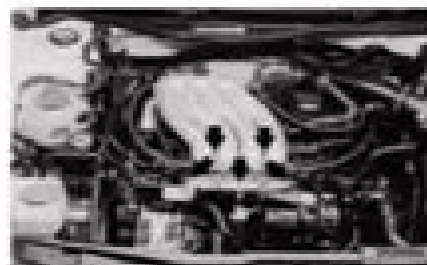


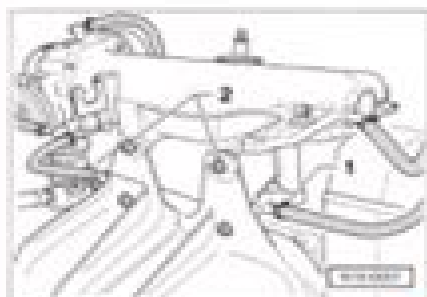
Volkswagen Bora 1999-2005 Workshop Manual

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

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



- Seal off disconnected fuel and vacuum lines to prevent contamination.
- Remove air cleaner assembly and connecting hoses to throttle housing.
- Disconnect accelerator cable from throttle control module (air intake and cable retainers, (M20 engine only).
- Unplug wiring harness connector from throttle control module.
- Remove 2 coolant hoses from throttle control module that connect to the reservoir and cylinder head.
- Disconnect vacuum hose connected for power brake booster on the back of intake manifold and any remaining electrical and vacuum connections on intake manifold.



- Loosen and remove bolts (arrow) holding upper and lower sections of intake manifold together (M20 engine shown).
- On the rear upper section of intake manifold, remove screws (7) and mounting bolts (8) for water pump.



- On the rear upper section of intake manifold and top water pump, off-mount water pump on lower section with suitable strap clasp or water hose (arrow) or other suitable material.

Drive belts, assembly

1. Bolt
 - Remove cap nut.
 - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (M21).
 - To loosen and tighten, counter-bolt with 34 N.
 - Threads and shoulder must be free of oil and grease.
 - Additional quarter turn torque obtained on 1st 1/2 turn (M21) stage.
2. Bolt
 - Remove cap nut.
 - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (M21).
3. Bolt
 - Remove cap nut.
 - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (M21).
4. Bolt
 - Remove cap nut.
 - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (M21).
5. Timing belt guard, middle section
6. Bolt
 - Tighten to 40 Nm (30 ft-lb).
7. Right engine mount
10. Timing belt guard, upper section
11. Timing belt
 - Rotate engine direction of rotation before removing.
 - Check for wear.
 - Do not reuse.
12. Water pump
13. Bolt
 - Remove cap nut.
 - Tighten to 120 Nm (20 ft-lb) + 1/2 turn (M21).
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-bolt with 34 N.



17. Camshaft sprocket
 - Release from camshaft using two-part pulley.
18. Timing belt roller
 - Remove automatic timing belt roller spring roller.
19. Water pump
20. Injection pump sprocket
 - Two-piece construction.
21. Bolt
 - Tighten to 20 Nm (15 ft-lb).
22. Timing belt guard, rear
23. Coolant pump
 - Check impeller for signs of movement.
24. Water pump
 - Remove before removing cap and nut.
25. Camshaft timing belt drive sprocket
26. Bushing, threaded
27. Diesel injection pump
28. Assembly bracket
 - Mounting for diesel injection pump, generator power steering pump, and air conditioner compressor.
29. Bolt
 - Tighten to 40 Nm (30 ft-lb).

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Volkswagenwerk GMBH (Germany)

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the Volkswagenwerk GMBH (Germany) text.

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