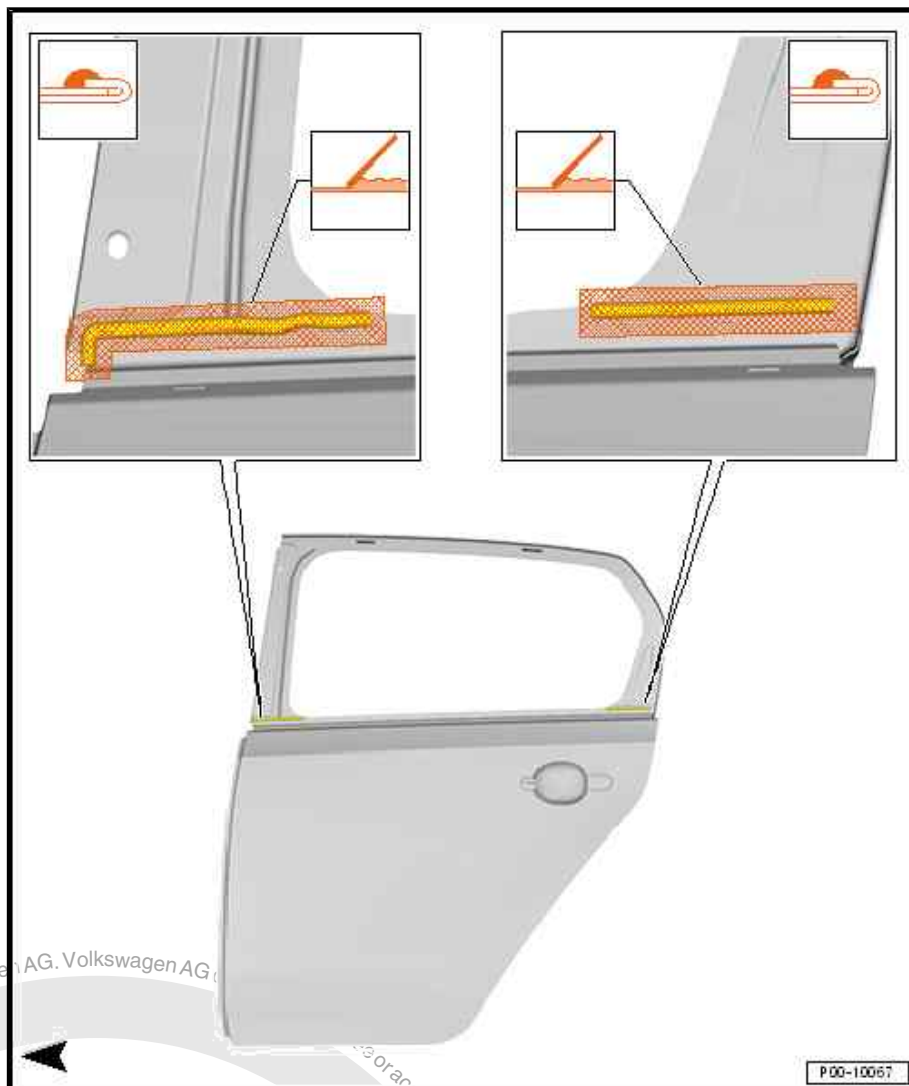


#### - Fine seam sealing

- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.



#### Note

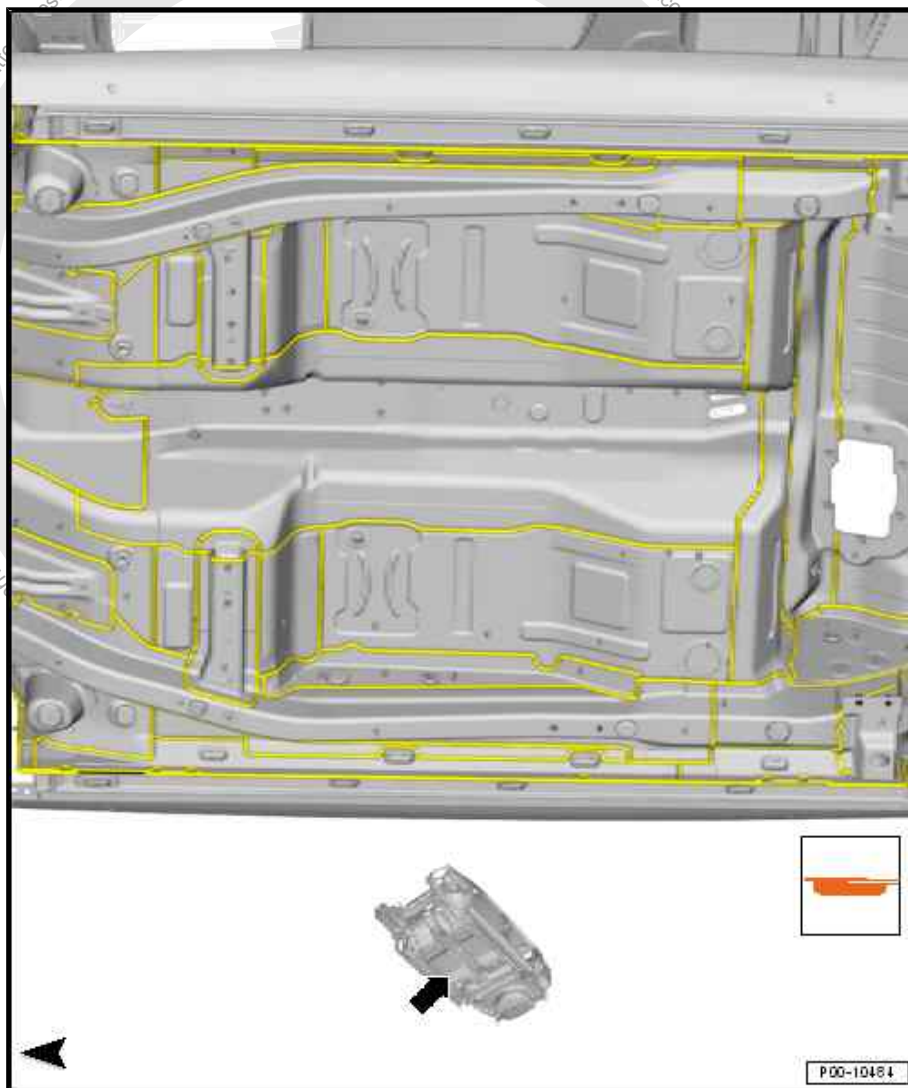
*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*

#### Sealing on middle underbody



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



### 5.3 Seam seals, rear body



#### Note

- ◆ When performing repair work, the seam sealing should be restored to match the original appearance and layer thickness.
- ◆ To avoid damage or faulty operation, brush seam seals smooth near parts which must be attached.
- ◆ Water drainage holes must remain clear.
- ◆ All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the extent of the sealing work.
- ◆ Sealant must never be applied to bare substrates. Substrates must always be surfaced first.

#### Sealing, rear panel

The left side is shown in the magnifying glass views. The right side is the mirror image.





