

9. Clean the lower half of the flange washer (5) and lubricate the lower half of flange washer. Place the lower half of the flange washer (5) on both sides of the center main bearing cap (4). The groove on the flange washer must be oriented against the resistance.

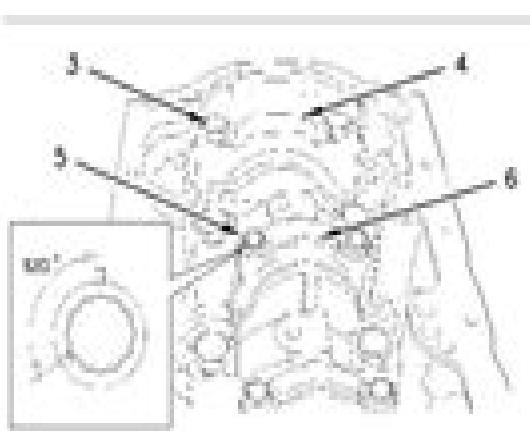


Diagram 8

p007375

10. Install the main bearing caps (4) in the position that was marked during the removal process. All of the bearing sets for the main bearings should be on the same side. Install the main bearing cap bolts (3). Tighten the bolts to a torque of  $245 \pm 20 \text{ N m}$  ( $180 \pm 14 \text{ lb ft}$ ).
11. Ensure that the upper connecting rod bearings are centered in the connecting rod. Install the lower connecting rod bearings in the connecting rod cap. Lubricate the bearing sleeves with clean engine oil.

**Note:** Do not reuse the old washers (7) in order to ensure the connecting rod cap (6).

**Note:** Ensure that the etched number on the connecting rod bearing cap matches the etched number on the connecting rod. Ensure that the etched numbers are on the same side.

12. Install the connecting rod caps (6). Install new washers (7) on the connecting rod. Tighten the washers evenly to a torque of  $23 \text{ N m}$  ( $17 \text{ lb ft}$ ).
13. Tighten the washers evenly to a torque of  $70 \text{ N m}$  ( $52 \text{ lb ft}$ ).
14. Use Tooling (5) to achieve the correct final torque.

**Note:** If Tooling (5) is not used, place an index mark on each bolt.

15. Turn the washers for an additional 120 degrees.
16. Rotate the crankshaft in order to ensure that there is no Tooling.

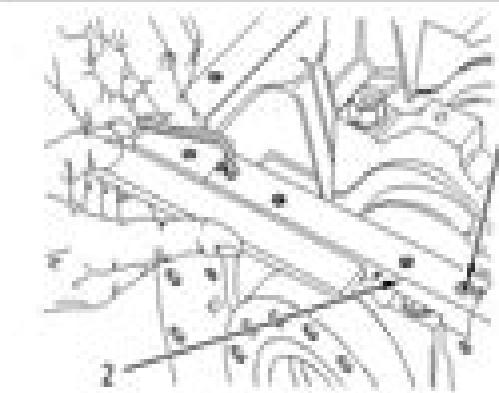


Diagram 9

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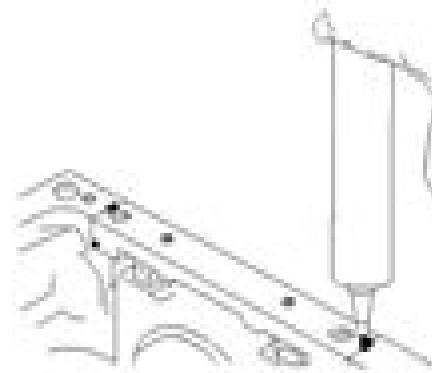


Diagram 10

p007400

17. Clean the bridge and the face of the cylinder block. Apply a thin bead of Tooling (A) on the corners of the seat for the bridge. Also apply Tooling (A) around the threaded holes in the seat for the bridge. Use the following steps when you apply Tooling (A) to the cylinder block and the bridge.

