

## 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 contact Warranty



Audi

# Safety Recall Circular

Code: 20L8/JY

Subject: 2001-2004 MY Audi A6 quattro® 2.7L, 2.8L, 3.0L or 4.2L

2001-2005 MY Audi allroad quattro® 2.7L or 4.2L

2002-2003 Audi S6 quattro® 4.2L

2003 Audi RS6 quattro® 4.2L (U.S.) and 2004 RS6 quattro® 4.2L (CAN)

Reinforce Fuel Tank Rollover Valve Nipple

**REVISED**

July 2011

### Revision Summary July 2011

Added suffix "A" to Part number 4B0 298 403 in SAGA claim entry procedure

### Revision Summary June 2011

Additional models and engines added:

- 2001-2004 A6 quattro and 2002-2003 S6 quattro (4.2L)
- 2003 RS6 quattro with 4.2L (U.S.) and 2004 RS6 quattro with 4.2L (CAN)

Added dual clamp part number for RS6 models

### 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 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 Ranges & Production Dates

#### **NOTE:**

- ElsaWeb is the only valid campaign inquiry/verification source. Check ElsaWeb on the day the campaign work will be performed to verify vehicle eligibility for the repair in order to receive claim payment consideration. Campaign status must show "open".
- If this repair appears to have already been performed on the vehicle but the code still shows open in ElsaWeb, contact Warranty before proceeding further. Another dealer may have recently performed this repair but not yet entered a claim for it in the system.
- ElsaWeb may also show additional open action(s); if so, inform your customer - this work can be done while the vehicle is in for this campaign.
- Contact Warranty if you have any questions.

#### **U.S.A.**

2001-2004 A6, S6 quattro

WAU\_\_4B\_1N102740 – WAU\_\_4B\_4N103225

Production date: September 19, 2001 – June 8, 2004

2001-2005 allroad quattro

WA1\_\_4B\_2N026098 – WA1\_\_4B\_5N027457

Production date: September 6, 2001 – June 1, 2005

2003 RS6 quattro

WUA\_\_4B\_3N903941 – WUA\_\_4B\_3N905813

Production date: May 13, 2003 – March 9, 2004

#### **CANADA**

2001-2004 A6, S6 quattro

WAU\_\_4B\_1N159360 – WAU\_\_4B\_4N100648

Production date: July 11, 2001 – May 5, 2004

2001-2005 allroad quattro

WA1\_\_4B\_2N029574 – WA1\_\_4B\_5N027348

Production date: August 29, 2001 – June 1, 2005

2004 RS6 quattro

WUA\_\_4B\_4N901231 – WUA\_\_4B\_4N901551

Production date: February 26, 2004 – April 8, 2004

**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 may be involved in an additional action(s); any additional work can be done while the vehicle is in for this action.vehicles

### Allocation Report of Affected Vehicles

Electronic allocation lists for the added models will be posted under My Dealership Reports on AccessAudi on or about June 21, 2011. A list will not be posted for dealers who have no affected vehicles.

### Parts Information and Allocation

Parts allocation for the added models will take place prior to customer notification. If you have exhausted your allocated parts but have exceeded your weekly Upper Order Limit, please submit your requests for additional parts via email to upperorderlimits@audi.com. If you have questions regarding parts, please contact the Parts Helpline at 800-767-6552.

### Owner Notification Mailing

On or about June 21, 2011, Audi will notify all additional known owners of affected vehicles by first class mail. A sample copy of the owner letter is enclosed.

### Important Reminder on Vehicles Affected by Safety and Compliance Recalls

**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.**

## Claim Entry Procedure

Immediately upon completion of the repair work, enter the Applicable Criteria ID and Repair Operation from the following chart. **The Applicable Criteria ID 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 ElsaWeb 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** or **403A** as Causal Part.

Sold vehicle = 7 10

Unsold vehicle = 7 90

### Accounting Instructions

#### 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	4B0 298 403	or 403A	Repair kit
6	N 019 926 1		Bolt
1	183 521 141A		Gasket
2	D 001 001		Mixing nozzle
2	Z3MDP8005		3M™ adhesive
0.10	AKL 450 005 05		Butyl adhesive/sealant
2	191 253 141F		Exhaust clamp (if needed)
2	8L9 253 139A		Dual Clamp (if needed, RS6 only)

### Outside Labor

Loaner (one day maximum)

**LOAN16D1**                                up to \$40(USD)    \$40(CAD)

***There is NO reimbursement for Vehicle Wash***

### If customer refused repairs

Fax the Repair Order to the warranty team at (248) 754-6533 (U.S) and (905) 428-4811 (CAN). Provide the VIN, applicable Service Number, Customer information, Dealer number and date.