#### - Coarse seam sealing

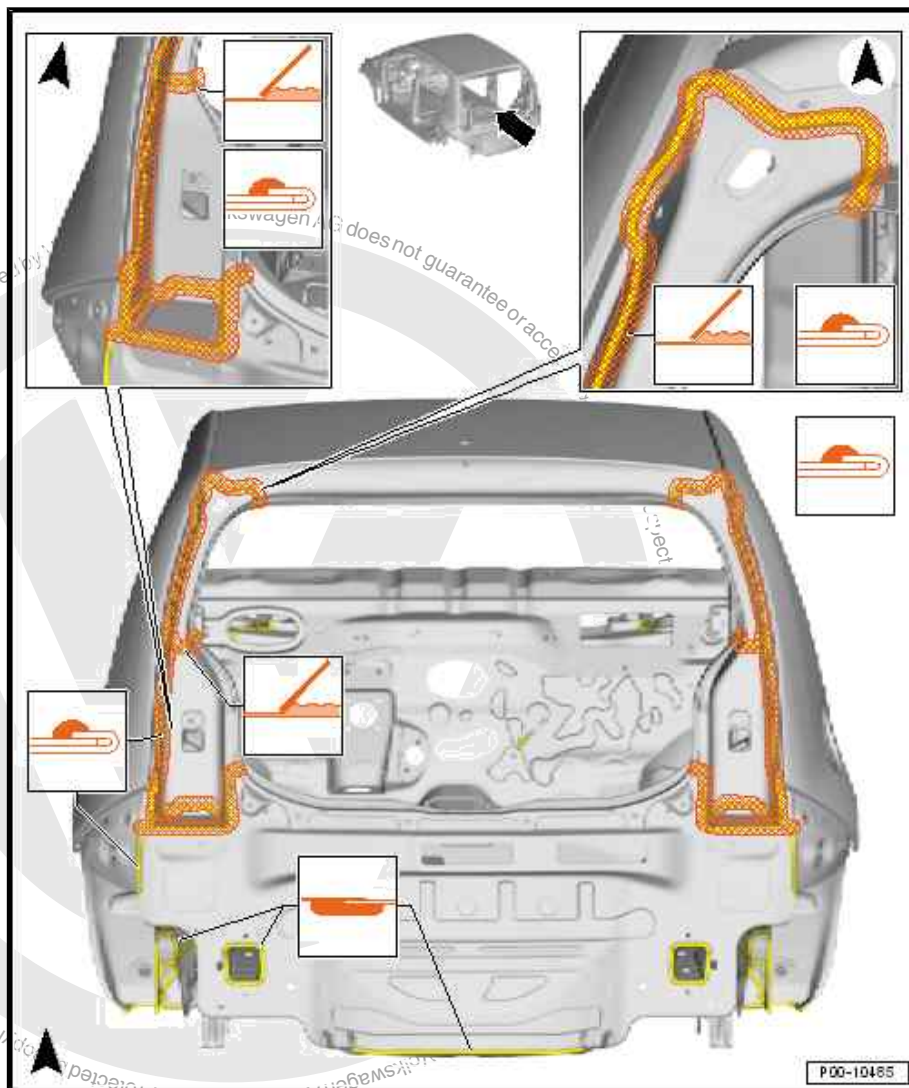
- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.

#### - Fine seam sealing

- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.



#### Note

*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*

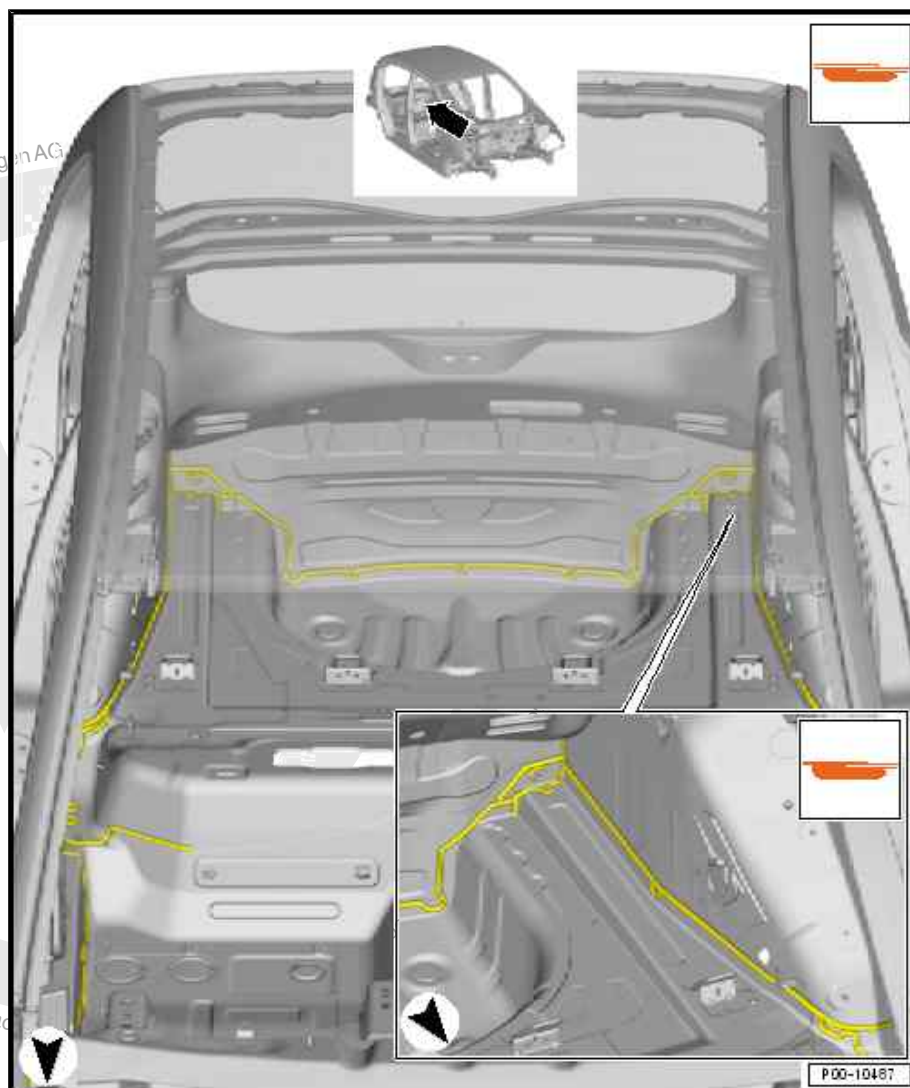
#### Sealing in luggage compartment

The left side is shown in the magnifying glass view. The right side is the mirror image.



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



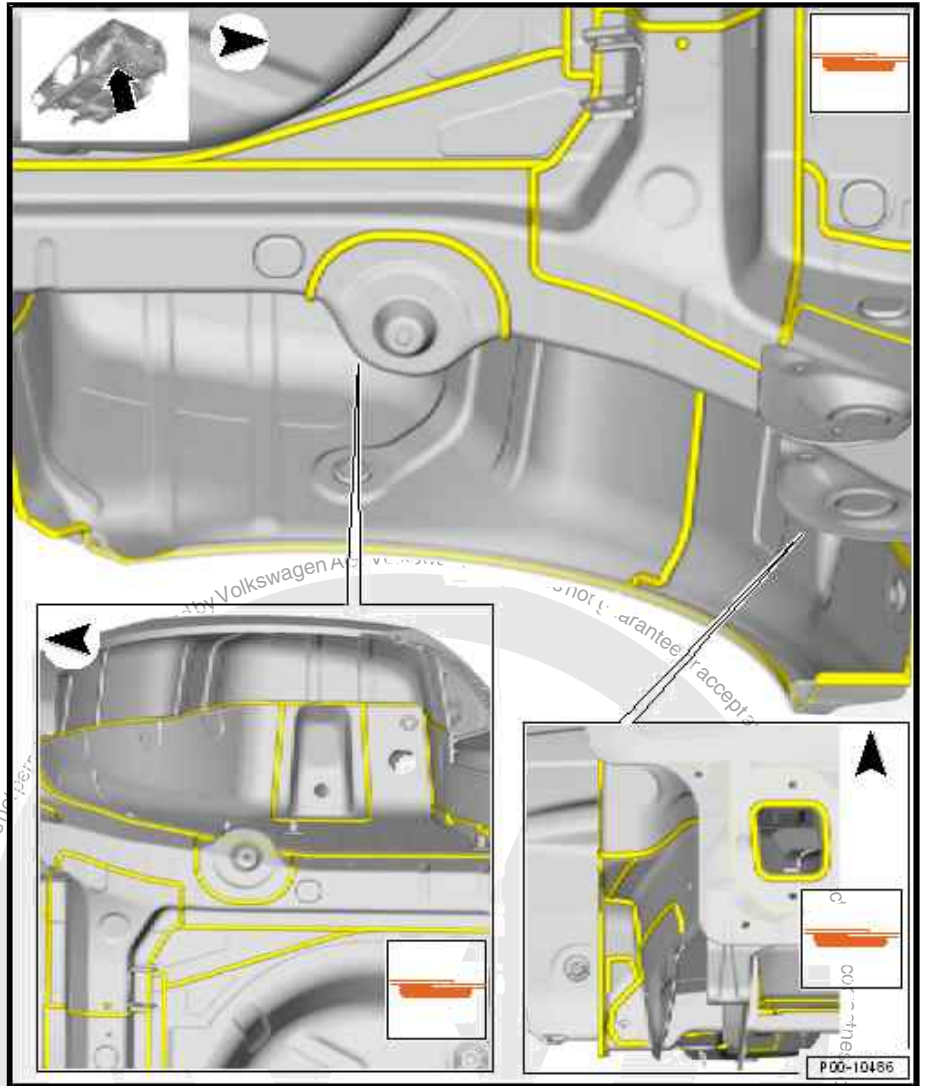
#### Sealing, rear left wheel housing

Illustration shows left side. The right side is the mirror image.



