

VOLKSWAGEN

GROUP OF AMERICA

MARIA COTTER NAME
LEAD CAMPAIGN ADMINISTRATOR TITLE
PRODUCT COMPLIANCE DEPARTMENT
248-754-5000 PHONE
248-754-5093 FAX
JANUARY 29, 2009 DATE

Ms. Delia Lopez
Recall Analyst for Safety Assurance
National Highway Traffic Safety Administration
Attn: Recall Management Division (NVS-215)
U.S. Department of Transportation
1200 New Jersey Avenue, S.E.
Washington, DC 20590

VOLKSWAGEN GROUP OF AMERICA, INC.
3800 HAMLIN ROAD
AUBURN HILLS, MI 48326
PHONE +1 248 754 5000

**Subject: Revised Documents for Recall Campaigns 08V-157 (20L8/JY),
08V-064 (70D1/JX) and 07V-375 (JL00/JL)**

Dear Ms. Lopez:

Pursuant to the requirements set forth in Part 573.6 of Title 49 of the Code of Federal Regulations, we are submitting three (3) copies of the following revised communications for recall campaigns 08V-157 (20L8/JY), 08V-064 (70D1/JX) and 07V-375 (JL00/JL):

- Dealer notification letter
- Work Procedure and Claiming Instructions

If you have any questions or require additional information, please contact me.

Sincerely,



Maria Cotter
Volkswagen Group of America, Inc.
Lead Campaign Administrator
Product Compliance -Service and Quality
Enclosures

Audi of America, Inc.



SAFETY RECALL INFORMATION

Audi of America, Inc.
3800 Hamlin Road
Auburn Hills, MI 48326
United States of America
www.audiusa.com

January 2009

**Subject: Revision to Safety Recalls 20L8/JY, 70D1/JX and JL00/JL
SAGA claim coding instructions**

Dear Service Manager and Warranty Administrator:

This letter is to inform you that the following Safety Recalls have been revised:

20L8/JY – Reinforce Fuel Tank Rollover Valve Nipple

70D1/JX – Replace C-pillar trim cover clip

JL00/JL – Fuel pump replacement

These three Safety Recalls now require the **part number in the material field** to be selected as the causal indicator when entering a claim in SAGA. Please refer to the applicable campaign circular for further details.

Sincerely,

Audi Product Quality and Technical Service

IMPORTANT INFORMATION

Please inform and provide a copy of this document to every person in your dealership with campaign-related responsibilities, including Service, Parts and Accounting personnel. By law, dealers must correct, prior to delivery for sale or lease, any vehicle that fails to comply with an applicable Federal Motor Vehicle Safety Standard or that contains a defect relating to motor vehicle safety. If you have questions regarding this or any other campaign, please call (800) 741-2919.



Safety Recall Circular

Code: 20L8/JY

**Subject: 2001-2004 MY Audi A6 quattro® equipped with 2.7L, 2.8L, or 3.0L
and 2001-2005 MY Audi allroad quattro® equipped with 2.7L or 4.2L
Reinforce Fuel Tank Rollover Valve Nipple**

REVISED January 2009

Revision Summary

Added Causal Indicator to SAGA Claim Entry Procedure chart.

Problem Description

Audi has decided that certain model year A6 allroad quattro vehicles may exhibit aging of the plastic material in the fuel tank rollover valve – combined with bending stress from the aluminum ventilation line to the rollover valve nipple – may lead to cracking of the nipple. If this happens, a fuel leak may result. A fuel leak in the presence of an ignition source could lead to a vehicle fire.

Corrective Action

To prevent or repair cracking at the nipple, dealers will reinforce the nipple on the rollover valve of affected vehicles.

VIN Range and Production Date of Affected Vehicles

U.S.A.

2001-2004 A6 quattro

WAU___4B_1N157331 – WAU___4B_4N104386

2001-2005 allroad quattro

WA1___4B_2N026098 – WA1___4B_5N027457

Production date: June 2, 2001 – June 1, 2005

CANADA

2001-2004 A6 quattro

WAU___4B_1N159360 – WAU___4B_4N100648

2001-2005 allroad quattro

WA1___4B_2N029574 – WA1___4B_5N027348

Production date: June 2, 2001 – June 1, 2005

NOTE: Check ElsaWeb on the day of repair to verify vehicle eligibility and attach the screen print to the repair order. This is the only valid campaign inquiry and verification source. Some vehicles may be involved in an additional action(s); any additional work can be done while the vehicle is in for this action.

Allocation Report of Affected Vehicles

In the Service Manager's Package, dealers with affected vehicles received a report containing the VIN, customer name, city, state and zip code. Dealers did not receive a report if they have no affected vehicles.

Parts Information and Allocation

On or about June 25, 2008 you received an initial allocation of parts. Ensure that these parts are inventoried in a secure manner and are used ONLY for this campaign. If you have exhausted your allocated parts for vehicles affected by this safety recall, but have exceeded your Upper Order Limit, please submit your requests for additional material via email to upperorderlimits@audi.com.

Owner Notification Mailing

On or about June 27, 2008 Audi began customer notification to all known owners of affected vehicles. A sample copy of this letter is enclosed.

Special Tools

Special tools are required for this action:

- Applicator gun VAS 5155
- Feed plunger VAS 5155/3

Dealers received one (1) each of the above-mentioned special tools, free of charge. Additional or replacement tools can be obtained at dealer expense by calling Equipment Solutions at 1 (800) 892-9650.

Claim Entry Procedure

Immediately upon completion of the repair work, enter the Repair Operation(s) from the chart on the following page and the **Applicable Criteria ID that is shown in ElsaWeb**. Claims will only be paid for vehicles that show this campaign open in ElsaWeb on the day of the repair. To help ensure prompt and proper payment, attach the screen print to the repair order.

Saga Claim Entry Procedure

Check in the system Service-Online, FISH (VSI), to determine whether the "20L8" campaign is open.

Service No.: 20L8

Damage Code: 0099

Parts Manufacturer - Removed part: Use vendor code 002.

Causal indicator - Select Repair Kit, part number 4B0 298 403 as Causal Part. NEW

Claim Type

Sold vehicle = 7 10

Unsold vehicle = 7 90

Criteria Code 4B

- Check fuel tank rollover valve; if mold is present & repair is completed, NO further work required

Repair operation: 2010 01 99

20 TU

Criteria Code 4B

- Reinforce fuel tank rollover valve nipple

Repair operation: 2010 05 99

200 TU

1	Repair kit	4B0 298 403
6	Bolt	N 019 926 1
1	Gasket	183 521 141A
2	191 253 141F	Exhaust clamp (if needed)
2	Mixing nozzle	D 001 001
2	3M™ adhesive	Z3MDP8005
0.10	Butyl adhesive/sealant	AKL 450 005 05

There is NO reimbursement for Vehicle Wash

Outside Labor

Loaner (one day max.)

