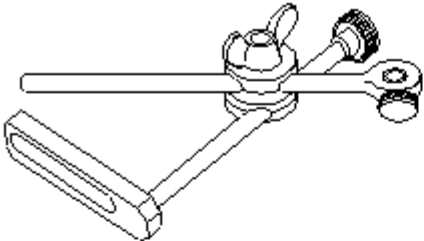
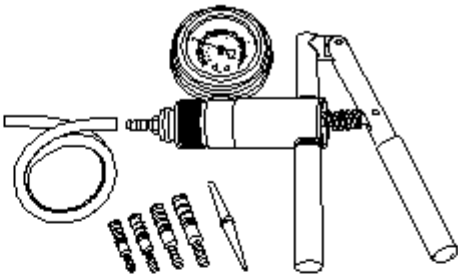
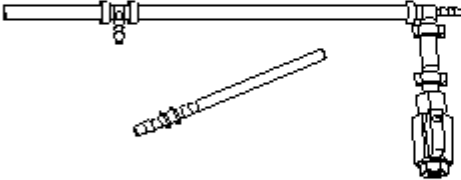
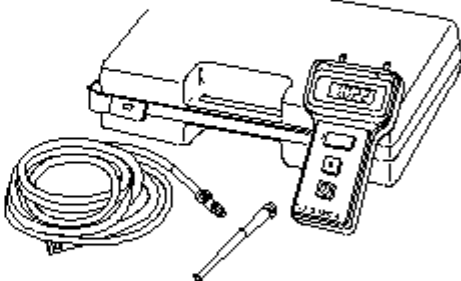
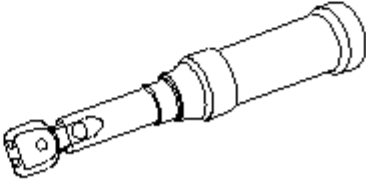


Adjusting vacuum unit for turbocharger

Turbocharger removed

VW 387 	VAS 6213 
VAS 6342 	V.A.G 1397 A 
VAS 6341 	V.A.G 1783  G21-10000

Special tools and workshop equipment required

- ♦ Universal dial gauge bracket -VW 387-
- ♦ Hand vacuum pump -VAS 6213-
- ♦ Pressure control valve -VAS 6342-
- ♦ Turbocharger tester -V.A.G 1397A-
- ♦ Dial gauge set, 4 pieces -VAS 6341-
- ♦ Torque wrench -V.A.G 1783-