#### - Coarse seam sealing

- ❑ Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.



#### Seam seals, rear lid

Illustration shows left side. The right side is the mirror image.

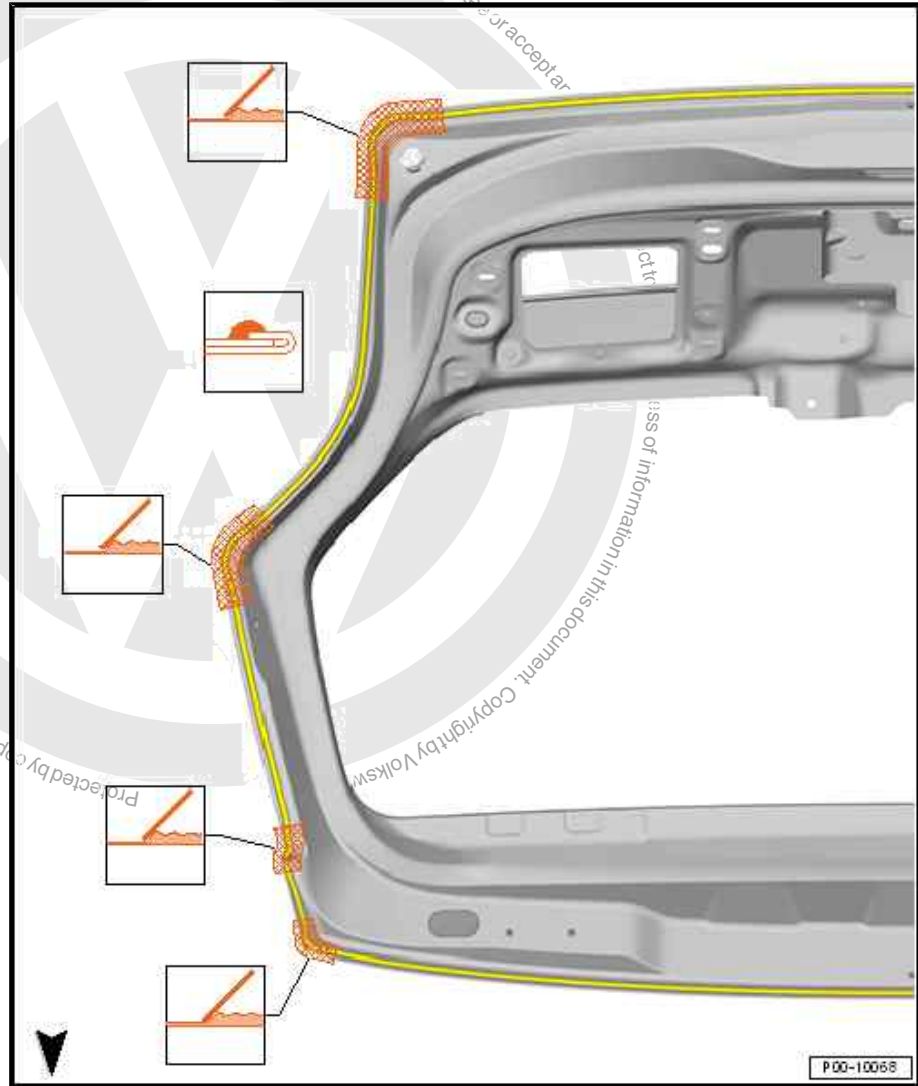


#### - Fine seam sealing

- ❑ Fine seam seals require that the sealant extend at least 3 mm from the seam in each direction and must have a thickness of 0.5 mm.

#### - Smoothing seals

- ❑ Sealant in the marked areas must be smoothed following application.



#### Note

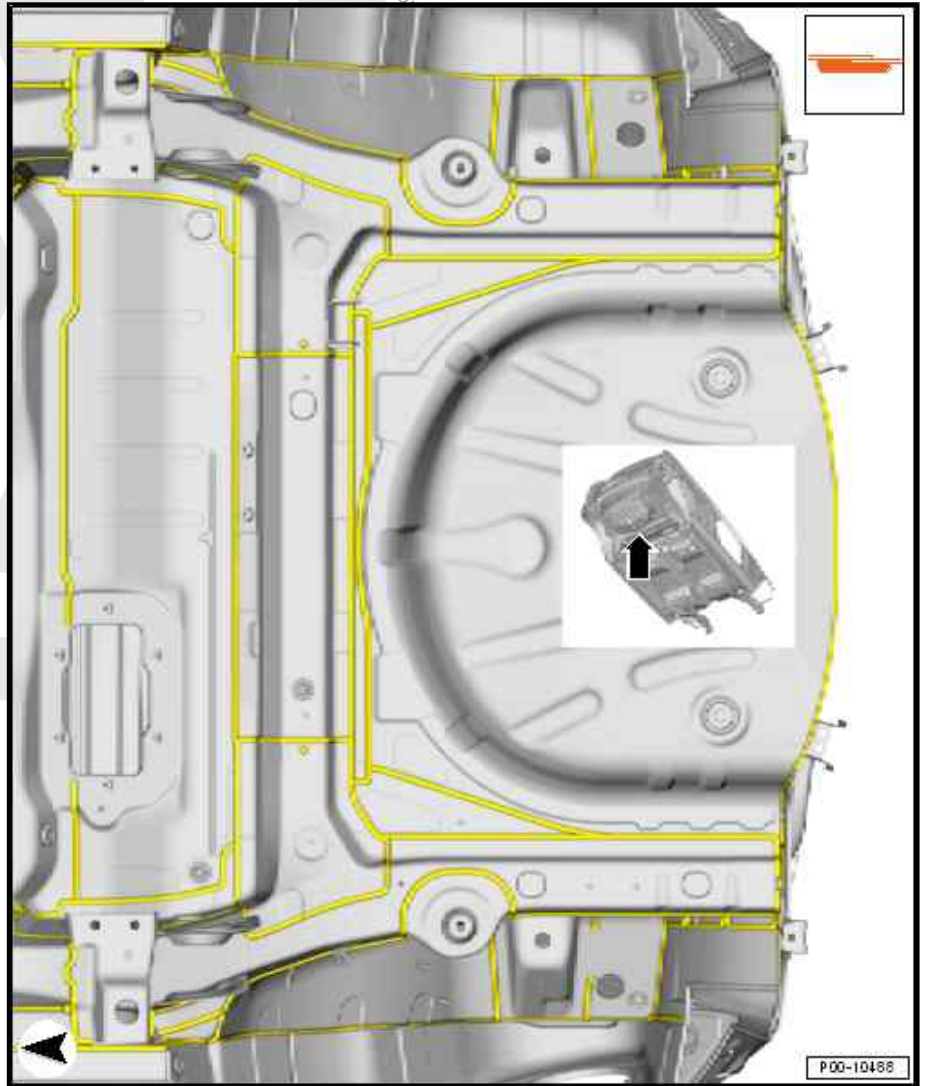
*When smoothing the sealant seam, ensure that the sheet metal edges which are to be protected are not exposed. The metal must be covered with a sufficiently thick layer of PVC.*

#### Seam seals, rear underbody



#### - Coarse seam sealing

- Coarse seam seals require that the sealant be applied at least 8 mm wide and 2 mm high.







## 6 Underseal

⇒ "6.1 Undersealed areas, body overview indicating differing coat thicknesses", page 50

⇒ "6.2 Underseal, protected areas", page 51

### 6.1 Undersealed areas, body overview indicating differing coat thicknesses



#### Note

- ◆ Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.
- ◆ Water drainage holes must remain clear.
- ◆ All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.