LOAN16D1

up to \$40(USD) \$40(CAD)

If Customer Refuses Repairs:

Fax the Repair Order to VWoA at (248) 754-5093 and provide VIN, applicable Service Number, Customer Information, Dealer Number, and Date.

Customer Letter Example (United States)

June 2008

Subject: Safety Recall JY / 20L8

2001 – 2004 Model Year Audi A6 quattro® vehicles equipped with 2.7L, 2.8L, or 3.0L engine
2001 – 2005 Model Year Audi allroad quattro® vehicles equipped with 2.7L or 4.2L engine
Reinforce Fuel Tank Rollover Valve Nipple

Dear Audi Owner:

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act. Audi has decided that a defect, which relates to motor vehicle safety, exists in some 2001-2004 model year Audi A6 quattro vehicles and some model year 2001-2005 allroad quattro vehicles.

What Is The Issue?

The aging of the plastic material in the fuel tank rollover valve – combined with bending stress from the aluminum ventilation line to the rollover valve nipple – may lead to cracking of the nipple. If this happens, a fuel leak may result. A fuel leak in the presence of an ignition source could lead to a vehicle fire.

What Audi Will Do

To prevent or repair cracking at the nipple, we will reinforce the nipple on the rollover valve.

What We Would Like You To Do

Please contact your authorized Audi dealer and arrange for an appointment without delay. This service will take about six hours and will be free of charge. Please keep in mind that your dealer may need additional time for the preparation of the repair, as well as to accommodate their daily workshop schedule.

To help expedite this repair, we ask that the fuel level in your vehicle be at approximately one-quarter (1/4) tank or less on the day of your scheduled appointment, if possible.

Lease Vehicles

If you are the lessor and registered owner of the vehicle identified in this action, the law requires you to forward this information immediately via first-class mail to the lessee within ten (10) days of receipt of this notification.

Have You Changed Your Address Or Sold The Vehicle?

If you have moved, please fill out the enclosed prepaid Owner Reply card and mail it to us so we can update our records.

Reimbursement of Expenses

If you have previously paid for a repair or replacement of the fuel tank due to leaking at the fuel tank rollover valve nipple, the enclosed form explains how to request reimbursement. We would be pleased to review your reimbursement request.

Service Help from Us

If your authorized Audi dealer fails or is unable to complete this work free of charge within a reasonable time, please call or write to:

Audi of America, Inc.
Attn: Customer Relations (JY / 20L8)
3499 West Hamlin Road
Rochester Hills, MI 48309
1-800-253-2834

If you still cannot obtain satisfaction, you may file a complaint with: Administrator, National Highway Traffic Safety Administration, 1200 New Jersey Avenue S.E., Washington, DC 20590; or call the toll-free Vehicle Safety Hotline at 1-888-327-4236 (TTY: 1-800-424-9153), or go to <http://www.safercar.gov/>.

We regret any inconvenience this matter may cause. Thank you for your continued loyalty!

Audi Product Compliance

The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

Customer Letter Example (Canada)

June 2008

Subject: Safety Recall JY / 20L8

2001 – 2004 Model Year Audi A6 quattro® vehicles equipped with 2.7L, 2.8L, or 3.0L engine

2001 – 2005 Model Year Audi allroad quattro® vehicles equipped with 2.7L or 4.2L engine

Reinforce Fuel Tank Rollover Valve Nipple

Dear Audi Owner:

This notice is sent to you in accordance with the requirements of the Canadian Motor Vehicle Safety Act. Audi has decided that a defect, which relates to motor vehicle safety, exists in some 2001-2004 model year Audi A6 quattro vehicles and some model year 2001-2005 allroad quattro vehicles.

What Is The Issue?

The aging of the plastic material in the fuel tank rollover valve – combined with bending stress from the aluminum ventilation line to the rollover valve nipple – may lead to cracking of the nipple. If this happens, a fuel leak may result. A fuel leak in the presence of an ignition source could lead to a vehicle fire.

What Audi Will Do

To prevent or repair cracking at the nipple, we will reinforce the nipple on the rollover valve.

What We Would Like You To Do

Please contact your authorized Audi dealer and arrange for an appointment without delay. This service will take about six hours and will be free of charge. Please keep in mind that your dealer may need additional time for the preparation of the repair, as well as to accommodate their daily workshop schedule.

To help expedite this repair, we ask that the fuel level in your vehicle be at approximately one-quarter (1/4) tank or less on the day of your scheduled appointment, if possible.

Lease Vehicles

If you are the lessor and registered owner of the vehicle identified in this action, the law requires you to forward this information immediately via first-class mail to the lessee within ten (10) days of receipt of this notification.

Have You Changed Your Address Or Sold The Vehicle?

If you have moved, please fill out the enclosed prepaid Owner Reply card and mail it to us so we can update our records.

Reimbursement of Expenses

If you have previously paid for a repair or replacement of the fuel tank due to leaking at the fuel tank rollover valve nipple, the enclosed form explains how to request reimbursement. We would be pleased to review your reimbursement request.

Service Help from Us

If your authorized Audi dealer fails or is unable to complete this work free of charge within a reasonable time, please call or write to:

*Audi Canada
Attn: Customer Relations (JY / 20L8)
P.O. Box 842 STN. A
Windsor, ON N9A 9Z9
1-800-253-2834*

We regret any inconvenience this matter may cause. Thank you for your continued loyalty!

Audi Product Compliance

The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

Campaign Work Procedure

20L8/JY Safety Recall

If there are questions regarding the work procedure, contact the Campaign Helpline at 1-800-741-2919.

Parts:

Quantity	Part Number	Part Name
1	4B0 298 403	Repair kit
		<div>Contents:<ul style="list-style-type: none">- Mold for adhesive- Spacer plate- Serrated rubber clip- Washer 2x- Cleaning fluid- Socket head flange bolt M8x35</div>
6	N 019 9261	Bolt
1	183 521 141A	Gasket
2	191 253 141F	Dual exhaust clamp (if needed)
2	D 001 001	Mixing nozzle
2	Z3MDP8005	3M™ adhesive (See shelf-life charts on Pages 6 and 7)
0.10	AKL 450 005 05	Butyl adhesive/sealant cord

The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

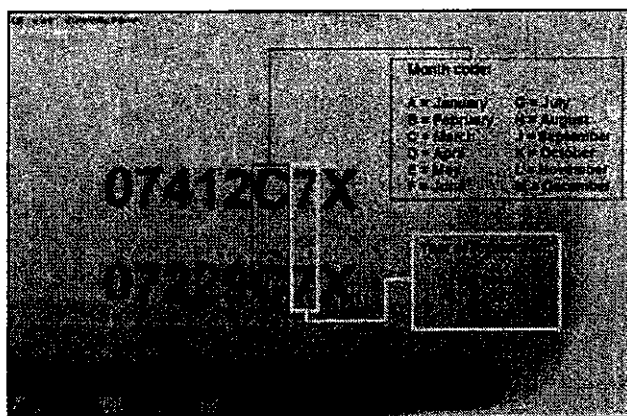
3M™ Adhesive Storage / Expiration

- Shelf life 6 months @ 40°F (5°C)
- Shelf life 3 months @ room temperature
- DO NOT STORE AT EXCESSIVE TEMPERATURES

DATE CODING FOR Z3M DP8 005 ADHESIVE

THERE ARE 2 CODING METHODS. BOTH REPRESENT SHIP DATE.

