9. PRACTICE APPLICATION OF SEAL PACKING HEADING TIPS FOR QUICK AND ACCURATE APPLICATION

[IMPORTANT] 6 TIPS TO PREVENT WORK ERRORS

a) Using a Practice Sheet (supplied in actual size, and a small copy of the sheet is on the next page), practice until you are able to apply seal packing quickly and precisely as instructed.

- Each component must be attached within 5 minutes of seal packing application, and all bolts must be tightened to the specified torque within 15 minutes of the application.
- DO NOT erroneously apply seal packing to the L-shaped grooves.

<table>
<thead>
<tr>
<th>Judgment</th>
<th>Locations to apply seal packing</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>OK</strong></td>
<td>Apply to the inner edge of the level surface</td>
</tr>
<tr>
<td><strong>NG</strong></td>
<td>Apply to the “L” shape groove</td>
</tr>
</tbody>
</table>

(Note: Conceptual cross-section drawings for seal packing application area are shown below.)

**Sufficient seal on flat surfaces**

**Insufficient seal on flat surfaces may cause leaks**

**NOTE:**
Control the seal packing widths by adjusting the speed of sealer gun movement and operation of the sealer gun lever.

Moved quickly
Thick

Moved slowly
Thick

Moved quickly
Thin

Moved slowly
Thin
10. REINSTALL TIMING CHAIN OR BELT COVER SUB-ASSEMBLY

a) Remove the seal packing, which has got hard, from the tip of the sealer gun.

b) Using the sealer gun, apply seal packing to the chain cover.

- **DO NOT** allow gaps between the ends of applied seal packing.
- Each component must be attached within 5 minutes of seal packing application, and all bolts must be tightened to the specified torque within 15 minutes of the application.

---

**DO NOT** allow gaps between seal packing ends

---

**Apply sealer outward**

**Areas A and B**

**Notice:** To prevent air and fluid holes from being clogged, apply seal packing in an outward direction.

---

Bolt hole C at 5 locations

**Apply sealer outward**

**Notice:** Apply seal packing only to the 5 specified areas.

C

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Perimeter areas other than areas A and B

**Apply sealer inward**

---

All areas

**Maintain uniform width**

3.5 to 4.5 mm (0.137 to 0.177 in.)
c) Install the timing chain or belt cover sub-assembly.
   1) Using the procedure outlined in the illustration (detailed procedures are described below),
      clean and degrease the timing chain or belt cover sub-assembly.

      **Components must be installed within 5 minutes of seal packing application, and the bolts must be tightened to the specified torques within 15 minutes of the application.**

2) Clean and degrease the timing chain or belt cover sub-assembly installation surfaces on the engine.

3) While sets the timing chain or belt cover sub-assembly prepared for adhesion using the 2 guide bolts and holds it in place as shown, check the contact surfaces for any oil.

4) Clean and degrease as necessary.

5) Attach the timing chain or belt cover sub-assembly.
d) Remove the 2 guide bolts and temporarily install the 32 bolts.

<table>
<thead>
<tr>
<th>Bolt type</th>
<th>Width across flats mm / in.</th>
<th>Bolt length mm / in.</th>
<th>Bolt Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>10 / 0.39</td>
<td>20 / 0.79</td>
<td>3</td>
</tr>
<tr>
<td>B</td>
<td></td>
<td>50 / 1.97</td>
<td>2</td>
</tr>
<tr>
<td>C</td>
<td>12 / 0.47</td>
<td>25 / 0.98</td>
<td>20</td>
</tr>
<tr>
<td>D</td>
<td></td>
<td>60 / 2.36</td>
<td>7</td>
</tr>
</tbody>
</table>
e) Uniformly tighten the 32 bolts to the specified torque in the specified order in several passes.

**Specified torque:**

7 ft.*lbf (10 N*m, 102 kgf*cm)  (5 bolts with 10 mm (0.39 in.) width across flats, bolts 1 to 5 inside the dotted lines in the illustration)

18 ft.*lbf (25 N*m, 255 kgf*cm)  (27 bolts with 12 mm (0.47 in.) width across flats)

f) Place a paint mark on the bolt head after tightening to the specified torque, so as not to leave any bolt untightened.