#### Underseal overview

##### a - Underseal

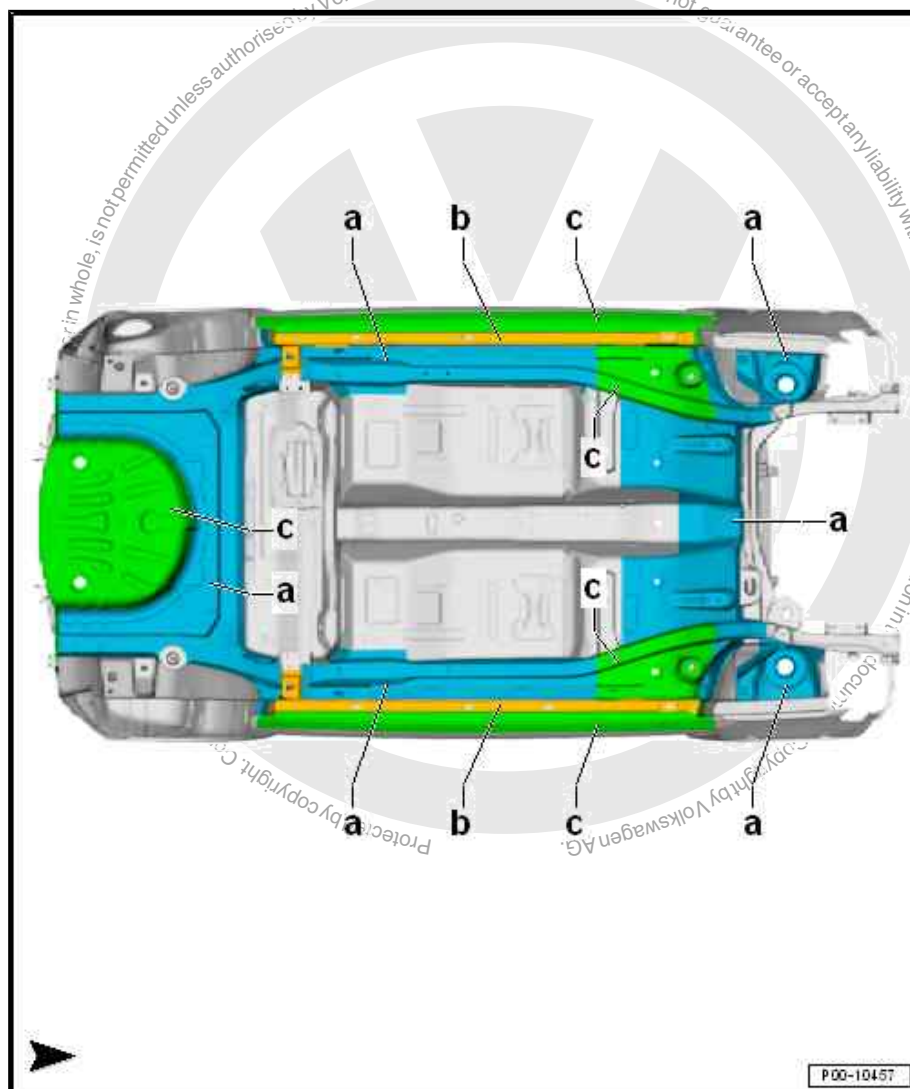
- Coat thickness: 0.3 mm

##### b - Underseal

- Coat thickness: 1.2 mm

##### c - Underseal

- Coat thickness: 0.5 mm







## 6.2 Underseal, protected areas



### Note

- ◆ Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.
- ◆ Water drainage holes must remain clear.
- ◆ All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.

### Underseal, front left wheel housing

Illustration shows left side. The right side is the mirror image.

#### a - Underseal

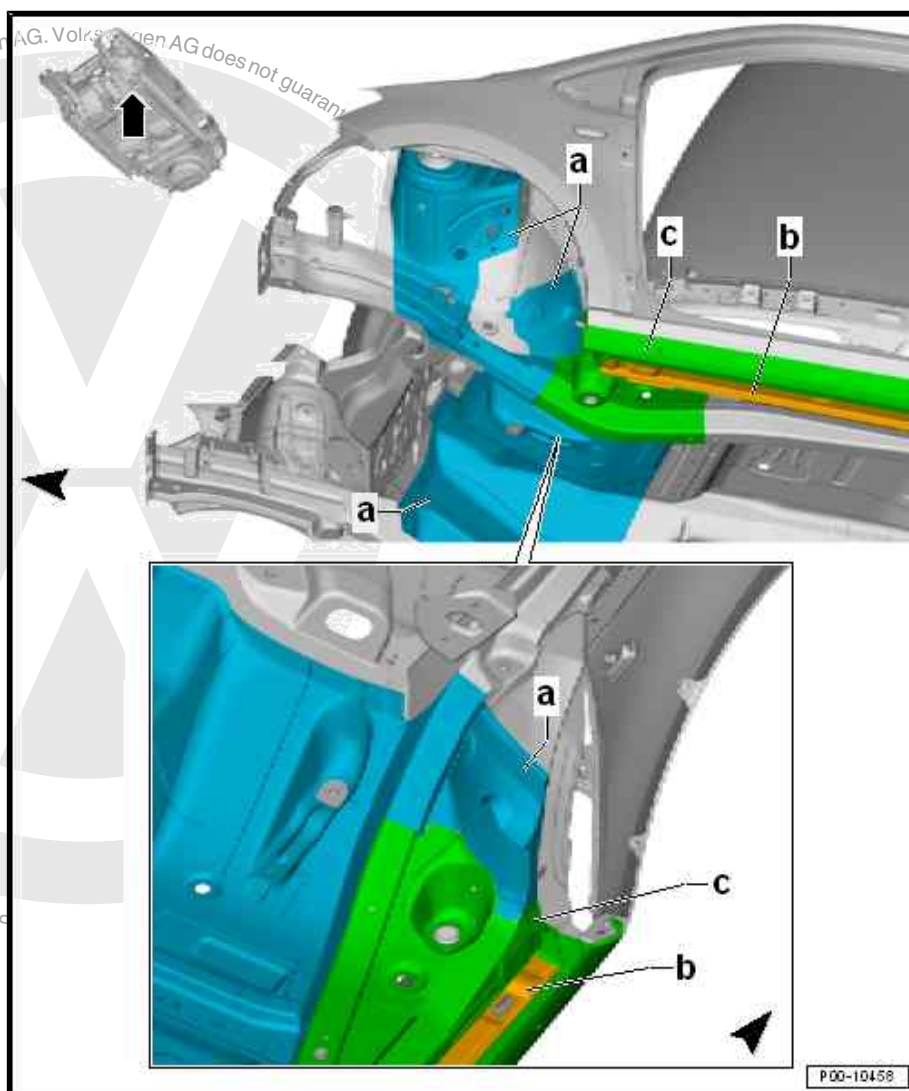
- Coat thickness: 0.3 mm

#### b - Underseal

- Coat thickness: 1.2 mm

#### c - Underseal

- Coat thickness: 0.5 mm





## Note

- ◆ Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.
- ◆ Water drainage holes must remain clear.
- ◆ All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.

## Undercoating, front

The left side is shown in the magnifying glass view. The right side is the mirror image.

