TOYOTA SERVICE BULLETIN

Group: 01 No.: 01 Date: Mar, 18

Model: Aurion

Subject: Corrections to Repair Manual RM02N2E

Please ensure these pages are distributed to all relevant staff for their information; and a copy made available for future reference, with the above repair manual.

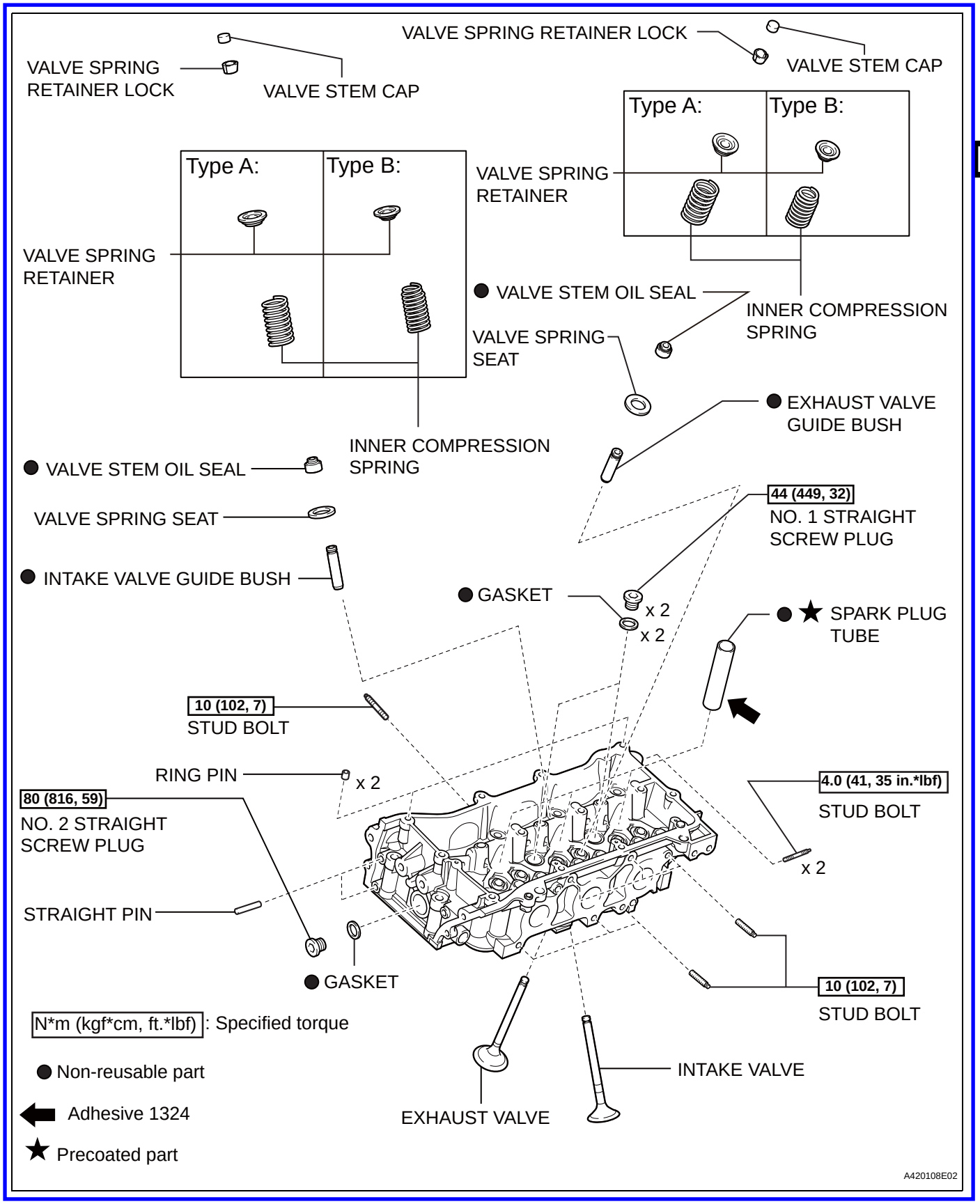
Section	Title	Paragraph
2GR-FE ENGINE MECHANICAL	ENGINE UNIT	COMPONENTS
		REASSEMBLY

The revised pages listed above are attached.

(The corrected parts are indicated by arrows.)

This bulletin does not cause the Flat Rate Manual to be changed

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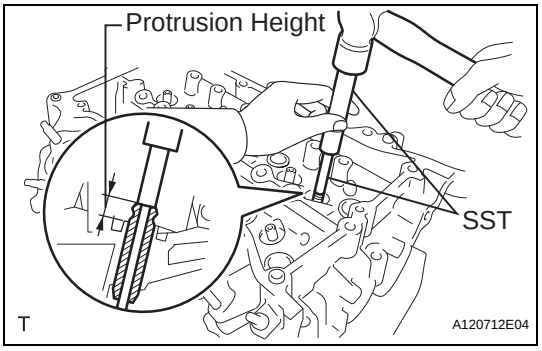
[Corrected]

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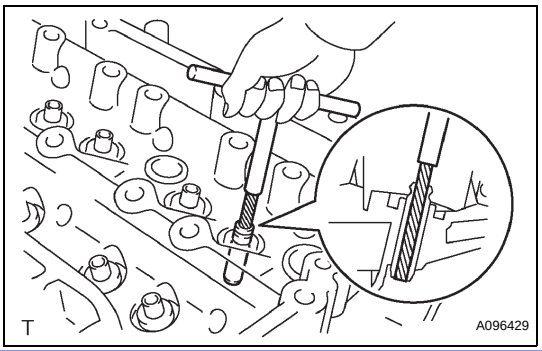
If the bush bore diameter of the cylinder head is greater than 10.306 mm (0.4057 in.), machine the bush bore to the dimension of 10.335 to 10.356 mm (0.4069 to 0.4077 in.) to install an O/S 0.05 valve guide bush.
If the bush bore diameter of the cylinder head is greater than 10.356 mm (0.4077 in.), replace the cylinder head.