## Customer Letter Example (United States)

<CUSTOMER NAME>  
<CUSTOMER ADDRESS>  
<CUSTOMER CITY STATE ZIPCODE>

**Vehicle Identification Number (VIN):** <VIN>

<MONTH YEAR>

**Subject: Safety Recall 20L8/JY  
2001-2004 Model Year Audi A6, 2002-2003 Model Year Audi S6, and 2003 Model Year Audi RS6 with 4.2L Engines  
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 the fuel tank rollover valve nipple in your vehicle may crack under certain conditions. If this happens, it is possible for fuel to leak from the nipple. Our records show that your vehicle was built within the production date range of vehicles that may experience this issue.

### What Is The Issue?

The aging of the plastic material in the fuel tank rollover valve – combined with bending stress from the 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 several 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 – Hills East (20L8/JY)  
3499 West Hamlin Road  
Rochester Hills, MI 48309  
1-800-253-2834*

If you still cannot obtain satisfaction, you may file a complaint with: The Administrator, National Highway Traffic Safety Administration, 1200 New Jersey Avenue, SE., 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 also invite you to visit our website at [www.audiusa.com](http://www.audiusa.com) where you can check to see if this or any other action may be open on your vehicle.

We apologize for any inconvenience this matter may cause; however we are taking this action to help ensure your safety and continued satisfaction with your vehicle. Thank you for your continued loyalty!

Sincerely,

Audi Product Quality & Technical Service

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. ©2011 Audi of America LLC and Audi Canada. All Rights Reserved.

## Customer Letter Example (Canada)

<CUSTOMER NAME>  
<CUSTOMER ADDRESS>  
<CUSTOMER CITY STATE ZIPCODE>

**Vehicle Identification Number (VIN):** <VIN>

<MONTH YEAR>

**Subject: Safety Recall 20L8/JY  
2001-2004 Model Year Audi A6, 2002-2003 Model Year Audi S6, and 2004 Model Year Audi RS6 with 4.2L Engines  
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 the fuel tank rollover valve nipple in your vehicle may crack under certain conditions. If this happens, it is possible for fuel to leak from the nipple. Our records show that your vehicle was built within the production date range of vehicles that may experience this issue.

### What Is The Issue?

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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.

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### 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 (20L8/JY)**  
**P.O. Box 842, Stn. A**  
**Windsor, ON N9A 9Z9**  
**1-800-253-2834**

Complaints relating to the correctness or adequacy of this notice, the failure to correct in accordance with this notice or the failure or inability to correct within 60 days of this notice may be directed to the Road Safety and Motor Vehicle Directorate.

We also invite you to visit our website at [www.audi.ca](http://www.audi.ca) where you can check to see if this or any other action may be open on your vehicle.

We apologize for any inconvenience this matter may cause; however we are taking this action to help ensure your safety and continued satisfaction with your vehicle. Thank you for your continued loyalty!

Sincerely,

Audi Technical Service

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If there are questions regarding the work procedure:

- U.S. dealers, contact Warranty
- Canadian dealers, open an ATA ticket using concern group Compliance/Recall Assistance

**Required Parts:**

<u>Quantity</u>	<u>Part Number</u>	<u>Part Name</u>														
1	4B0 298 403A	Repair kit <table border="1" style="margin-left: 20px;"> <tr> <td colspan="2"><b>Contents:</b></td> </tr> <tr> <td>- Mold for adhesive</td> <td>---</td> </tr> <tr> <td>- Spacer plate</td> <td>---</td> </tr> <tr> <td>- Serrated rubber clip</td> <td>8E0 130 722D</td> </tr> <tr> <td>- Washer 2x</td> <td>N 904 773 02</td> </tr> <tr> <td>- Cleaning fluid</td> <td>D 009 401 04</td> </tr> <tr> <td>- Socket head flange bolt M8x35</td> <td>N 908 706 02</td> </tr> </table>	<b>Contents:</b>		- Mold for adhesive	---	- Spacer plate	---	- Serrated rubber clip	8E0 130 722D	- Washer 2x	N 904 773 02	- Cleaning fluid	D 009 401 04	- Socket head flange bolt M8x35	N 908 706 02
<b>Contents:</b>																
- Mold for adhesive	---															
- Spacer plate	---															
- Serrated rubber clip	8E0 130 722D															
- Washer 2x	N 904 773 02															
- Cleaning fluid	D 009 401 04															
- Socket head flange bolt M8x35	N 908 706 02															
6	N 019 9261	Bolt														
1	183 521 141A	Gasket														
2	D 001 001	Mixing nozzle														
2	Z3MDP8005	3M™ adhesive <b>(See shelf-life explanations on Pages 6, 7 and 8)</b>														
0.10	AKL 450 005 05	Butyl adhesive/sealant cord														
2	191 253 141F	Exhaust clamp (if needed)														
<b>2</b>	<b>8L9 253 139A</b>	<b>Dual Clamp (if needed, RS6 only)</b>														