### a - Underseal

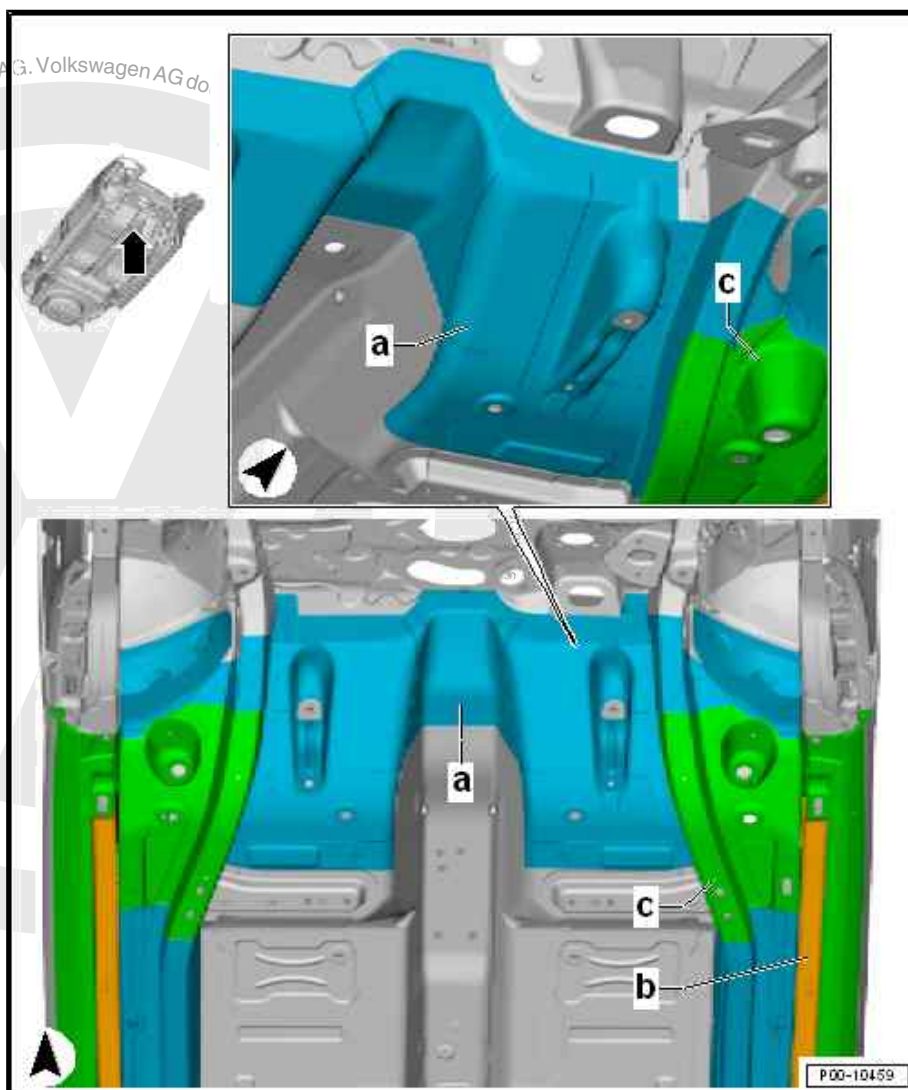
- Coat thickness: 0.3 mm

### b - Underseal

- Coat thickness: 1.2 mm

### c - Underseal

- Coat thickness: 0.5 mm





## Note

- ◆ *Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.*
- ◆ *Water drainage holes must remain clear.*
- ◆ *All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.*

## Undercoating with sectional view of side

Illustration shows left side. The right side is the mirror image.

### a - Underseal

- Coat thickness: 0.3 mm

### b - Underseal

- Coat thickness: 1.2 mm

### c - Underseal

- Coat thickness: 0.5 mm

### - Dimension -x-

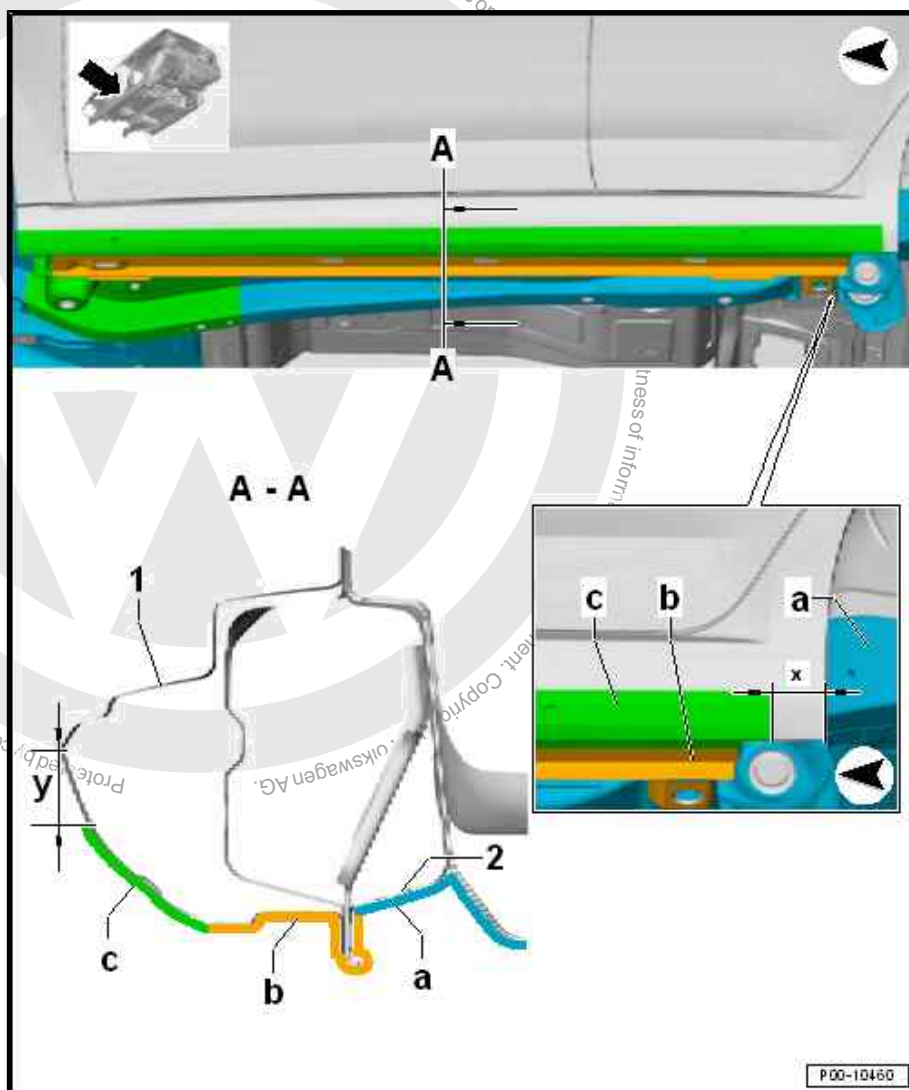
- 30 mm

### - Dimension -y-

- 25 mm

### 1 - Outer side panel

### 2 - Inner side member



## Note

- ◆ *Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.*
- ◆ *Water drainage holes must remain clear.*
- ◆ *All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.*



## Undercoating in area of side member

Illustration shows left side. The right side is the mirror image.

### a - Underseal

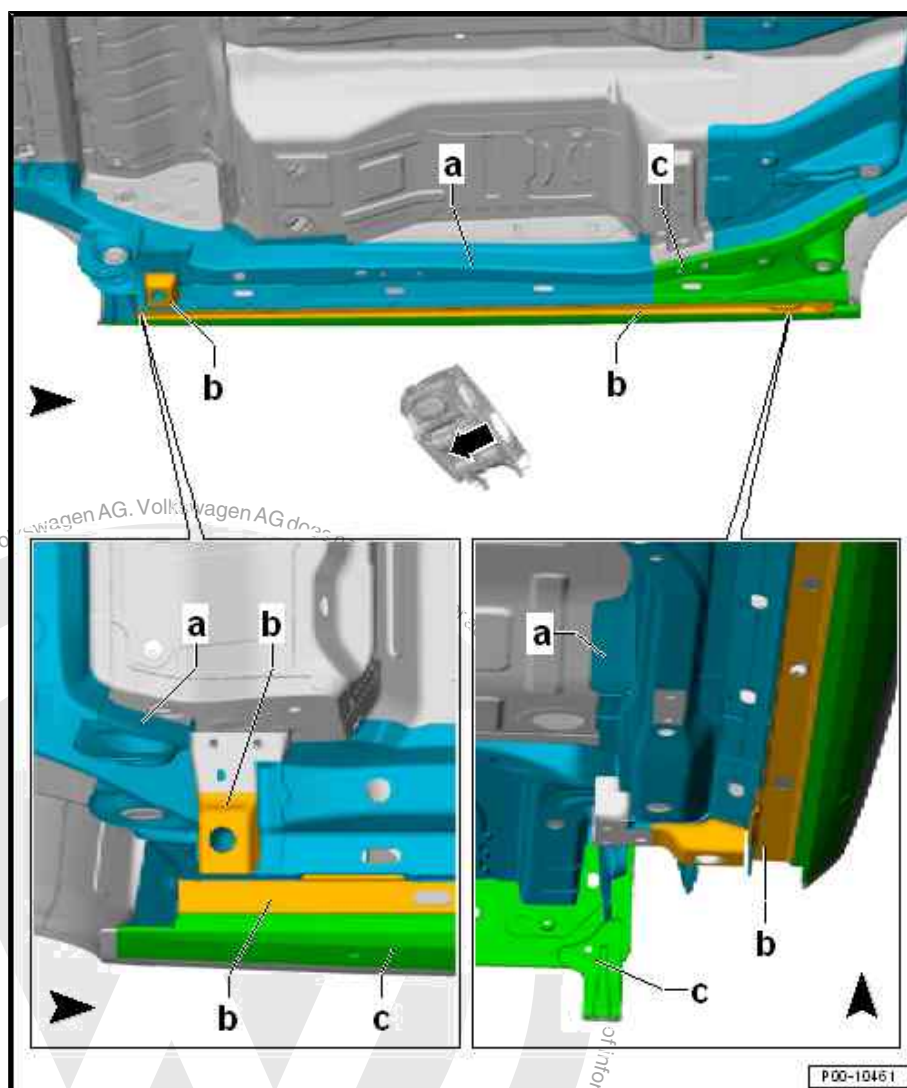
- Coat thickness: 0.3 mm

### b - Underseal

- Coat thickness: 1.2 mm

### c - Underseal

- Coat thickness: 0.5 mm



### Note

- ◆ Underseal (stone-chipping protection) applied during repair work must be identical in appearance and thickness to the original underseal.
- ◆ Water drainage holes must remain clear.
- ◆ All threaded studs and welded nuts with metric threads as well as all other studs and contact surfaces for assembly must be functional following the application of the underseal.

