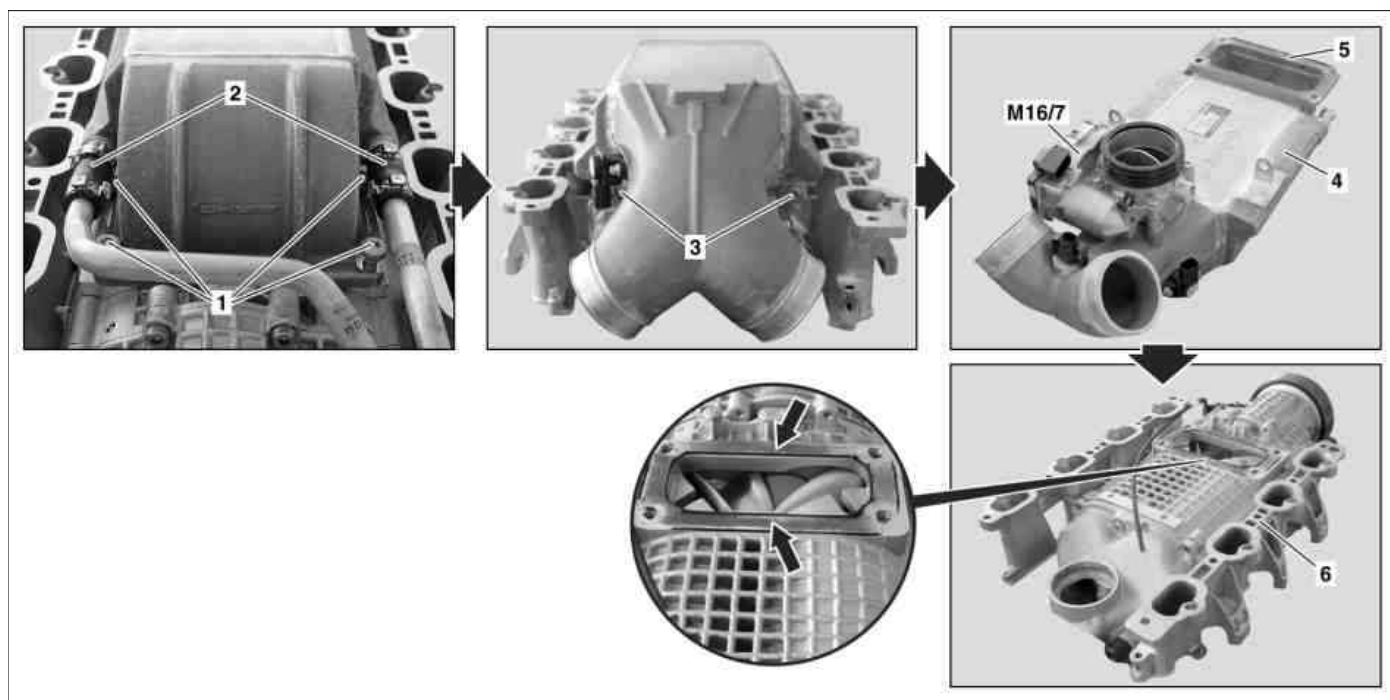


ENGINE 113.990 in MODEL 211.076 /276, 219.376
ENGINE 113.991 in MODEL 215.374, 220.074
ENGINE 113.992 in MODEL 230.474 except CODE (802) Model year 2002
ENGINE 113.995 in MODEL 230.472



P09.50-2073-09

- | | | |
|-----------------|---------------------|---------------------------------------|
| 1 Bolts | 4 Charge air cooler | 6 Compressor |
| 2 Coolant lines | 5 Sealing surface | M16/7 Air recirculation flap actuator |
| 3 Bolts | | |

	Removing		
1	Remove compressor (6)	Model 211.076 /276, 215.374, 220.474, 230.472 /474 Model 219.376	AR09.50-P-4705SVK AR09.50-P-4705TZ
2	Remove coolant lines (2) from charge air cooler (4)		
3	Remove bolts (1, 3)		
4	Disconnect compressor (6) from charge air cooler (4)	 Carefully pry off charge air cooler (4).	
5	Remove air recirculation flap actuator (M16/7)		
	Install		
6	Attach air recirculation flap actuator (M16/7)	 Torx bolt for air recirculation flap actuator	AR09.50-P-8843-01T *BA09.50-P-1002-01B
7	Close off openings on compressor (6) and charge air cooler (4)		
	Clean		
8	Clean sealing surfaces (arrows) on compressor (6) and sealing surfaces (5) on charge air cooler (4)	 Do not use any sharp-edged tools or abrasive paper as this will damage the sealing surfaces.  Dirt particles must not be allowed to find its way into the compressor (6) or the charge air cooler (4) since this would lead to destruction of the compressor (6). Loctite 7200 Cleaning spray, Loctite 7063 (150ml)	AR01.00-P-0050-01A *BR00.45-Z-1038-04A *BR00.45-Z-1046-04A
9	Apply sealant thinly	 No excess sealant should be allowed to find its way into the compressor (6) since this could destroy the compressor (6). Loctite sealant 5970	*BR00.45-Z-1013-01A
10	Attach charge air cooler (4) to compressor (6)	 Installation: Moisten sealing ring on air recirculation flap actuator (M16/7) with liquid lubricant.  Bolt, compressor to charge air cooler Lubricant paste	*BA09.50-P-1001-01B *BR00.45-Z-1002-06A

11	Attach coolant lines (2) to charge air cooler (4)		
12	Install compressor (6)	Model 211.076 /276, 215.374, 220.474, 230.472 /474 Model 219.376	AR09.50-P-4705SVK AR09.50-P-4705TZ
13	Teach in air recirculation flap actuator using STAR DIAGNOSIS Connect STAR DIAGNOSIS and read out fault memory		AD00.00-P-2000-04A

Supercharger

Number	Designation		Engine 113.990	Engine 113.991	Engine 113.992/ 995
BA09.50-P-1001-01B	Bolt, supercharger to charge air cooler	Nm	20	20	20
BA09.50-P-1002-01B	Torx bolt for air recirculation flap actuator	Nm	7	7	7

Repair materials

Number	Designation	Order number
BR00.45-Z-1013-01A	Loctite sealant 5970	A 003 989 98 20
BR00.45-Z-1002-06A	Lubricating paste, rubber parts 2.5 kg, DB supply specification 6867.00	A 000 989 01 60
BR00.45-Z-1038-04A	Loctite 7200	Henkel Loctite Deutschland GmbH Arabellastrasse 17 81925 München Germany Tel. +49 899268-0 Fax + 49 899101978 www.Loctite.de
BR00.45-Z-1046-04A	Cleaning spray, Loctite 7063 (150ml)	A 001 986 71 71 10