- ◆ Open-end spanner insert AF 10 -V.A.G 1783/1-

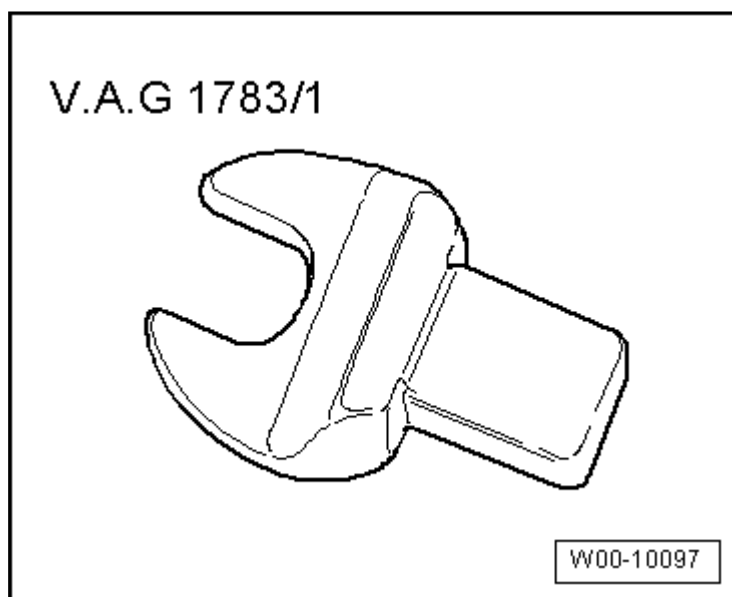
Adjusting



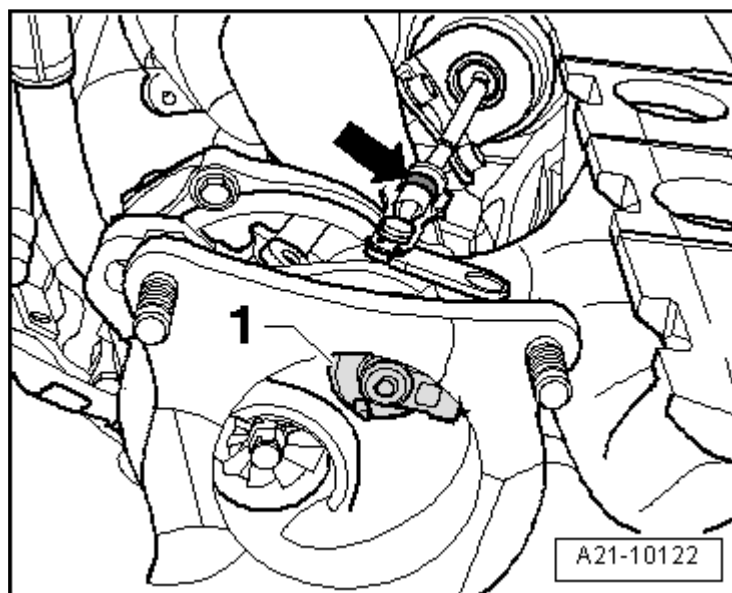
Note

It is only necessary to adjust the vacuum unit if the vacuum unit has been removed.

- Tightening torques → **Anchor**



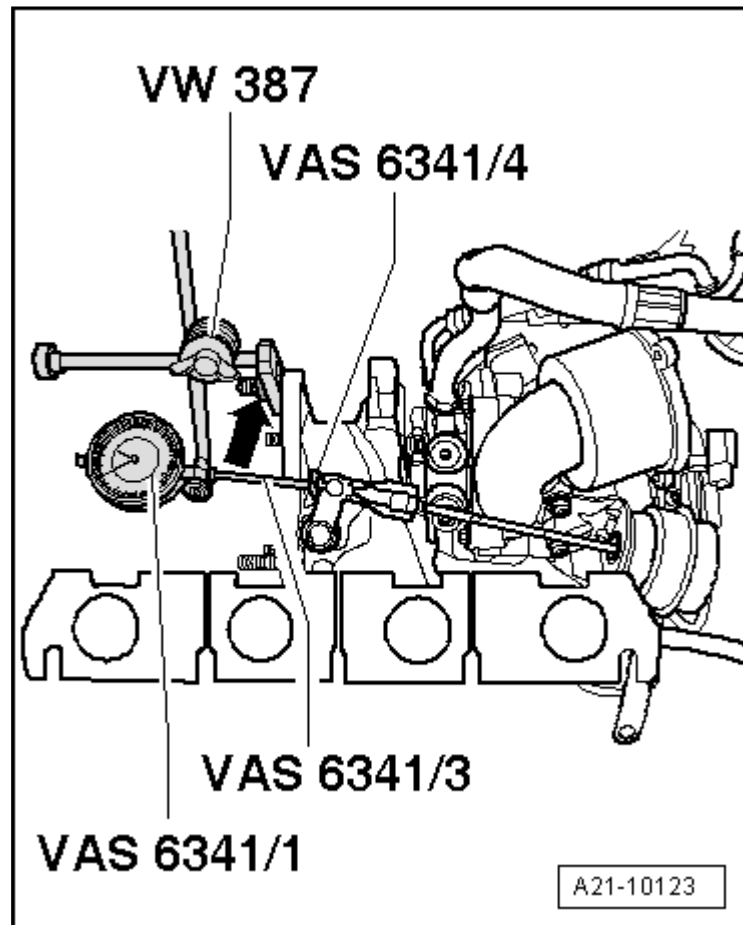
- Pre-adjust bypass flap -1- via nut - arrow- so that bypass flap can still just be turned by hand.



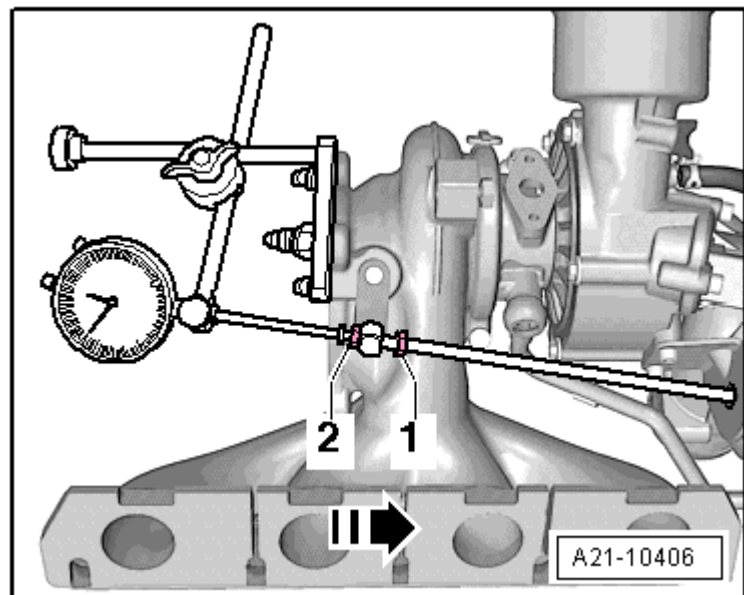
- Secure universal dial gauge bracket - VW 387- to turbocharger -arrow-.