**3M™ Adhesive Storage / Expiration**

- Shelf life 6 months @ 80°F (27°C) or below
- DO NOT STORE AT EXCESSIVE TEMPERATURES

**DATE CODING FOR Z3M DP8 005 ADHESIVE**

When stored in its original unopened cartridges at temperatures below 80F (27C), 3ZMDP8005 - 3M adhesive has a shelf life of six months.

An expiration date label from 3M will be affixed on top of the original date stamp. See pictures below.

**Old date coding method**

**New date coding method**



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In the case of older stock parts continue to use the Julian date code method explained below:

### JULIAN DATE CODE METHOD

Example:

**8206AZ**

FIRST NUMBER (**8**) = YEAR OF  
MANUFACTURE

SECOND 3 DIGITS (**206**) = JULIAN DATE OF  
MANUFACTURE

(See [conversion chart on page 8](#) for Gregorian date)

In this case 206th day of  
365

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



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## Gregorian to Julian conversion calendar

January							February							March									
							353	354	355	19	20	21	22	23	24	25	47	48	49	50	51	52	53
							1	2	3	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											
					78	79	80	81	108	109	139	140	141	142	143	144					
					1	2	3	4	1	2	1	2	3	4	5	6					
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									
					169	170	171	172	200	231	232	233	234	235							
					1	2	3	4	1	1	2	3	4	5							
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									
					261	262	263	292	293	294	295	296	297	298	322	323	324	325	326		
					1	2	3	1	2	3	4	5	6	7	1	2	3	4	5		
264	265	266	267	268	269	270	299	300	301	302	303	304	305	327	328	329	330	331	332	333	
4	5	6	7	8	9	10	8	9	10	11	12	13	14	6	7	8	9	10	11	12	
271	272	273	274	275	276	277	306	307	308	309	310	311	312	334	335	336	337	338	339	340	
11	12	13	14	15	16	17	15	16	17	18	19	20	21	13	14	15	16	17	18	19	
278	279	280	281	282	283	284	313	314	315	316	317	318	319	341	342	343	344	345	346	347	
18	19	20	21	22	23	24	22	23	24	25	26	27	28	20	21	22	23	24	25	26	
285	286	287	288	289	290	291	320	321	348	349	350	351	352	27	28	29	30	31			
25	26	27	28	29	30	31	29	30													

Blue = Julian Date

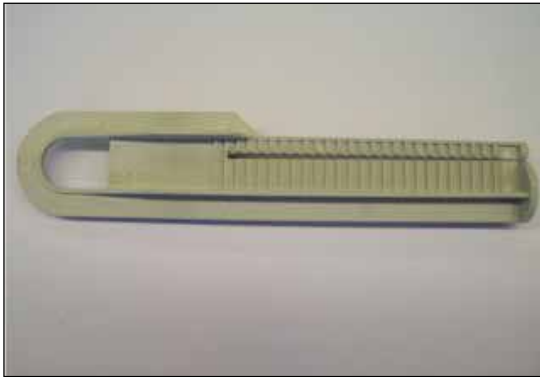
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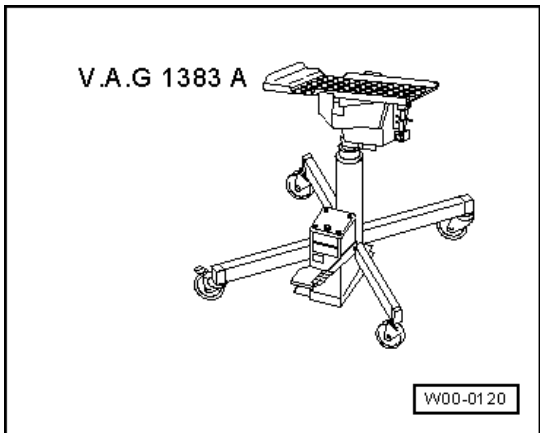
## Required Tools:



