TOYOTA SERVICE BULLETIN
Group: 03 No.: 09 Date: Aug, 14

Kluger

Corrections to Repair Manual RM06K6E

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
Please see the attached list on page 2.		

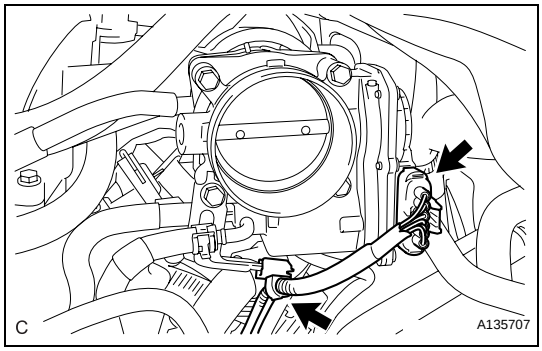
The revised pages listed above are attached.
(The corrected parts are indicated by arrows.)

This Bulletin does not cause the Flat Rate Manual to be changed.

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Section	Title	Paragraph
2GR-FE ENGINE CONTROL SYSTEM	THROTTLE BODY	REMOVAL (2007/05-2008/08)
		REMOVAL (2008/08-2010/07)
		REMOVAL (2010/07-2013/08)
		REMOVAL (2013/08-)
		INSTALLATION (2007/05-2008/08)
		INSTALLATION (2008/08-2010/07)
		INSTALLATION (2010/07-2013/08)
		INSTALLATION (2013/08-)
2GR-FE ENGINE MECHANICAL	ENGINE ASSEMBLY	REMOVAL (2007/05-2008/08)
		REMOVAL (2008/08-2010/07)
		REMOVAL (2010/07-2012/07)
		REMOVAL (2012/07-2013/08)
		REMOVAL (2013/08-)
		INSTALLATION (2007/05-2008/08)
		INSTALLATION (2008/08-2010/07)
		INSTALLATION (2010/07-2012/07)
		INSTALLATION (2012/07-2013/08)
		INSTALLATION (2013/08-)

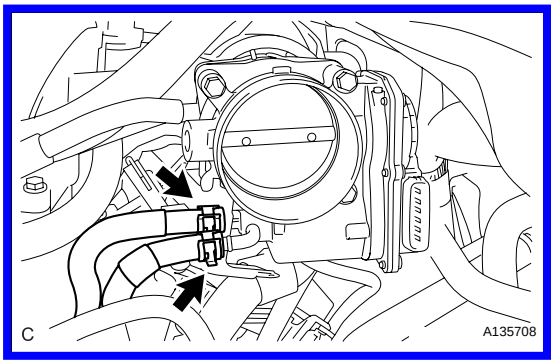
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11. REMOVE THROTTLE BODY

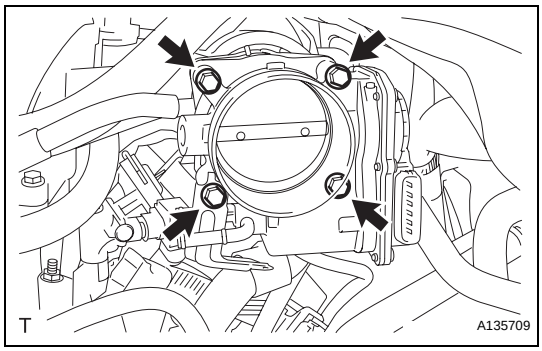
(a) Disconnect the throttle body connector and clamp.

ES

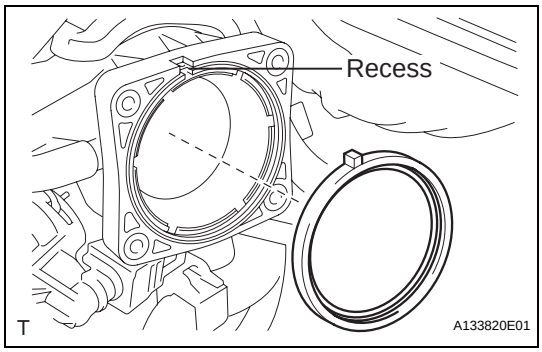


(b) Disconnect the 2 water by-pass hoses from the throttle body.

[Corrected]



(c) Remove the 4 bolts and throttle body.



(d) Remove the throttle body gasket from the intake air surge tank assembly.

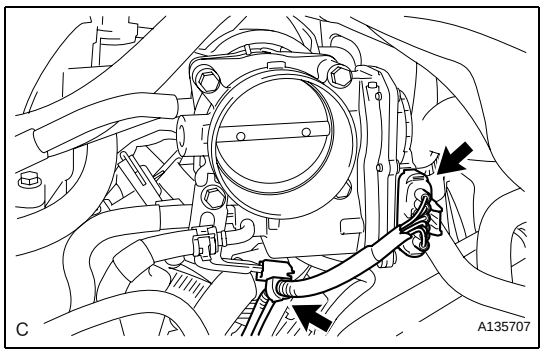
REMOVAL

(2008/08-2010/07)

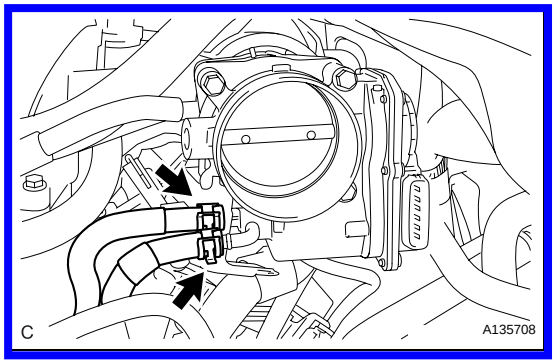
1. **REMOVE ENGINE UNDER COVER ASSEMBLY (See page)**
2. **REMOVE NO. 1 ENGINE UNDER COVER (See page)**
3. **DRAIN ENGINE COOLANT (See page)**
4. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**
5. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
6. **REMOVE COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
7. **REMOVE WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**

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8. **REMOVE OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
9. **REMOVE V-BANK COVER SUB-ASSEMBLY (See page)**
10. **REMOVE AIR CLEANER CAP SUB-ASSEMBLY (See page)**
11. **REMOVE THROTTLE BODY**
    (a) Disconnect the throttle body connector and clamp.

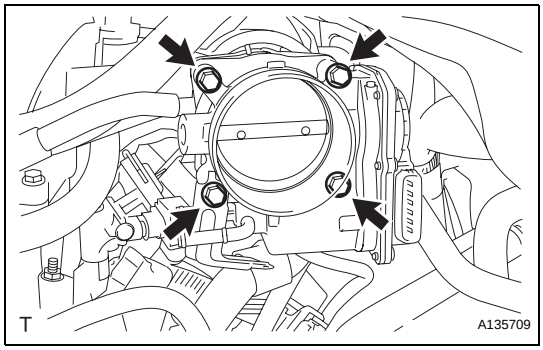


(b) Disconnect the 2 water by-pass hoses from the throttle body.

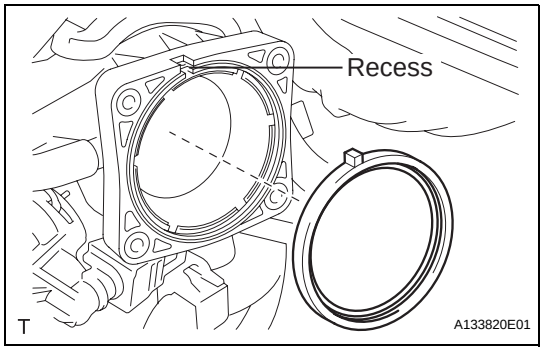


[Corrected]

(c) Remove the 4 bolts and throttle body.



(d) Remove the throttle body gasket from the intake air surge tank assembly.