FIRST METHOD	
Example: 08123A8W	
FIRST 5 DIGITS (08123) = LOT NUMBER	
FIRST LETTER (A or 6th character) = MONTH OF MANUFACTURE	
A =	JANUARY
B =	FEBRUARY
C =	MARCH
D =	APRIL
E =	MAY
F =	JUNE
G =	JULY
H =	AUGUST
J =	SEPTEMBER
K =	OCTOBER
L =	NOVEMBER
M =	DECEMBER
NUMBER AFTER FIRST LETTER (8) = YEAR OF MANUFACTURE	
8 =	2008
9 =	2009
FINAL LETTER (W) = PACKAGING LOCATION	



- Check 3M™ adhesive production date by referencing 3M™ Adhesive Storage / Expiration chart above



Note: Ensure product is not expired

Discard expired 3M™ adhesive

⇐ Production date located on 3M™ adhesive tube label

The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

SECOND METHOD

Example: 8206AZ

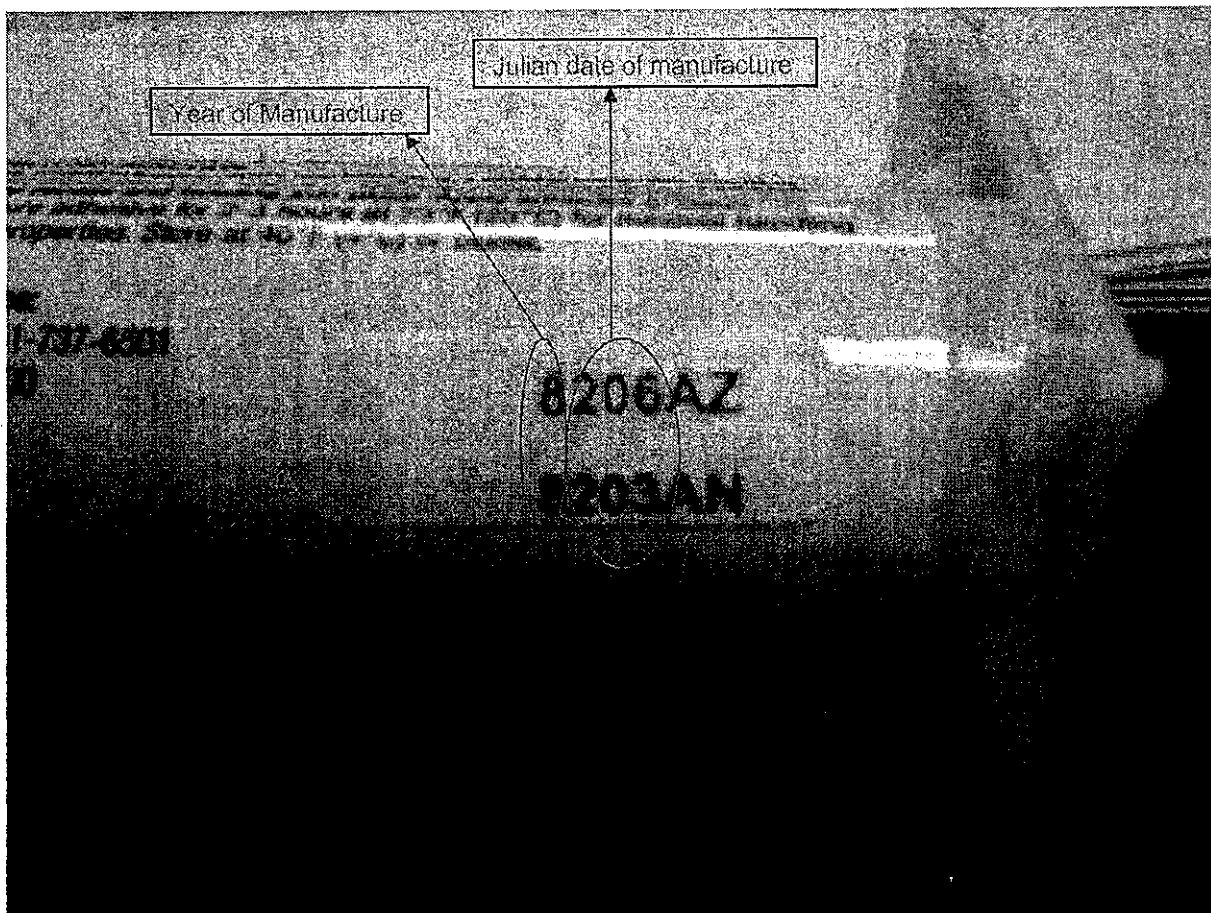
FIRST NUMBER (8) = YEAR OF MANUFACTURE

SECOND 3 DIGITS (206) = JULIAN DATE OF
MANUFACTURE

(See conversion chart on next page for Gregorian date)

In this case 206th day of 365

LAST 2 CHARACTERS (AZ) = LOT CODE (random, not sequential)



The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

Gregorian to Julian conversion calendar

January													February							March						
													19	20	21	22	23	24	25	47	48	49	50	51	52	53
													1	2	3	4	5	6	7	1	2	3	4	5	6	7
356	357	358	359	360	361	362							26	27	28	29	30	31	32	54	55	56	57	58	59	60
4	5	6	7	8	9	10							8	9	10	11	12	13	14	8	9	10	11	12	13	14
363	364	365	1	2	3	4							33	34	35	36	37	38	39	61	62	63	64	65	66	67
11	12	13	14	15	16	17							15	16	17	18	19	20	21	15	16	17	18	19	20	21
5	6	7	8	9	10	11							40	41	42	43	44	45	46	68	69	70	71	72	73	74
18	19	20	21	22	23	24							22	23	24	25	26	27	28	22	23	24	25	26	27	28
12	13	14	15	16	17	18														75	76	77				
25	26	27	28	29	30	31														29	30	31				