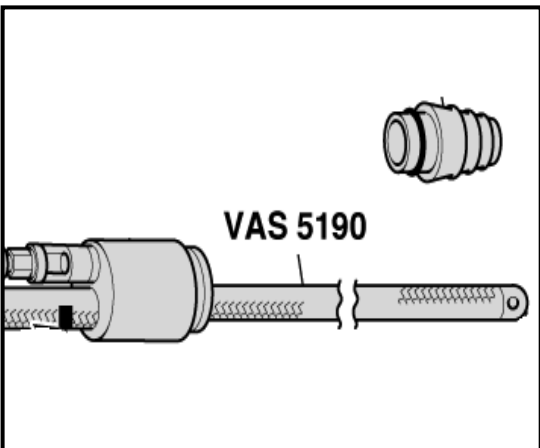
- ⇐ Applicator gun VAS 5155  
*(Dealers received one (1) each of these tools, free of charge. Additional or replacement tools can be obtained at dealer expense by calling Equipment Solutions at 1(800) 892-9650.)*



- ⇐ Feed plunger VAS 5155/3  
(for glue cartridge with mixing ratio 1:10)  
*(Dealers received 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



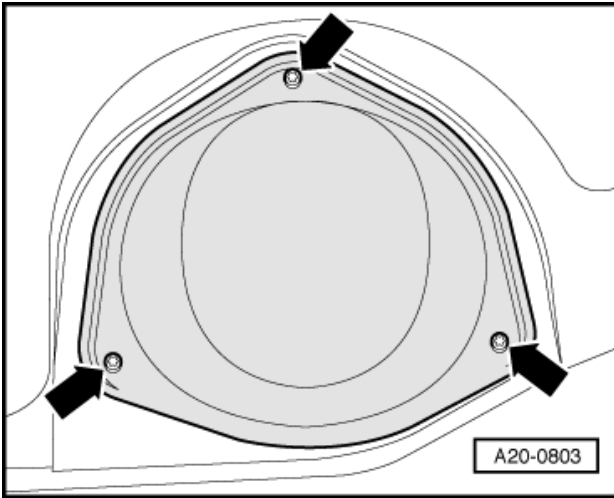
- ⇐ Fuel siphoning device VAS 5190 or equivalent

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## Work Procedure:

### 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**

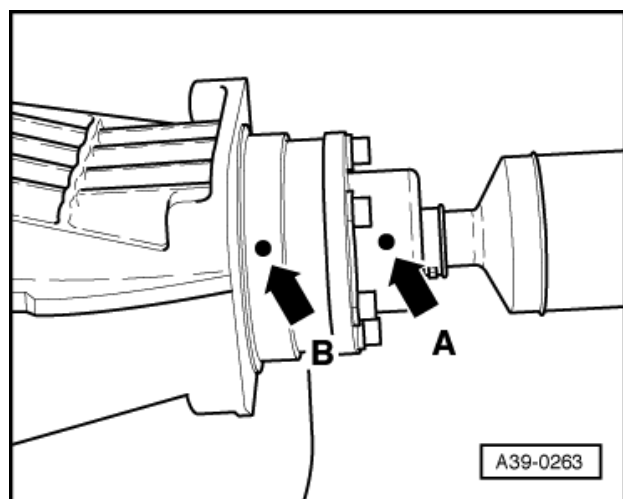
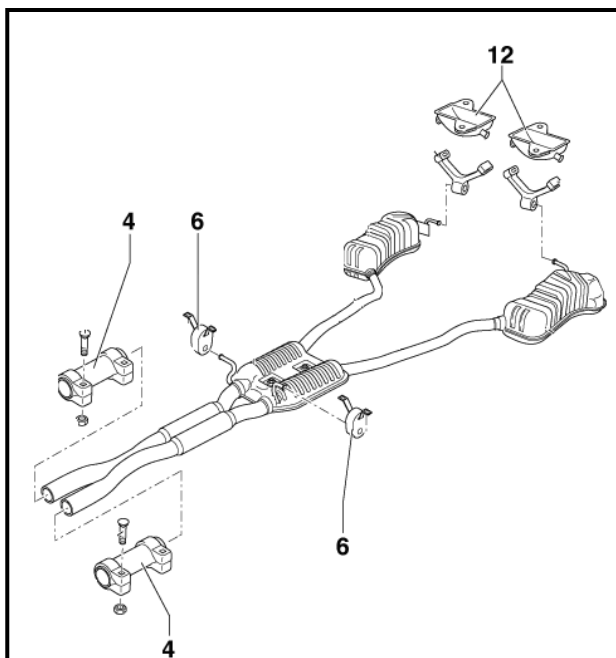
## Section B – Preparation For Access To Breather Valve

