



1.2 Assembly overview - sealing flange, belt pulley end

1 - Bolt

- ☐ Renew after removing
- ☐ Loosen and tighten with counterhold - 3415-
- ☐ Do not additionally oil the thread and shoulder
- ☐ 180 Nm +135°

2 - Crankshaft pulley

- ☐ Contact surface between toothed belt pulley and crankshaft must be free from oil
- ☐ Fitting possible in one position only.

3 - Crankshaft oil seal for belt pulley end

- ☐ Do not additionally oil or grease the oil seal sealing lip.
- ☐ Before installing, remove oil residue from crankshaft journal using a clean cloth.
- ☐ Renewing = [page 44](#)

4 - Sealing flange at belt pulley end

- ☐ Insert with silicone sealant = Electronic Parts Catalogue (ETKA)
- ☐ Must seat on dowel pins.
- ☐ Removing and installing = [page 46](#)

5 - Cylinder block

6 - Dowel pin

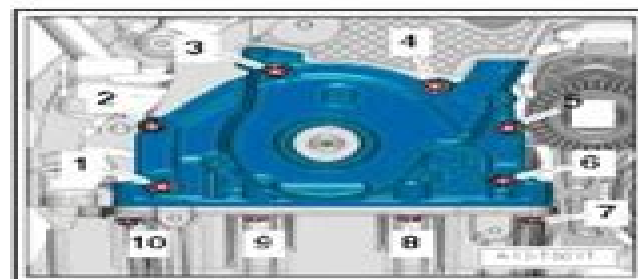
7 - Bolt

- ☐ Specified torque and tightening sequence = [page 34](#)

Sealing flange at belt pulley end - Prescribed torque and tightening sequence

- Tighten bolts for sealing flange at belt pulley end in the sequence -1 ... 10- in 3 stages as follows:

1. Screw bolts -1 ... 10- in as far as stop by hand.
2. Tighten bolts -1 ... 6- in diagonal sequence to 15 Nm.
3. Tighten bolts -7 ... 10- to 15 Nm.



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SA Adler



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Table of Contents 3 Jetta Tdi Factory Service Manual

1. Understanding the eBook 3 Jetta Tdi Factory Service Manual
 - The Rise of Digital Reading 3 Jetta Tdi Factory Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 3 Jetta Tdi Factory Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 3 Jetta Tdi Factory Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 3 Jetta Tdi Factory Service Manual
 - Personalized Recommendations

- 3 Jetta Tdi Factory Service Manual User Reviews and Ratings
- 3 Jetta Tdi Factory Service Manual and Bestseller Lists
- 5. Accessing 3 Jetta Tdi Factory Service Manual Free and Paid eBooks
 - 3 Jetta Tdi Factory Service Manual Public Domain eBooks
 - 3 Jetta Tdi Factory Service Manual eBook Subscription Services
 - 3 Jetta Tdi Factory Service Manual Budget-Friendly Options
- 6. Navigating 3 Jetta Tdi Factory Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - 3 Jetta Tdi Factory Service Manual Compatibility with Devices
 - 3 Jetta Tdi Factory Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 3 Jetta Tdi Factory Service Manual
 - Highlighting and Note-Taking 3 Jetta Tdi Factory Service Manual
 - Interactive Elements 3 Jetta Tdi Factory Service Manual
- 8. Staying Engaged with 3 Jetta Tdi Factory Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 3 Jetta Tdi Factory Service Manual
- 9. Balancing eBooks and Physical Books 3 Jetta Tdi Factory Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 3 Jetta Tdi Factory Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 3 Jetta Tdi Factory Service Manual
 - Setting Reading Goals 3 Jetta Tdi Factory Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 3 Jetta Tdi Factory Service Manual
 - Fact-Checking eBook Content of 3 Jetta Tdi Factory Service Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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