April													May							June						
82	83	84	85	86	87	88							110	111	112	113	114	115	116	145	146	147	148	149	150	151
5	6	7	8	9	10	11							3	4	5	6	7	8	9	7	8	9	10	11	12	13
89	90	91	92	93	94	95							117	118	119	120	121	122	123	152	153	154	155	156	157	158
12	13	14	15	16	17	18							10	11	12	13	14	15	16	14	15	16	17	18	19	20
96	97	98	99	100	101	102							124	125	126	127	128	129	130	159	160	161	162	163	164	165
19	20	21	22	23	24	25							17	18	19	20	21	22	23	21	22	23	24	25	26	27
103	104	105	106	107									131	132	133	134	135	136	137	166	167	168				
26	27	28	29	30									24	25	26	27	28	29	30	28	29	30				
													138													
													31													

July													August							September						
173	174	175	176	177	178	179							201	202	203	204	205	206	207	236	237	238	239	240	241	242
5	6	7	8	9	10	11							2	3	4	5	6	7	8	6	7	8	9	10	11	12
180	181	182	183	184	185	186							208	209	210	211	212	213	214	243	244	245	246	247	248	249
12	13	14	15	16	17	18							9	10	11	12	13	14	15	13	14	15	16	17	18	19
187	188	189	190	191	192	193							215	216	217	218	219	220	221	250	251	252	253	254	255	256
19	20	21	22	23	24	25							16	17	18	19	20	21	22	20	21	22	23	24	25	26
194	195	196	197	198	199								222	223	224	225	226	227	228	257	258	259	260			
26	27	28	29	30	31								23	24	25	26	27	28	29	27	28	29	30			
													229	230												
													30	31												

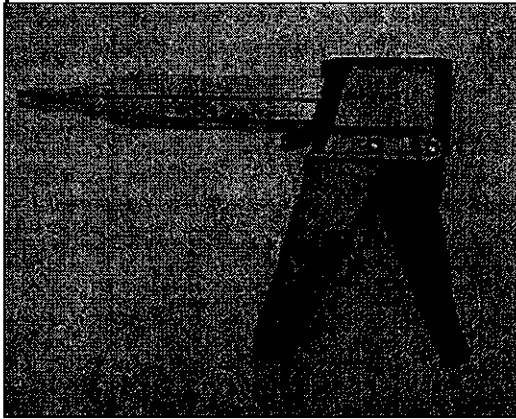
October													November							December						
264	265	266	267	268	269	270							292	293	294	295	296	297	298	327	328	329	330	331	332	333
4	5	6	7	8	9	10							1	2	3	4	5	6	7	6	7	8	9	10	11	12
271	272	273	274	275	276	277							299	300	301	302	303	304	305	334	335	336	337	338	339	340
11	12	13	14	15	16	17							8	9	10	11	12	13	14	13	14	15	16	17	18	19
278	279	280	281	282	283	284							306	307	308	309	310	311	312	341	342	343	344	345	346	347
18	19	20	21	22	23	24							15	16	17	18	19	20	21	20	21	22	23	24	25	26
285	286	287	288	289	290	291							313	314	315	316	317	318	319	348	349	350	351	352		
25	26	27	28	29	30	31							22	23	24	25	26	27	28	27	28	29	30	31		
													320	321												
													29	30												

Blue = Julian Date

* In case of leap year add one day after February 28

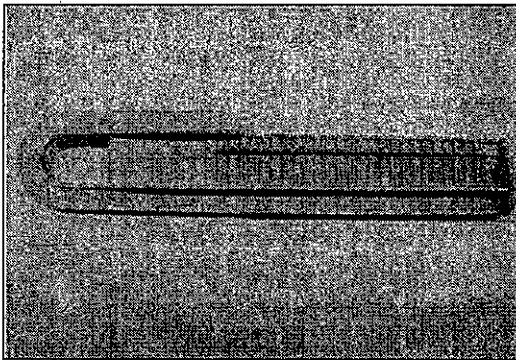
The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

Special Tools:



⇐ Applicator gun VAS 5155

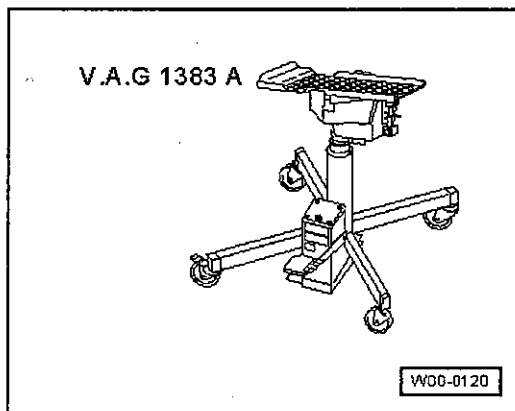
(Dealers will receive one (1) each of these tools, free of charge. Additional or replacement tools can be obtained at dealer expense by calling Equipment Solutions at 1(800) 892-9650.



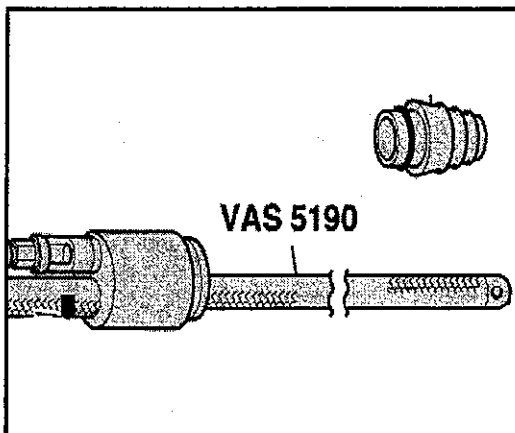
⇐ Feed plunger VAS 5155/3

(for glue cartridge with mixing ratio 1:10)

(Dealers will receive one (1) each of these tools, free of charge. Additional or replacement tools can be obtained at dealer expense by calling Equipment Solutions at 1(800) 892-9650.)



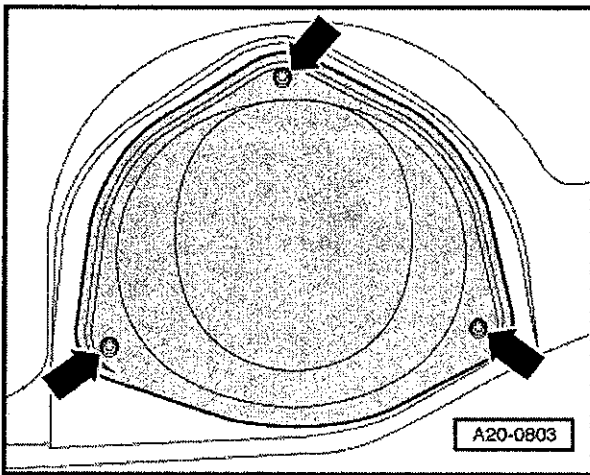
⇐ V.A.G. 1383 A with universal support V.A.G. 1359/2 or equivalent