**Note**

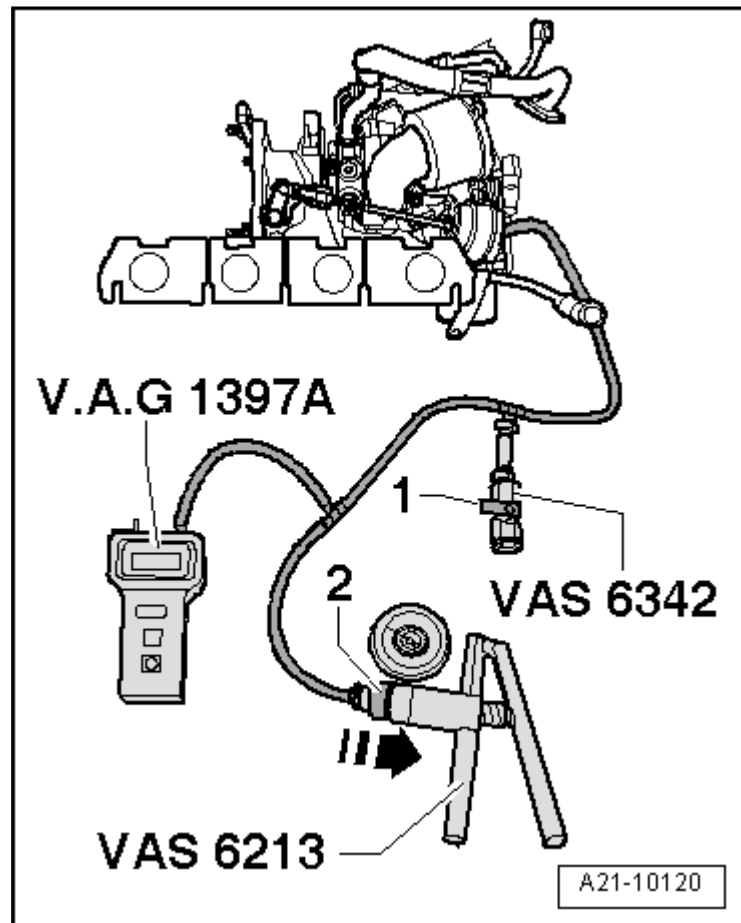
- ♦ *The dial gauge values (mm) listed here include the 1 mm preload that is initially set on the gauge.*
- ♦ *Dial gauge -VAS 6341/1- with dial gauge extension, 30 mm -VAS 6341/3- must align with linkage of vacuum unit.*
- Attach dial gauge -VAS 6341/1- with extension, 30 mm -VAS 6341/3- and flat probe -VAS 6341/4- to universal dial gauge bracket -VW 387-.
- Set dial gauge -VAS 6341/1- to 1 mm preload.
- Set scale of dial gauge -VAS 6341/1- to 0.
- Make sure that dial gauge can move freely.



- Turn nut -1- approx. 7 turns in direction of -arrow-.
- Turn nut -2- in direction of -arrow- until dial gauge displays 7 mm.
- Hand-tighten nut -1-.
- Set dial gauge -VAS 6341/1- to 1 mm preload.
- Set scale of dial gauge -VAS 6341/1- to 0.



- Connect up hand vacuum pump -VAS 6213-, turbocharger tester -V.A.G 1397A- (connection II) and pressure control valve -VAS 6342- as shown in illustration.
- Switch on turbocharger tester -V.A.G 1397A- and set sliding switch to position II.
- Close pressure control valve -VAS 6342- at lever -1-.



- Move adjuster ring -1- on hand vacuum pump -VAS 6213- to position -B- to select „pressure“.