## Undercoating, rear wheel housing

Illustration shows left side. The right side is the mirror image.



**a - Underseal**

- ☐ Coat thickness: 0.3 mm

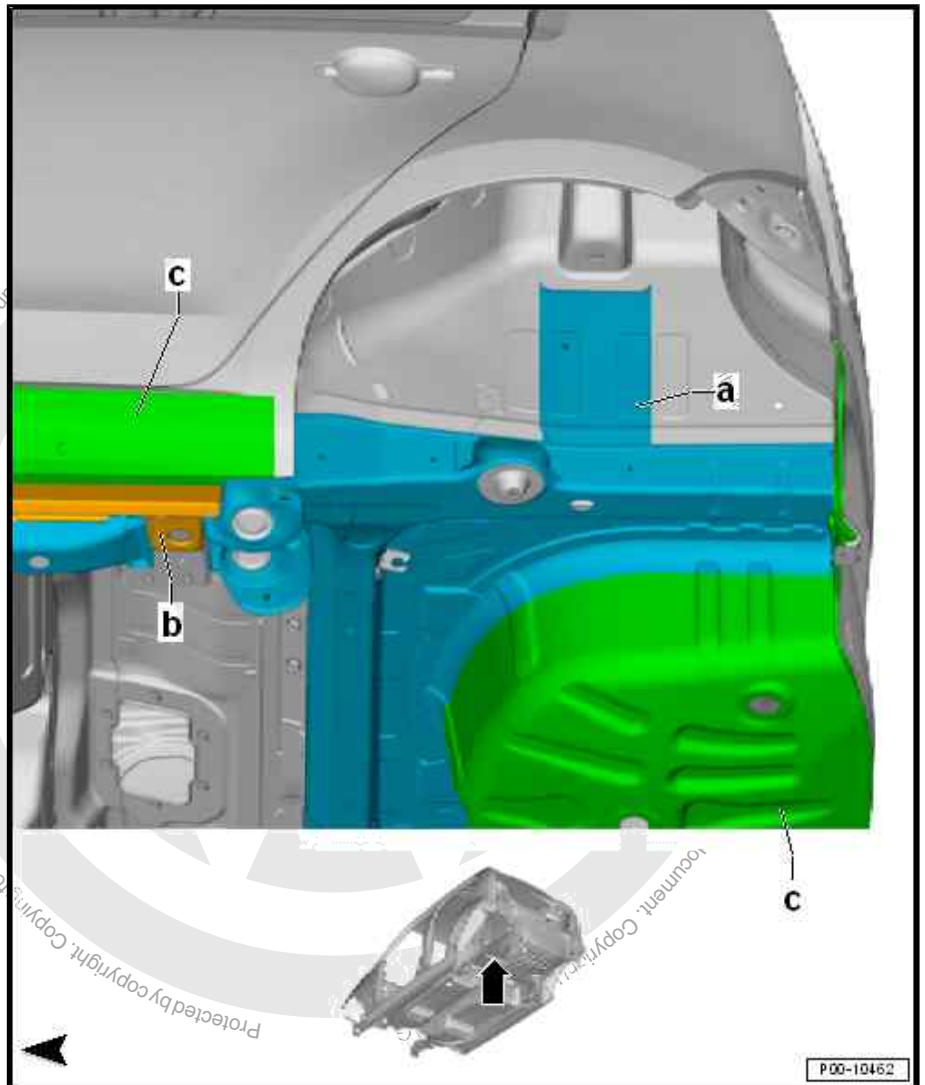
**b - Underseal**

- ☐ Coat thickness: 1.2 mm

**c - Underseal**

- ☐ Coat thickness: 0.5 mm

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Underseal, rear





**a - Underseal**

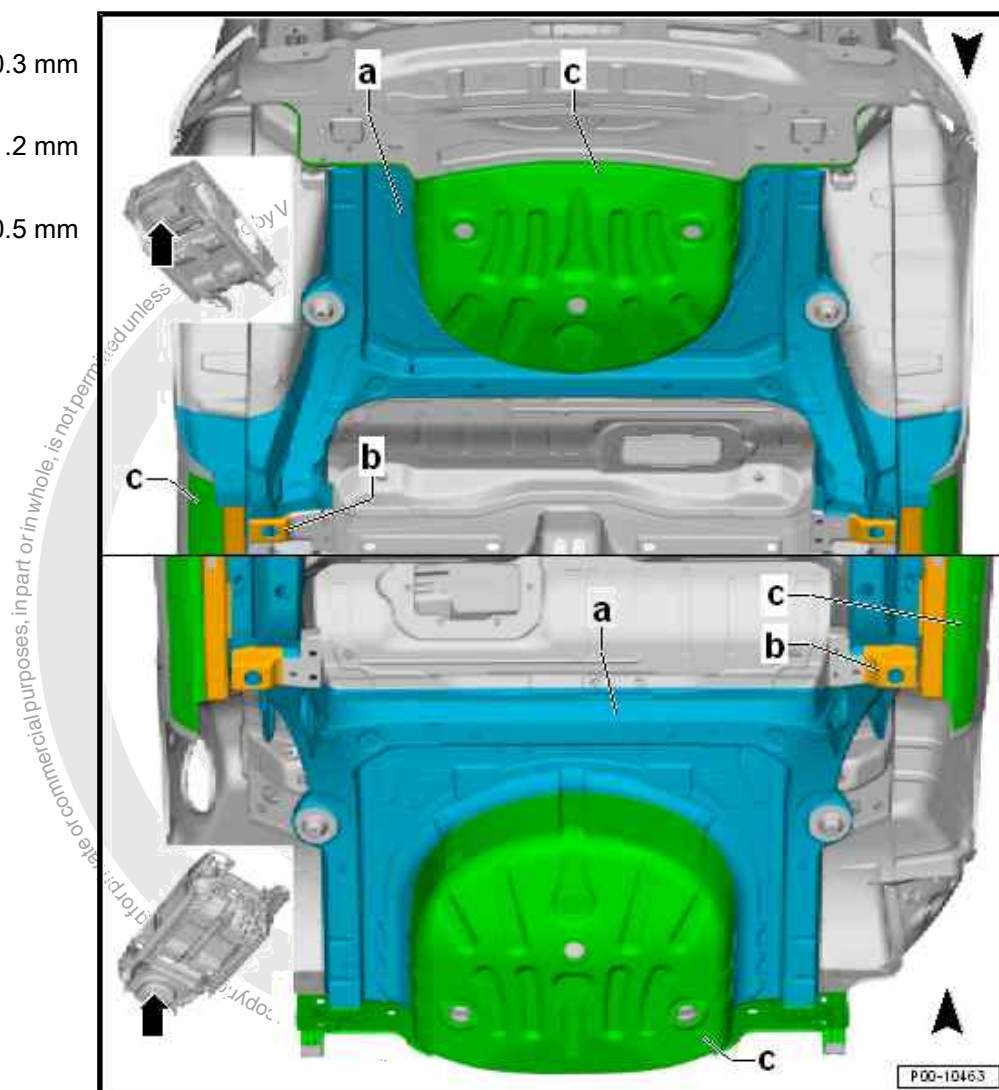
- Coat thickness: 0.3 mm

**b - Underseal**

- Coat thickness: 1.2 mm

**c - Underseal**

- Coat thickness: 0.5 mm







## 7 Cavity sealing

⇒ [“7.1 Cavity sealing, overview of body”, page 57](#)

⇒ [“7.2 Cavity sealing, front body”, page 57](#)

⇒ [“7.3 Cavity sealing, middle body”, page 58](#)