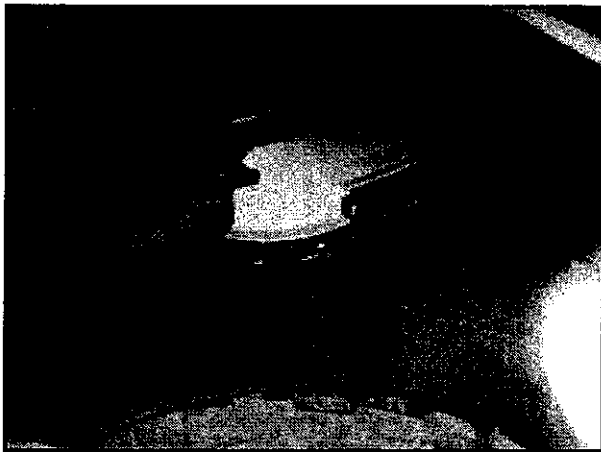
⇐ Fuel siphoning device VAS 5190 or equivalent

The information in this document is intended for use only by skilled technicians who have the proper tools, equipment and training to correctly and safely maintain your vehicle. These procedures are not intended to be attempted by "do-it-yourselfers," and you should not assume this document applies to your vehicle, or that your vehicle has the condition described. To determine whether this Information applies, contact an authorized Audi dealer. ©2008 Audi of America LLC and Audi Canada. All Rights Reserved.

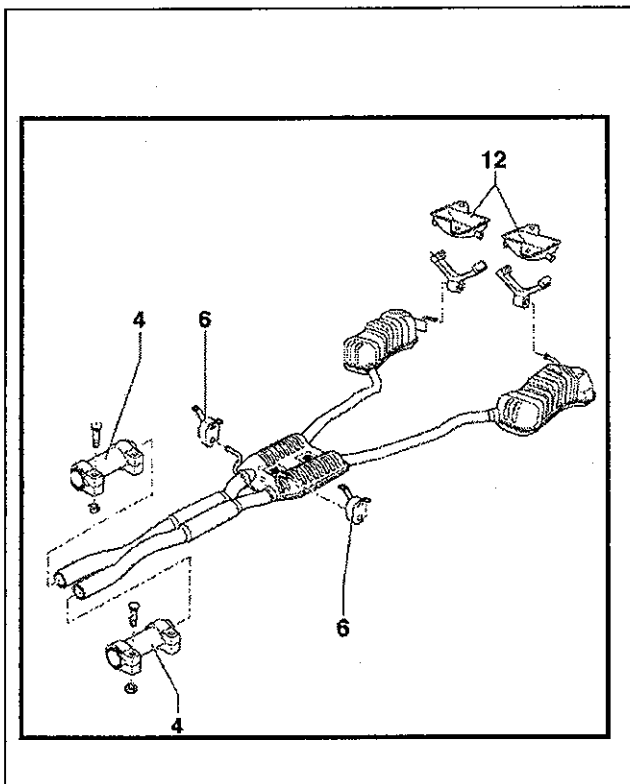
Section A – Inspection



- Remove rear seat bench
- ⇐ Remove cover for flange on fuel tank under rear seat bench (driver side)



If black mold (shown white in picture) and 3M™ adhesive are present, no further work is required; otherwise, proceed to Section B



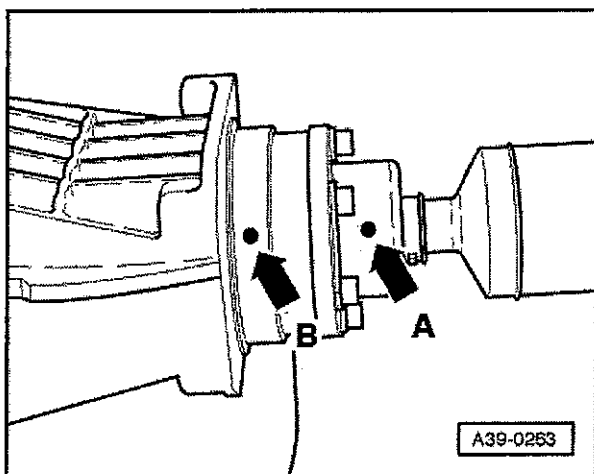
Section B – Preparation For Access To Breather Valve

- Check fuel level and note quantity. If more than $\frac{1}{4}$ tank, drain fuel using siphoning device VAS 1590 or equivalent

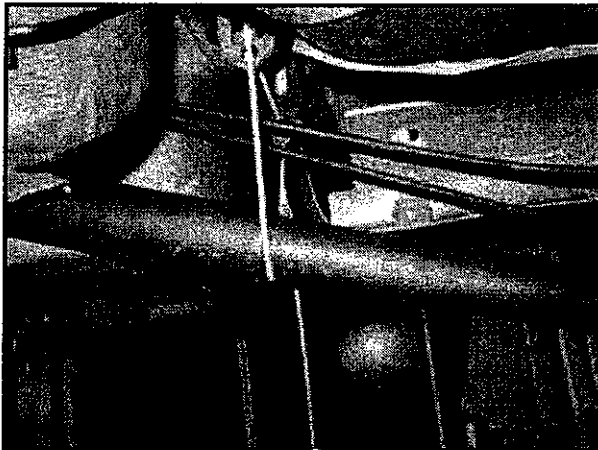


Tip: Advise customers to bring in vehicles with low fuel in tank
If fuel tank is full, empty fuel tank

- Lift vehicle
- ⇐ Disconnect rear exhaust at clamps -4-
- ⇐ With assistance of another person, disconnect rear support brackets -12- and -6- and lower exhaust onto floor
- Move exhaust from underneath vehicle and place aside



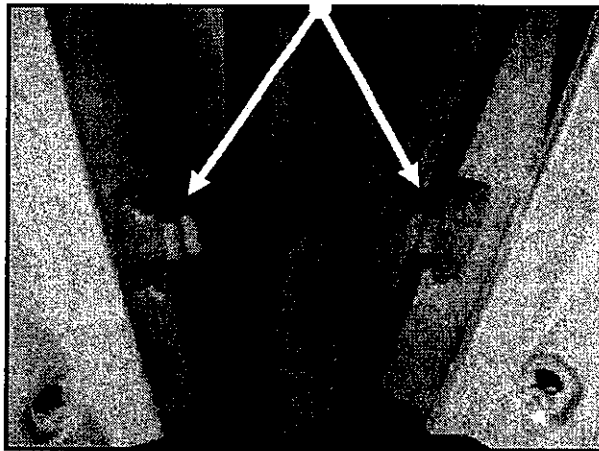
- ⇐ Check whether there is a factory marking (paint) on driveshaft. If not, mark location of driveshaft flange -arrow A- to rear final drive -arrow B-



⇐ Detach driveshaft from rear final drive, lower it slightly (max. permissible angle 15°) and tie wrap to exhaust system brackets