REMOVAL

(2010/07-2013/08)

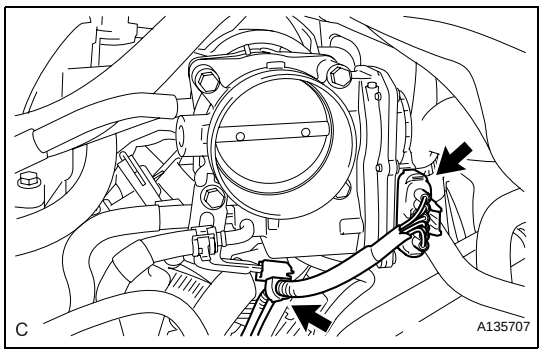
1. **REMOVE ENGINE UNDER COVER ASSEMBLY (See page)**
2. **REMOVE NO. 1 ENGINE UNDER COVER (See page)**
3. **DRAIN ENGINE COOLANT (See page)**
4. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**

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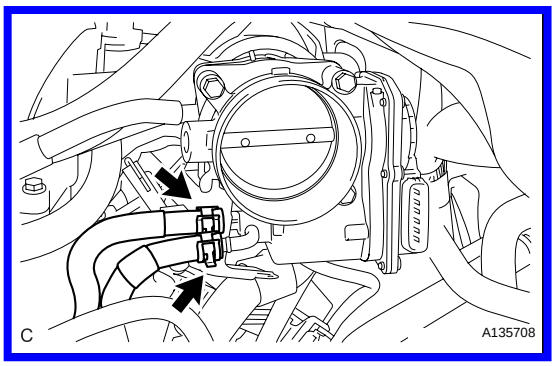
ES

5. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
6. **REMOVE COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
7. **REMOVE WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
8. **REMOVE OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
9. **REMOVE V-BANK COVER SUB-ASSEMBLY (See page)**
10. **REMOVE AIR CLEANER CAP SUB-ASSEMBLY (See page)**
11. **REMOVE THROTTLE BODY**

(a) Disconnect the throttle body connector and clamp.

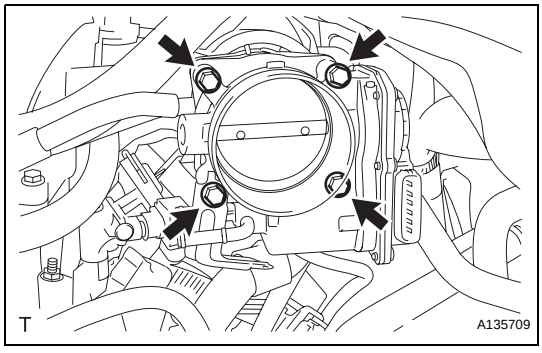


(b) Disconnect the 2 water by-pass hoses from the throttle body.

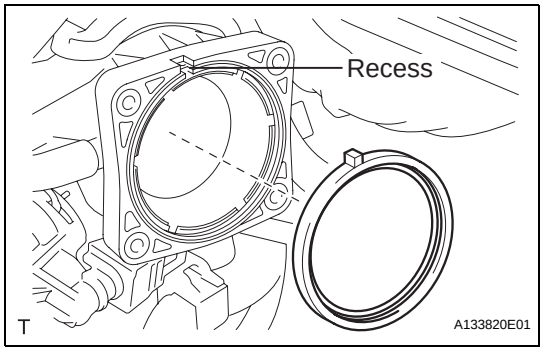


[Corrected]

(c) Remove the 4 bolts and throttle body.



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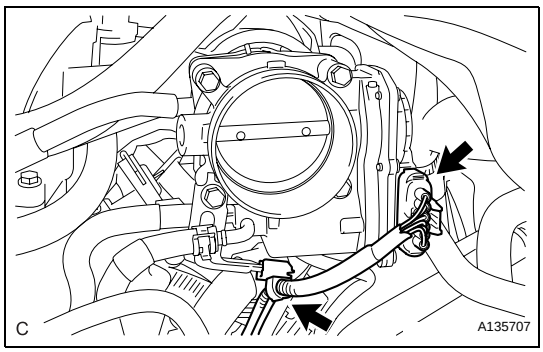
(d) Remove the throttle body gasket from the intake air surge tank assembly.

REMOVAL

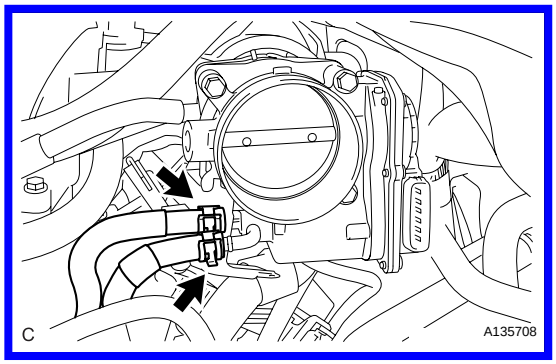
(2013/08-)

1. **REMOVE ENGINE UNDER COVER ASSEMBLY (See page)**
2. **REMOVE NO. 1 ENGINE UNDER COVER (See page)**
3. **DRAIN ENGINE COOLANT (See page)**
4. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**
5. **REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
6. **REMOVE COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
7. **REMOVE WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
8. **REMOVE OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
9. **REMOVE V-BANK COVER SUB-ASSEMBLY (See page)**
10. **REMOVE AIR CLEANER CAP SUB-ASSEMBLY (See page)**
11. **REMOVE THROTTLE BODY**

(a) Disconnect the throttle body connector and clamp.

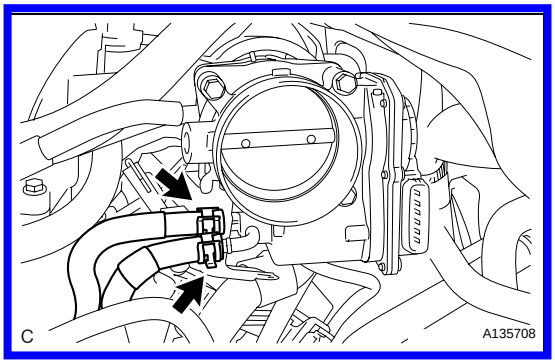


(b) Disconnect the 2 water by-pass hoses from the throttle body.



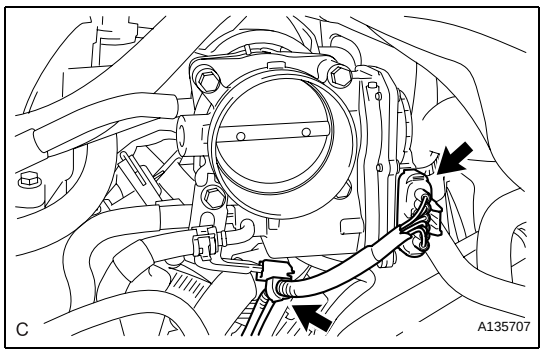
[Corrected]

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(c) Connect the 2 water by-pass hoses.

[Corrected]

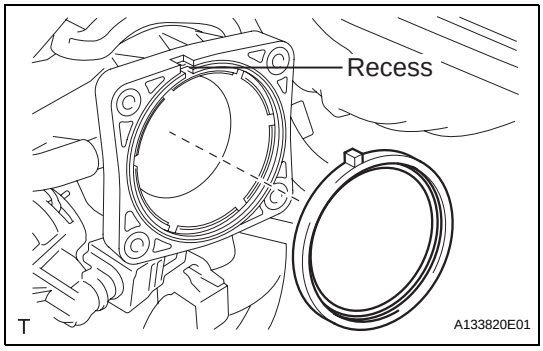


(d) Connect the throttle body connector and clamp.

ES

2. **INSTALL AIR CLEANER CAP SUB-ASSEMBLY (See page)**
3. **ADD ENGINE COOLANT (See page)**
4. **INSPECT FOR COOLANT LEAK (See page)**
5. **INSTALL OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
6. **INSTALL WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
7. **INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
8. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
9. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**
10. **INSTALL V-BANK COVER SUB-ASSEMBLY (See page)**
11. **INSTALL NO. 1 ENGINE UNDER COVER (See page)**
12. **INSTALL ENGINE UNDER COVER ASSEMBLY (See page)**

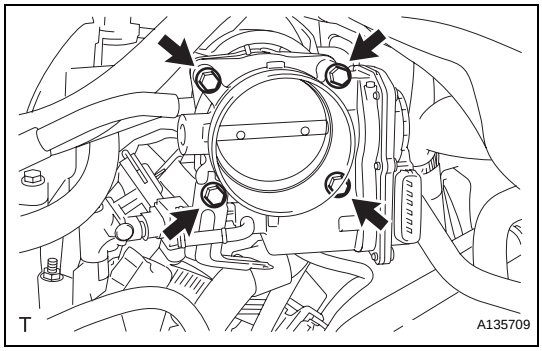
INSTALLATION



(2008/08-2010/07)

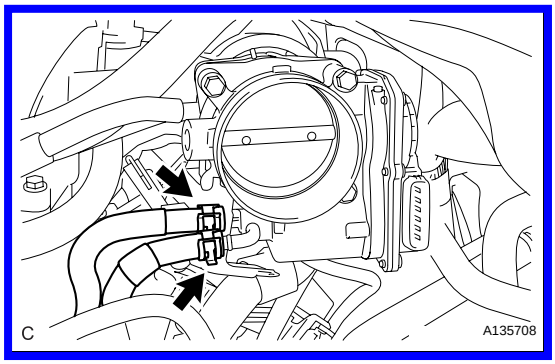
1. **INSTALL THROTTLE BODY**
   (a) Install a new throttle body gasket to the intake air surge tank assembly.

