

# TECHNICAL REPORT

Assembly instructions of seal  
71000600 for VAG Group  
Engines

## PURPOSE

Assembly instructions for the correct **disassembly and assembly of seal 71000600** with housing and integrated cover, and PTFE lip for VAG engines:

DIESEL	1.4 TDI, 1.9 TDI
PETROL	1.4 FSI, 1.6, 1.6 FSI, 1.8 20v, 2.0, 2.0 TSI, 2.0 FSI, 2.0 TFSI

## DISASSEMBLY

- 1. Drain engine oil
- 2. **Remove bolts of the oil pan** and disassembly oil pan, remove seal bolts from the block..
- 3. To remove the seal without damaging the crankshaft or the block surface, **use three M6 screws** and introduce them in the threaded holes in the seal.

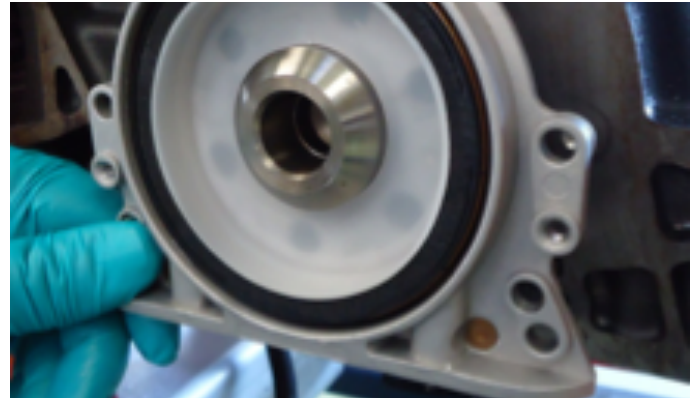


*Tighten screws progressively and in alternate way to remove the seal in a uniform way.*

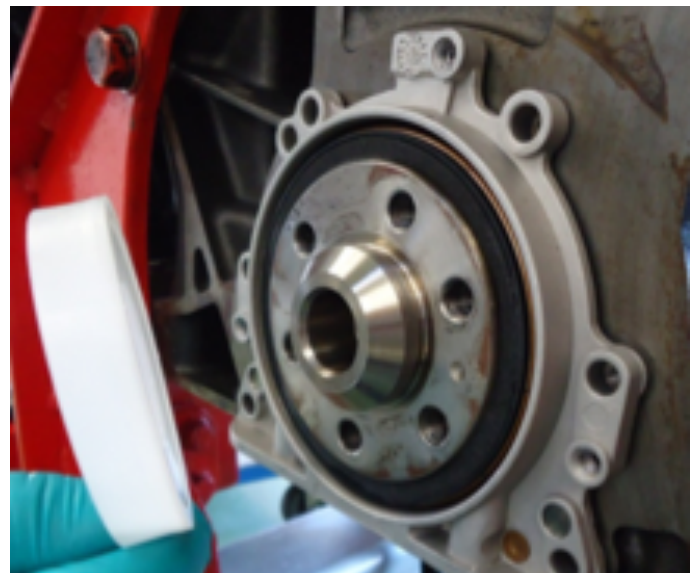
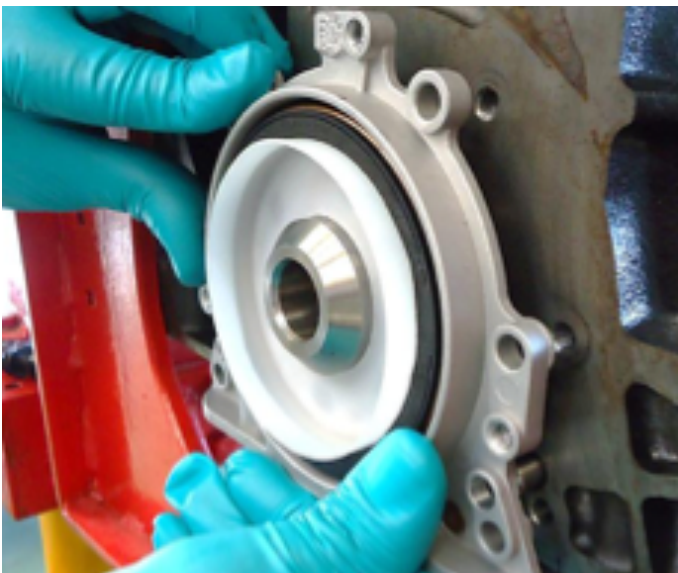
- 4. Once the seal has been removed, **clean the crankshaft axis and check it is not damaged**; if it were damaged, repair would be needed, since a small defect in the axis will cause an oil leak.

## ASSEMBLY

- 1. **Do not remove the seal out of its protecting cover** to avoid dirtiness or dust. Do not manipulate the sealing lip.
- 2. This type of PTFE seal is supplied with a **plastic shell**, which as well as **protecting the lip** it is also good as applicator for the seal assembly. Without the applicator, the tight tool must be used.
- 3. Once the lip has been positioned and aligned, **push the housing uniformly** until it gets in touch with the block surface and the dowel pins fit in the seal holes.



*The plastic shell has a hole which fits the crankshaft ledge and works as a dowel pin to assembly the seal perfectly aligned.*



- 4. Tighten the seal bolts with the engine block at **specified torque**.
- 6. **Assembly the oil pan** in the engine and tighten bolts at specified torque.



*1,5 kpm*

- 5. **Clean the surfaces off oil and sealant** of the previous assembly, both in the block and oil pan and apply a new silicone cord without covering the bolts holes, always in the inner side.



## NOTES

The **cord of sealant must be around 3 mm** to prevent the excess of material gets into the oil pan, obstructing the vacuum pipe of the oil pump.

After applying sealant (Ajusil), put together the oil pan to the block **before sealant begins getting harder** (10 min. approx).

**Do not lube with oil or grease on the crankshaft axis or seal lip**; surfaces on both sides must be totally dry.

The **crankshaft surface** must be in **perfect conditions**, otherwise it must be rebuilt by an expert technician.

In order the seal PTFE lip adapt to the crankshaft shape for the right sealing, **engine must not be started until 4 hours** after the seal assembly.

The rubber coating on the base of the seal, does not seal by itself, so it is necessary in every case to **use additional sealant** or oil pan gasket to assure the complete sealing in that area.