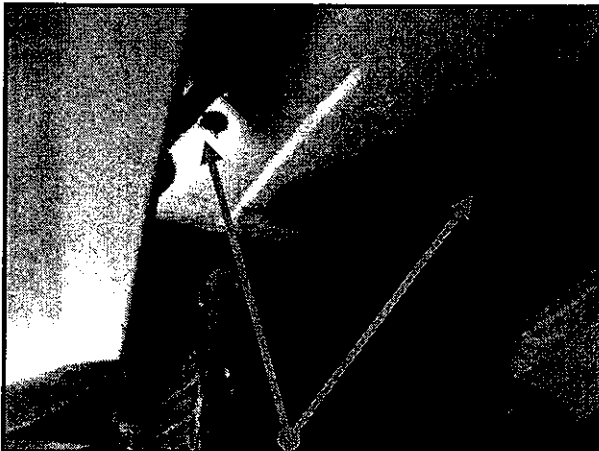


Note: To prevent damage to transmission ensure driveshaft not lowered more than 15°



⇐ Detach parking brake cable from heat shield clips located on each side of the driveshaft

- Support fuel tank with V.A.G. 1383 A with universal support V.A.G. 1359/2
- Detach fuel tank retaining straps and carrier plate



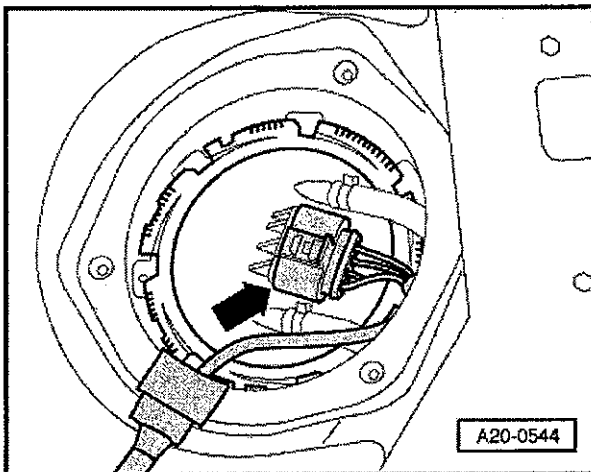
⇐ Remove 2 bolts in heat shield above rear differential and driveshaft -arrows-



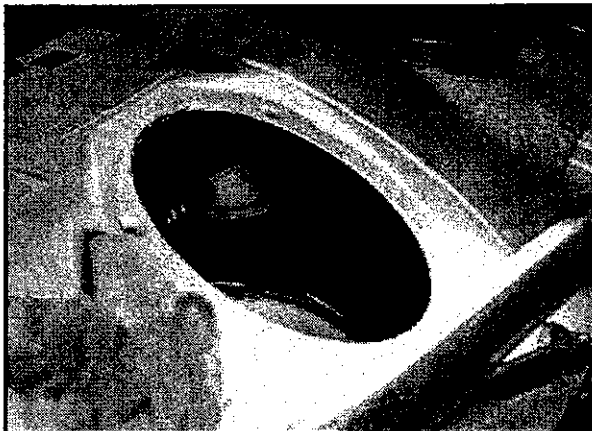
- ⇐ Lower fuel tank as far as rear final drive
(Tank can rest on rear final drive as shown)



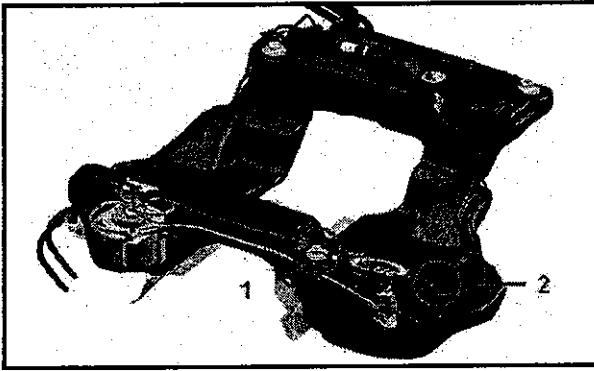
Note: Fuel tank is not removed completely from vehicle



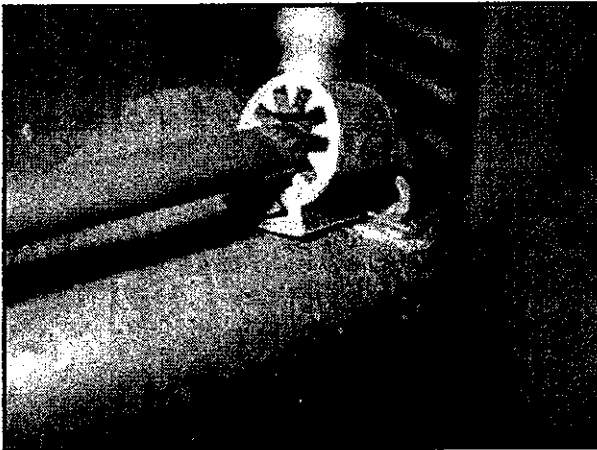
- Lower vehicle
- ⇐ Carefully release 4-pin connector -arrow- and disconnect harness for fuel sending unit



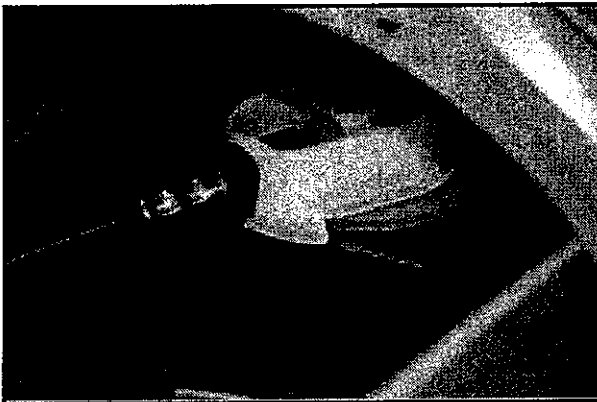
- ⇐ Clean rollover valve carefully with cleaning fluid (D 009 401 04) to ensure valve is free of dust and grease



- ⇐ Install serrated rubber clip -2- from kit (4B0 298 403) onto ventilation line leading to rollover valve connection and release clip from mounting on fuel tank



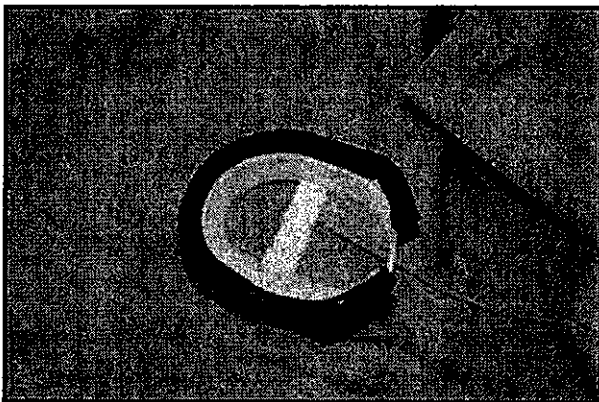
- ⇐ Close rubber clip and allow ventilation line to rest on fuel tank (as shown); **proceed to Section C**