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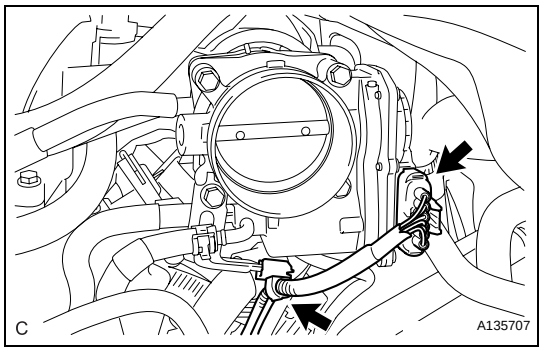
(b) Install the throttle body with the 4 bolts.
Torque: 10 N*m (102 kgf*cm, 7 ft.*lbf)

ES



(c) Connect the 2 water by-pass hoses.

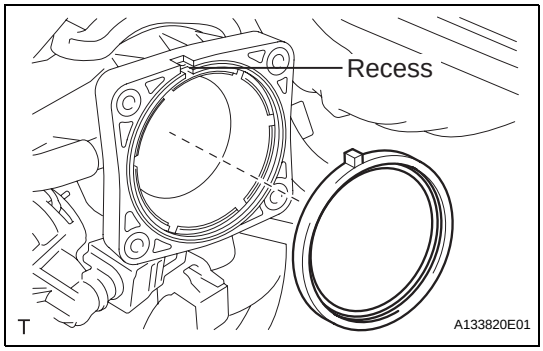
[Corrected]



(d) Connect the throttle body connector and clamp.

2. **INSTALL AIR CLEANER CAP SUB-ASSEMBLY (See page)**
3. **ADD ENGINE COOLANT (See page)**
4. **INSPECT FOR COOLANT LEAK (See page)**
5. **INSTALL OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
6. **INSTALL WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
7. **INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
8. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
9. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**
10. **INSTALL V-BANK COVER SUB-ASSEMBLY (See page)**
11. **INSTALL NO. 1 ENGINE UNDER COVER (See page)**
12. **INSTALL ENGINE UNDER COVER ASSEMBLY (See page)**

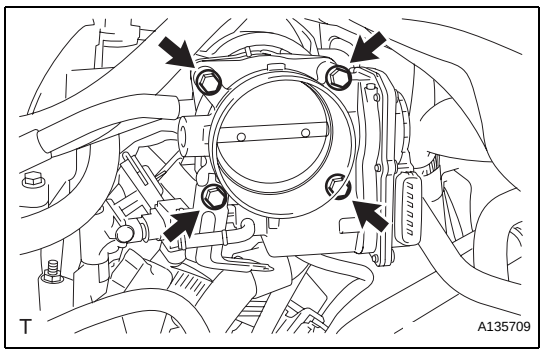
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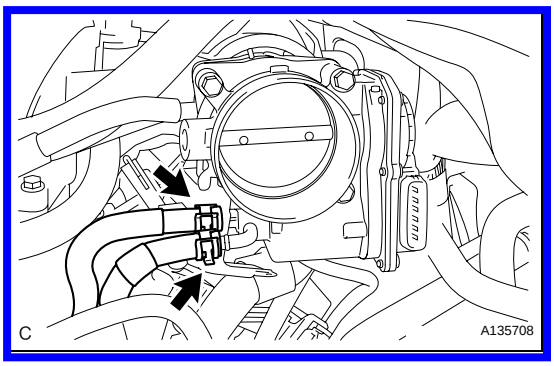
INSTALLATION

(2010/07-2013/08)

1. **INSTALL THROTTLE BODY**
   (a) Install a new throttle body gasket to the intake air surge tank assembly.

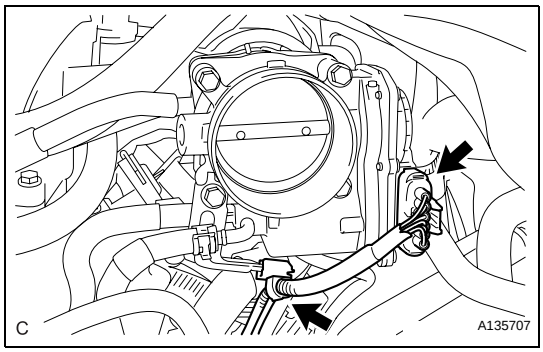


   (b) Install the throttle body with the 4 bolts.
   Torque: 10 N*m (102 kgf*cm, 7 ft.*lbf)



   (c) Connect the 2 water by-pass hoses.

[Corrected]



   (d) Connect the throttle body connector and clamp.

2. **INSTALL AIR CLEANER CAP SUB-ASSEMBLY (See page)**
3. **ADD ENGINE COOLANT (See page)**
4. **INSPECT FOR COOLANT LEAK (See page)**
5. **INSTALL OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
6. **INSTALL WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
7. **INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
8. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
9. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**
10. **INSTALL V-BANK COVER SUB-ASSEMBLY (See page)**

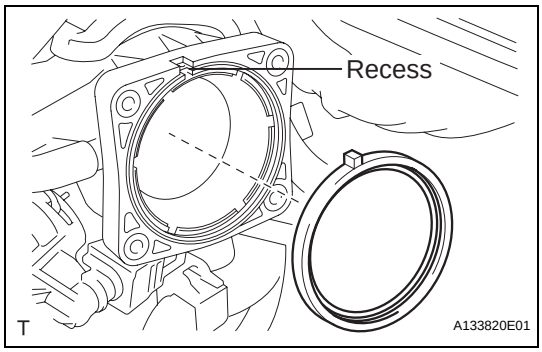
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11. **INSTALL NO. 1 ENGINE UNDER COVER (See page)**
12. **INSTALL ENGINE UNDER COVER ASSEMBLY (See page)**

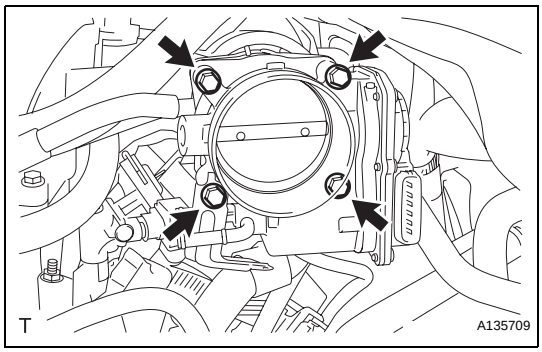
INSTALLATION

(2013/08-)

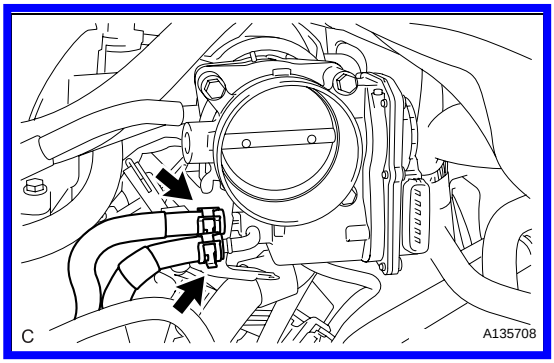
1. **INSTALL THROTTLE BODY**
   (a) Install a new throttle body gasket to the intake air surge tank assembly.



   (b) Install the throttle body with the 4 bolts.
   Torque: 10 N*m (102 kgf*cm, 7 ft.*lbf)

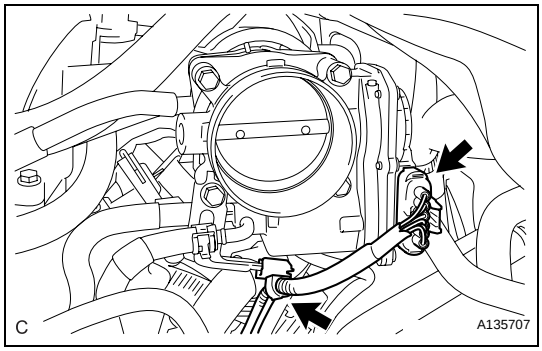


   (c) Connect the 2 water by-pass hoses.



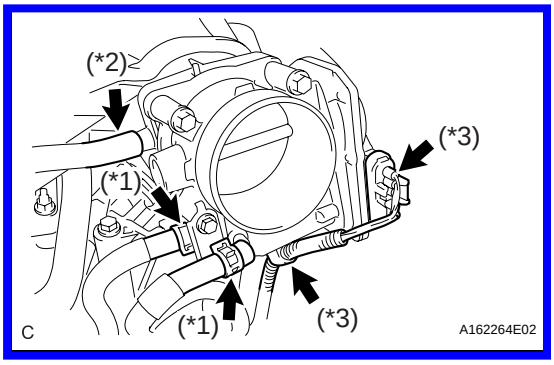
[Corrected]

   (d) Connect the throttle body connector and clamp.



