

## **2.0L - METAL CYLINDER HEAD GASKET**

### **Article Text**

1996 Volkswagen Golf  
For Volkswagen Technical Site  
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Friday, August 20, 1999 12:06AM

### **ARTICLE BEGINNING**

#### **TECHNICAL SERVICE BULLETIN**

#### **METAL CYLINDER HEAD GASKET**

Model(s): 1995-on Volkswagen Golf, GTI, Jetta built from 03/95  
with 2.0 liter, engine code ABA  
Group: 15 - Engine - Cylinder Heads Valve Drive  
Bulletin No.: 96-03  
Date: May 15, 1996

File this Technical Bulletin in Repair Manual No.: W42 011 294 105.

### **SERVICE INFORMATION**

The following Repair Manual information is new and will be integrated with the next Repair Manual update.

#### **CYLINDER HEAD, REMOVING AND INSTALLING**

Refer to Fig. 1.

- 11 - Cylinder head bolt
  - \* Always replace.
  - \* Different versions depending on cylinder head gasket type.
- 14 - Cylinder head gasket
  - \* Always replace.
  - \* New metal gasket from 03/95.
  - \* Installing replacement metal gasket requires different cylinder head bolts.
  - \* When replacing gasket, replace engine coolant.

#### **CHECKING CYLINDER HEAD FOR DISTORTION**

Maximum permissible distortion: 0.1 mm (0.004 in.) See Fig. 2.

#### **CYLINDER HEAD BOLT IDENTIFYING FEATURES**

See Fig. 3.

- A - Bolt with smooth head  
For previous version cylinder head gasket
- B - Bolt with raised markings on bolt head (arrows)  
For metal cylinder head gasket

#### **CYLINDER HEAD, REMOVING AND INSTALLING**

Special tools, testers and auxiliary items

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- \* Guide pin 3070
- \* Torque wrench - 40-200 N.m (30-150 ft-lb)

#### Conditions

- \* Engine cold
- \* Pistons not at Top Dead Center (TDC)

CAUTION: \* Only remove the new cylinder head gasket from its package immediately before installing.

- \* Handle the new gasket with extreme care. Damage to the silicone coating or around the beading will lead to leaks.
- \* If a metal gasket is being installed as a replacement for the previous softer gasket, new cylinder head bolts must also be installed.

#### REMOVING

- Follow sequence when loosening cylinder head. See Fig. 4.
- Carefully remove remains of gasket, making sure that no scoring or long scratches are formed (abrasive materials must be 100 grit minimum).
- Carefully remove metal particles and remains of abrasive materials.

#### INSTALLING

- To align cylinder head, install guide pins from 3070 into holes for cylinder head bolts -8- and -10-. See Fig. 5.
- Install cylinder head gasket.
  - \* Lettering (Part No.) faces up.
- Install cylinder head and 8 remaining bolts, and tighten by hand.
- Remove guide pins using removal tool from 3070, then install 2 remaining cylinder head bolts.
- Tighten cylinder head in sequence shown in Fig. 6, following same sequence for each of for stages.
- First pre-tighten with torque wrench.
  - \* Stage I = 40 N.m (30 ft-lb)
  - \* Stage II = 60 N.m (44 ft-lb)
- Turn further with standard wrench.
  - \* Stage III = 1/4 turn (90°)
  - \* Stage IV = 1/4 turn (90°)