- 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

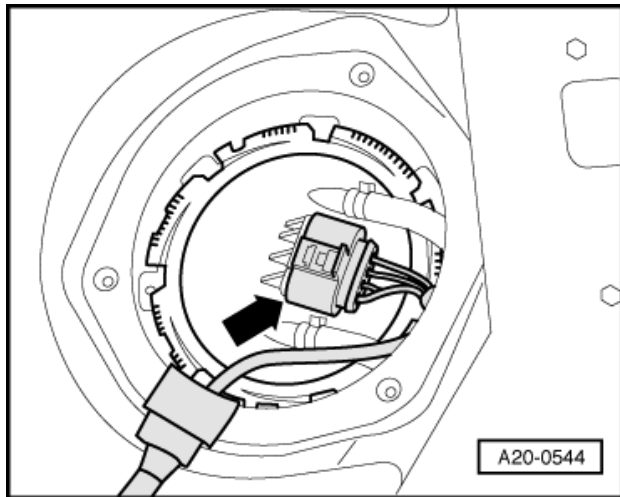


⇐ Remove 2 bolts in heat shield above rear differential and driveshaft <arrows>



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

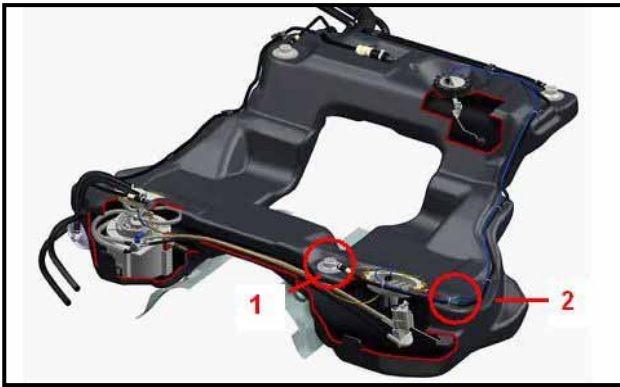
⚠ Note: Fuel tank is not removed completely from vehicle



- 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



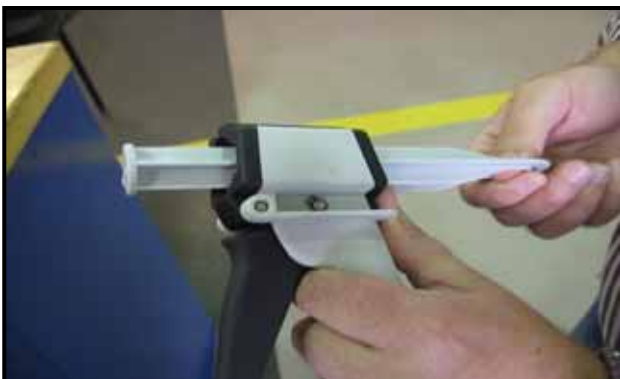
- Install mold with butyl sealant cord (AKL 450 005 05) into position over rollover
- ⇐ Seal off remaining openings at the connection with the butyl sealant cord (AKL 450 005 05) <arrow>

⚠ 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

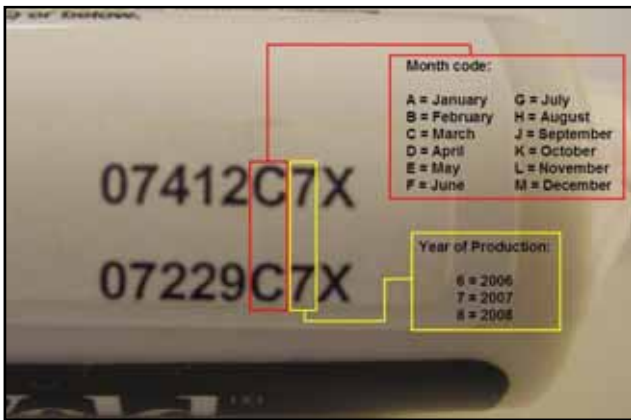
1.