2. **INSTALL AIR CLEANER CAP SUB-ASSEMBLY (See page)**
3. **ADD ENGINE COOLANT (See page)**
4. **INSPECT FOR COOLANT LEAK (See page)**
5. **INSTALL OUTER COWL TOP PANEL SUB-ASSEMBLY (See page)**
6. **INSTALL WINDSHIELD WIPER MOTOR AND LINK ASSEMBLY (See page)**
7. **INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)**
8. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH (See page)**
9. **INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH (See page)**

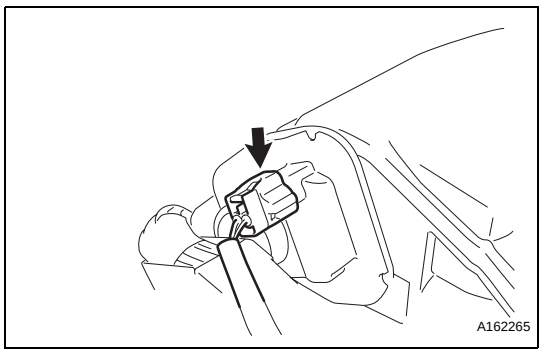
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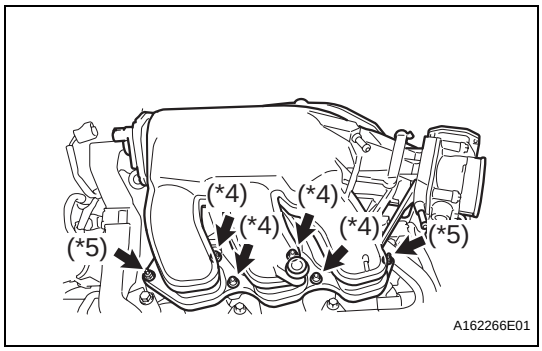
77. REMOVE INTAKE AIR SURGE TANK ASSEMBLY

(a) Disconnect the 2 water by-pass hoses from the throttle with motor body assembly (*1).
(b) Disconnect the vapor feed hose (*2).
(c) Disconnect the throttle with motor body assembly connector and clamp (*3).
(d) Disconnect the No. 1 ventilation hose.

[Corrected]



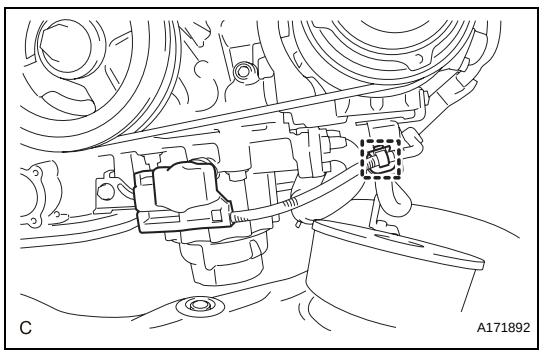
(e) Disconnect the connector.
(f) Remove the 4 bolts, No. 1 surge tank stay and throttle body bracket.



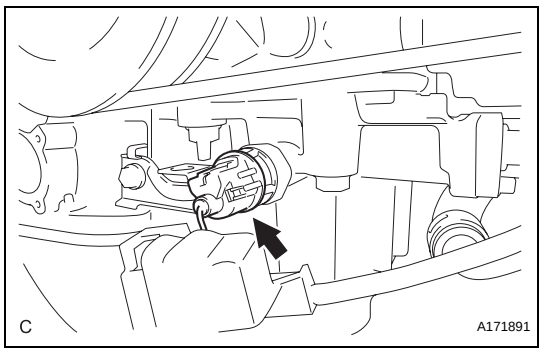
(g) Using a 5 mm socket hexagon wrench, remove the 4 bolts (*4).
(h) Remove the 2 nuts and intake air surge tank (*5).
(i) Remove the gasket from the intake air surge tank.

78. REMOVE ENGINE WIRE (for LHD)

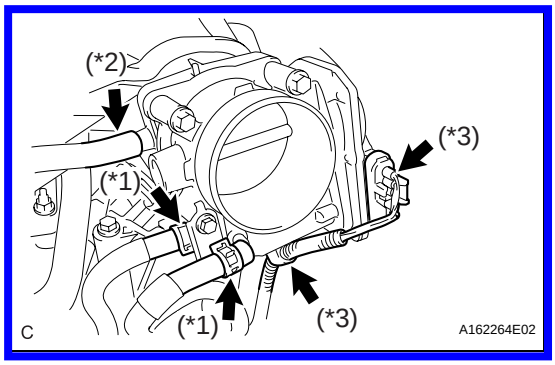
(a) Disconnect the oil pressure switch cover and clamp.



(b) Disconnect the oil pressure switch assembly connector.



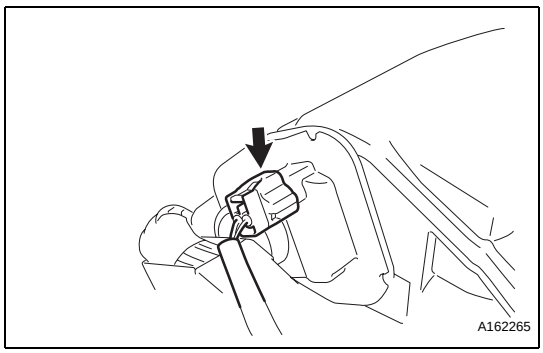
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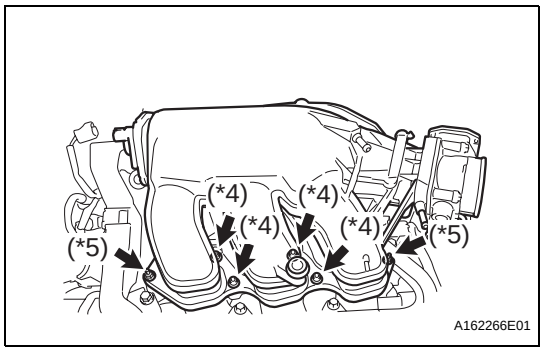
77. REMOVE INTAKE AIR SURGE TANK ASSEMBLY

(a) Disconnect the 2 water by-pass hoses from the throttle with motor body assembly (*1).
(b) Disconnect the vapor feed hose (*2).
(c) Disconnect the throttle with motor body assembly connector and clamp (*3).
(d) Disconnect the No. 1 ventilation hose.

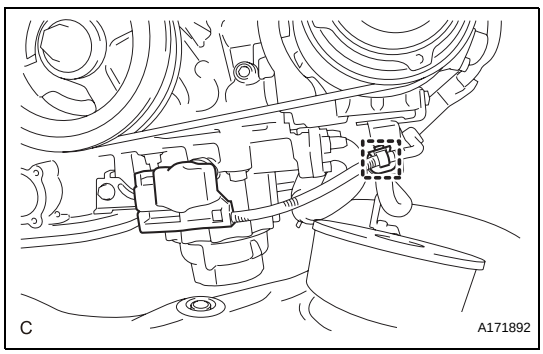
[Corrected]



(e) Disconnect the connector.
(f) Remove the 4 bolts, No. 1 surge tank stay and throttle body bracket.

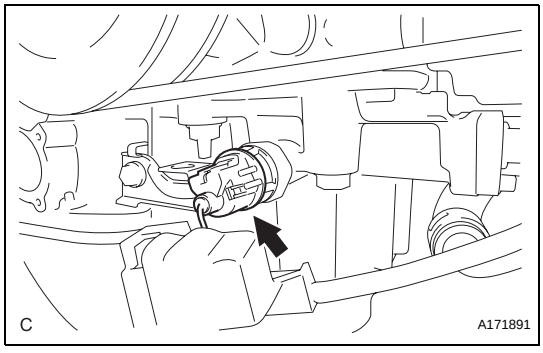


(g) Using a 5 mm socket hexagon wrench, remove the 4 bolts (*4).
(h) Remove the 2 nuts and intake air surge tank (*5).
(i) Remove the gasket from the intake air surge tank.



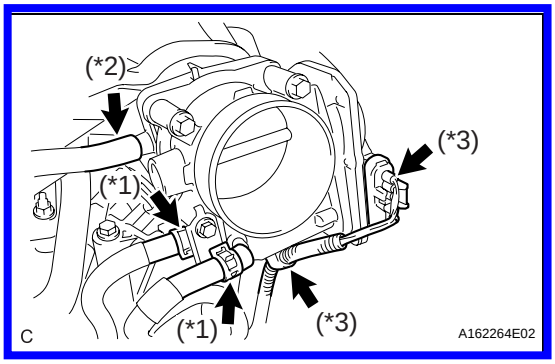
78. REMOVE ENGINE WIRE (for LHD)

(a) Disconnect the oil pressure switch cover and clamp.