Section C – Servicing Rollover Valve

- Test fitting of the mold
- ⇐ To ensure proper fit, place mold for adhesive in position on rollover valve **without** butyl cord

Note: Mold must be pushed toward hose connection and shoulder of mold must fit against flange of fuel tank -arrow-, not against the flange of the rollover valve



⇐ Remove mold from rollover valve, then place butyl cord around mold



Note: Leave an opening for the ventilation line connection

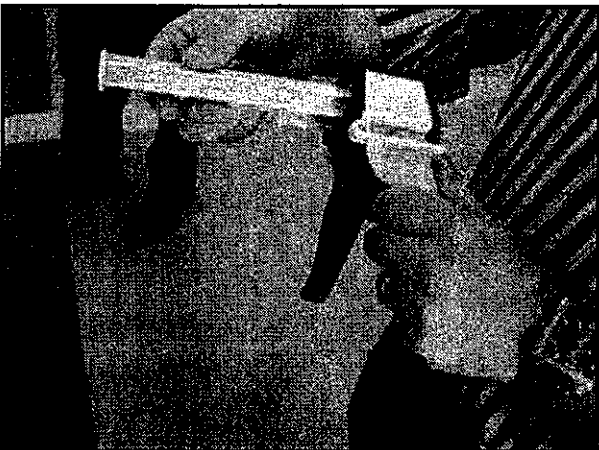


- Install mold with butyl sealant cord (AKL 450 005 05) into position over rollover valve

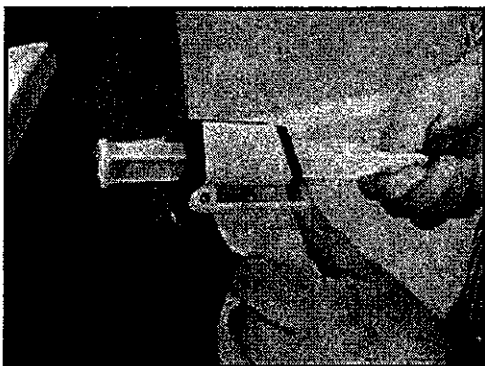
⇐ Seal off remaining openings at the connection with the butyl sealant cord (AKL 450 005 05)
-arrow-



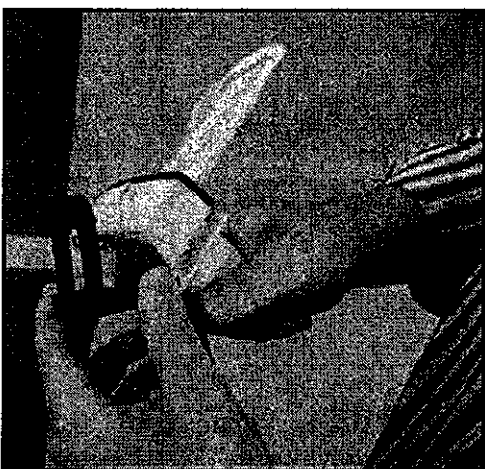
Note: Ensure all openings are closed completely to prevent leaking from mold



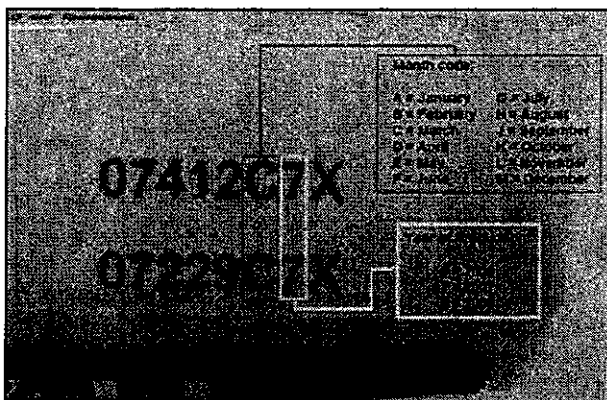
⇐ Assemble VAS 5155 applicator gun by sliding the VAS 5155/3 (10:1) plunger into applicator gun



⇐ Pull plunger VAS 5155/3 to rear



⇐ Lift black tab and fold to front of applicator gun

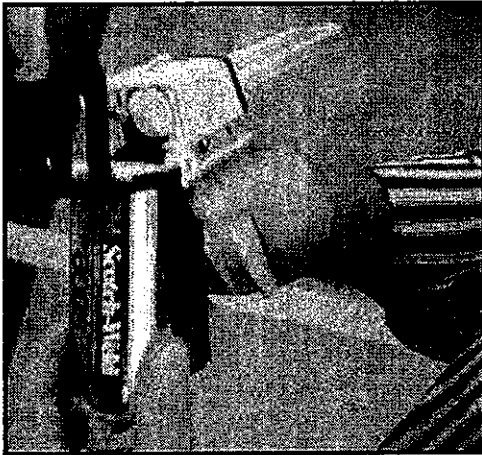


- Check 3M™ adhesive production date by referencing 3M™ Adhesive Storage/Expiration chart on p. 5

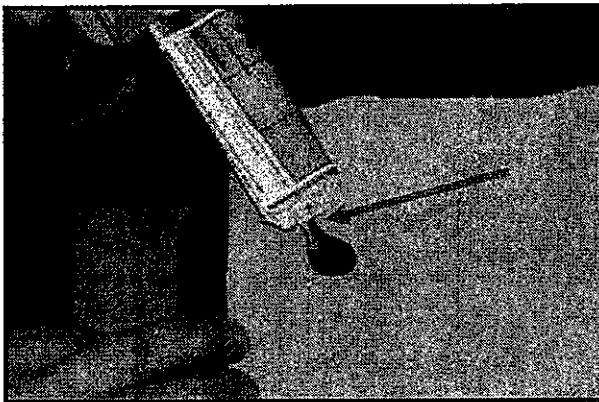
⇐ Production date located on 3M™ adhesive tube label



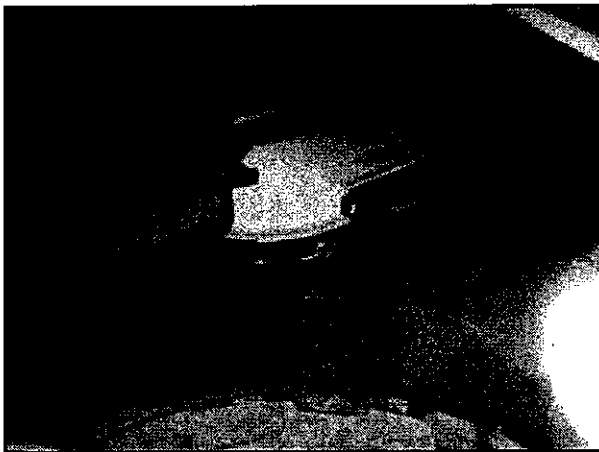
Note: DO NOT use expired adhesive



- ⇐ Insert adhesive cartridge (Z3MDP8005) in the VAS 5155 applicator gun and remove cap