**[Bolt Tightening Sequences]**

NOTE: 3 illustrations are used to show the bolt tightening sequences, just to simplify each drawing for easier understanding. However, it does NOT mean to complete tightening of bolts 1 to 10 and then proceed to tightening of bolts 11 to 20, and further on. Be sure to uniformly tighten the 32 bolts in several steps, in the sequence shown in a continuous manner.
g) Put a sign onto the vehicle that shows the time when the timing chain or belt cover sub-assembly was reinstalled and the time the engine will be allowed to start.

h) The engine should not be started until 2 hours elapse after the reinstallation (adhesion).
11. REINSTALL SPARK PLUGS (for RH Bank)
   a) Using a 14 mm (0.55 in.) spark plug wrench, reinstall the 2 spark plugs.  
      Specified torque:
      13 ft.*lbf (17 N*m, 173 kgf*cm)

12. REINSTALL IGNITION COIL ASSEMBLIES (for RH Bank)
   a) Reconnect the 2 connectors and attach the clip (included in the Valve Spring Kit).  
   b) Reinstall the 2 ignition coil assemblies with the 2 bolts.  
      Specified torque:
      75 in.*lbf (8.5 N*m, 87 kgf*cm)

13. REINSTALL SPARK PLUGS (for LH Bank)
   a) Using a 14 mm (0.55 in.) spark plug wrench, reinstall the 2 spark plugs.  
      Specified torque:
      13 ft.*lbf (17 N*m, 173 kgf*cm)

14. REINSTALL IGNITION COIL ASSEMBLIES (for LH Bank)
   a) Reinstall the 2 ignition coil assemblies with the 2 bolts.  
      Specified torque:
      75 in.*lbf (8.5 N*m, 87 kgf*cm)
   b) Reconnect the 2 connectors and attach the clip (included in the Valve Spring Kit).
15. INSTALL TIMING CHAIN OR BELT COVER OIL SEAL
   a) Apply engine oil to the lip of a *NEW* timing chain or belt cover oil seal.

   **WARNING:** DO NOT allow any foreign matter to adhere to the oil seal lip.

   b) Using SST, tap in the timing chain or belt cover oil seal until its surface is flush with the timing chain or belt cover edge.

   SST : 09950-60010
   (09951-00490, 09951-00650, 09952-06010)
   09950-70010 (09951-07100)

16. REINSTALL CRANKSHAFT PULLEY
   a) Reinstall the spacer.
   b) Install a *NEW* O-ring.

   **NOTE:**
   Part No.: SU003-02190 (8069390609R)
   \( \phi 39.0 \text{ mm (1.54 in.) inner diameter,} \)
   \( \phi 43.0 \text{ mm (1.69 in.) outer diameter} \)

   c) Apply engine oil to the bolt threads and the bolt seat.
   d) Install the spacer, the crankshaft pulley and the bolt.
e) Attach the crank pulley tool to the crankshaft pulley.

Be sure to set the tool facing the correct direction as shown. (In the orientation opposite to that for removal, so that the claws engage with the pulley when tightening the nut.)

f) While another worker holds the crankshaft pulley in place using SST, install the bolt.

**Specified torque:**
15 ft.*lbf (20 N*m, 204 kgf*cm)
Be sure to observe the specified instructions. The crankshaft pulley must be installed by angle controlled tightening method.

g) Draw a reference line on the crankshaft pulley set bolt, with a marker, according to the line engraved around the crankshaft pulley set bolt head (Mark the bolt).

**NOTE:**
Lines are engraved on a crankshaft pulley set bolt head every 90°.

h) Draw a reference line on the crankshaft pulley, with a marker, according to the engraved line 90° clockwise from the drawn line (Mark the pulley).

i) While another worker holds the pulley in place, further tighten the bolt by 90° until the marks on the bolt and pulley are aligned.

17. REINSTALL ENGINE WIRE

a) Reconnect the 5 connectors.
b) Reconnect the 4 connectors.
c) Attach the clip (included in the Valve Spring Kit).

d) Reinstall the 2 wire harness brackets with the 2 bolts.
   **Specified torque:**
   57 in.*lbf (6.4 N*m 65 kgf*cm)

e) Reinstall the harness clamp bracket with the bolt.
   **Specified torque:**
   57 in.*lbf (6.4 N*m 65 kgf*cm)

f) Reconnect the connector.

18. REINSTALL WATER PUMP PULLEY
a) Temporarily install the water pump pulley with the 3 bolts.
b) Using SST, hold the water pump pulley in place.
   **SST:** 09960-10010
   (09962-01000, 09963-00700)
c) Tighten the 3 bolts to the specified torque to install the water pump pulley.
   **Specified torque:**
   10 ft.*lbf (14 N*m, 143 kgf*cm)
19. REINSTALL V-RIBBED BELT TENSIONER ASSEMBLY
   a) Temporarily install the V-ribbed belt tensioner assembly with the 4 bolts.
   b) Tighten the 4 bolts in the order specified in the illustration.