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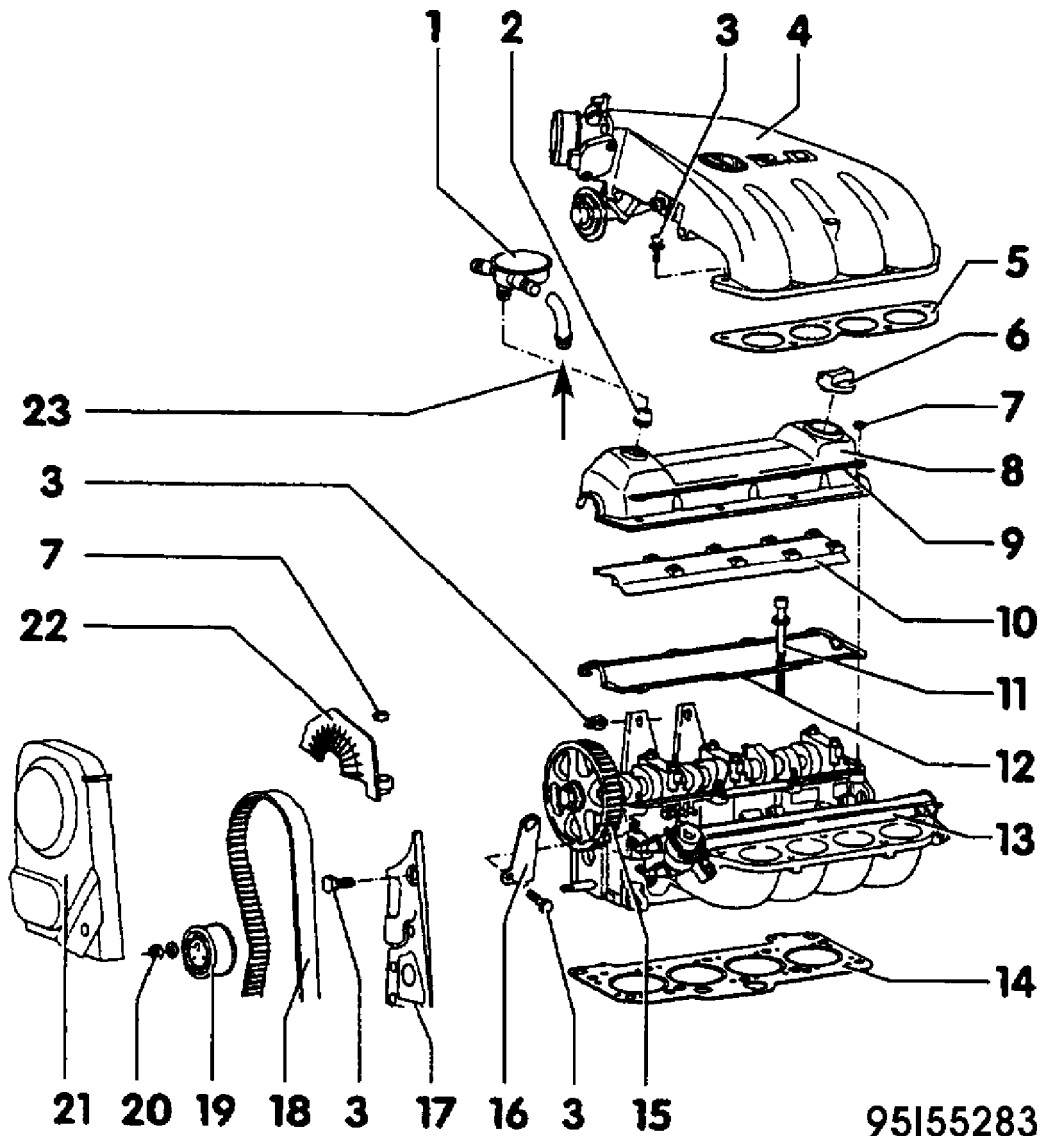


Fig. 1: Cylinder Head, Gaskets & Covers

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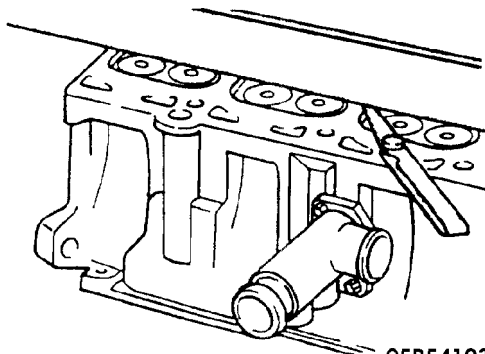