(b) Disconnect the oil pressure switch assembly connector.

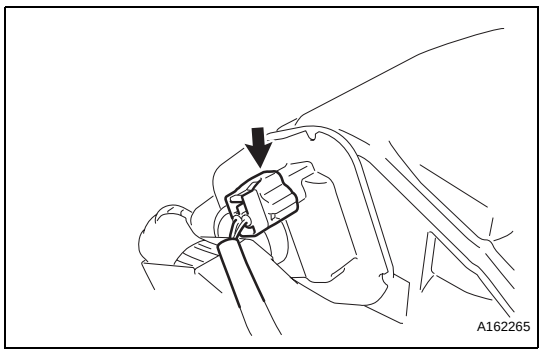
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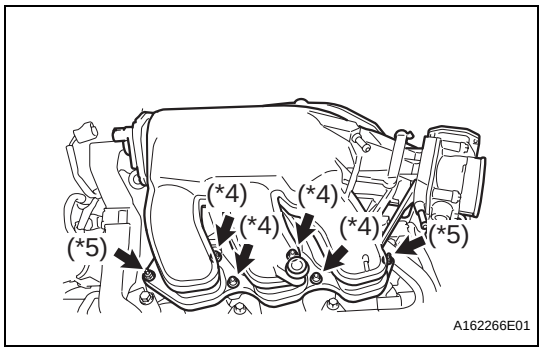
77. REMOVE INTAKE AIR SURGE TANK ASSEMBLY

(a) Disconnect the 2 water by-pass hoses from the throttle with motor body assembly (*1).
(b) Disconnect the vapor feed hose (*2).
(c) Disconnect the throttle with motor body assembly connector and clamp (*3).
(d) Disconnect the No. 1 ventilation hose.

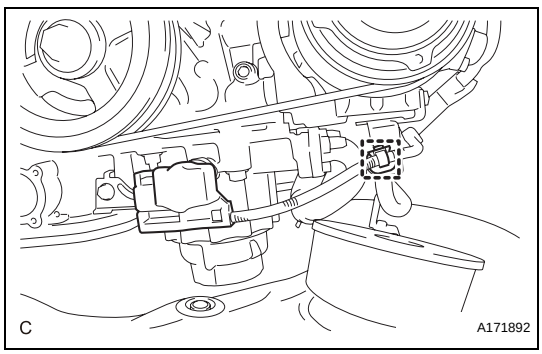
[Corrected]



(e) Disconnect the connector.
(f) Remove the 4 bolts, No. 1 surge tank stay and throttle body bracket.

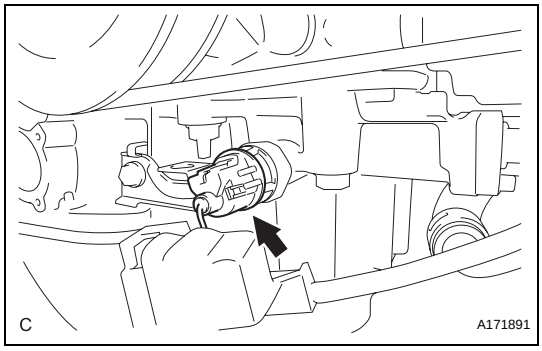


(g) Using a 5 mm socket hexagon wrench, remove the 4 bolts (*4).
(h) Remove the 2 nuts and intake air surge tank (*5).
(i) Remove the gasket from the intake air surge tank.



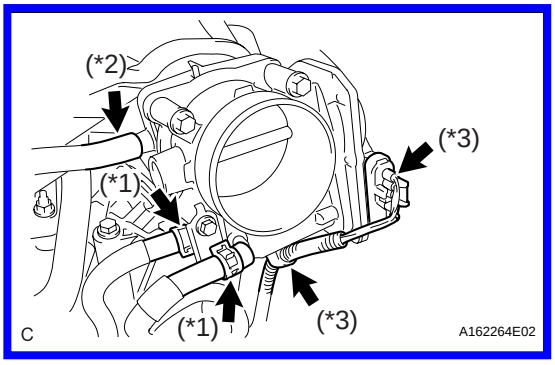
78. REMOVE ENGINE WIRE (for LHD)

(a) Disconnect the oil pressure switch cover and clamp.



(b) Disconnect the oil pressure switch assembly connector.

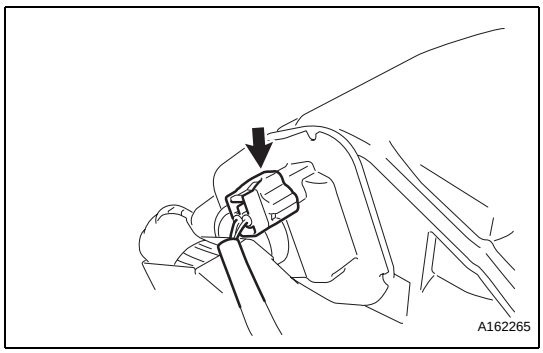
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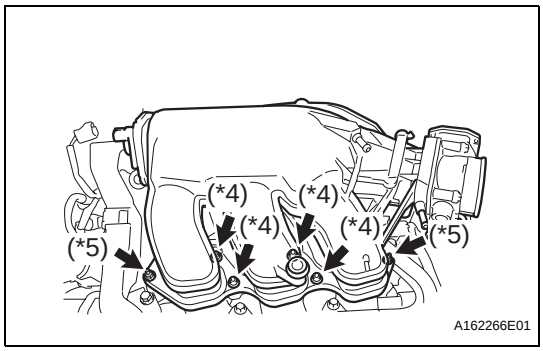
77. REMOVE INTAKE AIR SURGE TANK ASSEMBLY

(a) Disconnect the 2 water by-pass hoses from the throttle with motor body assembly (*1).
(b) Disconnect the vapor feed hose (*2).
(c) Disconnect the throttle with motor body assembly connector and clamp (*3).
(d) Disconnect the No. 1 ventilation hose.

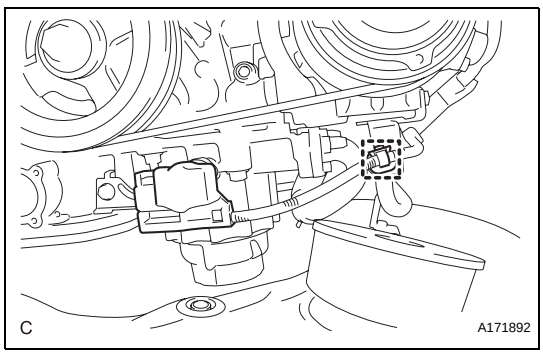
[Corrected]



(e) Disconnect the connector.
(f) Remove the 4 bolts, No. 1 surge tank stay and throttle body bracket.

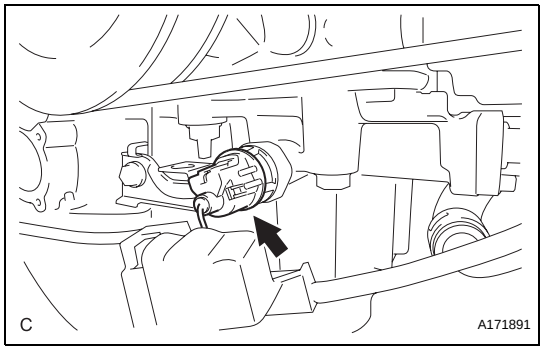


(g) Using a 5 mm socket hexagon wrench, remove the 4 bolts (*4).
(h) Remove the 2 nuts and intake air surge tank (*5).
(i) Remove the gasket from the intake air surge tank.



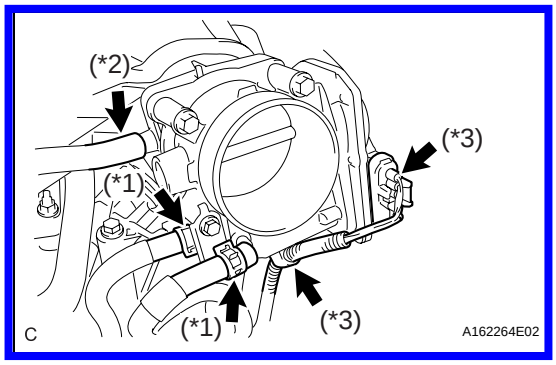
78. REMOVE ENGINE WIRE (for LHD)

(a) Disconnect the oil pressure switch cover and clamp.



(b) Disconnect the oil pressure switch assembly connector.