# Th460b Service Manual

**Volkswagen of America, Inc**

## Th460b Service Manual:

**Service Manual** Caterpillar Tractor Company (U.S.A),1983      **Volkswagen Beetle, Karmann Ghia Official Service Manual, Type 1** Volkswagen of America, Inc,1972 The Volkswagen Beetle and Karmann Ghia Service Manual Type 1 1966 1969 features wiring diagrams including 6 volt systems convertible top repair carburetor rebuilding 30 PICT 1 and 30 PICT 2 and comprehensive year and model specifications and troubleshooting tables Amazon com      *Service Manual* ,1970

*Long 360-460-510 Series Tractors* ,1983      *Service Repair Manual* David Brown Tractors Ltd,1979      *Service Manual* ,

*VW Golf & Jetta Automotive Repair Manual* George Parise,2002 Inside this manual the reader will learn to do routine maintenance tune up procedures engine repair along with aspects of your car such as cooling and heating air conditioning fuel and exhaust emissions control ignition brakes suspension and steering electrical systems wiring diagrams      **Service Manual** Diamond T Motor Car Company. Service Dept,1948      *Volkswagen Jetta, Golf, GTI, Cabrio Service Manual*, 1993-1999 Bentley Publishers,Robert Bentley, inc,1999 Bentley Publishers is the exclusive factory authorized publisher of Volkswagen Service Manuals in the United States and Canada In every manual we provide full factory repair procedures specifications tolerances electrical wiring diagrams and lubrication and maintenance information Bentley manuals are the only complete authoritative source of Volkswagen maintenance and repair information Even if you never intend to service your car yourself you ll find that owning a Bentley Manual will help you to discuss repairs more intelligently with your service technician      **Technical Service Manual** ,      *Volkswagen Jetta, Golf, GTI Service Manual* Bentley Publishers,2003

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and reconditioning including bench testing procedures and specifications for 25hp and 36hp motors Solex 28 PCI carburetor and Solex fuel pump troubleshooting rebuilding and adjustment Transmission removal rebuilding and adjustment including special needle bearings on synchromesh transmissions Frame floor and body panel repair All measurements and detailed cutting alignment and welding instructions Painting preparation and procedures Body repair and replacement procedures including the sliding fabric sunroof and convertible top Complete wiring diagrams All factory changes and updates are noted in the text by manufacturing date chassis number engine number and part number Full explanations of the operation of all systems with exploded views cutaways and diagrams Required workshop equipment tools and equipment for local manufacture listings Troubleshooting tables for clutch carburetor fuel pump steering brakes generator starter and wipers Maintenance and lubrication charts and procedures

**Volkswagen: Fastback, Squareback** Volkswagen of America, Inc,1974 This manual covers all 1968 through 1973 Fastback Squareback models with the latest data from Volkswagen of America Inc You will find step by step procedures for testing troubleshooting the fuel injection system without special equipment Clear photos show the order of assembly for rebuilding the manual automatic transmissions along with all wear tolerance specifications Like other Bentley manuals it features full wiring diagrams complete specifications troubleshooting tables for every year model

**Service Manual** ,1968 **Volkswagen FastBack and Squareback (Type 3) Service Manual: 1968-1973** Volkswagen of America,1984-01-01 This Type 3 Manual covers the Fastback Type 3 Sedan and the Squareback of Model Years 1968 1969 1970 1971 1972 and 1973 Cars of each Model Year are usually introduced in August of the preceding year Throughout this Manual the Fastback is usually referred to as the Type 3 Sedan

**Volkswagen Fox Service Manual** Robert Bentley, inc,Bentley Publishers,2003-04 Bentley Publishers is the exclusive factory authorized publisher of Volkswagen Service Manuals in the United States and Canada In every manual we provide full factory repair procedures specifications tolerances electrical wiring diagrams and lubrication and maintenance information Bentley manuals are the only complete authoritative source of Volkswagen maintenance and repair information Even if you never intend to service your car yourself you ll find that owning a Bentley Manual will help you to discuss repairs more intelligently with your service technician

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