- ⇐ Operate adhesive gun **without** the mixing nozzle (D 001 001) until visible amount of adhesive comes out of both chambers of the cartridge -arrow-
- Clean tip of cartridge and fit the mixing nozzle (D 001 001)
- With nozzle installed, check 3M™ adhesive flow to ensure compounds are blended

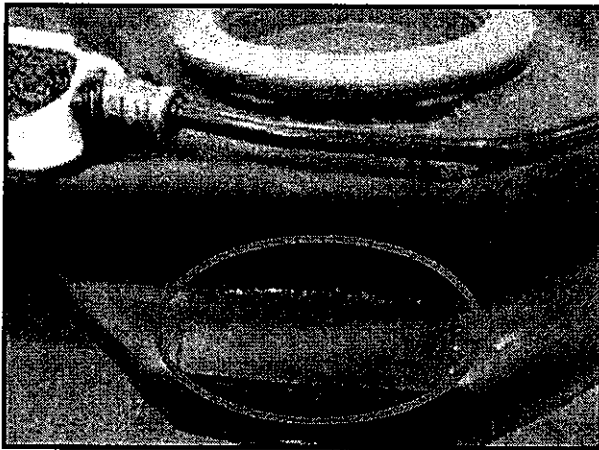


⌚ Note: Compounds must be blended as exiting the applicator nozzle
If compounds separate, **DO NOT USE!**
If compounds appear clumpy or gel-like, **DO NOT USE!**

⌚ Note: Adhesive must be applied within 10 minutes from time cartridge is opened

- Fill mold slowly and evenly with adhesive
- Wait approximately three (3) minutes for material to settle after the mold has been completely filled
- After material has settled, top-off/fill the mold completely (portion of a second cartridge may be required)

🗑 Tip: Remaining material will be used in next step. **DO NOT DISCARD**



Section D – Install Spacer Plate

- Lift vehicle
- Apply small amount of adhesive to spacer plate
- ⇐ Attach spacer plate to contact surface of fuel tank -circle-



Note: Ensure that the spacer plate fits flat onto the surface of the fuel tank and not over the upward curve of the fuel tank wall

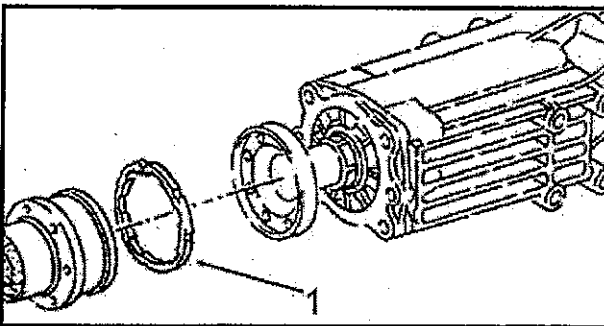
Section E – Reassembly

- Raise fuel tank carefully to its original position
- Fit retaining strap on passenger side of vehicle into original position
- Loosely tighten bolts
- ⇐ Fit both 3 mm spacer washers (N 904 773 02) between carrier plate and vehicle underside -3- with M8x35 mm bolt (N 908 706 02)
- ⇐ Torque retaining strap bolts -3- and -5- to 23 Nm

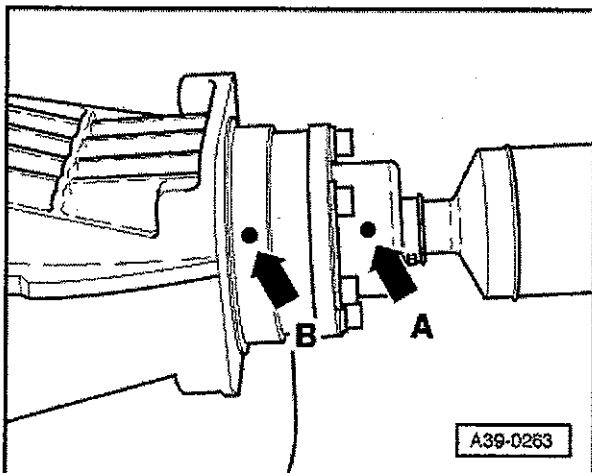


Tip: This lowers the position of the fuel tank by 6 mm

- Install bolts on carrier plate and heat shield



- To replace rear final drive gasket (183 521 141A), peel off backing foil, then affix self-adhesive side of gasket to flange shaft

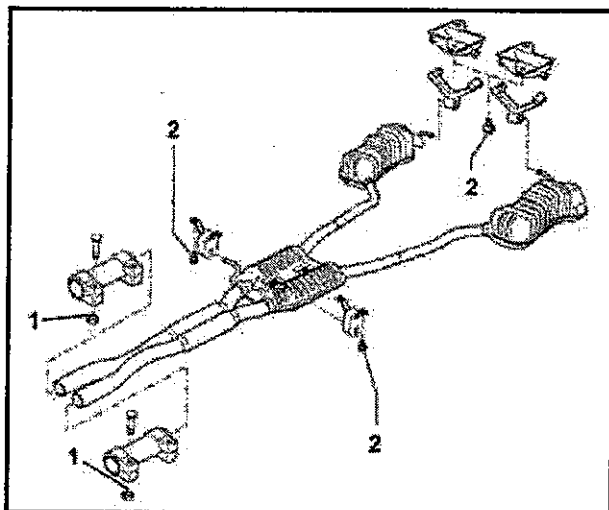


⇐ Using new bolts (N 019 926 1), install driveshaft by lining up marks -A- and -B-, torque to 55 Nm

Note: For proper balance, the driveshaft flanges -arrow A- and the rear final drive -arrow B- must be installed so that the factory color markings or markings which were made afterward are aligned

The threads in the drive flanges of the rear final drive must absolutely be cleaned of locking compound residue; otherwise, there is a possibility that the new bolts may get jammed when installed and shear when removed

Cleaning can be performed with a thread tap



- Install rear exhaust
- Position exhaust system free of tension
- ⇐ Tighten clamp bolts -1- to 40 Nm
- ⇐ Tighten mounting bracket bolts -2- to 25 Nm
- Reconnect 4-pin connector for fuel sending unit
- Reinstall cover for flange on fuel tank under rear seat bench (driver side) and reinstall rear seat bench
- Replace any fuel removed from vehicle

Note: Let vehicle sit for approximately six (6) hours for adhesive to cure to prevent damage due to vibrations or movement of ventilation line

Best curing results if vehicle stored at approximately 73°F (23°C) or higher

WORK IS COMPLETE