   Specified torque:
   27 ft.*lbf (36 N*m, 367 kgf*cm)

20. REINSTALL NO. 2 IDLER PULLEY SUB-ASSEMBLY
   a) Reinstall the pulley cover in the direction shown in the illustration.
   b) Reinstall the No. 2 idler pulley with the bolt.

   Specified torque:
   27 ft.*lbf (36 N*m 367 kgf*cm)

21. REINSTALL NO. 1 IDLER PULLEY SUB-ASSEMBLIES
   a) Reinstall the pulley cover in the direction shown in the illustration.
   b) Reinstall the 2 pulleys to their original locations, with the pulley applied with a mark upon removal to the upper left hand side, with the 2 bolts.

   Specified torque:
   27 ft.*lbf (36 N*m, 367 kgf*cm)

22. REINSTALL INJECTOR COVER (for RH Bank)
   a) Re-engage the clamp and reinstall the injector cover with the 2 bolts.

   Specified torque:
   14 ft.*lbf (19 N*m, 194 kgf*cm)

   b) Attach the harness clamp.
23. REINSTALL INJECTOR DRIVER

**STOP** DO NOT apply impact to the injector driver.

a) The injector driver is grounded at the bolt and the nut. To ensure that it is grounded, clean all oil and foreign matter from the installation areas of the injector driver and the engine before installing the injector driver.

b) Reinstall the injector driver with the 3 bolts. **Specified torque:**
   57 in.*lbf (6.4 N*m 65 kgf*cm)

c) Reconnect the 3 connectors with lock, and securely lock them by moving the lock levers in the direction indicated by the arrow.

d) Reconnect the normal connector.

24. REINSTALL INJECTOR COVER (for LH Bank)

a) Reinstall the injector cover with the 2 bolts. **Specified torque:**
   14 ft.*lbf (19 N*m, 194 kgf*cm)
XX. REINSTALLATION OF ENGINE ASSEMBLY

1. ATTACH ENGINE HANGER
   a) Attach the engine hanger with the bolt.
      **Specified torque:**
      32 ft.*lbf (43 N*m, 439 kgf*cm)

2. CHECK KNOCK PINS
   a) Confirm that 2 knock pins are on the transmission assembly contact surface of the engine block, at the 2 locations shown in the illustration.
   b) If there are no knock pins in the specified locations, remove them from the transmission assembly and reinstall them to the engine block.

3. SUSPEND ENGINE ASSEMBLY
   a) Suspend the engine assembly.
   b) Remove the 4 bolts and remove the engine stand from the engine.

4. REINSTALL ENGINE ASSEMBLY
   a) Align the knock pins and the stud bolts on the engine block with each hole on the transmission assembly, while another worker observes them.

   **DO NOT** allow any wire harness, air conditioning piping, or fuel hose, etc. to get caught.
b) Reinstall the 2 transmission coupling bolts.  
**Specified torque:**  
37 ft.*lbf (50 N*m, 510 kgf*cm)

5. **REMOVE MAGNET SHEETS**

6. **REMOVE GARAGE JACK**  
a) Remove the garage jack and the attachment that are supporting the transmission.
7. REINSTALL EXHAUST MANIFOLD TO HEAD GASKETS (Requires 2 Workers)

a) With the engine and the transmission assemblies suspended, hang the left side exhaust manifold to head gasket on the stud bolts diagonally from the vehicle under side.

b) Use a mirror and hang the right side exhaust manifold to head gasket on the stud bolts diagonally from the vehicle under side.

NOTE:
- The 2 gaskets are identical and can be installed facing either side.
- When the exhaust manifold is brought close to the engine block to reinstall the exhaust manifold, the exhaust manifold to head gaskets cannot be visually confirmed if they are reinstalled properly. Thus, be sure to properly set the gaskets as described in the following procedures.

c) The worker in charge of engine lifting: While lowering the engine, use a mirror to check the clearance between the engine and the exhaust manifold, and the gaskets to ensure that they are not detached.

**Engine lowering stop position:** Just before the right side stud bolt on the engine block is taken in the exhaust manifold hole.