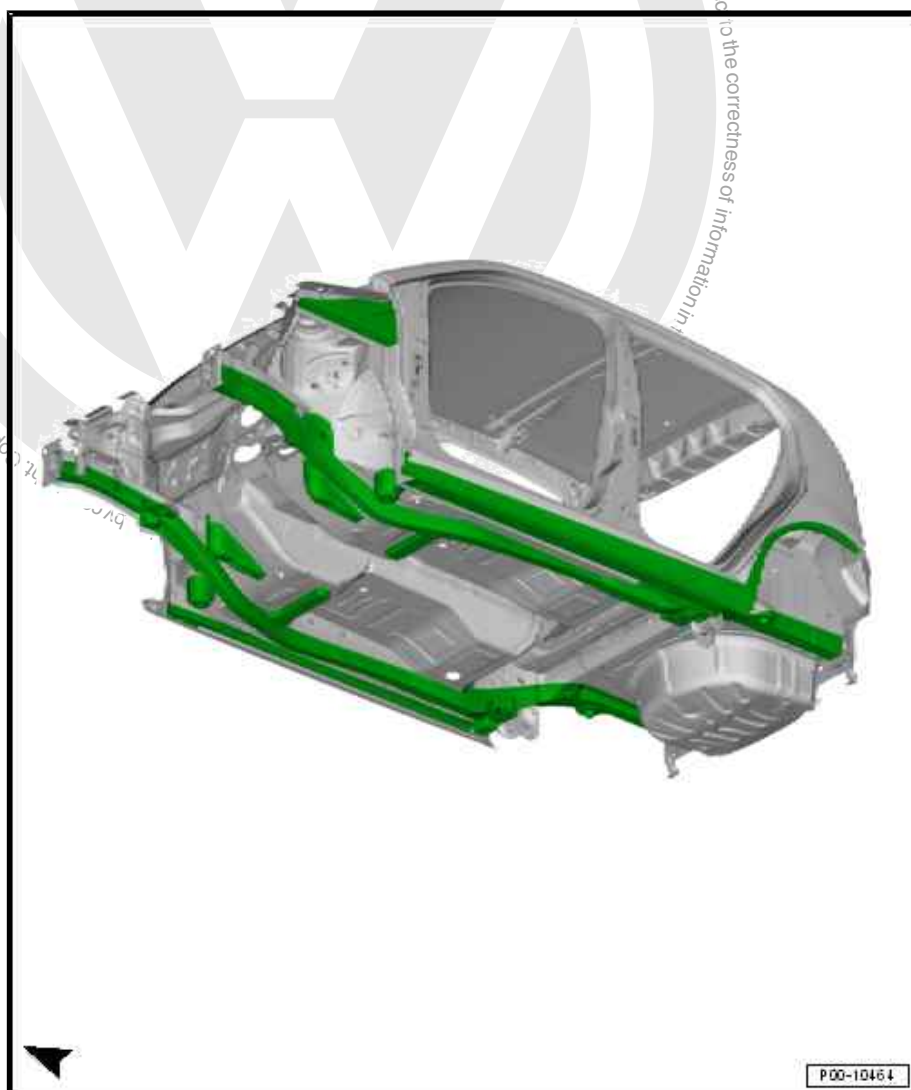
⇒ [“7.4 Cavity sealing, rear body”, page 60](#)

### 7.1 Cavity sealing, overview of body



#### Note

*The indicated areas have been treated with cavity sealant and must be resealed following repairs.*



### 7.2 Cavity sealing, front body



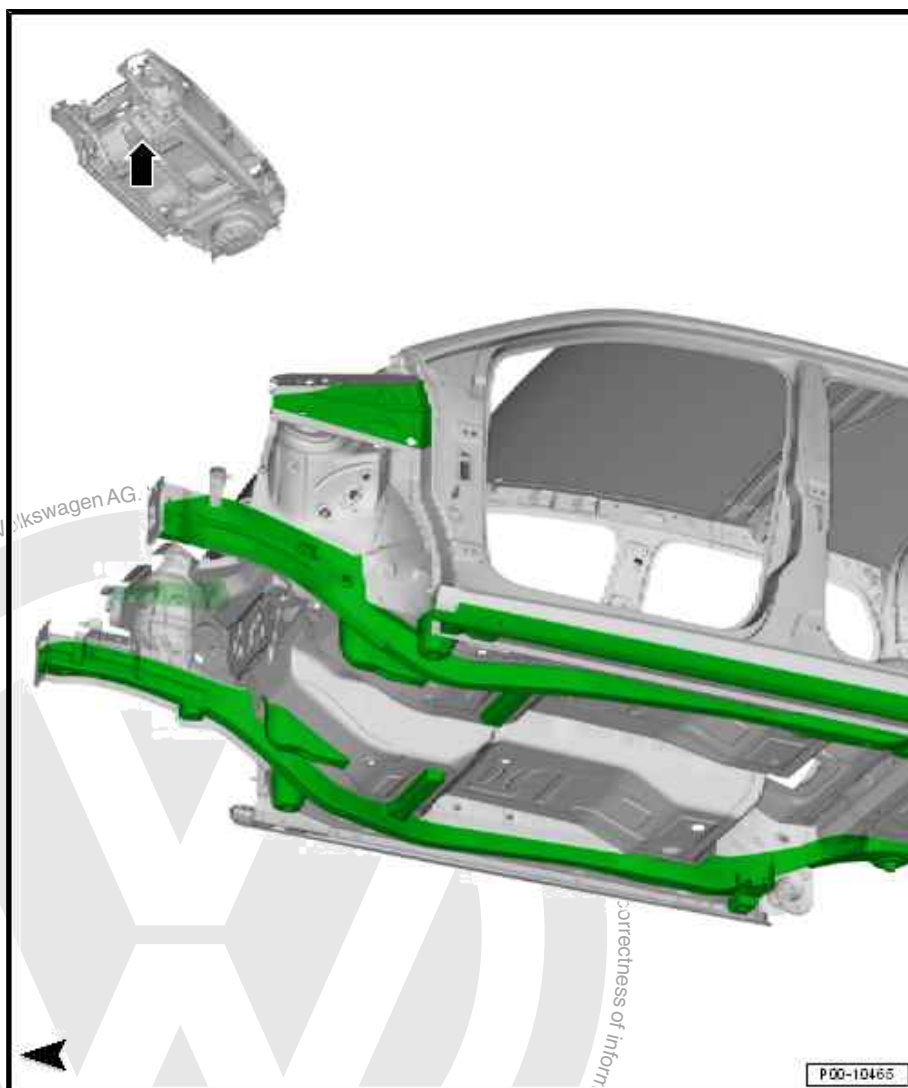
#### Note

*The indicated areas have been treated with cavity sealant and must be resealed following repairs.*



## Cavity sealing, front body

Illustration shows left side. The right side is the mirror image.



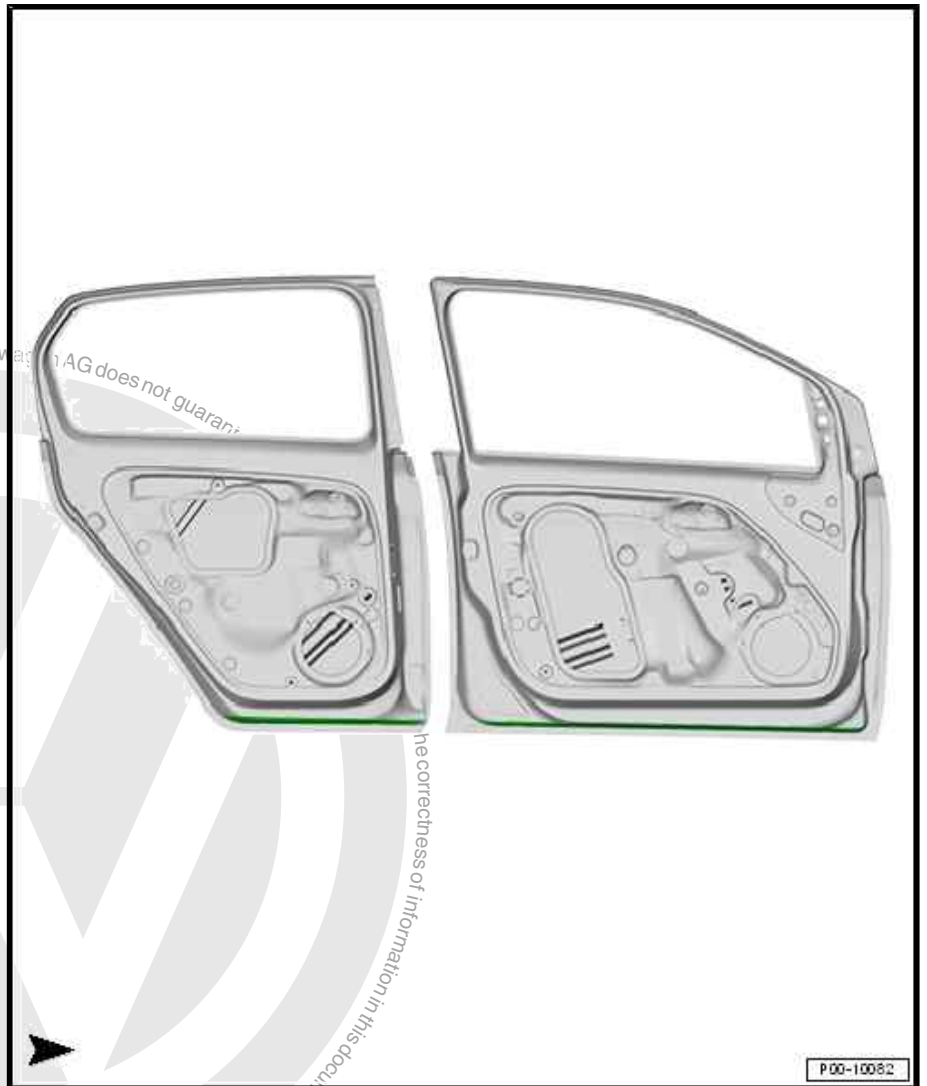
## 7.3 Cavity sealing, middle body



### Note

*The indicated areas have been treated with cavity sealant and must be resealed following repairs.*

