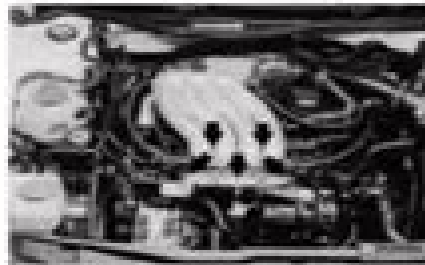
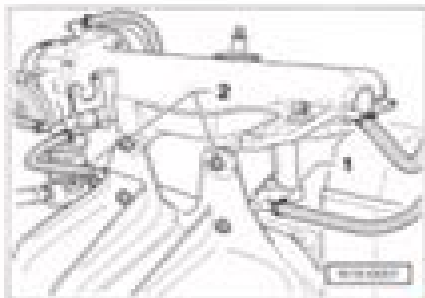


# Volkswagen Bora 1999-2005 Workshop Manual

15c-30 CYLINDER HEAD AND VALVETRAIN (2.0L ENGINE)



- Seal all disconnected fuel and vacuum lines to prevent contamination.
- Remove air plenum assembly and connecting hoses to throttle housing.
- Disconnect accelerator cable from throttle control module. Use storage and cable retainers. (MSD engine only).
- Unplug wiring harness connectors from throttle control module.
- Remove 2 support braces from throttle control module that connect to the distributor and cylinder head.
- Disconnect vacuum lines connected to power brake booster on the back of intake manifold and any remaining electrical and vacuum connections on intake manifold.



- A Loosen and remove bolts (assembly holding upper and lower sections of intake manifold together. (MSD engine shown).
- A On the rear upper section of intake manifold, remove screws (7) and mounting bolts (8) for venturi tubes.



- On the upper section of intake manifold and top ends of venturi tubes, remove upper parts of lower section with bolts and nuts (10) at each top (arrow) or other suitable fastener.

CYLINDER HEAD AND VALVETRAIN (1.5L) 15b-15

## Drive belts, assembly

1. Bolt
  - Remove cap nut.
  - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (20°).
  - To loosen and tighten counter lock with 24 N.
  - Torques and tolerances must be free of oil and grease.
  - Additional torque tolerance (shown) in Nm (1/2 turn (20°) steps).
2. Bolt
  - Remove cap nut.
  - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (20°).
3. Bolt
  - Remove cap nut.
  - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (20°).
4. Bolt
  - Remove cap nut.
  - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (20°).
5. Timing belt guard, middle section
  - Tighten to 10 Nm (7 ft-lb).
6. Bolt
  - Tighten to 40 Nm (30 ft-lb).
7. Right engine mount
  - Tighten to 40 Nm (30 ft-lb).
10. Timing belt guard, water section
  - Tighten to 10 Nm (7 ft-lb).
11. Timing belt
  - Rotate engine direction of rotation before assembly.
  - Check for wear.
  - Do not reuse.
12. Water pulley
  - Tighten to 10 Nm (7 ft-lb).
13. Bolt
  - Remove cap nut.
  - Tighten to 20 Nm (15 ft-lb) + 1/2 turn (20°).
14. Nut
  - Tighten to 20 Nm (15 ft-lb).
15. Bolt
  - Tighten to 20 Nm (15 ft-lb).
16. Bolt
  - Tighten to 40 Nm (30 ft-lb).
  - To loosen and tighten bolt, counter lock using 20 N.



17. Camshaft sprocket
  - Rotate from camshaft using lever and nut.
18. Tensioning roller
  - Set in automatic timing belt tensioning roller.
19. Water pulley
  - Tighten to 10 Nm (7 ft-lb).
20. Injection pump sprocket
  - Two-piece construction.
21. Bolt
  - Tighten to 40 Nm (30 ft-lb).
22. Timing belt guard, rear
  - Tighten to 10 Nm (7 ft-lb).
23. Crankshaft pulley
  - Check together for ease of movement.
24. Water pulley
  - Remove before removing belt and gears.
25. Camshaft timing belt drive sprocket
  - Tighten to 40 Nm (30 ft-lb).
26. Bushing, threaded
  - Tighten to 40 Nm (30 ft-lb).
27. Diesel injection pump
  - Refer to Diesel injection pump, generator power door, fly bolts, and air conditioner compressor.
28. Assembly bracket
  - Refer to Diesel injection pump, generator power door, fly bolts, and air conditioner compressor.

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