To be safe, **DO NOT** get directly under the engine.
e) The worker in charge of engine lifting:
   Raise the exhaust manifold by hand and insert the 2 stud bolts on the engine to the holes in the exhaust manifold.

f) The other worker:
   Temporarily install a **NEW** nut to the exhaust manifold from underneath the vehicle.
8. REMOVE ENGINE SLING DEVICE AND ENGINE HANGER

9. RECONNECT FUEL HOSES NO. 1, NO. 2 AND NO. 3

g) Slowly lower the engine and lead the engine mounting stud bolts through the cross member holes.
10. RECONNECT TRANSMISSION OIL COOLER HOSE NO. 3 AND HEATER WATER HOSE OUTLET B (for Automatic Transmission)
XXI. REINSTALLATION OF ENGINE ACCESSORIES

1. REMOVE TORQUE CONVERTER STOPPER
   (for Automatic Transmission)

2. SET HOOD SUB-ASSEMBLY

3. REINSTALL DRIVE PLATE AND TORQUE CONVERTER SETTING BOLTS
   (for Automatic Transmission)
   (Requires 2 Workers)

   [Worker in charge of holding the crankshaft]
   a) Using SST, rotate and hold the crankshaft pulley at positions where the bolts can be removed.

   [Worker in charge of tightening the bolts]
   b) Reinstall the 6 bolts (all identical) while another worker maintains the crankshaft pulley in place.
      1) Be sure to set a piece of cloth in the service hole to prevent the bolts from falling in.
      2) Tighten the bolts one at a time through the service hole.

      Specified torque:
      18 ft.*lbf (25 N*m, 255 kgf*cm)

4. REINSTALL FLYWHEEL HOUSING UNDER COVER (for Automatic Transmission)

   The work space is very narrow. The procedure below is an example of a right handed work.

   a) Use packing tape (DO NOT use tape with weak adhesion) and stick the bolt to the tip of the pointer finger.
   b) Check the position of the bolt hole with the middle finger.
   c) Align the bolt to the bolt hole and temporarily screw into place.
   d) Use a tool (Take care not to let it drop) and tighten the bolt.
5. REINSTALL STARTER ASSEMBLY

a) Using a 12 x 14 mm (0.47 x 0.55 in.) offset wrench and a 12 mm (0.47 in.) hexagon socket, tighten the bolt on the upper portion of the starter.

Specified torque:
37 ft.*lbf (50 N*m, 510 kgf*cm)

Use the formula below to calculate the torque reading values as the extension tool is used.

6. REINSTALL FRONT CROSSMEMBER SUB-ASSEMBLY

7. RECONNECT HEATER WATER HOSES (for Manual Transmission)
8. CONNECT TRANSMISSION OIL COOLER HOSE NO. 1 AND HEATER WATER HOSE INLET A  
(for Automatic Transmission)  
a) Remove the hose plugs, plastic bags, etc.  
b) Reconnect the 2 hoses.

9. REINSTALL AUTOMATIC TRANSMISSION ASSEMBLY COUPLING BOLTS AND NUTS  
(for Manual Transmission)  
a) Reinstall the clutch housing cover with the 2 bolts.  
   Specified torque:  
   37 ft.*lbf (50 N*m, 510 kgf*cm)  
b) Reinstall the 2 nuts.  
   Specified torque:  
   37 ft.*lbf (50 N*m, 510 kgf*cm)

10. REINSTALL MANUAL TRANSMISSION ASSEMBLY COUPLING BOLTS AND NUTS  
(for Automatic Transmission)  
a) Reinstall the automatic transmission assembly with the 2 bolts and 2 nuts.  
   Specified torque:  
   37 ft.*lbf (50 N*m, 510 kgf*cm)
11. REINSTALL EARTH CABLES

12. RECONNECT RADIATOR OUTLET HOSE

13. REINSTALL EXHAUST MANIFOLD

14. REINSTALL FRONT STABILIZER BARS RH AND LH (for Automatic Transmission)

15. INSTALL FRONT STABILIZER LINK ASSEMBLIES RH AND LH (for Automatic Transmission)
   a) Set 2 NEW front stabilizer link assemblies on the vehicle (the 2 assemblies are identical and can be installed facing either direction).
   b) Using a 6 mm (0.34 in.) socket hexagon, hold the stud bolt.
   c) Using a 17 mm (0.67 in.) union nut wrench, install 4 NEW nuts while holding the stud bolt.
   Specified torque:
   34 ft.*lbf (46 N*m, 469 kgf*cm)

Be sure to use the formula below to calculate the torque reading values as an extension tool is used.

\[
\text{Torque Setting (ft.lbs)} = \frac{34 \times L}{C + L}
\]

- \(L\) Length of torque wrench (in.)
- \(C\) Length of crowfoot wrench (in.)
16. REINSTALL REAR ENGINE UNDER COVER LH AND RH (w/ Floor Under Cover)
17. REINSTALL No.1 ENGINE UNDER COVER
18. REINSTALL No.2 ENGINE UNDER COVER

19. REINSTALL OXYGEN SENSOR
   a) Reconnect the connector and attach the 2 clips (included in the Valve Spring Kit) to reinstall the oxygen sensor.