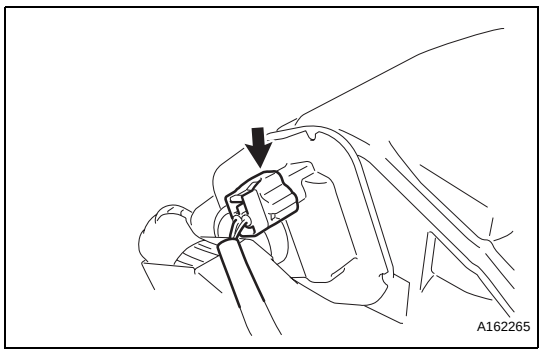
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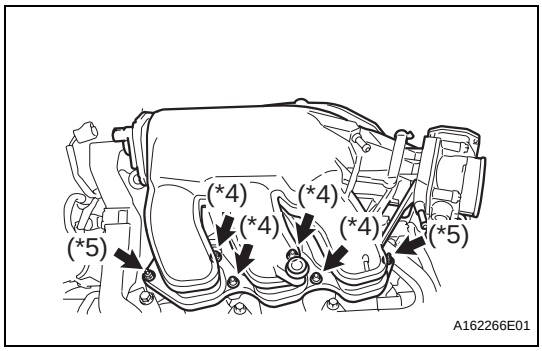
77. REMOVE INTAKE AIR SURGE TANK ASSEMBLY

(a) Disconnect the 2 water by-pass hoses from the throttle with motor body assembly (*1).
(b) Disconnect the vapor feed hose (*2).
(c) Disconnect the throttle with motor body assembly connector and clamp (*3).
(d) Disconnect the No. 1 ventilation hose.

[Corrected]



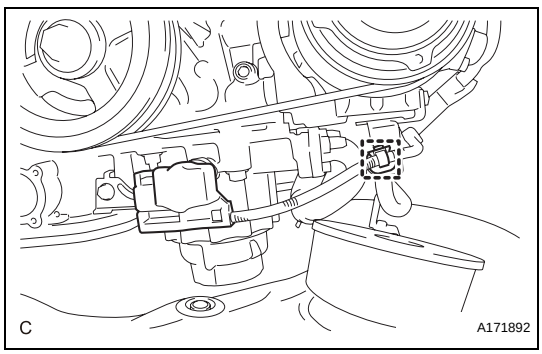
(e) Disconnect the connector.
(f) Remove the 4 bolts, No. 1 surge tank stay and throttle body bracket.



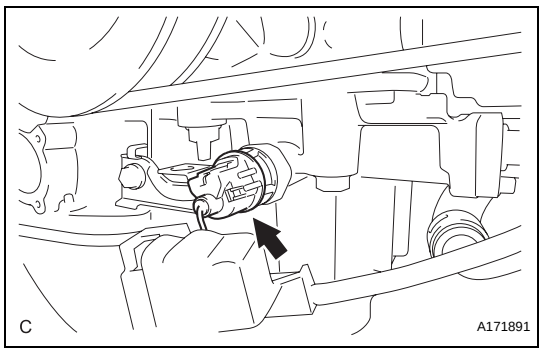
(g) Using a 5 mm socket hexagon wrench, remove the 4 bolts (*4).
(h) Remove the 2 nuts and intake air surge tank (*5).
(i) Remove the gasket from the intake air surge tank.

78. REMOVE ENGINE WIRE (for LHD)

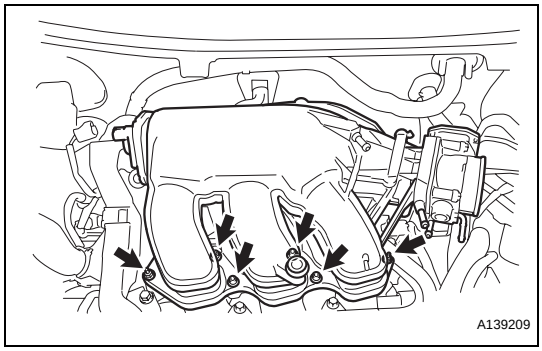
(a) Disconnect the oil pressure switch cover and clamp.



(b) Disconnect the oil pressure switch assembly connector.

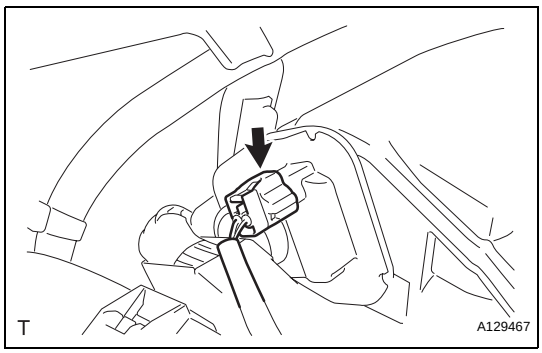


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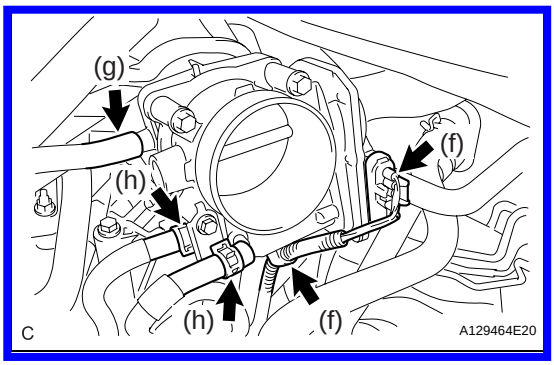


(b) Using a 5 mm hexagon socket wrench, install the 4 bolts and 2 nuts.
Torque: Bolt
18 N*m (184 kgf*cm, 13 ft.*lbf)
Nut
16 N*m (163 kgf*cm, 12 ft.*lbf)

(c) Install the throttle body bracket, No. 1 surge tank stay and 4 bolts.
Torque: 21 N*m (214 kgf*cm, 15 ft.*lbf)

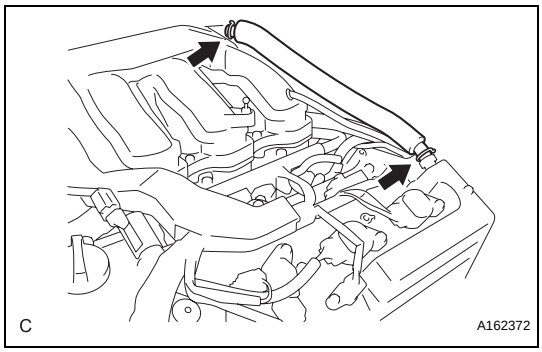


(d) Connect the connector.
(e) Connect the No. 1 ventilation hose.



(f) Install the clamp and connect the throttle with motor body assembly connector.
(g) Connect the vapor feed hose.
(h) Connect the 2 water by-pass hoses to the throttle with motor body assembly.

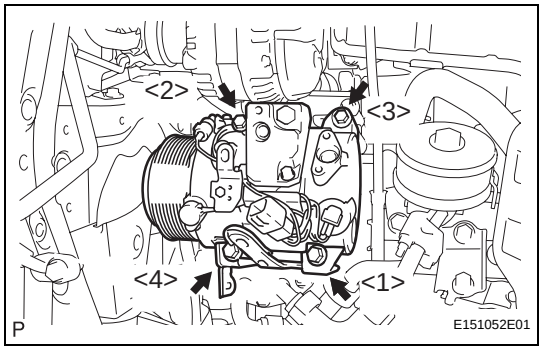
[Corrected]



24. INSTALL VENTILATION HOSE

(a) Using pliers, grip the claws of the 2 clips and slide the 2 clips to the intake air surge tank assembly and ventilation valve.

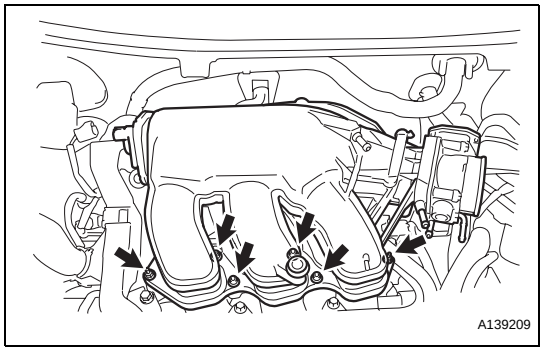
25. TEMPORARILY TIGHTEN COMPRESSOR AND MAGNETIC CLUTCH (See page)



26. INSTALL COMPRESSOR AND MAGNETIC CLUTCH

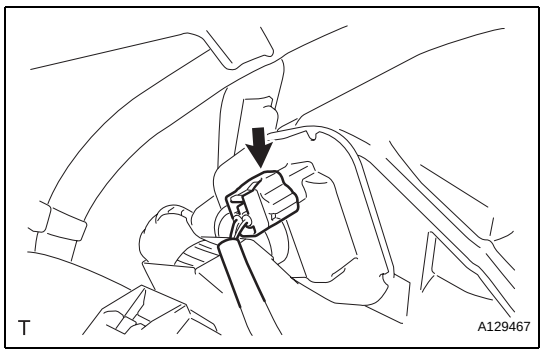
(a) Install the compressor and magnetic clutch with the 4 bolts.
Torque: 25 N*m (255 kgf*cm, 18 ft.*lbf)
NOTICE:
Tighten the bolts in the order shown in the illustration to install the compressor and magnetic clutch.