(b) Heat the cylinder head to 80 to 100°C (176 to 212°F).

(c) Place the cylinder head on wooden blocks.



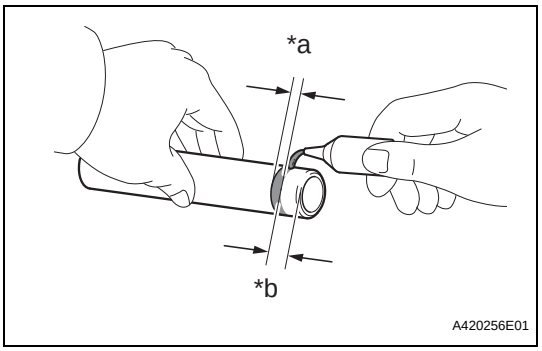
(d) Using SST, tap in new valve guide bushes to the specified protrusion height.
SST 09201-10000 (09201-01050), 09950-70010 (09951-07100)
Protrusion height:
9.30 to 9.70 mm (0.3661 to 0.3819 in.)



(e) Using a sharp 5.5 mm reamer, ream the valve guide bushings to obtain the specified clearance.
Standard oil clearance:
0.030 to 0.065 mm (0.0012 to 0.0026 in.)

13. INSTALL SPARK PLUG TUBE

HINT:
When using a new cylinder head LH, the spark plug tubes must be replaced.



(a) Apply adhesive to a new spark plug tube as shown in the illustration.
Text in Illustration

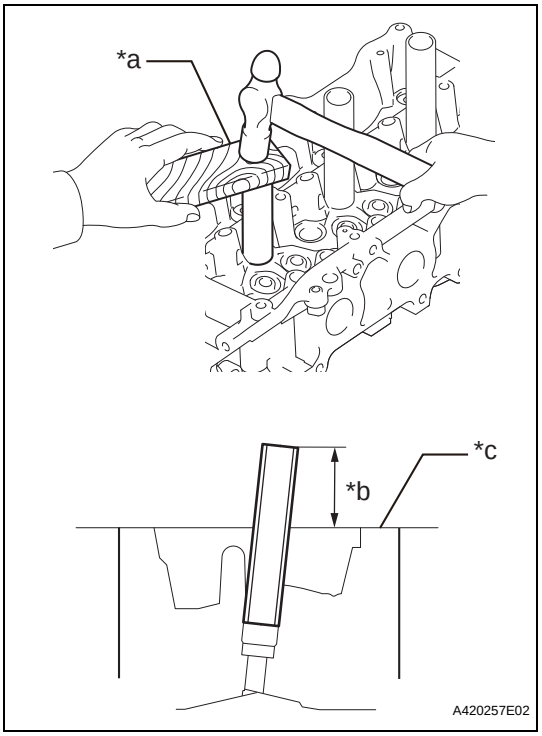
*a	Application Width
*b	9.0 to 15.0 mm (0.354 to 0.591 in.)

Adhesive:
Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent
Standard Application Width:
1.0 to 3.0 mm (0.0394 to 0.118 in.)
NOTICE:
Install the spark plug tube within 3 minutes of applying adhesive.

[Added]

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(b) Using a hammer and wooden block, install the 3 spark plug tubes to the specified protrusion height.

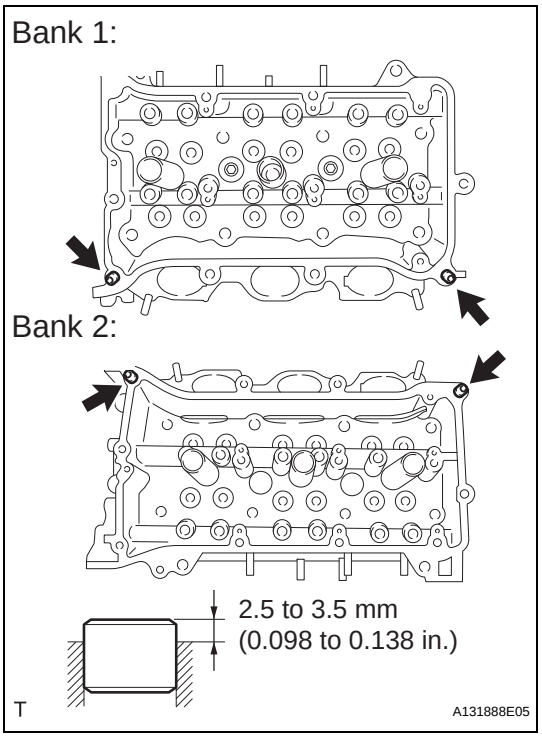
Text in Illustration

*a	Wooden Block
*b	Protrusion Height
*c	Cylinder Head LH Top Surface

Standard Protrusion Height:
72.9 mm (2.87 in.)

NOTICE:

- **Do not tap in the spark plug tube more than specified.**
- **Do not start the engine for at least 1 hour after installation.**
- **Be careful not to deform the spark plug tubes.**
- **Be careful not to let adhesive drip into the cylinder head LH.**



14. INSTALL RING PIN

(a) Using a plastic hammer, tap in new ring pins to the specified protrusion height.

[Added]

Specified protrusion height:
2.5 to 3.5 mm (0.098 to 0.138 in.)

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