**Note**

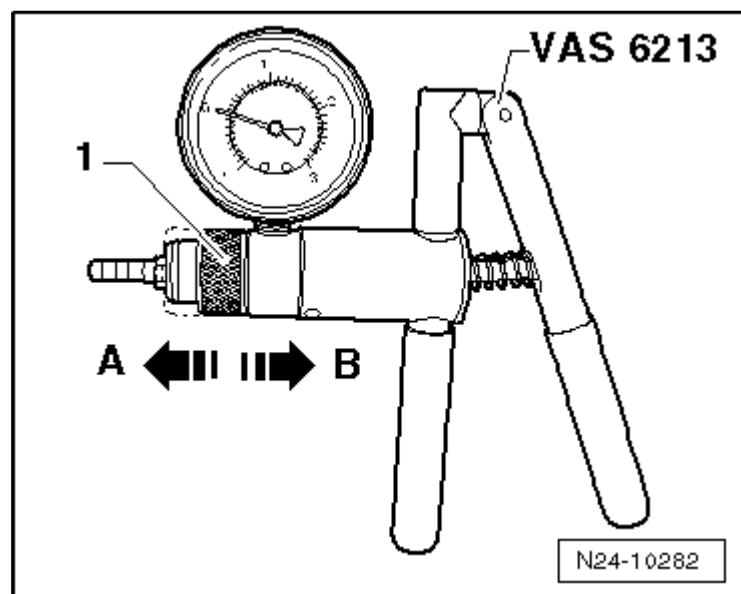
The following measurements must be performed in continuous sequence. Do not allow the pressure to drop to 0 between measurements.

- Operate hand vacuum pump -VAS 6213- until turbocharger tester -V.A.G 1397A- indicates 460 +/- 5 mbar.

**Note**

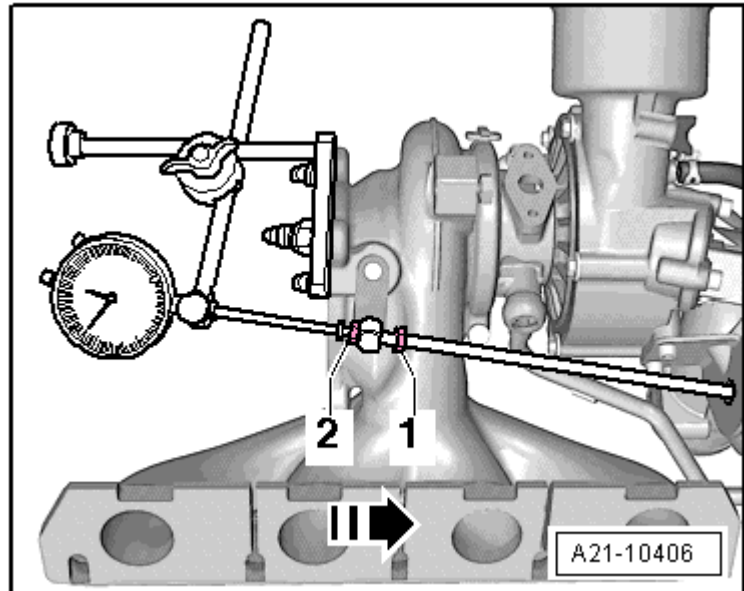
If value exceeds 460 +/-5 mbar, repeat entire measurement.

- Read off and note value indicated on dial gauge -VAS 6341/1-.
- Operate hand vacuum pump -VAS 6213- until turbocharger tester -V.A.G 1397A- indicates 650 to 700 mbar.
- Vent system via pressure control valve -VAS 6342- so that pressure reading drops to 460 +/- 5 mbar.

**Note**

If value does not reach 460 +/- 5 mbar, repeat entire measurement.

- Read off and note value indicated on dial gauge -VAS 6341/1-.
- Add values 1 and 2 together and divide by 2.
- The result (mean value) should be 5 +/- 0.5 mm.
- If value is higher, relieve pressure until it is 0 bar, loosen nut -1- and turn nut -2- half a turn in direction of arrow and hand-tighten nut -1-.
- Set dial gauge -VAS 6341/1- to 1 mm preload.
- Set scale of dial gauge -VAS 6341/1- to 0 and repeat measurement.
- If result (mean value) is 5 +/- 0.5 mm, tighten lock nut and repeat measurement.
- If result (mean value) is 5 +/- 0.5 mm, secure nuts with sealing paint. Sealing paint → [Electronic parts catalogue](#).



- Secure new locking plate -1- on linkage of vacuum unit.