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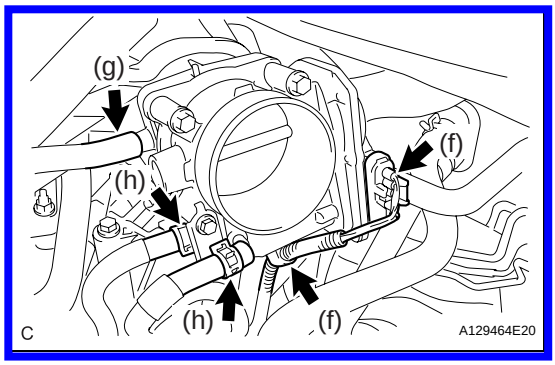


(b) Using a 5 mm hexagon socket wrench, install the 4 bolts and 2 nuts.
Torque: Bolt
18 N*m (184 kgf*cm, 13 ft.*lbf)
Nut
16 N*m (163 kgf*cm, 12 ft.*lbf)

(c) Install the throttle body bracket, No. 1 surge tank stay and 4 bolts.
Torque: 21 N*m (214 kgf*cm, 15 ft.*lbf)

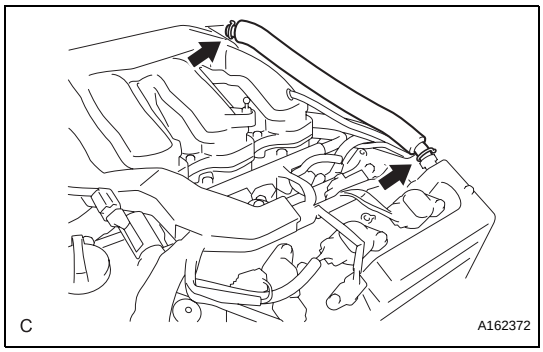


(d) Connect the connector.
(e) Connect the No. 1 ventilation hose.



(f) Install the clamp and connect the throttle with motor body assembly connector.
(g) Connect the vapor feed hose.
(h) Connect the 2 water by-pass hoses to the throttle with motor body assembly.

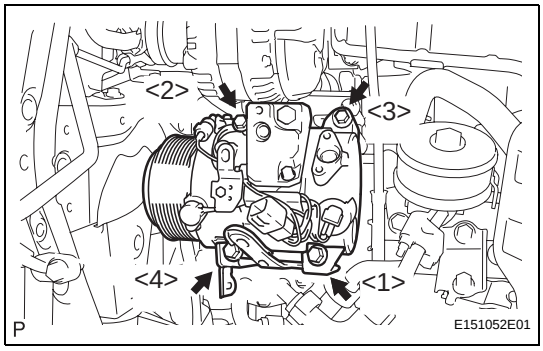
[Corrected]



24. INSTALL VENTILATION HOSE

(a) Using pliers, grip the claws of the 2 clips and slide the 2 clips to the intake air surge tank assembly and ventilation valve.

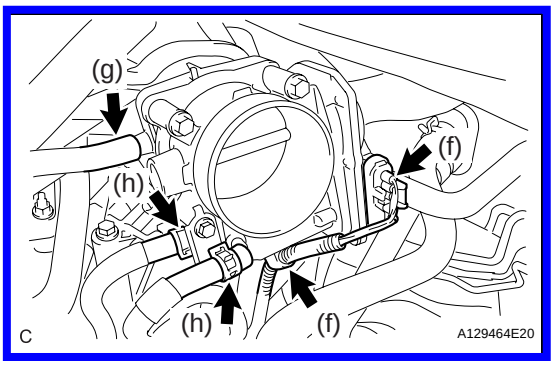
25. TEMPORARILY TIGHTEN COMPRESSOR AND MAGNETIC CLUTCH (See page)



26. INSTALL COMPRESSOR AND MAGNETIC CLUTCH

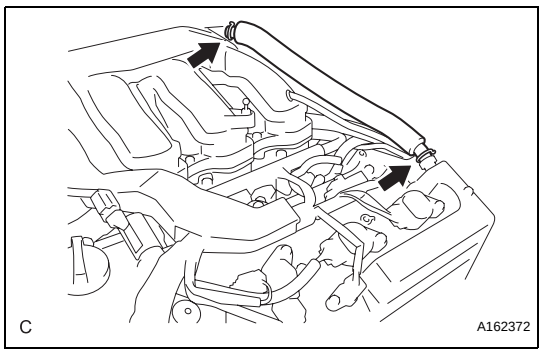
(a) Install the compressor and magnetic clutch with the 4 bolts.
Torque: 25 N*m (255 kgf*cm, 18 ft.*lbf)
NOTICE:
Tighten the bolts in the order shown in the illustration to install the compressor and magnetic clutch.

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(f) Install the clamp and connect the throttle with motor body assembly connector.
(g) Connect the vapor feed hose.
(h) Connect the 2 water by-pass hoses to the throttle with motor body assembly.

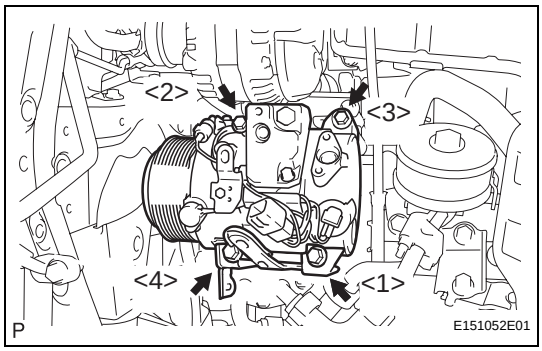
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24. INSTALL VENTILATION HOSE

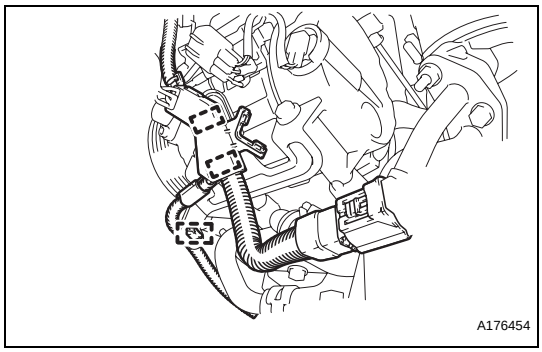
(a) Using pliers, grip the claws of the 2 clips and slide the 2 clips to the intake air surge tank assembly and ventilation valve.

25. TEMPORARILY TIGHTEN COMPRESSOR AND MAGNETIC CLUTCH (See page)



26. INSTALL COMPRESSOR AND MAGNETIC CLUTCH

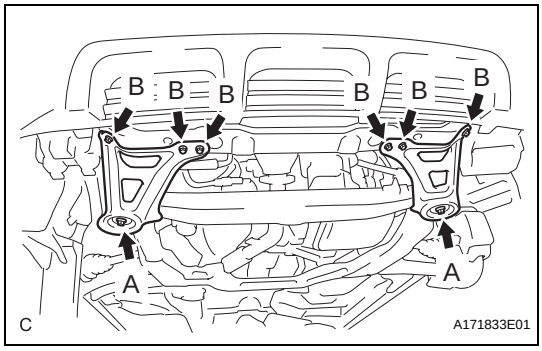
(a) Install the compressor and magnetic clutch with the 4 bolts.
Torque: 25 N*m (255 kgf*cm, 18 ft.*lbf)
NOTICE:
Tighten the bolts in the order shown in the illustration to install the compressor and magnetic clutch.



(b) Engage each clamp.
(c) Connect the connector.

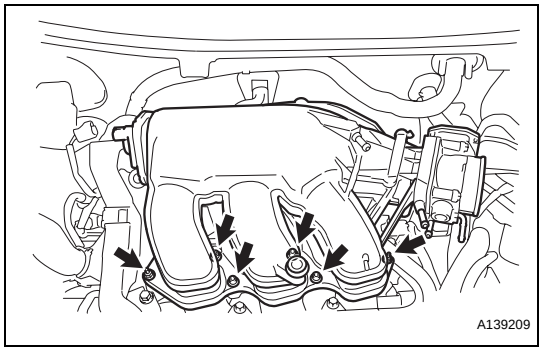
27. INSTALL ENGINE ASSEMBLY WITH TRANSAXLE

(a) Set the engine assembly with transaxle on the engine lifter.
(b) Install the engine assembly to the vehicle.