⇐ 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

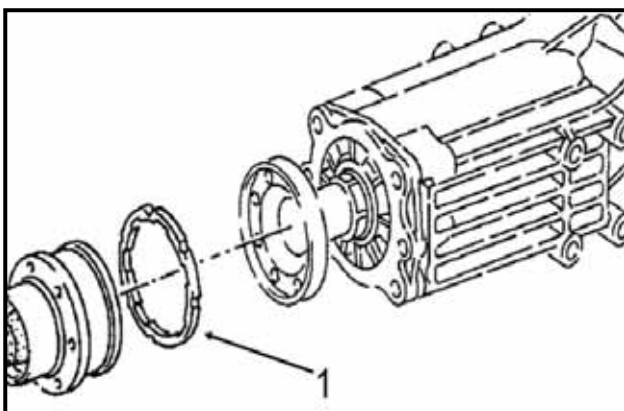
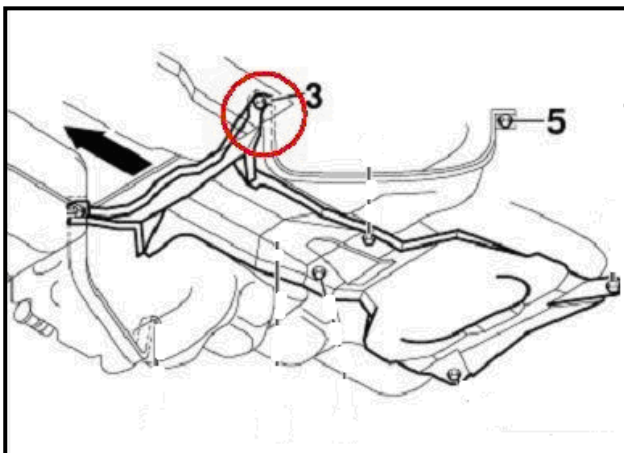


- Lift vehicle
  - Apply small amount of adhesive to spacer plate
- ⇐ Attach spacer plate to contact surface of fuel tank <circle>

⚠ 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

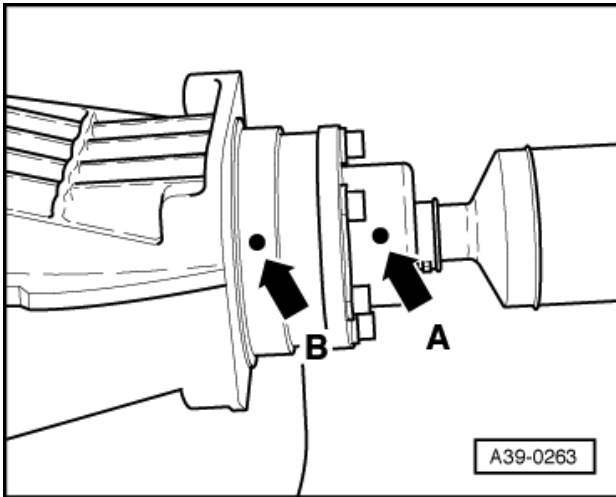
## Section E – Reassembly

- 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:

- 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

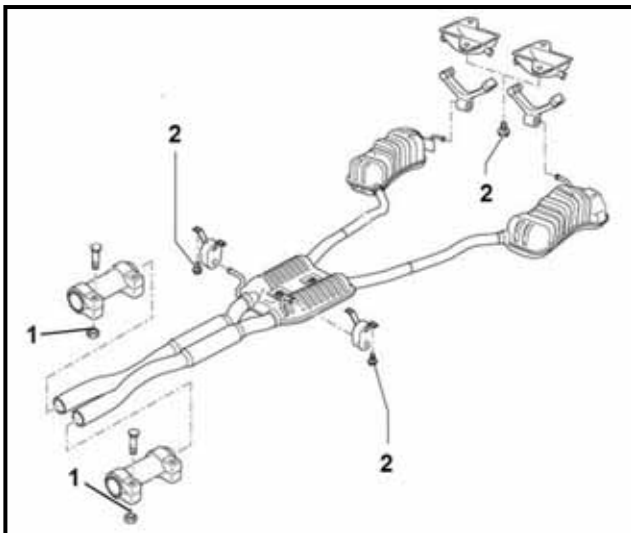


⇐ Using new bolts (N 019 926 1), install driveshaft by lining up marks <A> and <B>, torque to 55 Nm

⚠ 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**

## **Section F**

### **Parts Return/Disposal**

Properly destroy and dispose of removed parts in accordance with all state and local requirements, unless otherwise indicated and/or requested through SAGA