20. REINSTALL AIR FUEL RATIO SENSOR

21. RECONNECT VACUUM TUBE CONNECTOR HOSE
22. RECONNECT ENGINE WIRE
23. REINSTALL THROTTLE WITH MOTOR BODY ASSEMBLY
24. REINSTALL GENERATOR ASSEMBLY
25. REINSTALL COMPRESSOR WITH MAGNET CLUTCH ASSEMBLY (for Models with Air Conditioning System)
26. RECONNECT NO. 1 COOLER REFRIGERANT DISCHARGE HOSE (for Models with Air Conditioning System)
   a) Remove the protective tape.
   b) Apply compressor oil (ND-OIL8) to a NEW O-ring and the compressor engagement portions.
   NOTE:
   Part No.: SU003-A0025 (73796KC0209R)
   \( \phi 10.8 \text{ mm (0.43 in.) inner diameter,} \)
   \( \phi 15.6 \text{ mm (0.61 in.) outer diameter} \)
   c) Install the NEW O-ring to the No. 1 cooler refrigerant discharge hose.
   d) Reinstall the bolt.
   Specified torque:
   7 ft.*lbf (10 N*m, 102 kgf*cm)

27. REINSTALL FAN AND GENERATOR V BELT
28. REINSTALL ENGINE OIL LEVEL DIPSTICK GUIDE
29. REINSTALL BELT GENERATOR COVER
30. REINSTALL GENERATOR COVER

31. REINSTALL RADIATOR INLET HOSE

32. REINSTALL AIR CLEANER WITH HOSE ASSEMBLY
33. REINSTALL FRONT SUSPENSION UPPER TO COWL BRACE SUB-ASSEMBLIES RH AND LH
34. REINSTALL FUEL TANK CAP ASSEMBLY
35. RECONNECT CABLE TO BATTERY NEGATIVE TERMINAL
   Specified torque:
   53 in.*lbf (6.0 N*m, 61 kgf*cm)

36. REINSTALL FRONT TIRES
   Specified torque:
   89 ft.*lbf (120 N*m, 1224 kgf*cm)

37. CHECK BEFORE STARTING ENGINE

38. REFILL ENGINE OIL

39. CHARGE REFRIGERANT HFC-134a (R134a) (for Models with Air Conditioning System)

40. ADD ENGINE COOLANT (Toyota Genuine Super LLC50)

41. INSPECT FOR COOLANT LEAKS

42. INSPECT FOR ENGINE OIL LEAKS

43. INSPECT FOR FUEL LEAKS

44. INSPECT FOR EXHAUST GAS LEAKS

45. CHECK FOR REFRIGERANT GAS LEAKS (for Models with Air Conditioning System)

46. INSPECT THROTTLE WITH MOTOR BODY ASSEMBLY

47. CHECK IGNITION TIMING

48. CHECK ENGINE IDLING SPEED

49. CHECK ENGINE COOLANT LEVEL
XXII. APPENDIX

A. CAMPAIGN DESIGNATION DECODER

<table>
<thead>
<tr>
<th>Year Campaign is Launched</th>
<th>Repair Phase</th>
<th>Current Campaign Letter for this year</th>
</tr>
</thead>
<tbody>
<tr>
<td>C</td>
<td>0</td>
<td>J</td>
</tr>
</tbody>
</table>

Year Campaign is Launched:
- 8 = 2008
- 9 = 2009
- A = 2010
- B = 2011
- C = 2012
- D = 2013
- E = 2014
- F = 2015
- Etc...

Current Campaign Letter for this year:
- 1st Campaign = A
- 2nd Campaign = B
- 3rd Campaign = C
- 4th Campaign = D
- 5th Campaign = E
- 6th Campaign = F
- 7th Campaign = G
- 8th Campaign = H
- 9th Campaign = I
- Etc...

Examples:
- A0D = Launched in 2010, Remedy Phase, 4th Campaign Launched in 2010
- B1E = Launched in 2011, Interim Phase, 5th Campaign Launched in 2011
- C1C = Launched in 2012, Interim Phase, 3rd Campaign Launched in 2012

B. CAMPAIGN PARTS DISPOSAL

As required by Federal Regulations, please make sure all campaign parts (original parts) removed from the vehicle are disposed of in a manner in which they will not be reused, **unless requested for parts recovery return.**