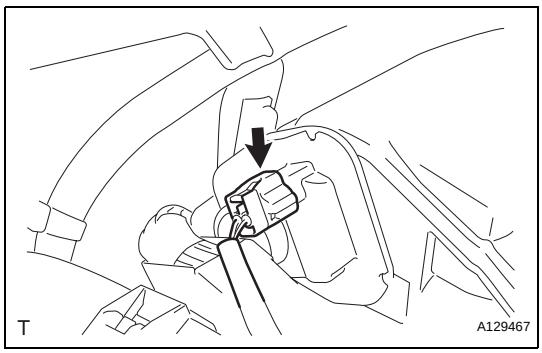
(c) Install the frame side rail plates RH and LH with the 6 bolts and 2 nuts.
Torque: A
85 N*m (867 kgf*cm, 63 ft.*lbf)
B
32 N*m (327 kgf*cm, 24 ft.*lbf)

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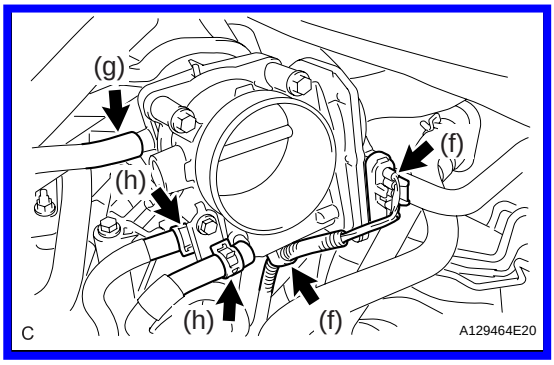


(b) Using a 5 mm hexagon socket wrench, install the 4 bolts and 2 nuts.
Torque: Bolt
18 N*m (184 kgf*cm, 13 ft.*lbf)
Nut
16 N*m (163 kgf*cm, 12 ft.*lbf)

(c) Install the throttle body bracket, No. 1 surge tank stay and 4 bolts.
Torque: 21 N*m (214 kgf*cm, 15 ft.*lbf)

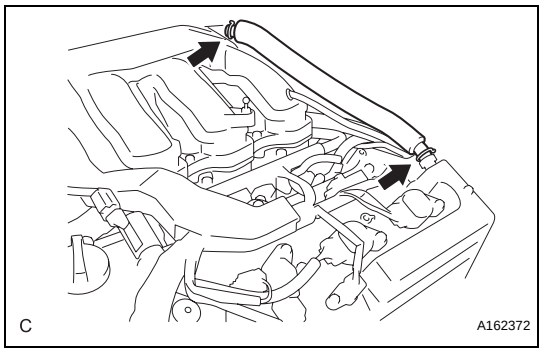


(d) Connect the connector.
(e) Connect the No. 1 ventilation hose.



(f) Install the clamp and connect the throttle with motor body assembly connector.
(g) Connect the vapor feed hose.
(h) Connect the 2 water by-pass hoses to the throttle with motor body assembly.

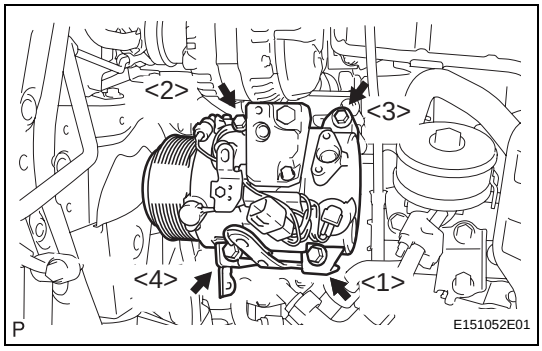
[Corrected]



24. INSTALL VENTILATION HOSE

(a) Using pliers, grip the claws of the 2 clips and slide the 2 clips to the intake air surge tank assembly and ventilation valve.

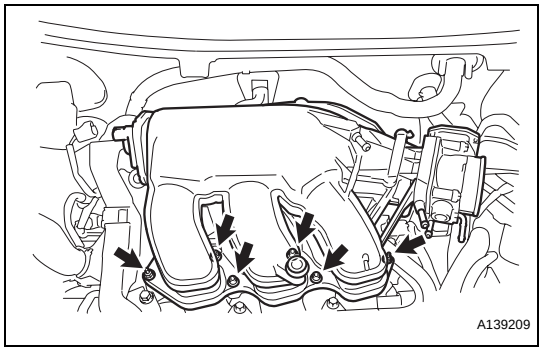
25. TEMPORARILY TIGHTEN COMPRESSOR AND MAGNETIC CLUTCH (See page)



26. INSTALL COMPRESSOR AND MAGNETIC CLUTCH

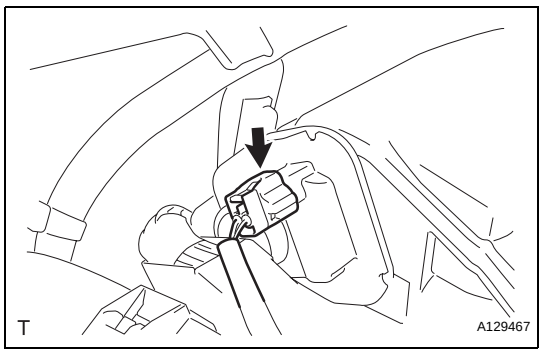
(a) Install the compressor and magnetic clutch with the 4 bolts.
Torque: 25 N*m (255 kgf*cm, 18 ft.*lbf)
NOTICE:
Tighten the bolts in the order shown in the illustration to install the compressor and magnetic clutch.

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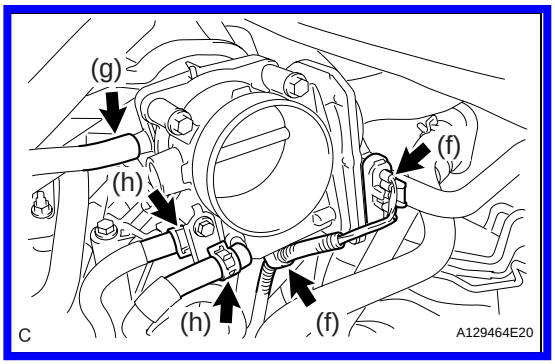


(b) Using a 5 mm hexagon socket wrench, install the 4 bolts and 2 nuts.
Torque: Bolt
18 N*m (184 kgf*cm, 13 ft.*lbf)
Nut
16 N*m (163 kgf*cm, 12 ft.*lbf)

(c) Install the throttle body bracket, No. 1 surge tank stay and 4 bolts.
Torque: 21 N*m (214 kgf*cm, 15 ft.*lbf)

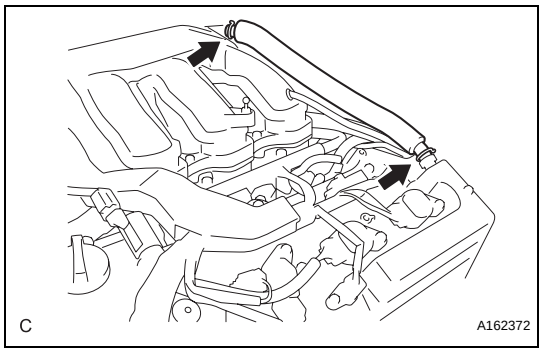


(d) Connect the connector.
(e) Connect the No. 1 ventilation hose.



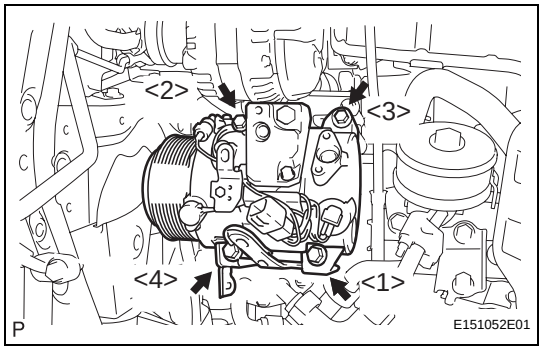
(f) Install the clamp and connect the throttle with motor body assembly connector.
(g) Connect the vapor feed hose.
(h) Connect the 2 water by-pass hoses to the throttle with motor body assembly.

[Corrected]



24. INSTALL VENTILATION HOSE
(a) Using pliers, grip the claws of the 2 clips and slide the 2 clips to the intake air surge tank assembly and ventilation valve.

25. TEMPORARILY TIGHTEN COMPRESSOR AND MAGNETIC CLUTCH (See page)



26. INSTALL COMPRESSOR AND MAGNETIC CLUTCH
(a) Install the compressor and magnetic clutch with the 4 bolts.
Torque: 25 N*m (255 kgf*cm, 18 ft.*lbf)
NOTICE:
Tighten the bolts in the order shown in the illustration to install the compressor and magnetic clutch.

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