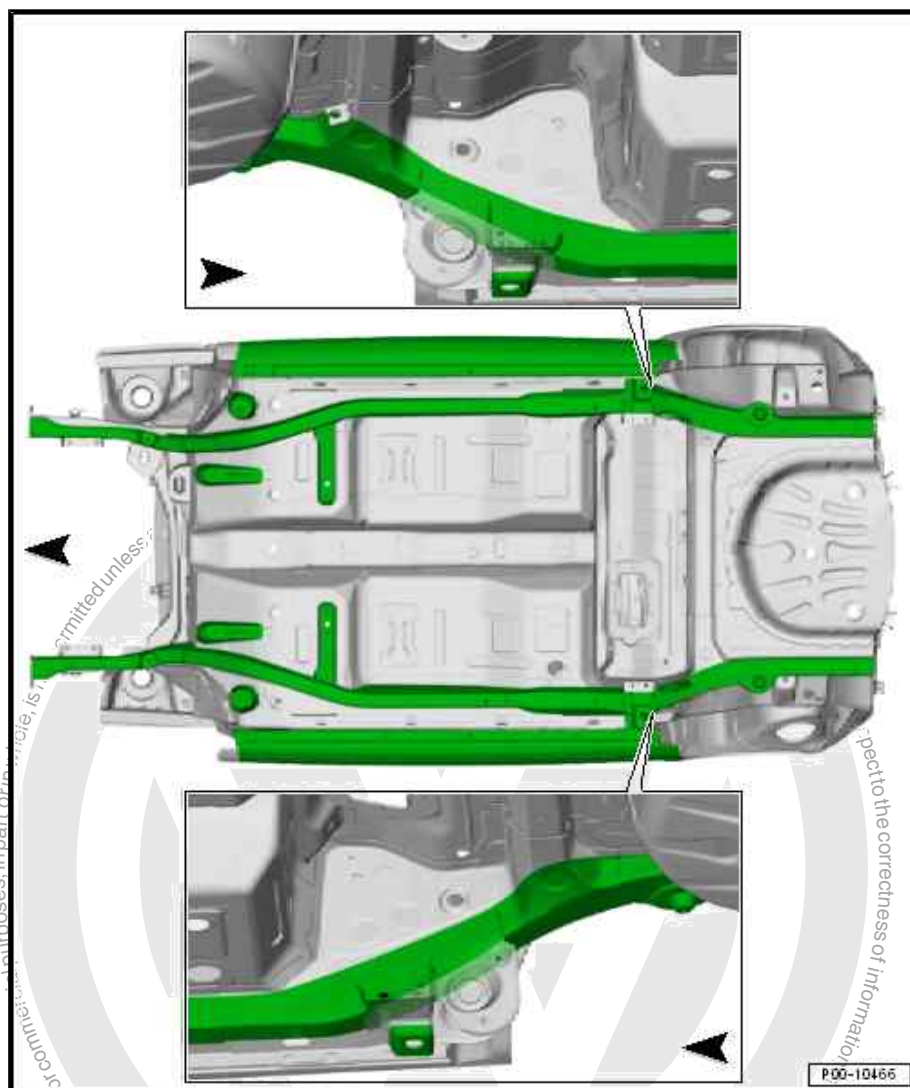
Illustration shows left side. The right side is the mirror image.



### Note

*The indicated areas have been treated with cavity sealant and must be resealed following repairs.*

### Undersealing, cavity sealing



## 7.4 Cavity sealing, rear body



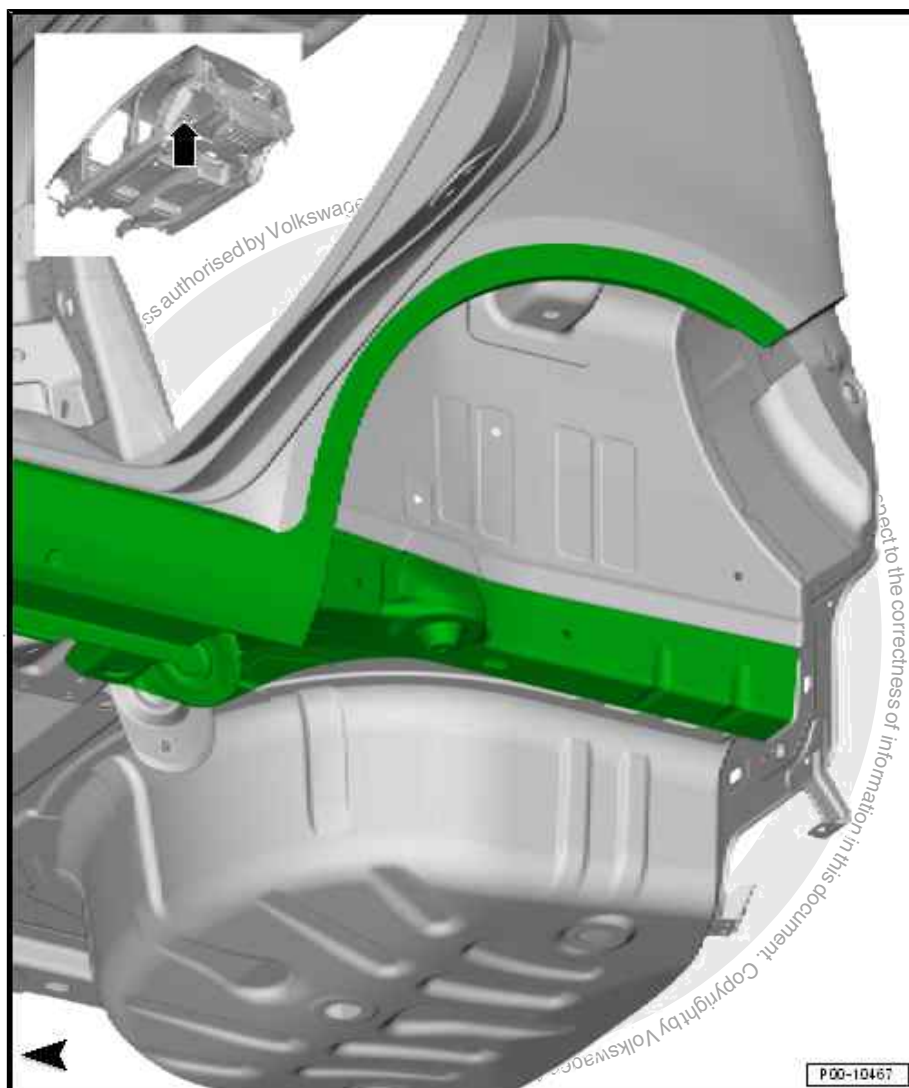
### Note

*The indicated areas have been treated with cavity sealant and must be resealed following repairs.*



## Cavity sealing, side panel and wheel housing

Illustration shows left side. The right side is the mirror image.





## 8 Contrasting colours

⇒ **"8.1 Contrasting colours, roof", page 62**

### 8.1 Contrasting colours, roof

#### 1 - Complete vehicle

- ☐ Standard colour

#### 2 - Roof

- ☐ Colour: black, solid  
»L-041«
- ☐ Colour: Candy White  
»L-B9A«
- ☐ Dimension -x- = 5 mm
- ☐ Dimension  
-y- = 5 to 10 mm