Fig. 2: Checking Cylinder Head Distortion

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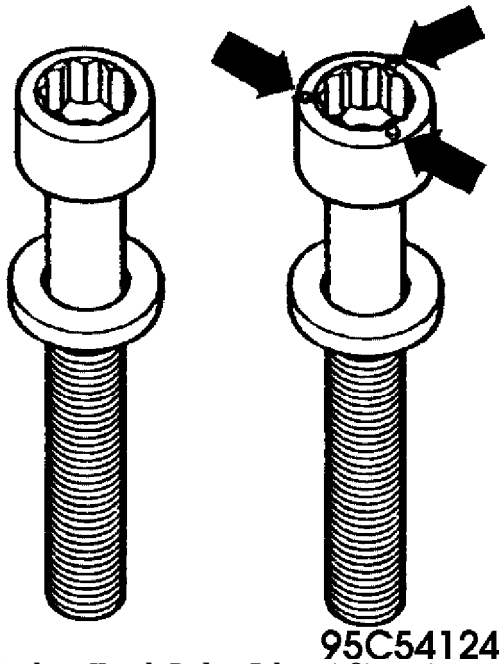
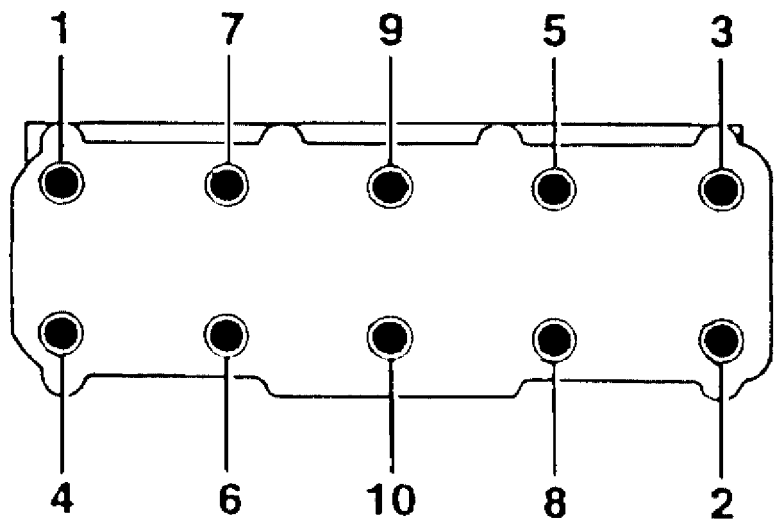


Fig. 3: Cylinder Head Bolt Identification



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Fig. 4: Cylinder Head Bolt Loosening Sequence

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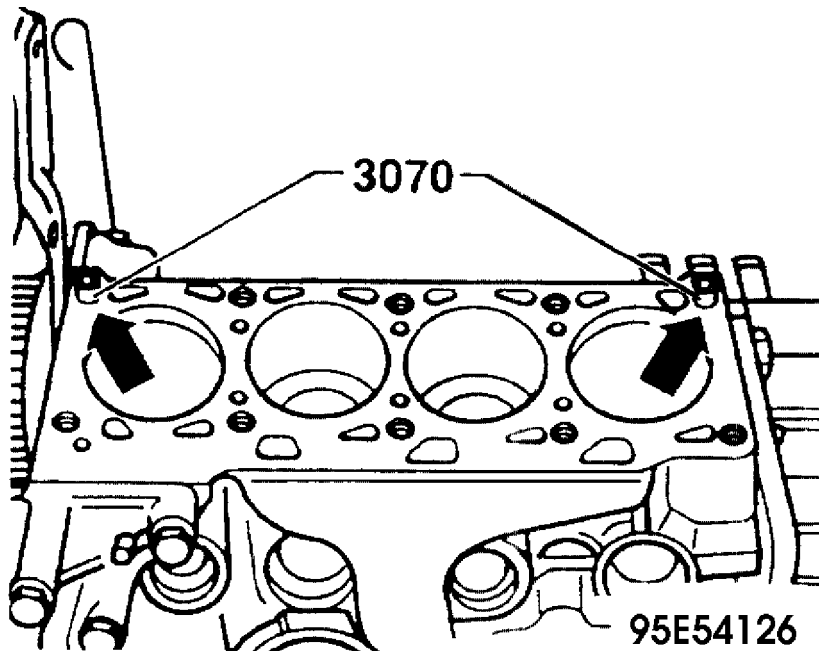


Fig. 5: Guide Pin Locations

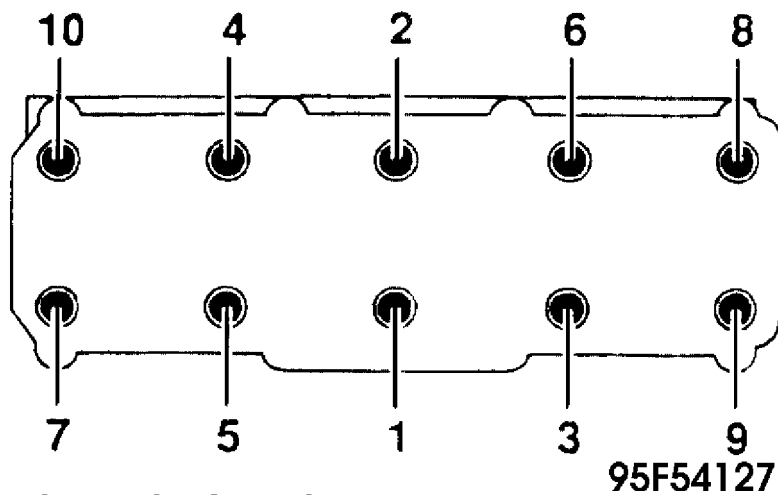


Fig. 6: Cylinder Head Bolt Tightening Sequence

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