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1) Lower Head Carefully Onto Gasket. Use Guide Pins (3070) To Keep Gasket And Head Aligned With Block. Tighten Cylinder Head Bolts In Sequence In 3 Stages. See Fig. 2. Tighten 12-point Bolts To 29 Ft. Lbs. (40 N.m) In First Step. 2) Tighten To 43 Ft. Lbs. (60 N.m) In Second Step. On Third Step, Turn Bolt 18 1th, 2024

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3) Align Vibration Damper Mark With Mark On Lower Timing Belt Cover. See Fig. 10. Install Timing Belt Around Camshaft Sprocket. Install Timing Belt Tension Scale (VW 210). To Tension Belt, Rotate Belt Tensioner Clockwise Until Tension Scale Reads 13-14. By Hand, Rotate Crankshaft 2 Turns And 3th, 2024

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